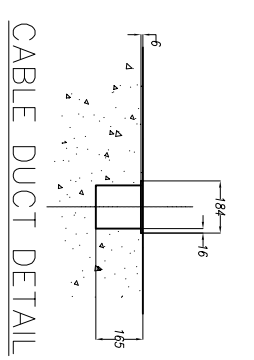


!!!NOTE: DO NOT DRILL HOLES FOR ANCHOR PLATES UNTIL MACHINE IS IN PLACE AND LEVEL AT FINAL INSTALLATION!!!

GENERAL NOTES:

- 1) Passivine of HSFDB 2500-B Based on 1016mm from Floor-Line
 - 2) Concrete Floor under HSFDB 2500-B to be a Minimum of 200mm Thick
 - 3) Total kW for HSFDB 2500-B = 83 kW (156 Amps)
 - 4) Total kW for HPR 260XD = 52 kW (75 Amps) (See Note On Layout)
 - 5) Primary Oxygen: 7.36 SCMH [Req'd @ each O₂]
 - 6) Cutting Oxygen: 7.36 SCMH [Req'd @ each G₂]
 - 7) Acetylene Gases: 0.71 SCMH [Req'd @ each G₂]
 - 8) Air Requirements: 8.0/8.6 bar, 1.13 SCMH [Req'd @]
 - 9) Torit Dust Collector Air Requirements: 6.2/6.9 bar, 0.28 SCMH [Req'd @]
 - 10) 113.6 L Hydraulic Oil (Mobil DTE #24 or Equval) [Req'd @]
 - 11) Anchor Bolts (Machine & Safety Stands) 20mm Anchor Bolts or Equval [30 Req'd]
 - 12) Anchor Bolts (Conveyors) 18mm Anchor Bolts or Equval [16 Req'd]
 - 13) Anchor Bolts (Safety Barrier) 12mm Anchor Bolts or Equval [4 Req'd]
 - 14) Network/Internet Connection for Data Transfer And Remote Diagnostics [Req'd @]
- See HPR 260XD Notes for Plasma Requirements



CUSTOMER TO SUPPLY COVER: 6mm THK, X 184mm WIDE
INSTALLED AFTER FINAL FIELD WIRING & SPRING

DRILL COOLANT RECOMMENDATION:
USE PEDDICOOL/UNIST COOL LUBE 2210EP COOLANT

GAS REQUIREMENTS: HPR 260XD
(Req'd @ Each)

The Following Requirements Are Recommended For Cutting Mild Steel:

PLASMA GAS TYPES	SHIELD GAS TYPES
O ₂	99.5% PURE, Clean, Dry, Oil-Free (LIQUID GAS RECOMMENDED)
Ar & N ₂	99.99% PURE, Clean, Dry, Oil-Free (LIQUID GAS RECOMMENDED)
ARGN (Ar)	Clean, Dry, Oil-Free

REQUIRED FLOW RATES & INLET PRESSURES

	OXYGEN	NITROGEN	ARGN
8 bar AT 4250 l/hr	8 bar AT 4250 l/hr	8 bar AT 4250 l/hr	8 bar AT 11350 l/hr

REV	REVISION/CHG	BY	DATE
E			
D			
C			
B			
A			

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

HSFDB 2500-B Layout
101

Scale: 1 : 30
DATE: 8/1/04
SHEET: 1 OF 1

Note: Customer To Determine Cable Ducting Arrangement For Main Power & Air Supplies
C 25/35 x 200mm THICK CONCRETE RECOMMENDED UNDER ALL EQUIPMENT

Anchor Bolt & Cable Ducting Layout