

Kjellberg
FINSTERWALDE

the
FINE FOCUS
company

Manual Cutting and Gouging with FineFocus Plasma Cutting Units

CUTLINE 10G
CUTLINE 20G
CUTLINE 40G

CUTLINE 20W
CUTLINE 40W



For all electrically conductive materials with plasma gas air
and gas- (G) or water-cooled (W) plasma torches with
FineFocus technology

CUTLINE = Manual plasma cutting with highest quality

Versatile application



- Suitable for straight line cutting, profile cutting and interrupted cutting; for bevel cutting, hole cutting and fusion drilling, scrap cutting in nearly all positions.
- Plasma gouging as the clean alternative to carbon arc gouging - **advantageous**, because no aftertreatment necessary, low heat input, very low distortion. The process easily can be followed visual, noise level and smoke formation are widely reduced.

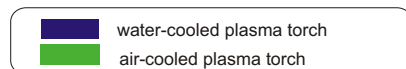
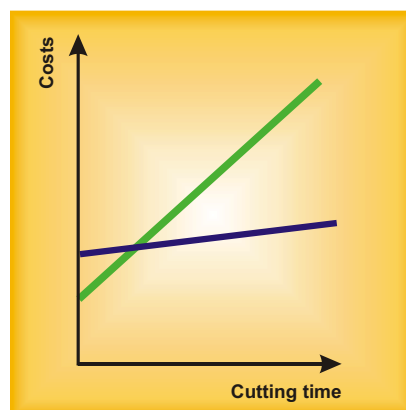
The units are distinguished by ...

- cutting speed up to eight times higher than with gas cutting
- excellent cutting results
 - due to the Double-Straight Effect both sides of the cut can be used ("Savings Cut")
 - small kerfs, therefore low loss of material and low pollution
- running cutting start as well as running piercing possible, no reference point required
- high longevity of consumables, because of soft-start circuit and directly water-cooled torches, very low time-wasting for change of consumables
- automatic power increase of pilot arc at work contact
- easy torch change without tools because of central connectors high rate of duty cycle through effective
- cooling; small-sized power sources require low placement space

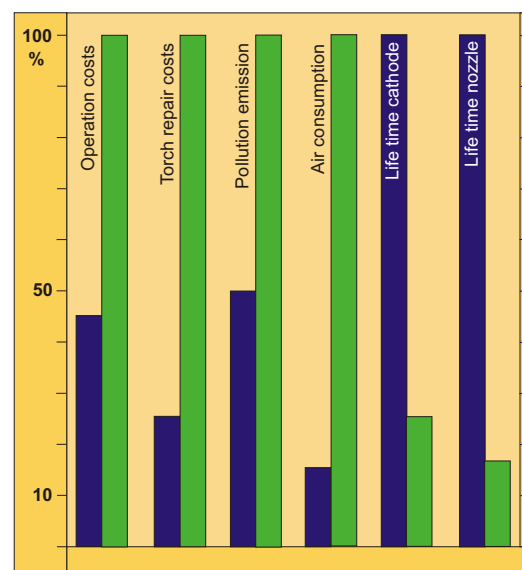
The choice is with you: water- or air-cooled?

Kjellberg Finsterwalde is the only supplier of manual plasma cutting units with FineFocus-technology.

Water cooled FineFocus-plasma torches with their direct cooling principle for the consumables are reaching a five times higher life time of nozzles and cathodes. Therefore we recommend for constant applications generally the use of water-cooled installations. The result is a considerably reduction of operating costs.



Advantages of water-cooled plasma torches



Flexible application of hand torches with various accessories

Kjellberg Finsterwalde offers a wide range of accessories for all plasma hand torches. There are contact caps and contact nozzles; distance caps and distance holders for **template cutting**; special nozzles, ceramic caps and shock protectors for the **gouging** process. The later three items are only to change, when preparing the standard hand torch for gouging, where the torch head is exposed to extreme heat and physical stress.

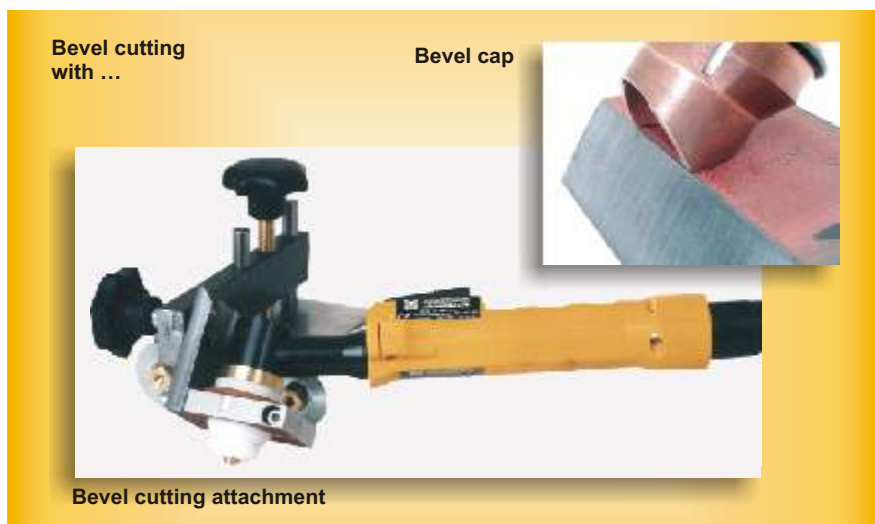
For the **beveling** of plate edges or for preparation of welding seams we are offering special bevel caps with 30° und 38°, as well as a bevel cutting attachment with free adjustable bevel angle.

When cutting along **marking lines** a wheel guide is very helpful. At higher dimensions the Plasma Tractor FE 1 can be used. **Circle cutting** easily can be performed when using the circle attachment in connection with a magnetic or suction holder for safe circle fixture.



Template cutting

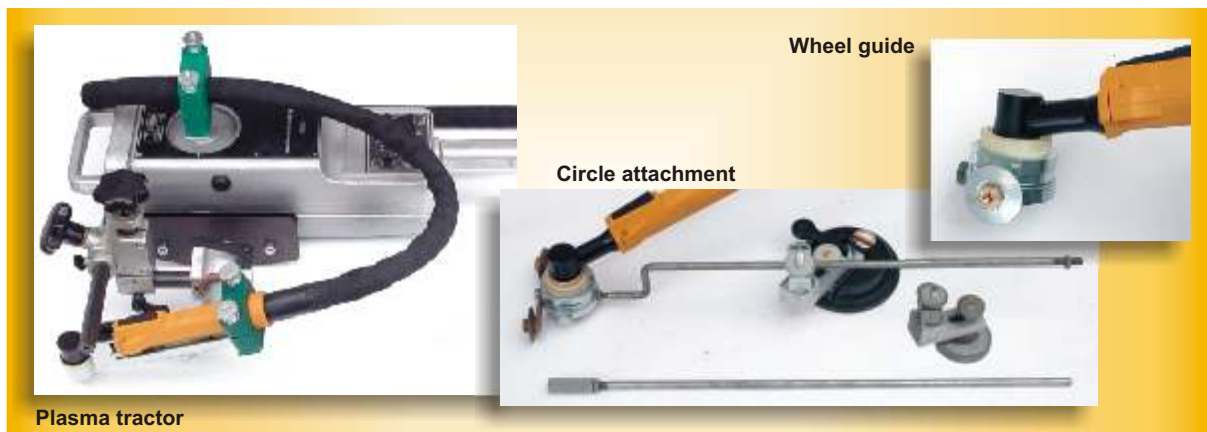
Gouging



Bevel cutting with ...

Bevel cap

Bevel cutting attachment



Plasma tractor

Circle attachment

Wheel guide

Our wide range of accessories enables the operator to solve various cutting problems. Please contact us, if you need support for your special application. We surely will help you.

Technical data

Type	CUTLINE 10G	CUTLINE 20G	CUTLINE 40G	CUTLINE 20W	CUTLINE 40W
Mains voltage, 50 Hz (V), 3 phase	230 / 400	230 / 400	400	230 / 400	400
Mains fuse, slow (A)	16 / 10	35 / 25	35	35 / 25	35
SPECIAL mains voltage, 50 Hz (V)	500	500	500	500	500
VERSION mains fuse, slow (A)	6	25	25	25	25
Connecting power (kVA)	8	16	24	16	24
Protection class	IP 22	IP 22	IP 22	IP 22	IP 22
Insulation class	F	F	F	F	F
Open circuit voltage (V)	275	275	275	275	275
Cutting current (A)	30	30 / 60	60 / 120	25 / 50	50 / 100
Duty cycle (%)	35	50	50	60	60
Cutting thickness 1) quality cut (mm)	6	15	30	15	30
max. cut (mm)	12	20	40	20	40
Plasma gas	air				
Ignition	high voltage				
Weight (kg)	38	74	122	84	132
Dimensions (L x W x H) (mm)	320x420x985	670x490x880	820x490x880	670x490x880	820x490x880

Torch type for plasma cutting unit	PB-S10 LH CUTLINE 10G	PHT-31 G/L CUTLINE 20G	PHT-51 G/L CUTLINE 40G	PHT-30 W/L ⁴⁾ CUTLINE 20W	PHT-45 W/L ⁴⁾ CUTLINE 40W
Cutting current (A)	45	70	120	80	130
Hose parcel length (m)	4	6	6	6 (10) ³⁾	6 (10) ³⁾
Cooling	air			water	
Air pressure (MPa/bar)	0,4 / 40	0,5 / 5	0,5 / 5	-	-
Ignition		100	130	-	-
Plasma gas air ²⁾	high voltage				
Pressure (MPa/bar)	0,4 / 4	0,5 / 5	0,5 / 5	0,5 / 5	0,5 / 5
Total air consumption (l/min)	105	117	150	25	25
Main arc start	Full-automatic power increase after workpiece contact through pilot arc				
Protective circuit	Protective cap with safety cut-off				

1) material depending, standard qualities

2) pressure and flow rate adaptations to work conditions possible

3) optimum

4) plasma torches with FineFocus-technology

Quality features



The plasma cutting units possess the CE conformity and also conform to the valid regulations of the European Union.



Development and production take place according to the following standards: EN 60974-1 (VDE 0544, part 1) and BGV D1.



The plasma cutting systems are in possession of the S mark and therefore applicable to work places with increased electrical endangerment.



All products are manufactured under strict quality assurance control and proved by certificates and product-related test records.

The production takes place according to DIN EN ISO 9001.

Our products are produced according to the latest technical developments. We reserve the rights for technical changes during production. Therefore, claims of whatever kind can't derived from prospectus.

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