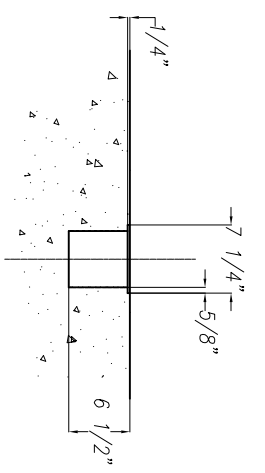


DRILL COOLANT RECOMMENDATION:
USE PEDDICOOL/UNIST COOL LUBE 2210EP COOLANT



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

GAS REQUIREMENTS: HPR 260XD
(Req'd @ Each)
The Following Requirements Are Recommended For Cutting Mild Steel.

PLASMA GAS TYPES:	SHIELD GAS TYPES:
O ₂	AIR
Ar & N ₂	NITROGEN (N ₂)
Ar	
AIR	

GAS QUALITY:
99.5% PURE Clean, Dry, Oil-Free (LIQUID GAS RECOMMENDED)
99.99% PURE, Clean, Dry, Oil-Free (LIQUID GAS RECOMMENDED)
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)
- 4) Total K.V.A. for HPR 260XD = 52 K.V.A. (64 Amps) (See Note On Layout)
- 5) Primary 460 V., 3 Ph., 60 Hz., [Req'd @]
- 6) Cutting Oxygen: 260 SCFH [Req'd @ each G]
- 7) Acetylene Gas: 25 SCFH [Req'd @ each G]
- 8) Air Requirements: 115/125 PSIG, 40 SCFM (1 1/2" NPT Female Connection On Machine) [Req'd @]
- 9) Tort Dust Collector Air Requirements: 90/100 PSIG, 10 SCFM [Req'd @]
- 10) 30 Gal. Hydraulic Oil (Mobil DTE #24 or Equal) [Req'd @]
- 11) Anchor Bolts (Machine & Safety Stands) 3/4" ITW Red Head WS-3470 or Equal [30 Req'd]
- 12) Anchor Bolts (Transfer Modules) 5/8" ITW Red Head WS-5870 or Equal [16 Req'd]
- 13) Network/Internet Connection for Data Transfer and Remote Diagnostics [Req'd @]
- 14) See HPR 260XD Notes for Plasma Requirements

Peddinghaus Corp.		IMPORTANT SAFETY NOTE:	
BRADLEY, ILL. U.S.A.		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.	
HSFDB 2500 B Layout		DRAWN BY: <i>B. Martin</i> SCALE: 3/8" = 1" DATE:	
for		DRWS. NO.	
REVISION/C.N.#		BY DATE	
LET.		THIS PRINT IS THE PROPERTY OF PEDDINGHAUS CORP. AND IS NOT TO BE USED IN ANY MANNER DETRIMENTAL TO THE INTERESTS OF SAID COMPANY.	

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