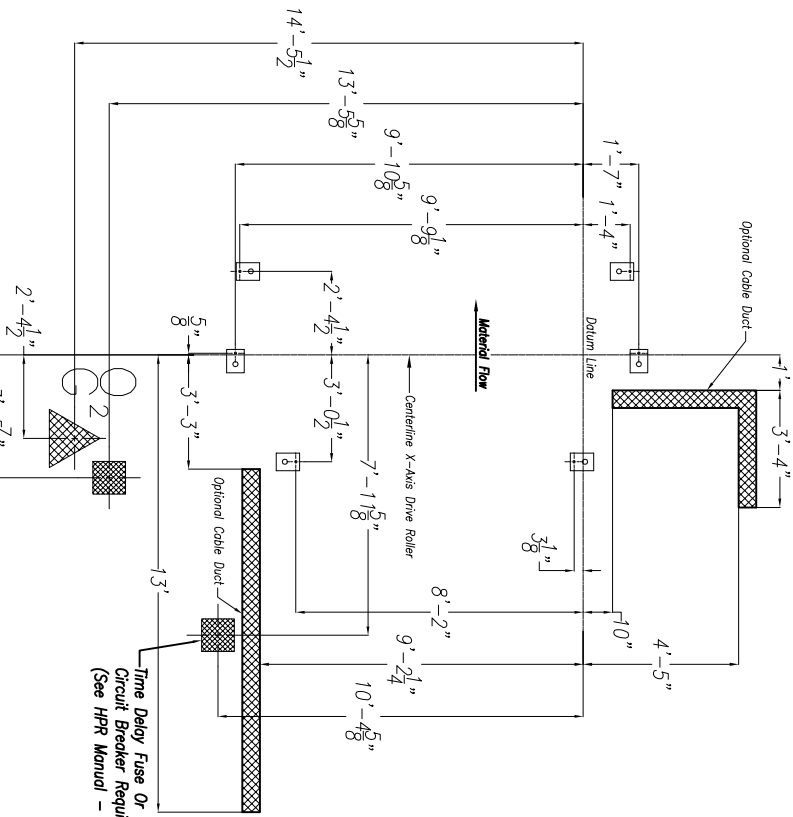
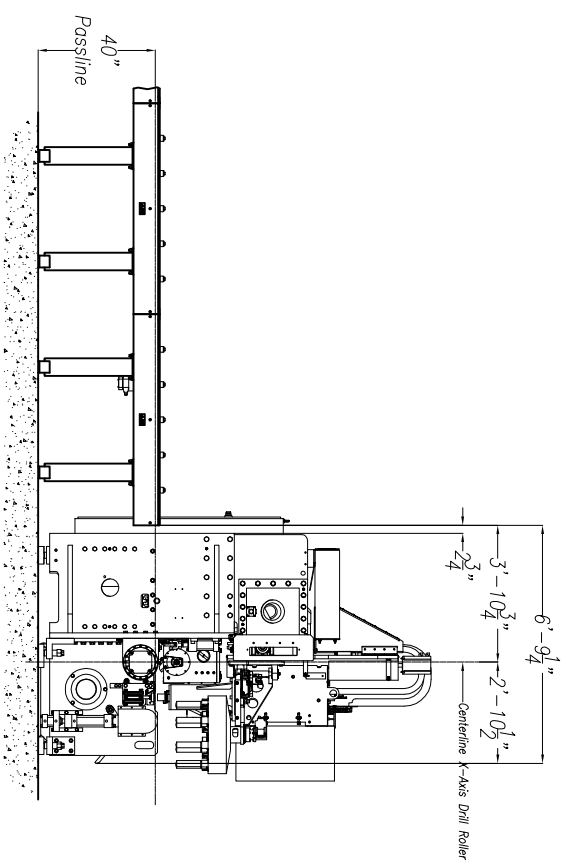


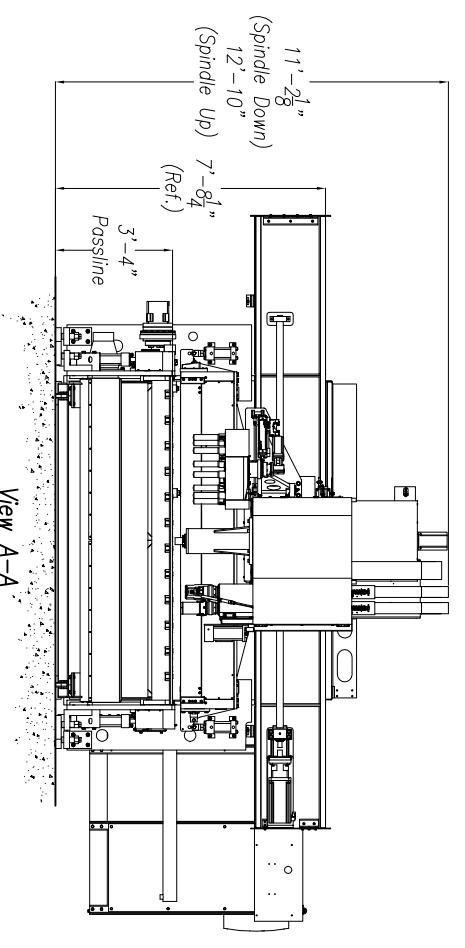
!!!NOTE: DO NOT DRILL HOLES FOR ANCHOR PLATES UNTIL MACHINE IS IN PLACE AND LEVEL AT FINAL INSTALLATION!!!



Anchor Bolt & Cable Ducting Layout

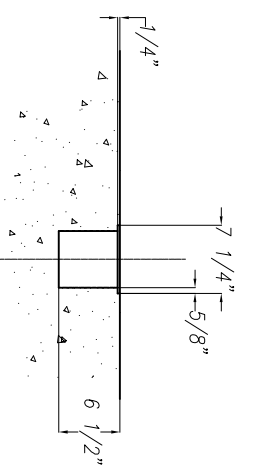


View B-B



MACHINE WEIGHT 36,045 lbs

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 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)
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 HSFD 2500/B Based on 40" from Floor-Line
- 2) Concrete Floor under HSFD 2500 to be a Minimum of 6" Thick
- 3) Total K.V.A. for HSFD 2500/B = 102 K.V.A. (128.5 Amps)
- 4) Total K.V.A. for HPR 400XD = 91 K.V.A. (129 Amps) (See Note On Layout)
- 5) Primary 440 V., 3 Ph., 60 Hz., [Req'd @]
- 6) Cutting Oxygen: 260 SCFH [Req'd @ each O₂]
- 7) LP Gas: 25 SCFH [Req'd @ each]
- 8) Air Requirements: 115/125 PSIG, 40 SCFM (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 400XD 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.	
HSFD 2500 B Layout		SCALE: 3/8" = 1'	DATE: 12-19-2011
for		DRAWN BY: <i>A. Martin</i>	DRWS. NO.
LET.	REVISION/C.N.#	BY	DATE

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