

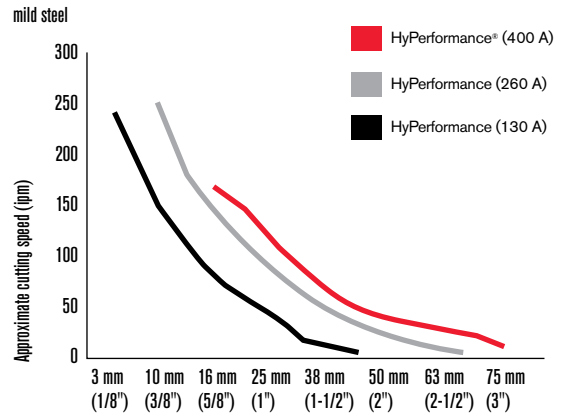
Operating data

Material	Current (amps)	Thickness (mm)	Approximate cutting speed (mm/min.)	Thickness (inches)	Approximate cutting speed (ipm)
Mild steel O ₂ plasma O ₂ shield	30	0.5	5355	.018	215
		3	1160	.135	40
		6	665	1/4	25
O ₂ plasma Air shield	80 [†]	3	6145	.135	180
		6	3045	1/4	110
		20	545	3/4	25
O ₂ plasma Air shield	130 [†]	6	4035	1/4	150
		10	2680	3/8	110
		25	550	1	20
O ₂ plasma Air shield	200	6	5248	1/4	200
		12	3061	1/2	115
		25	1167	1	45
		50	254	2	10
O ₂ plasma Air shield	260 [†]	10	4440	3/8	180
		20	2170	3/4	90
		64	195	2-1/2	8
O ₂ plasma Air shield	400 [†]	12	4430	1/2	170
		25	2210	1	85
		50	795	2	30
		80	180	3	10
Stainless steel F5 plasma N ₂ shield	60	3	2770	0.105	120
		4	2250	0.135	95
		5	1955	3/16	80
		6	1635	1/4	60
H35 plasma N ₂ shield	130 [†]	10	980	3/8	40
		12	820	1/2	30
		25	260	1	10
H35 plasma N ₂ shield	260 [†]	12	1710	1/2	65
		20	1085	3/4	45
		25	785	1	30
		50	270	2	10
H35 and N ₂ plasma N ₂ shield	400 [†]	20	1810	3/8	75
		40	720	1-1/2	30
		80	190	3	10
H35 plasma N ₂ shield	800 [†]	75	464	3	18
		125	155	5	6
		160	100	6-1/4	4
Aluminum Air plasma Air shield	45	1.5	4420	.048	220
		4	2575	.135	110
		6	1690	1/4	60
H35 plasma N ₂ shield	130 [†]	12	1455	1/2	55
		20	940	3/4	40
		25	540	1	20
H35 plasma N ₂ shield	260 [†]	12	5160	1/2	190
		20	2230	3/4	90
		50	390	2	14
H35 plasma N ₂ shield	400 [†]	20	2420	3/4	100
		40	1190	1-1/2	50
		80	210	3	10
H35 plasma N ₂ shield	800 [†]	75	907	3	35
		160	179	6-1/4	7

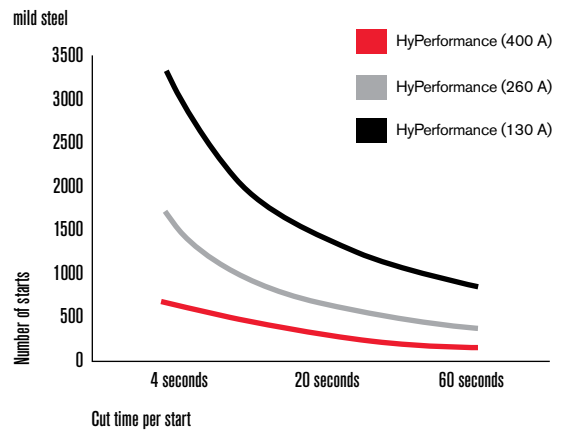
HDI

System comparisons

Cutting speed



Consumable life



Auto gas console

- Allows full control of all plasma system settings from the CNC, simplifying operator training requirements.
- Automatically changes processes on the fly to enable rapid switching between cutting and marking.
- Automatically adjusts for variations in incoming gas pressure to produce the most consistent cutting performance.
- The auto gas console is required to enable True Hole® technology and optimized gas mixing for mid-range stainless cutting.



The operating data chart does not list all processes available for the HPR130XD®, HPR260XD, HPR400XD, and HPR800XD. Please contact Hypertherm for more information.

[†]Consumables support up to 45° bevel capability.

