Cutmaster® 25mm

Industrial hand plasma equipment



The CUTMASTER 25 manual plasma system is specifically designed to serve the 25mm cutting market whilst maintaining maximum portability.

Operating from a 400V three phase supply, the inverter based design incorporates features such as auto-pilot re-start, True Guard roll bar and the industry renowned SL60 1Torch® for superior durability and consumable life. The unit can also be used for gouging applications when fitted with the correct torch consumables.

The unit is covered by a three year limited warranty and is ideal for heavier fabrication, construction and maintenance applications.

- True Cut ™– 25mm
- Quick Disconnect Torch for easy maintenance or machine torch conversion
- Auto-Restrike on mesh or expanded metal for maximum productivity
- True-Guard™ roll bar for ultimate protection
- TD Surelok® technology for better quality cuts and parts life

Industry

- Heavy Fabrication
- Farm and Ranch
- Construction
- Manufacturing
- Structural Steel
- Rental Fleets
- Pipe and Pipelines
- Mining
- Steel Service Centers

Visit **esab.com** for more information.



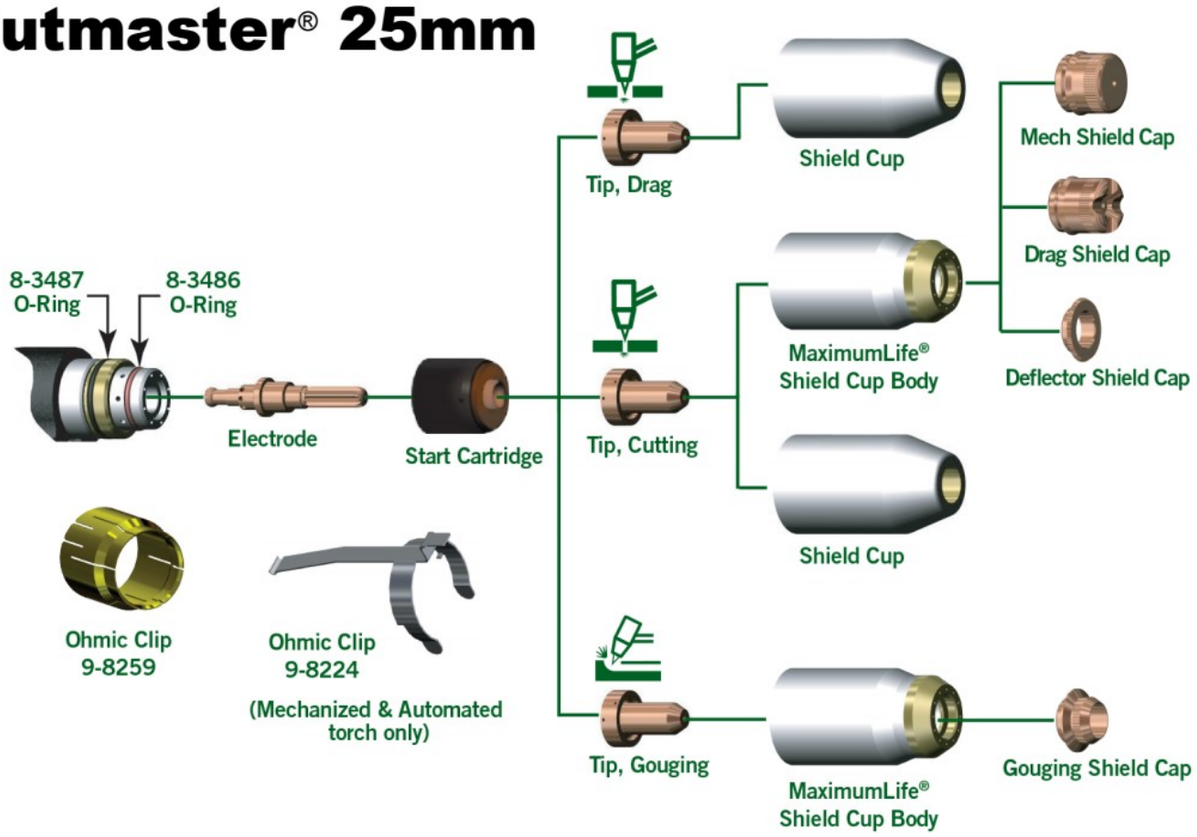
Cutmaster® 25mm

Specifications	
Amperage Output	10 – 80 A, continuously adjustable
Rated Output Power	9 kW
Input Voltage	400 VAC
Number of Phases	3 ph
Supply Frequency	50/60 Hz
Rated Duty Cycle	40% @ 80A
Amperage Draw	20A @400V, 3 ph
Work Lead	6.1m
Gas Requirements	Compressed air
Gas Pressure	5.2 bar
Air Flow Requirements (cutting & gouging)	190 l/min
Genuine Cut	25 mm
Maximum Cut	30 mm
Maximum Sever	38 mm
Torches – for use with the Cutmaster 25	SL60 1Torch (supplied) SL100 1Torch Mechanised SL100SLV 1Torch Automated
Dimensions	381 x 305 x 610 mm
Weight	19.5 kg
Warranty	3 Years Power Supply / 1 Year Torch

Ordering Information - Systems	
TD Cutmaster 25 3ph w. SL100 1Torch 6.1 m 75° Head	1-1330-4
TD Cutmaster 25 3ph w. SL100 1Torch 15.2m 75° Head	1-1331-4
Torches	
SL60 Torch and Lead 6.1 m, 75° Head	7-5204
SL60 Torch and Lead 15.2 m, 75° Head	7-5205
SL100 Mechanized Torch 25' (7.6 m) 180° Head	7-5215
SL100 Mechanized Torch 50' (15.2 m) 180° Head	7-5216

Packages Include: Cutmaster 25 power supply, SL60 75° torch with lead, 6.1 m work lead with ground clamp, spare parts kit, operating manual

Cutmaster® 25mm



Wear and Spare Parts 1Torch	
O-Ring	8-3487
O-Ring	8-3486
O-Ring Lubricant	8-4025
Electrode	9-8215
Start Cartridge	9-8213
Tip, 20A Drag	9-8205
Tip, 30A Drag	9-8206
Tip, 40A Drag	9-8207
Tip, 60A Drag	9-8252
Tip, 40A Standoff	9-8208
Tip, 50/55A Standoff	9-8209
Tip, 60A Standoff	9-8210
Tip, 70A Standoff	9-8231
Tip, 80A Standoff	9-8211
Tip A, Gouging	9-8225
Tip B, Gouging	9-8226
Tip C, Gouging	9-8227
Tip D, Gouging	9-8228

Wear and Spare Parts 1Torch	
Shield Cup	9-8218
Shield Cup Max Life	9-8237
Shield Cap, Drag, 40A	9-8244
Shield Cap, Drag, 50-60A	9-8235
Shield Cap, Drag, 70-100A	9-8236
Shield Cap, Mechanised, 40A	9-8245
Shield Cap, Mechanised, 50-60A	9-8238
Shield Cap, Mechanised, 70-100A	9-8239
Shield Cap, Deflector	9-8243
Shield Cap, Gouging	9-8241
Ohmic Clip (mechanised torches)	9-8224
Ohmic Clip (manual torches)	9-8259

GOUGING PROFILES				
	Output Range	Depth	Width	Profile
Tip A	40 Amps (MAX)	Shallow	Narrow	
Tip B	50-100 Amps	Deep	Narrow	
Tip C	60-120 Amps	Moderate	Moderate	
Tip D	60-120 Amps	Shallow	Wide	
Tip E	120 Amps	Moderate	Wide	

Cutmaster® 25mm

Options & Accessories	
Standoff Cutting Guide	9-8281
Cutting Guide Kit (Deluxe)	7-8910
Circle Cutting Guide Kit	7-3291
Radius/Roller Cutting Guide Kit	7-7501
Straight Line Cutting Guide	7-8911
Lead Extension, 4.6 m	7-7544
Lead Extension, 7.6 m	7-7545
Lead Extension, 15.2 m	7-7552
Leather Lead Covers 6.1 m	9-1260
Multi-Purpose Cart	7-8888
Single Stage Air Filter Kit	7-7507
Two Stage Air Filter Kit	9-9387

1Torch Consumables Parts Application Guide



Drag Tip Cutting
The preferred method of cutting light gauge metal up to 6 mm thickness. Produces the best cut quality narrowest kerf width, fastest cutting speeds, and with little to no distortion. Traditional drag cutting was limited to 40 A or less; now with Thermal Dynamics TRUE Cut Drag Tip Series™ technology , it is possible to cut up to 60 A. For best results, use the Shield Cup with the torch tip in direct contact with the work (up to 60 A).



Drag Shield Cutting
This is an operator-friendly method of cutting between 70 to 120 A while maintaining a constant standoff distance. For metal thickness greater than 6 mm, simply drag the shield cap in contact with the work piece. Use the shield cup body with the appropriate drag shield cap matching the current level being used. This method is not recommended for cutting light-gauge sheet metal.



Standoff Cutting
The preferred method of cutting metal thicker than 6 mm and at current levels above 60 A. Provides maximum visibility and accessibility. Shield cup for 'standoff' cutting (with the torch tip 3 mm to 6 mm from the work piece). Use the shield cup body together with the deflector for extended parts life and improved resistance to reflect heat. This combination provides cutting results similar to the single piece shield cup, as well as easy changeover to gouging or drag shield cutting.



Gouging
A simple method of metal removal by angling the torch to a lead angle of 35°-45°, and using a gouging tip. While maintaining a constant standoff distance, this allows for only a partial penetration into the work, thus removing metal from the surface. The amount of current, travel speed, standoff distance, lead angle, and tip size will determine the amount of material removed and the profile of the gouge. You can use the shield cup body with either the gouging shield cap or the shield deflector. Also, you can use the single piece shield cup.

ESAB / esab.com

GLOBALLY CERTIFIED

XA00203420 Rev1 11/2018 ESAB reserves the right to alter specifications without prior notice.