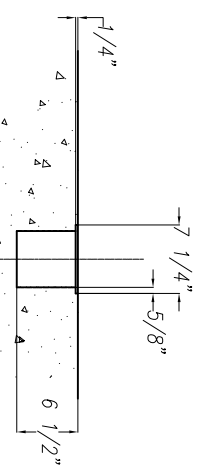


DRILL COOLANT RECOMMENDATION:
USE PEDDICOOL/UNIST COOL LUBE 2210EP COOLANT

MACHINE WEIGHT 42,000 lbs



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: OXYGEN (O2) ARGON (Ar)	SHIELD GAS TYPES: AIR NITROGEN (N2)
GAS QUALITY: O2 (LIQUID GAS RECOMMENDED) Ar & N2 (LIQUID GAS RECOMMENDED) AIR (LIQUID GAS RECOMMENDED)	REQUIRED FLOW RATES & INLET PRESSURES
AIR Clean, Dry, Oil-Free	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/C Based on 41.25" from Floor-Line
- 2) Concrete Floor under HSFD 2500 to be a Minimum of 6" Thick
- 3) Total K.V.A. for HSFD 2500/C = 100 K.V.A. (124 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 (1/2" 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 [24 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 @]
- See HPR 260XD Notes for Plasma Requirements

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

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.	
Peddinghaus Corp. BRADLEY, ILL. U.S.A.	
HSFD 2500 C Layout For	
DESIGN BY: <i>G. B. ...</i>	SCALE: 3/8" = 1'
DATE: _____	DATE: _____
REVISION/C.N.# _____	BY _____ DATE _____
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