



!!!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

DRILL COOLANT RECOMMENDATION:
USE PEDDICOOL/JUNST COOL. LUBE 221DEP COOLANT

GAS REQUIREMENTS: HPR 400XD

(Req'd @ Each ●)
The Following Requirements Are Recommended For Cutting Mild Steel:
PLASMA GAS TYPES: OXYFEN (O2) ARGON (Ar)
GAS QUALITY: 99.99% Pure Clean Dry, Oil-Free (LIQUID GAS RECOMMENDED)
SHIELD GAS TYPES: AIR NITROGEN (N2)
REQUIRED FLOW RATES & INLET PRESSURES:
OXYGEN 115 psf AT 150 scfh
ARGON 115 psf AT 150 scfh
AIR NITROGEN 115 psf AT 400 scfh

CABLE DUCT DETAIL

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

GENERAL NOTES:

- 1) Passline of HSFDB 2500/B Based on 40.50" 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 400XD = 91 K.V.A. (114 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) Propylene Gas: 25 SCFH [Req'd @ each G]
- 8) Tort 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 & Siefy Stands) 3/4" ITW Red Head WS-3470 or Equal [34 Req'd]
- 11) Anchor Bolts (Machine & Siefy) 1/2" ITW Red Head WS-1270 or Equal [29 Req'd]
- 12) Anchor Bolts (Conveyors & Inverted Rails) 5/8" ITW Red Head WS-5870 or Equal [52 Req'd]
- 13) Network/Internet Connection for Data Transfer and Remote Diagnostics [Req'd @]
- 14) See HPR 400XD Notes for Plasma Requirements

E	REVISION/CH.#	BY	DATE	URGENT SAFETY NOTE: Peddinghaus Corp. BRADLEY, ILL. U.S.A. HSFDB 2500 B Layout for S. Geyenker SCALE: 3/8" = 1" DATE: DRAWG. NO.
D				
C				
B				
A				

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