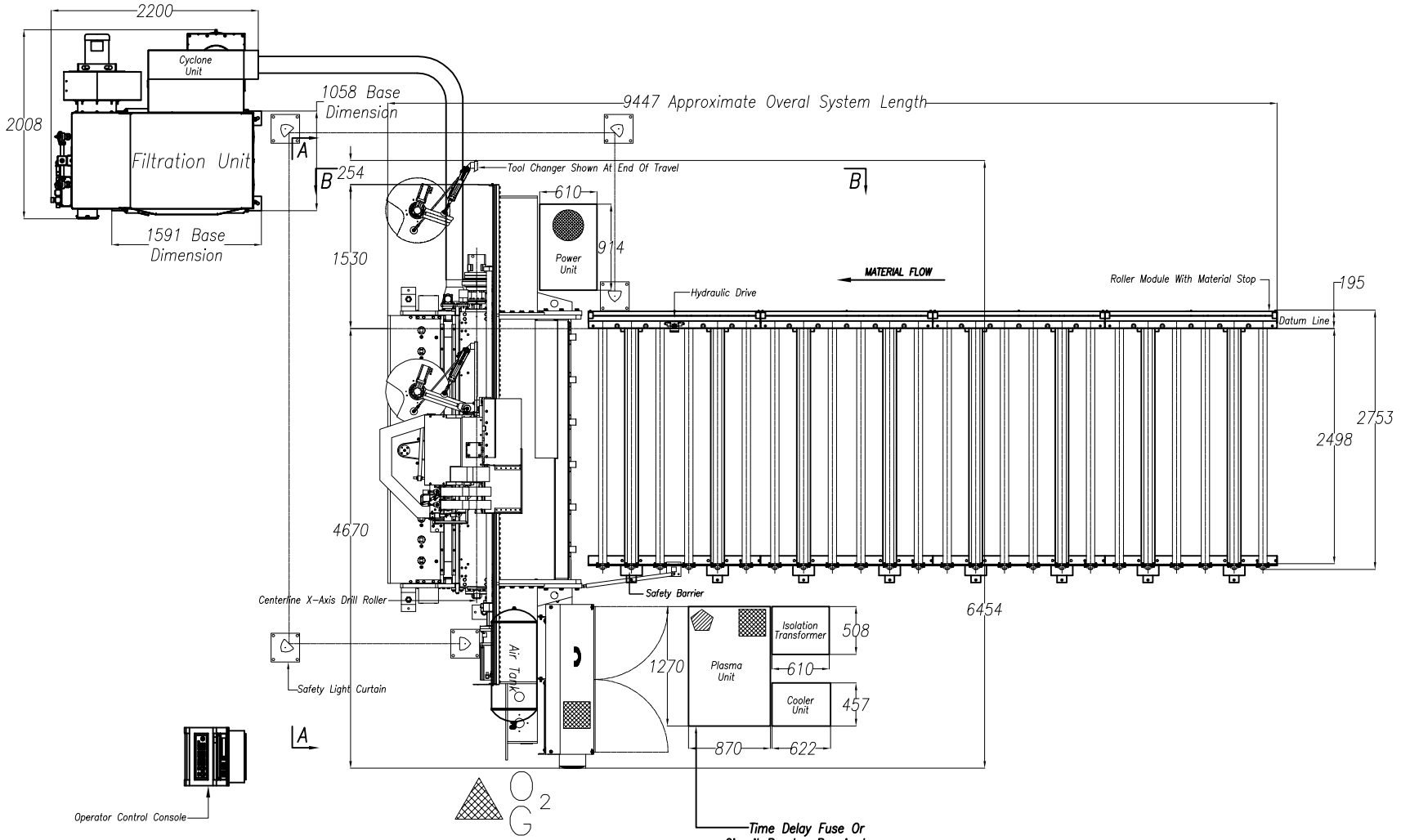
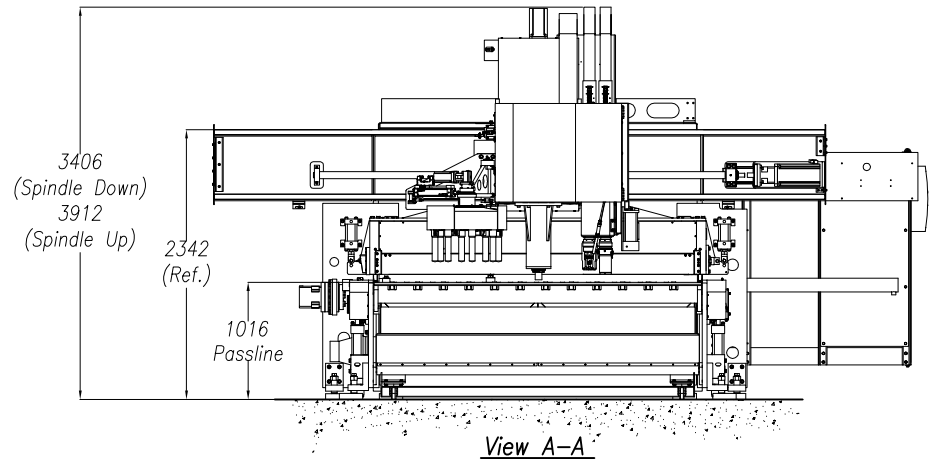




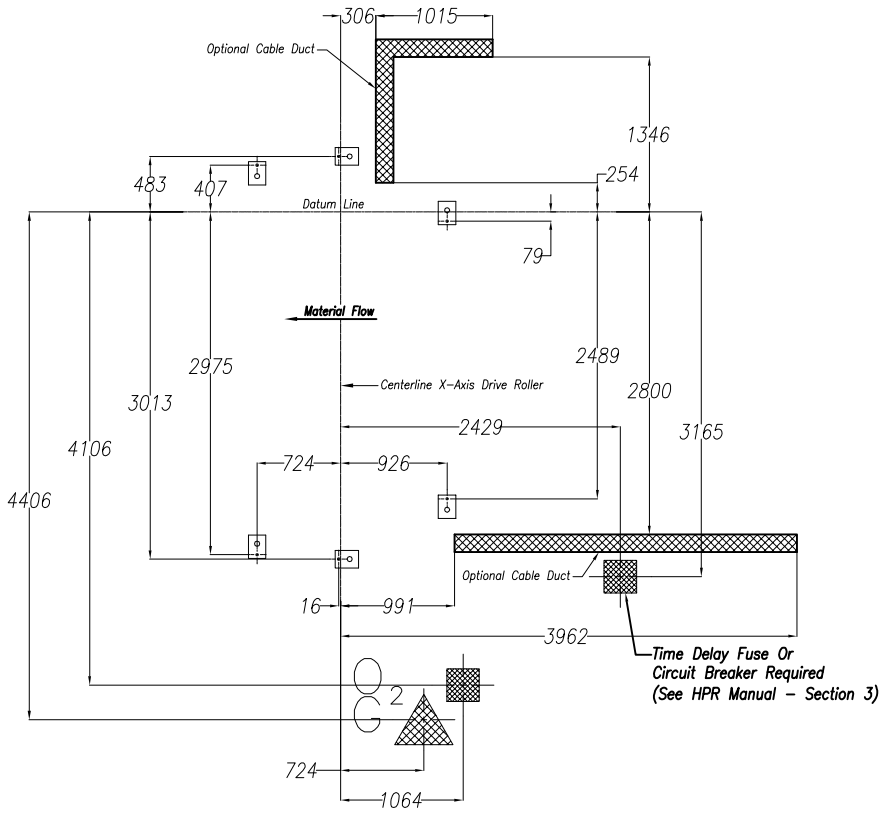
View A–A

MACHINE WEIGHT 36,045 lbs

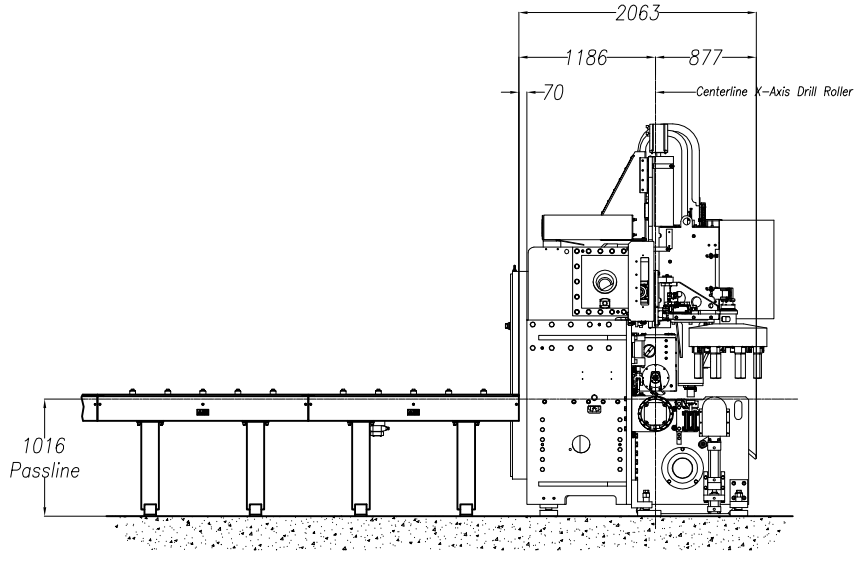
DRILL COOLANT RECOMMENDATION:

USE PEDDICOOL/UNIST COOL LUBE 2210EP COOLANT

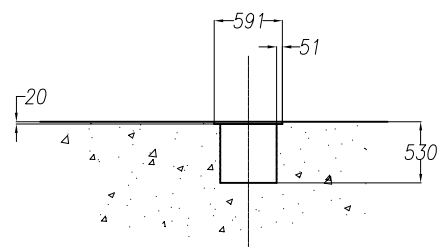
!!!NOTE: DO NOT DRILL HOLES FOR ANCHOR PLATES UNTIL MACHINE IS IN PLACE AND LEVEL AT FINAL INSTALLATION!!!



Anchor Bolt & Cable Ducting Layout



View B–B



CABLE DUCT DETAIL

CUSTOMER TO SUPPLY COVER; 6mm THK. X 184mm 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	8.3 bar AT 4250 l/hr
NITROGEN	8.3 bar AT 11610 l/hr
ARGON	8.3 bar AT 4250 l/hr
AIR	8.3 bar AT 11330 l/hr

GENERAL NOTES:

1) Passline 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)
   Total kW for HPR 400XD = 80 kW (138 Amps) (See Note On Layout)
4) Primary 400 V., 3 Ph., 50 Hz., [Req'd @]
5) Cutting Oxygen: 7.36 SCMH [Req'd @ each O_2]
6) Acetylene Gas: 0.71 SCMH [Req'd @ each G]
7) Air Requirements: 8.0/8.6 bar, 1.13 SCMM (12mm NPT Female Connection On Machine) [Req'd @]
8) Torit Dust Collector Air Requirements: 6.2/6.9 bar, 0.28 SCMM [Req'd @]
9) 113.6 L Hydraulic Oil (Mobil DTE #24 or Equal) [Req'd @]
10) Anchor Bolts (Machine & Safety Stands) 20mm Anchor Bolts or Equal [30 Req'd]
11) Anchor Bolts (Conveyors) 16mm Anchor Bolts or Equal [24 Req'd]
12) Network/Internet Connection for Data Transfer And Remote Diagnostics [Req'd @]
13) See HPR 400XD Notes for Plasma Requirements

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

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

HSFDB 2500 B Layout for

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: A. Martin | SCALE: 3/8" = 1' | DATE: 12-19-2011 | DRWG. NO.