

Digital Oxy-fuel Gas Manifold

DESCRIPTION:

The digital oxy-fuel gas manifold, in conjunction with the process cut charts embedded in the Hypertherm Phoenix CNC control software, allow the oxy-fuel process parameters to be automated. Gas pressures, event timing, cutting speed and kerf width are controlled by the cut charts. Pressures are controlled by pilot operated regulators and electro-pneumatic regulators eliminating the need for manually adjusted regulators. Once set up, a cut chart is saved for retrieval in the future.

FEATURES:

- Phoenix cut charts
- Electro-pneumatic regulators
- Pilot operated regulators
- Solenoid valves for each gas

TYPICAL APPLICATION:

- Heavy duty oxy-fuel cutting

Oxy Fuel Cut Chart - Rev 0

Process Selection:

- Torch Type: Harris Model 98
- Material Type: Mild Steel
- Specific Material: None
- Fuel Gas: Propane
- Material Thickness: 2.0
- Tip Size: 1
- Cutting Tip: 6290-WC

Preheat:

	Low	High	Pierce	Cut
Oxygen	12	35	20	100
Fuel Gas	4 oz	2	PSI	

Cut Speed: 13 IPM

Kerf: 0.09 inches

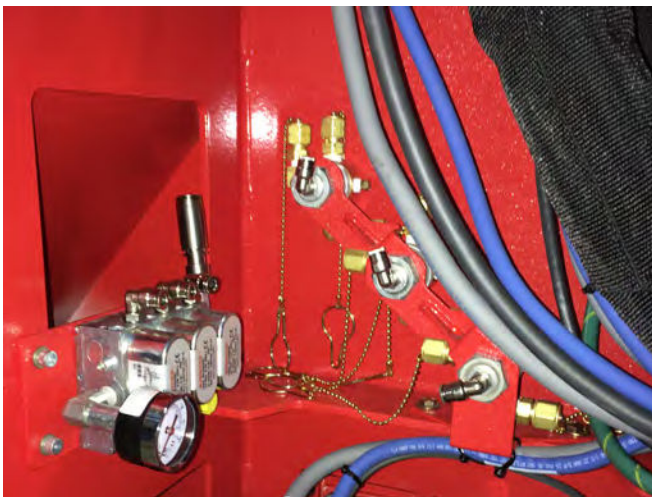
High Preheat Time: 20 sec

Pierce Time: 4.0 sec

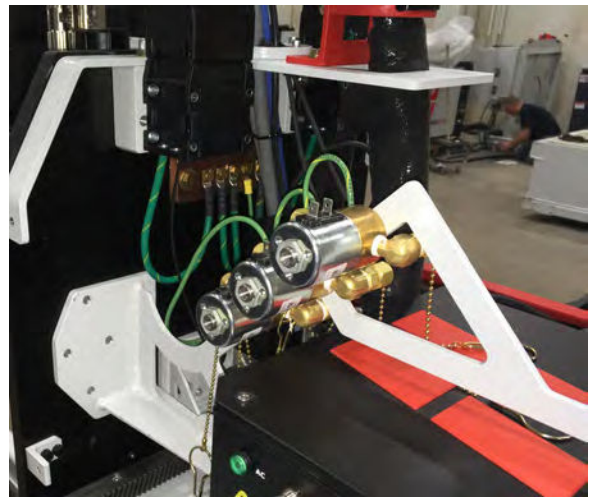
Moving Pierce Time: 0.0 sec

Creep Time: 0.0 sec

Hypertherm Phoenix software oxy-fuel cut chart



Pilot operated regulators and electro-pneumatic regulators inside machine frame end truck



Solenoid valves for cutting oxygen, preheat fuel and preheat oxygen are mounted behind the tool carriage