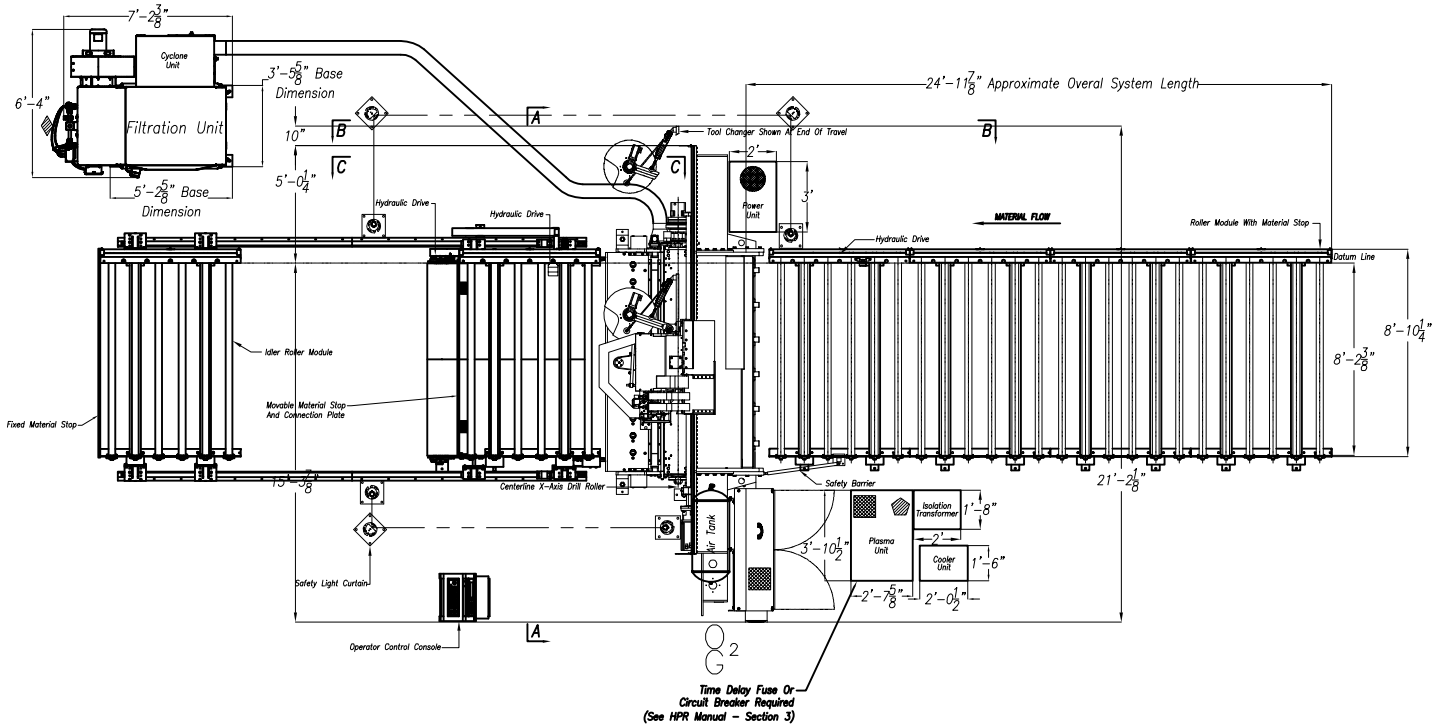
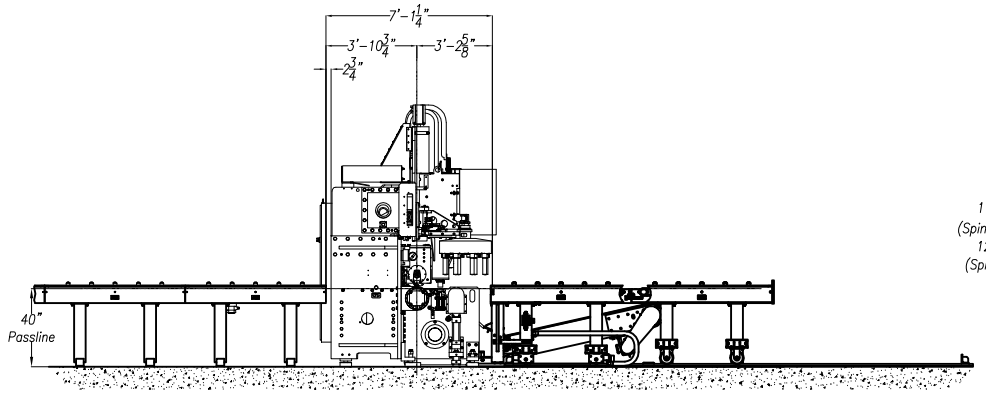
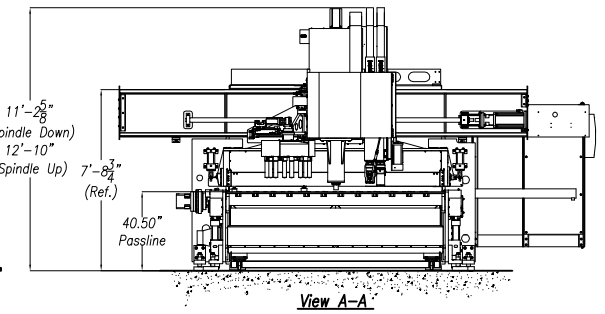


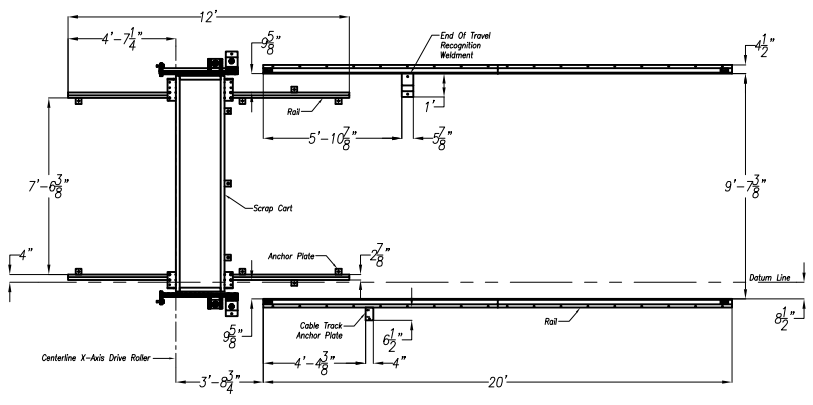


View B-B

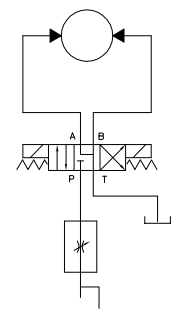


View A-A

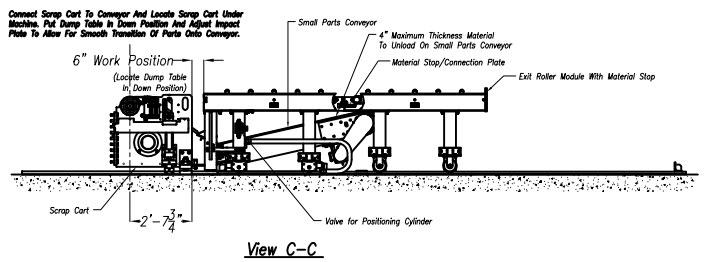
MACHINE WEIGHT 36,045 lbs



HYDRAULIC SCHEMATIC (EXIT CONVEYOR)



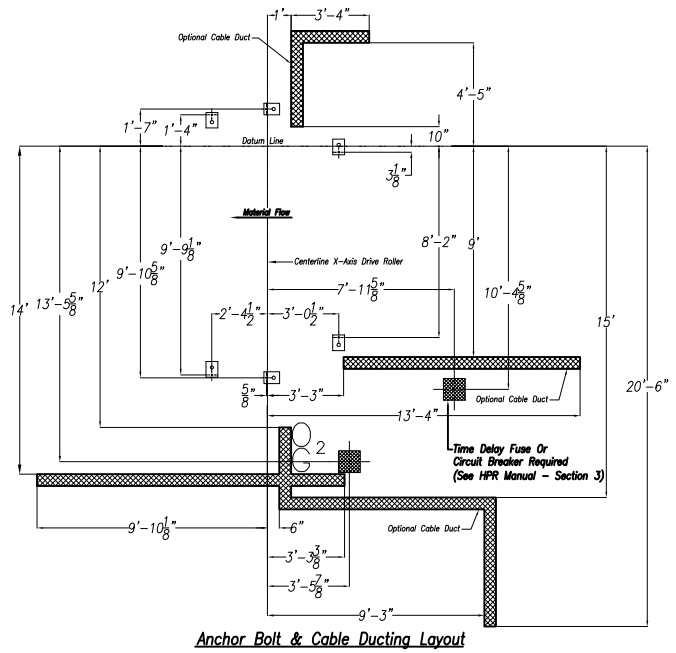
1500 PSI FROM POWER UNIT



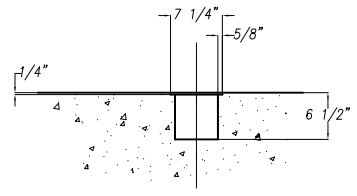
View C-C

!!!NOTE: DO NOT DRILL HOLES FOR ANCHOR PLATES UNTIL MACHINE IS IN PLACE AND LEVEL AT FINAL INSTALLATION!!!

Note: Customer To Determine Cable Ducting Arrangement For Main Power & Air Supplies



Anchor Bolt & Cable Ducting Layout



CABLE DUCT DETAIL

CUSTOMER TO SUPPLY COVER; 1/4" THK. X 7 1/4" WIDE INSTALLED AFTER FINAL FIELD WIRING & PIPING

GAS REQUIREMENTS: HPR 400XD

(Req'd @ Each ⬟)

The Following Requirements Are Recommended For Cutting Mild Steel.

PLASMA GAS TYPES:	SHIELD GAS TYPES:
OXYGEN (O2)	AIR
ARGON (Ar)	NITROGEN (N2)

GAS QUALITY:

O2	99.5% PURE, Clean, Dry, Oil-Free (LIQUID GAS RECOMMENDED)
Ar & N2	99.99% PURE, Clean, Dry, Oil-Free (LIQUID GAS RECOMMENDED)
AIR	Clean, Dry, Oil-Free

REQUIRED FLOW RATES & INLET PRESSURES

OXYGEN	115 psi AT 150 scfh
NITROGEN	115 psi AT 410 scfh
ARGON	115 psi AT 150 scfh
AIR	115 psi AT 400 scfh

GENERAL NOTES:

1) Passline of HSFDB 2500/B Based on 40" from Floor-Line
2) Concrete Floor under HSFDB 2500 to be a Minimum of 6" Thick
3) Total K.V.A. for HSFDB 2500/B = 102 K.V.A. (128.5 Amps)
   Total K.V.A. for HPR 400XD = 91 K.V.A. (114 Amps) (See Note On Layout)
4) Primary 460 V., 3 Ph., 60 Hz., [Req'd @ ▨]
5) Cutting Oxygen: 260 SCFH [Req'd @ each O_2]
6) Propylene Gas: 25 SCFH [Req'd @ each G]
7) Air Requirements: 115/125 PSIG, 40 SCFM (1/2" NPT Female Connection On Machine) [Req'd @ ▲]
8) Torit Dust Collector Air Requirements: 90/100 PSIG, 10 SCFM [Req'd @ ◈]
9) 30 Gal. Hydraulic Oil (Mobil DTE #24 or Equal) [Req'd @ ◍]
10) Anchor Bolts (Machine & Safety Stands) 3/4" ITW Red Head WS-3470 or Equal [34 Req'd]
11) Anchor Bolts (Rails & Cylinder) 5/8" ITW Red Head WS-5870 or Equal [42 Req'd]
12) Anchor Bolts (Transfer Modules) 5/8" ITW Red Head WS-5870 or Equal [18 Req'd]
13) Network/Internet Connection for Data Transfer and Remote Diagnostics [Req'd @ ❩]
14) See HPR 400XD Notes for Plasma Requirements

LET.	REVISION/C.N.#	BY	DATE
E			
D			
C			
B			
A			

Peddinghaus Corp.
BRADLEY, ILL. U.S.A.

HSFDB 2500 B Layout for

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IMPORTANT Safety Note!
Because of the difficulty to effectively guard the full length of the system it is the customers responsibility to prevent access by unauthorized personnel and to provide safe crossing.

DRAWN BY: E. Bass | SCALE: 1/4" = 1' | DATE:
DRWG. NO.
Sheet 1 of 1