

THERMAL DYNAMICS®

A THERMADYNE® Company

AUTOMATION



CUTMASTER™ 101

80 Amp Air Plasma Cutting System



**NEW Warranty
from Thermal Dynamics!**

3 Years (System)

1 Year (Torch)

Includes Repair Parts and Labor

Automated Plasma Cutting System

Automated Plasma Cutting

CUTMASTER™ 101

80 Amp Air Plasma Cutting System

Introducing the next generation of innovative CUTMASTER™ 1Series™ Automated Plasma Cutting Systems from Thermal Dynamics®.

The new 1Series includes the SL100 1Torch™ with Advanced Torch Connector (ATC™) Quick Disconnect as standard equipment in lengths of 25 ft. (7.6m), 35 ft. (10.7m) and 50 ft. (15.2m). Our new 1Torch start technology eliminates the electronic interference that can occur with other designs. 1Torch provides quick, reliable starts and a strong pilot arc to pierce heavy plate. It can even cut expanded metal quickly and easily.

CUTMASTER 1Series Automation Systems include a full-featured CNC interface accessible from either a CPC connector on the rear of the power supply or inside on a terminal strip. The CPC interface includes ON/OFF, OK to MOVE and an adjustable divided voltage signal. Full arc voltage is available inside the power supply.

With all the advantages of 1Torch and proven CUTMASTER reliability, the new automated CUTMASTER 1Series delivers the best in productivity, precision and performance.

IGBT Inverter Power Supply

SL100 Torch & Leads



Pinch Block Assembly



End Cap Assembly



Detachable 32 Pitch Gear Rack

Ohmic Clip



1Torch SL100 with ATC for Quick Disconnect

Electrode

Tip

Deflector

Shield Cap

1Torch™ SL100 Torch Head

Start Cartridge

Shield Cup Body

Shield Cup Body



Superior Cutting Performance

SureLok™ Electrode Technology

The innovative, patented, self-locking electrode mechanism, eliminates the need for an installation tool and ensures precise electrode and tip alignment. Both the electrode and tip are stationary which results in a highly defined arc and precise cuts. SureLok alignment also means longer tip and electrode life and reduced operating costs.



Total Gas Management™

The SL100™ 1Torch™ introduces a completely new tip technology which eliminates the need for a separate plasma gas distributor. Each tip includes plasma gas ports uniquely tuned to optimize cutting performance at its rated current. Select from 20, 30, 40, 60 or 80 Amp tips to optimize your cutting. The result is Total Gas Management. Precision gas control, longer consumable parts life and better cut performance.



Superior Quality at All Amperages

Whether you are fabricating 3/8" (10mm) plate or cutting ornamental shapes, the CUTMASTER™ 101 is perfect for the job.

At full 80 Amp output, CUTMASTER 101 produces BEST CUT on 3/8" (10mm) mild steel plate at 55 IPM (1.4m/min). For those cutting intricate shapes, select low amperage tips for kerf widths less

than .020" (0.5mm) wide. Whether you cut heavy plate, HVAC duct work or ornamental shapes, the CUTMASTER 101 is right for you.

Start Cartridge

High Frequency has been completely eliminated from the plasma system. A patent pending component called the "Start Cartridge" sits between the tip and electrode. It is normally in contact with the tip, but when air forces the tip and cartridge apart, the pilot arc is started. This unique design allows the pilot arc to start without moving either the tip or electrode, resulting in better parts life, cut performance and reliability.



Choice of Tip Shielding

Choose from two consumables styles:

- Extended Tip for cutting thin sheet at low power & narrow kerf
- Shielded Tip for heavier plate piercing and cutting



Extended Tip

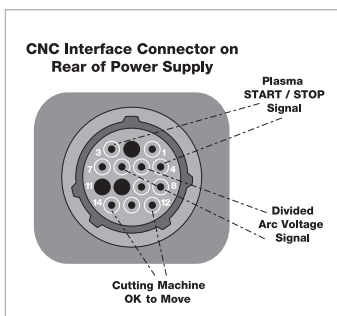


Shielded Tip

Note: Use the Ohmic Clip with the Shielded Tip design if ohmic plate sensing is required.

Advanced Features

Enhanced CNC Interface Connection



A CPC connector on the rear of the power supply provides access to START/STOP, OK TO MOVE and an adjustable Divided Arc Voltage signal suitable for controlling torch height control. Voltage is adjustable in 256 increments between 16.3:1 and 50:1. Full arc voltage is available inside the power supply.

ATC™ Quick Disconnect

This advanced torch connection makes it quick and easy to connect or disconnect the torch from the power supply – safely and securely, each and every time.



Operator Controls

Simple front panel controls that provide the user flexibility and ease:

- (1) Current Control (Infinite from 20-80 Amps)
- (2) ON / OFF Switch
- (3) LED Indicators
 - AC
 - GAS
 - TEMP
 - DC
- (4) RUN / RAPID AUTO RESTART / SET Switch
- (5) ATC Female Receptacle



CUTMASTER™ 101

80 Amp Air Plasma Cutting System

Ordering Information

Product Description	Catalog No.			Other
	208-230V, 1ph	460V, 1/3 ph	Other	
CUTMASTER™ 101 with SL100™ 180° Machine Torch, 25 ft. (7.6m) Lead*	1-1324-1	1-1324-2	1-1324-V	V (Voltage): 3 = 400V 3ph, 4 = 400V 3ph CE 5 = 600V
CUTMASTER™ 101 with SL100™ 180° Machine Torch, 35 ft. (10.7m) Lead*	1-1326-1	1-1326-2	1-1326-V	
CUTMASTER™ 101 with SL100™ 180° Machine Torch, 50 ft. (15.2m) Lead*	1-1325-1	1-1325-2	1-1325-V	

* Systems include Power Supply, Machine Torch with 1-3/8" (35mm) Diameter Non-Metallic Mounting Tube / 3/2 Pitch Rack (Detachable), Pinch Block Assembly, CNC Interface Cable, Hand Pendant, Spare Parts Kit, Input Power Cable (selected systems), Work Cable and Clamp.

Specifications (subject to change without notice)

Rated Output	80 Amps
Output Range (A)	20-80 Amps
Input Volts	208/230V, 1 ph, 50/60 Hz 380-415V, 3 ph, 50 Hz 460V, 1/3 ph, 60 Hz 600V, 3 ph, 60 Hz
Input Amps @ Rated Output	74A @ 208 VAC, 1 ph 67A @ 230 VAC, 1 ph 39A @ 460 VAC, 1 ph 25A @ 400 VAC, 3 ph 20A @ 460 VAC, 3 ph 13A @ 600 VAC, 3 ph
Duty Cycle	40% @ 80A @ 112 VDC, 100% @ 45A @ 98 VDC
MAX OCV	260 VDC
Gas Type	Air @ 70 psi (4.8 bar) @ 400 scfh (188 lpm)
Pilot	Start Cartridge
Weight	83 lbs. (37.6kg) Power Supply, Power Cable, Torch & Leads 1.6 lbs. (0.7kg) Torch Assembly & Mounting Tube 7.0 lbs. (3.2kg) 25ft./7.6m Lead Set with ATC™ (with Pigtail) 0.3 lbs. (0.1kg) Torch Leads (per ft.)
Shipping Weight	105 lbs. (47.6kg) Power Supply, Power Cable, Torch & Leads
Dimensions	18.0" (457mm) H x 12.4" (315mm) W x 27.4" (696mm) D
Work Cable	20 ft. (6.1m)
Control	CNC Interface - Rear CPC 14 Pin Connector with Standard TDC Pin-Out and Internal Terminal Strip
Input Power Cable	10 ft. (3.0m) with Plug (208/230V) 10 ft. (3.0m) without Plug (460V and 600V)
Limited Warranty	Three Years Power Supply & One Year Torch
Certifications	CSA, IP-23C, CSA NTRL/C, CE

Torch Configuration

Torch	SL100™ 180° Machine Torch & Leads w/ ATC™
Leads	5 ft. (1.5m), 10 ft. (3.0m), 25 ft. (7.6m), 35 ft. (10.7m), or 50 ft. (15.2m)
Optional Leads Ext.	15 ft. (4.6m), 25 ft. (7.6m), or 50 ft. (15.2m) Not to exceed 100 ft. (30.4m) maximum length.

Cutting Speed Chart

Torch Model	SL100™		The cut speeds in the charts below are representative of results when using new consumables, a quality torch height control, and a well maintained plasma system and cutting machine.		
Recommended Cutting Capacity	3/8" (10mm)				
Maximum Pierce Cutting Capacity	5/8" (15mm)				
Max Cutting Capacity (edge start)	1-1/4" (30mm)				
Material	Thickness [inch]	Best Cut Speed [IPM]	Current [Amps]	Thickness [mm]	Best Cut Speed [m/min]
Mild Steel					
Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	10 ga.	175	40	3	4.45
	16 ga.	350	60	1.5	8.89
	10 ga.	175	80	3	4.45
	10 ga.	230	80	3	5.84
	1/4	112		6	2.84
	3/8	55		10	1.40
	1/2	38		12	0.97
	3/4	18		20	0.46
1	10		25	0.25	
Stainless Steel					
Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	10 ga.	175	40	3	4.45
	16 ga.	350	60	1.5	8.89
	10 ga.	175	80	3	4.45
	10 ga.	200	80	3	5.08
	1/4	112		6	2.84
	3/8	55		10	1.40
	1/2	38		12	0.97
	3/4	18		20	0.46
1	10		25	0.25	
Aluminum					
Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	10 ga.	175	40	3	4.45
	16 ga.	350	60	1.5	8.89
	10 ga.	175	80	3	4.45
	10 ga.	230	80	3	5.84
	1/4	112		6	2.84
	3/8	55		10	1.40
	1/2	38		12	0.97
	3/4	18		20	0.46
1	10		25	0.25	

DISTRIBUTED BY:



WORLD HEADQUARTERS: Suite 300, 16052 Swingley Ridge Road • St. Louis, MO 63017 • 636-728-3000

THERMAL DYNAMICS®

82 Benning Street • West Lebanon, NH 03784
CUSTOMER SERVICE: 800-752-7621 • FAX 800-221-4401

International Customer Service
Oakville, Ontario, Canada
Ph: (1) 905-827-9777
Fax: (1) 905-827-9797

Thermadyne Canada
Oakville, Ontario Canada
Ph: (1) 905-827-1111
Fax: (1) 905-827-3648

Thermadyne Europe
Chorley, England
Ph: (44) 1257-261755
Fax: (44) 1257-224800

Thermadyne Asia Sdn. Bhd.
Kuala Lumpur, Malaysia
Ph: (603) 6092-2988
Fax: (603) 6092-1085

Cigweld Australia
Melbourne, Australia
Ph: (61) 3-9474-7400
Fax: (61) 3-9474-7510

Unique Welding Alloys
Johannesburg, South Africa
Ph: (27) 11-917-3600
Fax: (27) 11-917-8580

Thermadyne Victor Brasil
Rio de Janeiro, Brazil
Ph: (55) 21-2-485-8990
Fax: (55) 21-2-485-8735

Thermadyne Middle East
Dubai, United Arab Emirates
Ph: (971) 4-332-9060
Fax: (971) 4-332-5484

Thermadyne de Mexico
Mexico City, Mexico
Ph: (52) 55-5657-9494
Fax: (52) 55-5648-8805

Thermadyne Japan
Osaka, Japan
Ph: (81) 6-4809-8411
Fax: (81) 6-4809-8412

Thermadyne Italia
Lissone, Italy
Ph: (39) 039-214-4370
Fax: (39) 039-214-4677

Thermadyne Chile
Santiago, Chile
Ph: (56) 2-557-2465
Fax: (56) 2-557-5349