Plasma Arc Cutting

MANUAL & AUTOMATED SYSTEMS, TORCHES & ACCESSORIES

Quick Reference Product Guide

Introducing:
The Popular NEW CUTMASTER® TRUE™
Series Line of Plasma Cutters

(see page 6)

www.thermal-dynamics.com
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Cover Photo:
JOHN MOSBY Farmer’s Maine Copper Works, Ltd. [Galveston, TX]

After 11 years of service in the U.S. Marine Corps, John has spent the last five years doing maintenance and training for a growing metals fabrication company. Ever since getting his new Thermal Dynamics CUTMASTER TRUE Series 82, he’s seen an improvement in productivity and a serious reduction in downtime. “The 82 runs all day long and burns from 14 gauge to up to 1 inch.”
Introduction

Plasma Gas – What is it?
Plasma gas is gas heated to an extremely high temperature and ionized so that it becomes electrically conductive. The plasma arc cutting and gouging processes use plasma to transfer an electrical arc to the work piece. The metal to be cut or removed is melted by the heat of the arc and then blown away. A plasma arc creates a very clean, dross free cut with minimal heat input, usually requiring very little rework or cleanup.

Advantages of Plasma Cutting
Plasma arc cutting is an excellent choice for most cutting applications but it is particularly well suited for applications where speed and excellent cut quality are important. Because of the intense heat of the plasma arc – around 40,000° F (22,000° C) compared to 5,700° F (3150° C), with gases used with Oxy-Fuel torches – the cut is very clean with little or no dross. The plasma arc also cuts ferrous and non-ferrous metals much faster than an Oxy-Fuel torch or abrasive saws, with low or no heat affected zone, especially on thinner metals. A clean cut with little or no dross means less time and money is required to finish the work piece. Parts are virtually weld-ready.

With plasma cutting, less preparation work is required. A plasma arc is hot enough to burn through most surface coatings such as paint and rust and still provide excellent cutting results.

For applications where difficult shapes are being handled or cut, such as ventilation ductwork (HVAC), tanks or vessels, plasma cutting offers a considerable advantage since no fixturing is required. All you need is a place on the metal to attach the work clamp. And with plasma cutting, there is also minimal heat input and distortion of the metal as there is with jigsaws or cutting shears.

Thermal Dynamics® Plasma Terminology
• **Recommended Genuine Cut** – at Thermal Dynamics, our standard cut is called a ‘Genuine Cut’. A ‘Genuine Cut’ is an excellent, smooth cut surface with little or no dross, requiring little or no rework or grinding. It is achieved when cutting at 10” (254mm) and above per minute.
• **Dross Buildup** – molten material which is not blown out of the cut area and solidifies on the bottom of the plate.
• **Drag Tip Cutting** – with drag cutting you actually drag the tip of the torch along the work piece to cut the metal. This works particularly well on metal 1/4” (6mm) thick or less. This is often the easiest way to cut and minimize heat input and kerf width.
• **Standoff Cutting** – suitable where material thickness is 1/4” (6mm) or greater, the torch tip is held a distance of 1/8” (3mm) to 1/4” (6mm) from the work piece to achieve the desired cut. Special devices such as standoff guides and cutting guides can help make cutting easier. Cutting guides are particularly useful for cutting thinner metals.
• **Gouging** – plasma gouging produces a very smooth, clean surface which is often weld-ready. Plasma gouging can also be successfully used to separate two welds with less noise and less smoke than traditional gouging methods.
• **Piercing** – piercing with plasma produces a quick hole through the plate and is recommended on thickness up to 50% of the cutting system’s rating.

• **Front End Parts Visibility** – no matter if you are drag cutting or standoff cutting, it is important to be able to see your work while you are cutting. Thermal Dynamics is known in the plasma cutting business for designing torches with excellent visibility.

• **Consumables Parts** – generally refers to the torch tip and torch electrode. These parts must withstand the intense heat of the plasma arc and must be replaced periodically.

Selecting a Thermal Dynamics Plasma Cutting System

These basic questions will help you decide which system best fits your needs:

• **How thick is the metal you want to cut?**
  We offer a wide range of systems that can handle metal thickness from gauge to 2⅜”. For production applications you’ll want to refer to our literature for automated plasma cutting systems.

• **What cut quality do you require?**
  The cut quality you require will be an important factor in deciding which system is right for you. Cut quality is based on a number of factors – material type, thickness, and gas source. These factors need to be weighed to determine the best system for your needs.

• **What type of metal are you cutting?**
  Plasma can be used for cutting mild steel, stainless, and aluminum as well as most other metals, with excellent results.

• **What is your primary input power?**
  This refers to power at the wall or power source. Each plasma system will have a required input current (single or three phase) rated at maximum output based on your input voltage.

• **Gas Supply**
  Thermal Dynamics manual cutting systems require either air or nitrogen as a gas source – either from a high pressure gas cylinder or most often an air compressor. An air compressor draws on shop air so it is very important to control the air quality and keep it free from contaminants. We recommend purchasing an optional filtering accessory for your plasma system to ensure your system performs at its best.

• **Torch Lead Length**
  Our plasma systems are usually offered in either 20’ (6.1m) or 50’ (15.2m) lead lengths. (Our 1Torch® RPT® Torch is offered with Lead Extensions in 15’/4.6m, 25’/7.6m, and 50’/15.2m lengths.) How far away from your power source do you intend to operate your plasma cutter?

• **Price**
  Price is always an important consideration. How much money do you want to spend? Thermal Dynamics is committed to providing customers with quality product at the best value possible. We back our systems and torches with excellent warranties and the best customer and technical service in the industry.
The AirCut® 15C System

Thermal Dynamics® expanded their line of manual plasma cutting systems with the AirCut 15C. At just 29 lbs., the AirCut 15C meets the demand for a portable, self-contained (built-in air compressor) unit capable of cutting up to 3/16”. Simply unpack and plug in. The AirCut 15 sets the standard weighing 50% less and providing 25% faster cut speeds than competitive models. With its lightweight, built-in air compressor and standard 120V plug, you can easily use it just about anywhere!

AirCut 15C
(Brochure #63-2800)

- 1/8” (3mm) Recommended Cut Capacity
- 3/16” (5mm) Maximum Cut
- 15 Amps, Fixed
- Input Power: 120V (±10%), Single Phase, 60 Hz., leff: 12 Amps
- Duty Cycle: 35% @ 15A
- Built-In Air Compressor
- PCH-10 Torch
- Weight: 29 lbs.
- Light Duty Applications: Expanded Metal, HVAC Spiral Ducting, Metal Studs and Any Other Light Industrial Construction

NOTES:

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www.thermal-dynamics.com
CUTMASTER, Why TRUE?
The new CUTMASTER® TRUE™ Series has been designed with the idea that the recommended cut capacity should also be the TRUE cut capacity.

The True Series eliminates the concept of having to “buy up” – purchasing a machine larger than you actually need.

With the introduction of the CUTMASTER TRUE Series, a machine with a recommended cut capacity of 1/2” will cut 1/2” material **ALL DAY EVERY DAY. NO EXCEPTIONS.**

**TRUTHS**

#1: True Confidence – The CUTMASTER TRUE Series microprocessor controlled front panel LED’s assure extreme operator confidence and error free use from setup to clean up.

#2: True Strength – The CUTMASTER TRUE Series allows you to work all day at our recommended cut capacity. But when you need that extra punch, you can be confident that it’s there.

#3: True Protection – As if a 4 YEAR unlimited power supply warranty wasn’t enough, the CUTMASTER TRUE Series is the only line of plasma cutting machines that features TRUE GUARD™ – a rugged roll bar for added durability.

#4: True Tip – The Thermal Dynamics CUTMASTER TRUE Series plasma system offers the only 60 Amp drag cutting tip on the market today.

#5: True Flexibility – The new MULTI-VOLTAGE CUTMASTER TRUE Series features the flexible, patented 1Torch®. There’s one set of consumable parts for the entire range of machines, lead extensions provide cutting up to 100’ (30.5m) from power supply, and the flexibility to move quickly from hand to mechanized cutting with the change of a torch. (Add PCB for CNC interface.)

#6: True Portability – The CUTMASTER TRUE Series offers lighter, more portable machines without compromising performance.
CUTMASTER® 39
(Brochure #63-2727)
- 1/4" (6mm) Recommended Cut Capacity
- 5/8" (15mm) Maximum Cut
- Auto Pilot Restart for Expanded Metal
- 20-30 Amp, Adjustable
- Duty Cycle: 35% @ 30A
- SL60® 1Torch
- Weighs 39 lbs.
- Applications: Auto Body / Marine Repair, Plumbing / HVAC, Home Shop, Rental Fleets, Metal Building & Roof Construction

CUTMASTER 52
(Brochure #63-2727)
- 1/2" (12mm) Recommended Cut Capacity
- 1 1/8" (30mm) Maximum Cut
- Auto Pilot Restart for Expanded Metal
- 60 Amp Drag Tip
- 20-60 Amp, Adjustable
- Duty Cycle: 40% @ 60A
- SL60 1Torch
- Weighs 43 lbs.
- Applications: Construction, Maintenance/Repair, Fabrication

CUTMASTER 82
(Brochure #63-2727)
- 3/4" (20mm) Recommended Cut Capacity
- 1 1/2" (40mm) Maximum Cut
- Auto Pilot Restart for Expanded Metal
- 20-80 Amp, Adjustable
- Duty Cycle: 40% @ 80A
- SL60 1Torch
- Weighs 43 lbs.
- Applications: Heavy Fabrication, Manufacturing, Contractors

Four Year Warranty

See the next page for the CUTMASTER 102 and 152
CUTMASTER® 102
(Brochure #63-2727)

- 1” (25mm) Recommended Cut Capacity
- 1½” (45mm) Maximum Cut
- Auto Pilot Restart for Expanded Metal
- 20-100 Amp, Adjustable
- Duty Cycle: 40% @ 100A
- SL100® 1 Torch
- Weighs 62 lbs.
- Applications: Heavy Fabrication, Manufacturing

Cat. No. 1-1330-1
(208/230-460V)

CUTMASTER 152
(Brochure #63-2727)

- 1¼” (30mm) Recommended Cut Capacity
- 2” (50mm) Maximum Cut
- Auto Pilot Restart for Expanded Metal
- 20-120 Amp, Adjustable
- Duty Cycle: 60% @ 120A
- SL100 1Torch
- Weighs 62 lbs.
- Applications: Heavy Fabrication, Manufacturing

Cat. No. 1-1730-1
(208/230-460V)

NOTES:

FOUR YEAR WARRANTY

FOUR YEAR WARRANTY

Cat. No. 1-1330-1
(208/230-460V)

Cat. No. 1-1730-1
(208/230-460V)
The PAK® 200 System

Designed to meet the most demanding of manual plasma cutting applications, the PAK 200 provides 200 Amps of cutting and gouging power in a manual system. Based on a proven technology platform, the PAK 200 is poised to be the leader in heavy equipment maintenance and repair.

When compared to Conventional Air Carbon Arc Gouging, Plasma Arc Gouging with the PAK 200 offers superior removal rates and clear visibility of the gouging area. The PAK 200 also features dual gas for non-ferrous cutting and tip saver circuitry for optimal tip life. Only more reasons to own the PAK 200.

PAK 200
(Brochure #63-2803)

- 1½” (40mm) Recommended Cut Capacity
- 2⅞” (70mm) Maximum Cut
- 35-200 Amp, Adjustable
- Duty Cycle: 100% @ 200A
- PCH-200 Torch
- Liquid-Cooled Torch
- Dual Gas Capacity

NOTES:

- Cat. No. 1-1533
  (230/460V)

www.thermal-dynamics.com
1Torch® RPT® Torches

1Torch - the most innovative, reliable, high performance replacement torch available today. No other torch performs so well with so many major brands of power supplies, often with cutting results better than the original manufacturer's torch:

- easily attached to virtually all manufacturers’ systems providing superior performance
- includes the SureLok® electrode locking system permitting quick, precise changes of consumables
- out-of-the-box ready for all modes of operation including Drag Shield Cutting, Standoff Cutting and Drag Tip Cutting
- no moving consumable parts
- standard set of consumables for all power supplies

All you need is the 1Torch RPT torch and the appropriate Adapter Kit. Each torch comes complete with easy-to-install instructions.

ATC® Quick Disconnect Option

If you need additional flexibility, the 1Torch RPT torch is also available with ATC (Advanced Torch Connector). This quick disconnect enables you to change out a damaged torch, convert from a hand to machine torch, or put on a different sized torch in a matter of seconds. And no tools are required to complete the task. You can also customize the length of your leads by adding ATC Lead Extensions in 15 ft. (4.6m), 25 ft. (7.6m) or 50 ft. (15.2m) lengths.

1Torch SL60®/ SL55™

(Brochure #63-2217 / 63-2530 for SL55)

• Light / Medium Duty Torch
• 20-80 Amp Capacity
• SL55 Compatible with Lincoln Pro-Cut 55 (60 Amps)
• Available in 75° Torch Head Configuration
• Standard Connection or ATC Quick Disconnect Available (not for SL55)

1Torch SL100®/ SL80™

(Brochure #63-2217 / 63-2530 for SL80)

• Medium / Heavy Duty Torch
• 40-120 Amp Capacity
• SL80 Compatible with Lincoln Pro-Cut 80 (85 Amps)
• Available in 75° or 180° (not for SL80) Torch Head Configurations
• Standard Connection or ATC Quick Disconnect Available (not for SL80)

Lincoln and Pro-Cut are registered trademarks of Lincoln Electric Co. and are in no way affiliated with Thermal Dynamics or Thermadyne Industries, Inc.
## Torch Adapter Kits

The model of the plasma cutting system must be known to determine the adapter kit required.

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<th>Manufacturer</th>
<th>Power Supply Model</th>
<th>Cat No.</th>
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Drag Tip Cutting  The preferred method of cutting light gauge metal up to 1/4" (6mm) thickness. Produces the best cut quality, narrowest kerf width, fastest cutting speeds, with little to no distortion. Traditional drag cutting was limited to 40 Amps or less, now with Thermal Dynamics® TRUE Cut Drag Tip Series™ technology it is possible to cut up to 60 Amps. For best results, use the Shield Cup with the torch tip in direct contact with the work (up to 60 Amps).

Standoff Cutting  The preferred method for cutting metal thicker than 1/4" (6mm) and at current levels above 60 amps. Provides maximum visibility and accessibility. Use the single-piece Shield Cup for ‘standoff’ cutting (with the torch tip 1/8" to 1/4" from the workpiece). Use the Shield Cup Body together with the Deflector for extended parts life and improved resistance to reflected 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 degrees 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. 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.

**1Torch Consumable Parts Selection Guide**

For SL60 / SL100 Manual Cutting and Gouging Operations.

<table>
<thead>
<tr>
<th>Current Range</th>
<th>Mode Of Operation</th>
<th>Start Cartridge</th>
</tr>
</thead>
<tbody>
<tr>
<td>20-40 Amps</td>
<td>Drag Tip / Cutting</td>
<td>9-8231, 9-8211, 9-8212</td>
</tr>
<tr>
<td></td>
<td>Standoff Cutting</td>
<td>9-8253, 9-8254</td>
</tr>
<tr>
<td></td>
<td>Gouging Tip A</td>
<td>9-8226, 9-8227, 9-8228</td>
</tr>
<tr>
<td>50-60 Amps</td>
<td>Drag Tip Cutting</td>
<td>9-8237</td>
</tr>
<tr>
<td></td>
<td>Standoff Cutting</td>
<td>9-8237</td>
</tr>
<tr>
<td></td>
<td>Drag Shield Cutting</td>
<td>9-8237</td>
</tr>
<tr>
<td></td>
<td>Gouging Tip B, C, D</td>
<td>9-8237</td>
</tr>
<tr>
<td></td>
<td>Standoff Cutting</td>
<td>9-8237</td>
</tr>
<tr>
<td>70-100 Amps</td>
<td>Drag Shield Cutting</td>
<td>9-8237</td>
</tr>
<tr>
<td></td>
<td>Gouging Tip B, C, D</td>
<td>9-8237</td>
</tr>
<tr>
<td>120 Amps</td>
<td>Standoff Cutting</td>
<td>9-8237</td>
</tr>
<tr>
<td></td>
<td>Drag Shield Cutting</td>
<td>9-8237</td>
</tr>
<tr>
<td></td>
<td>Gouging Tip E</td>
<td>9-8237</td>
</tr>
</tbody>
</table>

1TORCH, a trademark of Thermal Dynamics Corporation, is registered with the U.S. Patent and Trademark Office, and is the subject of trademark registrations and pending applications in numerous other countries. For information on trademark registrations of Thermal Dynamics Corporation, contact the local trademark offices in the countries of interest.

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**Consumables**

**Plasma Cutting Systems, Torches & Access**

**1Torch® Consumable Parts Application Guide**

For SL60® / SL100® Manual Cutting and Gouging Operations.

**1Torch® Consumable Parts Application Guide**

For SL60® / SL100® Manual Cutting and Gouging Operations.

**1Torch Consumable Parts Selection Guide**

For SL60 / SL100 Manual Cutting and Gouging Operations.

Various front-end parts are available for different applications. The electrode and start cartridge remain the same for all applications.

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Plasma Cutting Systems, Torches & Accessories

In Plasma Cutting, the torch tip must be maintained at a constant standoff distance, lead angle, and tip size to determine the amount of material removed and the profile changeover to gouging or drag shield cutting. This combination provides cutting results similar to the single piece Shield Cup, as well as easy changeover for 'standoff' cutting (with the torch tip 1/8” to 1/4” from the workpiece). Use the Shield Cup Body together with the Deflector for extended parts life and improved resistance to reflected heat.

For SL60® / SL100® Manual Cutting and Gouging Operations.

1Torch Consumable Parts Selection Guide

The electrode and start cartridge remain the same for all applications. Various front-end parts are available for different applications. For SL60 / SL100 Manual Cutting and Gouging Operations.

For the preferred method of cutting light gauge metal up to 1/4” (6mm) thickness, simply drag the Shield Cap in contact with the workpiece. Use the Shield Cup Body with the Deflector for extended parts life and improved resistance to reflected heat. For metal thicknesses greater than 1/4” (6mm), traditional drag cutting was limited to 40 Amps or less, now with Thermal Dynamics® TRUE Cut Drag Tip / Cutting produces the best cut quality, narrowest kerf width, fastest cutting speeds, with little to no distortion.
CUTMASTER® A-Series Automated Systems

With all the advantages of the 1Torch® and proven CUTMASTER reliability, the new CUTMASTER A-Series delivers the best in productivity, precision, and performance in Automation. Systems feature CNC interface, 1Torch with ATC® Quick Disconnect and Diagnostic LED’s to a name a few.

**A40**
(Brochure #63-2809)  
Cat. No. 1-5134-1  
(208-230V)  
- 1/4” (6mm) Production Capacity  
- 40A Rated Output  
- Duty Cycle: 80% @ 40A  
- SL100 SV 1Torch with SureLok® Technology  
- CNC Interface

**A60**
(Brochure #63-2809)  
Cat. No. 1-1134-1  
(208-230V)  
- 3/8” (10mm) Production Capacity  
- 60A Rated Output  
- Duty Cycle: 80% @ 60A  
- SL100 SV 1Torch with SureLok Technology  
- CNC Interface

**A80**
(Brochure #63-2809)  
Cat. No. 1-1334-1  
(208-230V)  
- 1/2” (12mm) Production Capacity  
- 80A Rated Output  
- Duty Cycle: 80% @ 80A  
- SL100 SV 1Torch with SureLok Technology  
- CNC Interface

**A120**
(Brochure #63-2809)  
Cat. No. 1-1734-1  
(208-230V)  
- 5/8” (15mm) Production Capacity  
- 120A Rated Output  
- Duty Cycle: 80% @ 120A  
- SL100 SV 1Torch with SureLok Technology  
- CNC Interface
Auto-Cut® Series Conventional Automated Systems

The Thermal Dynamics® Auto-Cut Series delivers premium cut performance on both mild steel and non-ferrous materials. The power supplies are designed for reliable, low cost operation. Features like the XT™-301 consumable parts cartridge and the Machines Status Message Center make the Auto-Cut units easy to operate.

**Auto-Cut 100**

(Brochure #63-2511)  
Cat. No. 3-9111-1  
(208-230V)

- 5/8” (15mm) Production Cut
- 3/4” (20mm) Maximum Cut
- 1” (25mm) Edge Start
- 10-100 Amps
- Duty Cycle: 100% @ 100A @ 160V
- XT-301 Torch and Leads
- Water Mist Secondary (WMS®)
- CE, CSA, CCC

**Auto-Cut 200**

(Brochure #63-2600)  
Cat. No. 3-9112-1  
(208-230V)

- 1” (25mm) Production Cut
- 1 1/4” (30mm) Maximum Cut
- 2” (50mm) Edge Start
- 10-200 Amps
- Duty Cycle: 100% @ 200A @ 160V
- XT-301 Torch and Leads
- Water Mist Secondary (WMS)
- CE, CSA, CCC

**Auto-Cut 200₂**

(Brochure #63-2601)  
Cat. No. 3-9114-1  
(208-230V)

- 1” (25mm) Production Cut
- 1 1/2” (40mm) Maximum Cut
- 2” (50mm) Edge Start
- 10-200 Amps
- Duty Cycle: 100% @ 200A @ 180V
- XT-301 Torch and Leads
- Water Mist Secondary (WMS)
- High Speed Oxygen Cutting
- CE, CSA, CCC

www.thermal-dynamics.com
Auto-Cut 300
(Brochure #63-2713)
Cat. No. 3-9113-1
(208-230V)
- 1¼” (30mm) Production Cut
- 1½” (40mm) Maximum Cut
- 2½” (70mm) Edge Start
- 10-300 Amps
- Duty Cycle: 100% @ 300A @ 180V
- XT™-301 Torch and Leads
- Water Mist Secondary (WMS®)
- CE, CSA, CCC

Auto-Cut 3002
(Brochure #63-2775)
Cat. No. 3-9115-1
(208-230V)
- 1½” (40mm) Production Cut
- 1¾” (45mm) Maximum Cut
- 3” (75mm) Edge Start
- 10-300 Amps
- Duty Cycle: 100% @ 300A @ 180V
- XT-301 Torch and Leads
- Water Mist Secondary (WMS)
- High Speed Oxygen Cutting
- CE, CSA, CCC
XT™ Torch Technology for Maximum Performance

Patented XT Torch Technology brings plasma cutting to new levels of precision and productivity. The design of the XT-301 torch and consumable cartridge ensure precise relocation of components after a process change. a name a few.

**XT-301 Torch**

(Brochure #63-2524)

- ‘Leakless’ Torch Head Design
- Self-Centering Components
- Excellent Cuts on All Metals
- Longer Parts Life with MaximumLife® Consumables
- Keyless Consumables Cartridge
- Revolutionary SpeedLok™ Cartridge Design Allows Quick Change-Overs

**XT-301 Torch**

Cartridge

XT-301 Torch Head
GCM-1000 – Gas Control
Plasma and secondary gas pressures and WMS® (Water Mist Secondary) flows are precisely controlled at the power supply with dedicated regulators.

GCM-2000 – Gas Control
Digitally controlled plasma and secondary gases with dedicated regulators, pressure gauges and flowmeters.

Water Mist Secondary (WMS)
- Lop Operating Costs
- Dross-Free Cutting
- Oxide Free Surface
- Easy to Use

H₂ results in reducing atmosphere and scrubbing of oxides
# Ultra-Cut® Series High Precision Automated Systems

The Thermal Dynamics Ultra-Cut Series delivers premium precision and heavy-duty conventional plasma cutting on mild steel and non-ferrous alloys. With consumable parts for both precision and conventional plasma cutting from gage to 3” (75mm) it’s the only plasma system you will need. Select precision consumable parts for high precision cutting on mild steel. Or select conventional consumable parts for faster and more economical cutting with air plasma.

## Ultra-Cut 100
(Brochure #63-2512) Cat. No. 3-9116-1 (208-230V)
- 1/2” (12mm) Production Cut
- 5/8” (15mm) Maximum Cut
- 3/4” (20mm) Edge Start
- 10-100 Amps
- Duty Cycle: 100% @ 100A @ 180V
- XT-300 Torch and Leads
- Water Mist Secondary (WMS®)
- CE, CSA, CCC

## Ultra-Cut 200
(Brochure #63-2774) Cat. No. 3-9119-1 (208-230V)
- 1” (25mm) Production Cut
- 1 1/2” (40mm) Maximum Cut
- 2 1/2” (62mm) Edge Start
- 10-200 Amps
- Duty Cycle: 100% @ 200A @ 180V
- XT-300 Torch and Leads
- Water Mist Secondary (WMS)
- CE, CSA, CCC

## Ultra-Cut 300
(Brochure #63-2615) Cat. No. 3-9118-1 (208-230V)
- 1 1/2” (40mm) Production Cut
- 1 3/4” (45mm) Maximum Cut
- 3” (75mm) Edge Start
- 10-300 Amps
- Duty Cycle: 100% @ 300A @ 180V
- XT-300 Torch and Leads
- Water Mist Secondary (WMS)
- CE, CSA, CCC
**XT™-300 Torch Unique ‘Keyless’ Consumables Cartridge**

The unique Consumables Cartridge houses consumable parts only, no built-in head/torch body to drive replacement costs up. Changing cartridges is fast and easy - a couple of twists and the unique ‘rapid engagement’ retaining collar threads release the cartridge. Down-time is reduced to seconds and you can change from one process to another or from one application to another quickly and easily.

**XT-300 Torch**

(Brochure #63-2500)

- ‘Leakless’ Torch Head Design
- Self-Centering Components
- Excellent Cuts on All Metals
- ExtremeLife™ Consumables
- Keyless Consumables Cartridge
- Revolutionary SpeedLok™ Cartridge Design Allows Quick Change-Overs

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**Control Modules**

**GSM-2010 Gas Control Module**
- Plasma and Secondary Gas Control
- Dedicated Regulators, Flowmeters and Gauges
- Digitally Controlled

**RAS-1000 Remote Arc Starter**
- Water-cooled Negative HF Coil
- Rated to 300 Amps
PAK® 45
- 3” (75mm) Maximum Cut
- ¾” (20mm) Piercing
- 10-400 Amps
- Duty Cycle: 100% @ 400A @ 200V
- Liquid Cooled Torch
- N2, Ar-H2, Plasma
- CE, CSA, CCC

TA-500/1000
- 6” (150mm) Maximum Cut
- 2” (50mm) Piercing
- Paralleled to 1000 Amps
- Duty Cycle: 100% @ 500/1000A @ 200V
- Liquid Cooled Torch
- N2, Plasma
- Heavy Non-Ferrous

The TA-500 System is specifically designed for high-performance, machine-mounted production cutting.
## Accessories

Thermal Dynamics® offers accessories to help improve cutting performance.

### TORCH CUTTING GUIDES / GUIDE KITS

#### Cutting Guide Kit (Deluxe)

<table>
<thead>
<tr>
<th>Cat. No.</th>
<th>7-8910</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cuts circles from 2.125” (54mm) to 41.5” (1054mm) with proper cutting attachments. This kit includes easy add-on attachments to fit most Thermal Dynamics torches for precise straight line, circle cutting and beveling. Includes Carrying Case, Radius/Roller Kit (7-7501), Circle Cutting Guide Kit (7-3291), Magnetic Pivot, Suction Pivot.</td>
<td></td>
</tr>
</tbody>
</table>

#### Circle Cutting Guide Kit

<table>
<thead>
<tr>
<th>Cat. No.</th>
<th>7-3291</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cuts 2.125” (54mm) to 27.75” (705mm) circles (using magnetic attachment) when cutting or beveling is required. For use with most Thermal Dynamics torches. Guide shown with optional pivot (7-3148).</td>
<td></td>
</tr>
</tbody>
</table>

#### Radius / Roller Cutting Guide Kit

<table>
<thead>
<tr>
<th>Cat. No.</th>
<th>7-7501</th>
</tr>
</thead>
<tbody>
<tr>
<td>This easy-to-use guide cut circles from 3” (76mm) up to 28.75” (730mm). Maintains a consistent height off the work piece whether you are using the circle cutting attachment for cutting circles or the roller guide feature to improve your straight-line cutting. Both novices and experts will see noticeable improvement in quality, speed and parts life. Can be used with most Thermal Dynamics torches.</td>
<td></td>
</tr>
</tbody>
</table>

#### Torch Guide / Circle Cutting Attachment

<table>
<thead>
<tr>
<th>Cat. No.</th>
<th>7-7505</th>
</tr>
</thead>
<tbody>
<tr>
<td>Cuts 3.5” (89mm) to 29” (737mm) circles. Designed for use with the PCH/M-120 Torch, this accessory can be used as either a Roller Guide or a Circle Cutting Guide.</td>
<td></td>
</tr>
</tbody>
</table>

#### Straight Line Cutting Guide

<table>
<thead>
<tr>
<th>Cat. No</th>
<th>7-8911</th>
</tr>
</thead>
<tbody>
<tr>
<td>Introducing a new cutting guide accessory suitable for all hand torches, PCH-10 through PCH-102. This versatile, straight line cutter is for hand held systems and it cuts vertical, 90°, or bevel cuts. Its consistent standoff improves cut quality and maximizes overall performance. Produces more efficient straight line cuts. Lightweight, minimum set up time and no power required. Magnetic mounts ensure placement and ease of use. Optional suction plates available for non-magnetic applications (i.e. aluminum and stainless steel). The Cutting Guide Kit includes: 4 ft. (1.2m) standard rail Torch Holder and Busing Heavy Duty Magnets (2 ea.) Slide Assembly Wheels and Fasteners. Optional 4 ft. (1.2m) extensions (9-7971) available.</td>
<td></td>
</tr>
</tbody>
</table>

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**Accessories**

**Plasma Cutting Systems, Torches & Access**

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TORCH CUTTING GUIDES (CONT.)

Universal Standoff Cutting Guide
Cat. No. 9-8422
A great new standoff guide specifically designed to fit all shield cup designs for the PCH-62, PCH-102, SL60® and SL100® RPT® torches. Adjustable standoff height.

CUTMASTER® TRUE™ Series Standoff Cutting Guides
Cat. No. 9-8281 (CUTMASTER 52, 82, 102 & 152)
New standoff guides designed to fit the SL60 & SL100 torches specific to the CUTMASTER TRUE Series systems. The standoff is preset.

MISCELLANEOUS TORCH ACCESSORIES

Leather Leads Cover
15 ft. (4.6m)  9-1258
20 ft. (6.1m)  9-1260
25 ft. (7.6m)  9-1270
50 ft. (15.2m) 9-1280
These leads covers are suitable for both 1Torch® and SureLoc® leads. Snaps make it easy to install. For wider torches, consider snapping two covers together widthwise.

Torch Protector
Cat No. 9-8135 for 70° Torch,
Cat No. 9-8136 for 90° Torch
For use with the PCH-120 Torch, this rugged protector easily snaps onto the torch providing excellent protection against damage caused by excessive heat or metal sparks. Great accessory for your gouging project.

Trigger Guard Kits
SureLoc Torches (PCH-62 & PCH-102)
Cat No. 9-8418 - Short Trigger Guard,
Cat No. 9-8419 - Long Trigger Guard
1Torch (SL60 & SL100)
Cat No. 9-8420 - Short Trigger Guard,
Cat No. 9-8421 - Long Trigger Guard
These guards offer additional protection from accidental activation or damage to the torch switch.

Remote Pendant Control
Cat No. 7-3460 - 20 ft. (6.1m)
Remote Pendant Control for your mechanized application.

Hand Pendant Extension
Cat No. 7-7744 - 25 ft. (7.6m)

ATC® Lead Extensions
15 ft. (4.6m)  7-7544
25 ft. (7.6m)  7-7545
50 ft. (15.2m) 7-7552
Available for any system using 1Torch with ATC® Quick Disconnect. Leads Extensions enable you to customize your lead length to suit the cutting job.
### MISCELLANEOUS TORCH ACCESSORIES (CONT.)

#### TorCH® Leads Packages
(For CUTMASTER® TRUE™ Series and A-Series)

<table>
<thead>
<tr>
<th>HAND</th>
<th></th>
<th></th>
</tr>
</thead>
<tbody>
<tr>
<td>SL60®</td>
<td>20 ft. (6.1m) Torch/Leads</td>
<td>7-5204</td>
</tr>
<tr>
<td></td>
<td>50 ft. (15.2m) Torch/Leads</td>
<td>7-5205</td>
</tr>
<tr>
<td>SL100®</td>
<td>20 ft. (6.1m) Torch/Leads</td>
<td>7-5206</td>
</tr>
<tr>
<td></td>
<td>50 ft. (15.2m) Torch/Leads</td>
<td>7-5208</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>AUTO</th>
<th></th>
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</tr>
</thead>
<tbody>
<tr>
<td>SL100 SV 180°</td>
<td>25 ft. (7.6m) Torch/Leads</td>
<td>7-4001</td>
</tr>
<tr>
<td></td>
<td>35 ft. (10.7m) Torch/Leads</td>
<td>7-4002</td>
</tr>
<tr>
<td></td>
<td>50 ft. (15.2m) Torch/Leads</td>
<td>7-4003</td>
</tr>
</tbody>
</table>

<table>
<thead>
<tr>
<th>MECHANIZED</th>
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<tbody>
<tr>
<td>SL100 180°</td>
<td>5 ft. (1.5m) Torch/Leads</td>
<td>7-5213</td>
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<tr>
<td></td>
<td>10 ft. (3.0m) Torch/Leads</td>
<td>7-5214</td>
</tr>
<tr>
<td></td>
<td>25 ft. (7.6m) Torch/Leads</td>
<td>7-5215</td>
</tr>
<tr>
<td></td>
<td>50 ft. (15.2m) Torch/Leads</td>
<td>7-5216</td>
</tr>
</tbody>
</table>

#### Air Filter/Air Filter Kits
For improved consumable parts life and overall performance, Thermal Dynamics® recommends Air Filter Kits be used on all plasma cutting systems.

**Single Stage Air Filter Kit**
Cat. No. 7-7507 (Filter Body 9-7740, Hose 9-7742, Filter Element 9-7741)
For use with shop compressed air systems, this in-line filter will not allow moisture or water to pass through the filter element even if it becomes completely saturated. This hi-tech filter element actually blocks the absorption of water to increase performance and improve consumable parts life.

**Two Stage Air Filters**
Cat. No. 7-7502
For PakMaster® 150XL Systems
Cat. No. 7-7500
For CUTMASTER and PakMaster Systems
Cat. No. 9-9387
For CUTMASTER TRUE Series & A-Series Systems
The Two Stage Air Filter will remove moisture and contaminants from the air stream when using compressed air. The filter is capable of filtering to at least 5 microns. The filter assembly is pre-assembled at the factory and need only be installed on the power supply.

#### Automation Accessories

**Automation Interface Kit**
Cat. No. 9-8311 - For CUTMASTER TRUE Series and A-Series

**CNC Harness Cable**
Cat. No. 9-9385 - For CUTMASTER TRUE Series (Manual & Mechanized)

<table>
<thead>
<tr>
<th>CNC Interface Cable</th>
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<tbody>
<tr>
<td>25 ft. (7.6m)</td>
<td>9-8312</td>
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<tr>
<td>50 ft. (15.2m)</td>
<td>9-8313</td>
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<tr>
<td>75 ft. (22.8m)</td>
<td>9-8315</td>
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<tr>
<td>100 ft. (30.5m)</td>
<td>9-8316</td>
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<tr>
<td>150 ft. (38.0m)</td>
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</tbody>
</table>

**Pinion Assembly**
Cat. No. 7-2827
**PORTABLE GEAR**

**Multi-Purpose Cart**  
Cat. No. 7-8888  
Design for most portable manual cutting systems such as the CUTMASTER® 39, 52, 82 or any other similar sized systems.  
This rugged steel cart has easy rolling 8” (203mm) diameter wheels along with 3” (76mm) front mounted casters. This cart also serves as an excellent showroom display stand.

**MISCELLANEOUS ACCESSORIES**

**Dust Covers**  
Cat. No. 9-7072  
(for CUTMASTER 39, 52, 82, 102 and 152 Systems)

**Tool Boxes**  
Cat. No. 8-3141 - Small, Cat. No. 9-4173 - Large  
Plastic boxes with handy compartments for storage of your torch consumables.  
Small: 8.375” x 4.25” x 1.75” (13mm x 108mm x 44mm)  
Large: 17.5” x 7.75” x 3” (445mm x 197mm x 76mm)

**Welding Gloves**  
Cat. No. 9-1250

**TORCH COOLANT**

**Extra Cool™ Coolant**  
Cat. No. 7-3580  
Resists freezing down to +10°F (-12°C)

**Ultra Cool™ Coolant**  
Cat. No. 7-3581  
Resists freezing down to -27°F (-33°C)

**Extreme Cool™ Coolant**  
Cat. No. 7-3582  
Resists freezing down to -65°F (-51°C)

**De-I Cool™ Coolant**  
Cat. No. 7-3583  
De-ionized water mixture for use where freezing protection is not required.
Sales
At Thermal Dynamics®, we work hard to provide the product information, product demonstrations, technical expertise, and service your business expects. Thermal Dynamics’ District Business Managers work closely with welding distributors across the country to provide product information, demos and training. When you need product information or want to order our products, contact your local Thermal Dynamics Authorized Distributor. For a list of distributors in your area, call our Customer Care Center at 1-800-426-1888 or visit us on the web.

Literature Requests
Product literature, operating manuals, and service manuals are all available through our distributorships or on our web site. You can also order directly through our Copy Center at 1-800-PLASMA1 (1-800-752-7621).

Technical & Application Product Services
Our Technical Service specialists are some of the most valued and experienced in the industry. They can provide assistance with both troubleshooting day-to-day technical issues and provide cutting process expertise. Contact Technical Service at 1-800-PLASMA2 (1-800-752-7622).

In addition, we have Technical Training Field Managers available to conduct sales and service training schools. Contact your Thermadyne District Business Manager or call our Customer Care Center to arrange for training.

Service & Repair
Thermal Dynamics products either meet or exceed industry standards, and our torches and power supplies are backed with excellent warranties. With each system or torch, we include an Operating or Instruction Manual which includes basic troubleshooting procedures and parts replacement procedures. Service Manuals are also available by request to service technicians familiar with high voltage high power electronic equipment. Service Manuals cover complex troubleshooting procedures and include schematics.

Your local Distributor may also provide on-site service for the products they sell. Additionally, we have a network of authorized independent service centers across the country where you can take your equipment for service. For the service center nearest you, contact Thermal Dynamics’ Customer Care Center at 1-800-426-1888.
How to Contact Us

Main Phone Number: 1-603-298-5711

Customer Care Center: 1-800-426-1888
   FAX 1-800-535-0557

Automation Customer Care Center: 1-866-279-2628
   FAX 1-800-535-0557

International Customer Care Center: 1-905-827-9777
   FAX 1-905-827-9797

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