• Cutting area 2500 x 12000 mm

• Direct and phase cutting with plasma; max. cutting capacity with 50 mm piercing CS, 40 mm SS.AL; M3 360A

• Rail length 13.8m

• Rails installed on the floor, on steel plates (high side carriages)

Some advantages

• Precision hole technology in CS for up to 25 mm material (1:1 hole to plate thickness).

• Automatic compensation of the arc voltage when checking the height of the plasma torch, depending on the wear of the electrode; automatic warning when the limit value is reached. Ensures a constant cutting angle throughout the life of the electrode, regardless of wear.

• Ability to check the position of the bevel head and correct it automatically.

• Fast raising of the torch on plasma (116 mm/sec).

• Simple diagnostics - all important parameters are displayed.

• Annual maintenance and lifetime plasma torch warranty (one set at your workplace).

• XR nozzles for plasma - air as shield gas cutting is 10-30% faster than common competitive equipment.

• Fast cycle - optimized torch movement to save time when moving from part to part.

• Constant checking of the portal position during operation. The correct geometry of the parts is ensured.

• Light curtains for safety. It is safe to work in different work zones.

• All parts are made by one manufacturer, we are responsible for the technical solution.

• Parameter files (TDF files), fully automatically controlled processes for plasma cutting

• Controller startup wizard.

Power supply M3 360 3rd generation

Max. cutting current 360 A

Adjustment range 30-360 A

Max. marking current 36 A

Adjustment range 3-36 A

Connection voltage 400 volts 3 phases 50 Hz

Protection 3 x 200 A

Open voltage 427 volts DC

Interruption 100% 360 Amp

Gas tank For automatic adjustment of all gases

Plasma gas O2, N, technical air, H35

(purity 99.5%), dry, oil-free

Starting gas pressure 10 bar

Shielding gas N2 or air

Shielding gas pressure 10 bar

Ignition HF

Remote control Automatic NC control

Plasma torch PT 36

Cable and hose for the connection between the machine and the plasma

Earth connection between the machine, the cutting table and the power source

Cooling For an ambient temperature of -/+32 degrees

Max. total piercing CS: 40 mm

Max. total piercing SS: 40 mm

Max. total piercing AI: 40 mm

Service life of accessories - 1450 piercings

Cutting speed carbon steel: 10 mm 4400 mm/min

 20 mm 2800 mm/min (new 3000 mm/min)

 30 mm 1600 mm/min

 40 mm 925 mm/min (new 1400)

The speed depends on the quality of the steel.

Starting system HF

Cutting angle: according to ISO 9013: class 3

The plasma is controlled by both the pressure and flow of the cutting gas, which ensures the quality of the cut.

PLASMA VBA Global PRO - excellent preparation of the welding edge

Fully automated plasma phasing unit VBA with automatic +/- 540 degree rotation.

ESAB has been manufacturing plasma phasing equipment since 1991.

The new modification of the device was created in 2012 and includes the latest improvements in phase cutting technology. The device has a precise height control that automatically compensates for electrode wear errors and a built-in torch impact protection.

There is both an electrical system and a pneumatically balanced touch system for detecting the starting height, in case the sheet is rusty or for some other reason does not provide electrical contact.

• High speed positioning.

• Accurate initial height detection, pneumatically balanced initial height detection.

• The burner is attached to the assembly, which provides both protection against an accident and detection of the original height.

• Vertical speed up to 116 mm/sec.

• Encoder positioning (CNC controlled/programmable).

• Smart Voltage Height Control™ (logical control of voltage height). Plasma arc voltage testing and holding for m³ plasma systems. Continuously tests the arc voltage and automatically adjusts the arc voltage to achieve the correct torch height throughout the lifetime of the accessories.

• Character generator BUGE, writing in marking mode

• Precision Hole Technology™ - better internal contour quality for m³ plasma systems. The lift includes a built-in encoder that allows the VISION CNC to accurately determine the actual cutting height while cutting small openings regardless of arc voltage. This is the most accurate way to determine the correct height when cutting holes and internal contours and maximizes hole accuracy and concentricity.

Device width: 843 mm (including UV protection)

Up/down travel: max 250 mm

Rotation speed: up to 50 1/min (+/- 540°)

Slope angle adjustment: +/- 52° in 0.1° steps (provides a cutting angle of 45°)

Angle positioning speed: 30°/sec.

Lateral undercut compensation: 0.02 mm steps

Cutting height adjustment: automatic via arc tension control and/or touch sensor

Material thickness:

5 mm min. material thickness\*\* (depending on the construction/material of the cutting table, a smaller plate thickness is possible, deflection of the plate must be avoided)

Up to 32 mm max. For a 45 degree cut\*\*

Up to 45 mm for a vertical cut\*\*

Up to 50 mm when starting from the edge

depending on the power of the selected plasma system and the material to be cut

Max. cutting current: m³ plasma system 450 A. (oxygen plasma)

Accuracy:

Tilt angle positioning: +/- 0.2°

Automatic height adjustment: +/- 0.15 mm via arc tension and +/- 0.15 mm via touch sensor

Controller T5

Digital control based on Windows

Simplicity and ease of use are the principles that guided the development of the new VISION T5 touchscreen based controller.

The touch-sensitive and graphical user interface is also designed to provide additional information and feedback to the device user. Important information is always displayed, the work steps are understandable and intuitive, giving the user instructions at all times.

Usage Wizard

The new operating wizard provides the user with easy-to-understand step-by-step instructions from starting up the device to cutting. New users will quickly achieve good results by following simple instructions with limited options that lead from selecting a file to starting cutting.

Such a system simplifies the use of the controller. Advanced users can bypass the wizard if they wish, and take the necessary steps based on their experience.

Immediate access to the necessary process control elements for faster and easier use is guaranteed.

With the VISION T5, all cutting and marking torch controls are always on the screen.

All tools are fully automated through a built-in process database.

The built-in process database simplifies the setting of the cutting tool by automatically selecting parameters such as cutting speed, cutting offset and timers, depending on the material thickness, type and desired cutting quality, thus increasing the productivity of the device and the quality of work. At the beginning of the process, the user sees a picture of the consumable parts of the torch required for this job, together with the necessary product numbers.

Characteristics

- The large and bright 16:9 widescreen provides more easily arranged information.

- VISION T5 uses a 5-wire resistive touch display panel. The system is

 with high resolution, works even with the touch of any pen or gloved hand and is

 dirt, dust, water and light resistant.

- Dual processor design separates motion control and processing control from the user interface to ensure reliable real-time operation.

- Intuitive touch screen interface provides easy operation of the color-coded system.

- Multitasking increases productivity by allowing the user to do several things at once.

- The panel has a convenient ergonomic layout.

- Tools for all processes such as bevel cutting, marking or laser cutting

 management.

- Built-in process database eliminates manual process parameter setting so you get the same cut quality every time for every shift and for every user.

- Dual front panel USB sockets are protected and installed so as not to interfere with important user controls.

- The new operation wizard guides the user from starting the machine to the usual setup steps and cutting.

- Standard detail selection with interactive graphic preview includes 88 details

 with insertion and removal, small openings and optimization of internal contours.

- Easily import parts from DFX/DWG files and add optimized technology

 in the controller to achieve the best cutting quality.

- DXF import specification. All existing layers and linetypes in the DFX file will be imported. Only geometric elements line, arc and circle are allowed for cutting. All other geometric elements such as polygons, polynomials, blocks, dimensions, etc. cannot be imported. Inner and outer contours must be closed and may include double geometric elements.

- Remote diagnostics with an Internet connection allows real-time testing, troubleshooting and

 diagnostics that reduce machine downtime.

ESAB cutting table Sirius 750

Cutting table with divided sections Sirius 750

Sectional table for gas, plasma and laser cutting with extraction and slag boxes divided into sections. The table is divided into 750 mm wide sections connected by a longitudinal exhaust channel.

- The longitudinal discharge channel is equipped with pneumatic switches, one for each section and each is controlled by the movement of the machine. The movement of the cutting machine affects the cutting table damper in such a way that only one section is open at a time when it is under the burner.

- One 3/8" pressure regulator and pressure gauge in the pneumatic cylinder connection. A pressure of 6 bar and 5 m3/h is required for correct control of the cylinders. Dry and oil-free.

- The pipes between the pneumatic elements are made of copper.

Important!

- The floor must be flat, tolerance +/- 5 mm.

- Pipes between cutting table, filter, fans and chimneys are not included in the ESAB delivery.

cutting surface 2,700 \* 12,750 mm

Number of sections 17 pcs

Valve control Electronic

Cutting grate smooth steel h 100 \* T 6 mm distance 100 mm

Table height 700 mm

Exhaust channel Double sided

Max material thickness 125 mm

Max load 500 kg/m2

User manual in English

Tech. documentation in English

Filtering device ECO 12 CT

1 CENTRIFUGAL FAN SET installed on the ceiling of the filter, equipped with a motor whose power

calculated separately for each filter location and connection.

1 NOISE-PROOF BOX to reduce the noise level generated by the fan.

Fans with high pressure and/or power (> 15 kW) increase the noise level.

1 SPARK PROTECTOR equipped with a control hatch with an air inlet of Ø 350 mm.

1 ADJUSTMENT VALVE To adjust the power. The control valve is supplied separately from the filter unit, which is installed inside the pipes.

1 DUST catcher with suitable capacity.

1 TANK for compressed air, manufactured according to the European directive

87/404 EEC.

The tank is equipped with solenoid valves, which are necessary

to start the automatic cleaning system.

1 PRESSURE DIFFERENCE REDUCER for compressed air, equipped with a pressure indicator.

1 CHECK VALVE placed in the filter unit to allow downtime

impulse function.

FOR INTERIOR INSTALLATION:

1 ELECTRONIC BOARD for controlling the fan mounted on the filter structure.

1 ELECTRICAL CONTROL BOX installed on the filter structure, for the cartridge cleaning system, consists of:

- electronic board with cyclic pulse generator;

- ΔP plate for switching the cartridge cleaning system,

equipped with a manometer for visual inspection of the clogging level of cartridges.

1 NOISE PROTECTION covered with wire mesh, air outlet to increase soundproofing.

FOR OUTDOOR INSTALLATION:

1 ELECTRONIC BOARD for controlling the fan, supplied separately from the filter unit,

which is installed in place in the workshop.

1 ELECTRICAL CONTROL BOX is installed on the filter structure, for the cartridge cleaning system, consists of:

- electronic board with cyclic pulse generator;

- ΔP plate for switching the cartridge cleaning system,

equipped with a manometer for visual inspection of the clogging level of cartridges.

1 RAIN SHIELD (for outdoor installation only) to protect the engine from rain.

NOTE FOR FIELD INSTALLATION: As the best solution, the supplier recommends the installation of a filter unit

 under a light shelter wide enough to cover the entire filter structure from the elements and the sun.

Filtering device ECO 12 CT

Note: It is the customer's responsibility to obtain information on acceptable noise levels from relevant institutions, in accordance with Act 277 Section 5 of 1991, and to implement appropriate technical solutions.

APPLICATION: Suction and filtration of dust and fumes caused by thermal cutting of steel and iron plates.

NOTE: According to current regulations, the supplier advises the customer to build a proper staircase and platform near the exhaust pipe to ensure easy access for personnel.

TECHNICAL DESCRIPTION OF THE FILTER DEVICE

VOLUME 6000-10800 m³/h (oxygen)

\* Filter volumes are theoretical and may decrease accordingly

to the pipes located before and after the filters and the cassettes

to clogging.

RELATIVE HUMIDITY OF INHALED AIR < 50%

INTAKE AIR TEMPERATURE < 60 ° C

DUST EMISSION AFTER FILTERING < 2 mg/Nm3

NUMBER OF SOLENOID VALVES 12

COLOR Gray RAL 7030/Yellow RAL 1018

INSTALLATION Indoor/outdoor, air outlet to workshop or outside air

COMPRESSED AIR 6 bar min - 7 bar max. Dry and clean air

COMPRESSED AIR COST ± 50 Normal/lt with each pulse (average 6 pulses/min.)

PRINTED BOARD 24 V, AC, 50 Hz

ELECTRONICS CONTROL BOX 400 V - 3P+PE - 50/60 Hz

TYPES OF DUST metal dust (except dust from aluminum and light alloys, plastic materials, pre-painted tiles and tiles with oil stains)

NOTE Before insertion, install a circuit breaker with fuses or set the automatic differential switch sensitivity to 003 Amp. Calibration curve type "D" according to EN60947-2.

IMPORTANT! THERE IS NO FILTERING OF ALUMINUM AND OTHER LIGHT ALLOY DUSTS

ALLOWED BECAUSE IT COULD CAUSE THE FILTER TO EXPLODE.

THE SUPPLIER HAS CREATED THE ECO/R DUST COLLECTION LINE FOR THIS PURPOSE,

HOW TO MINIMIZE DAMAGES FROM A POSSIBLE EXPLOSION.

FILTRATION 12 HIGH CLASS highly efficient cartridge elements that give a total filtration area of ​​142.20 m2 and

99.999% efficiency for particles down to 0.5 microns.

Filtering device ECO 12 CT

Cleaning the filter unit: Automatic cartridge cleaning system with reverse aeration