Kjellberg® FINSTERWALDE

# Manual Plasma Cutting

## Cutting up to 50 mm with CUTi and CUTLINE


**Reliable Use**
**in Production, Workshops and Training Centres**

www.kjellberg.de

## CUTi – Mobile Cutting Inverter

The small power packages of the CUTi series are easy to handle and thus especially suitable for mobile use. From among the models of the series, the user may choose the unit which meets his individual requirements best.

With the plasma gas air mild steel, stainless steel, aluminium, brass, copper and other electrically conductive materials can be cut.

Included in delivery:
Original equipment kit (consumable parts, tools) and filter pressure regulator

All CUTi inverters operate with gas-cooled plasma torches and external compressed air supply. The CUTi 35C is additionally equipped with an integrated compressor.

Due to the sinusoidal power consumption with PFC (power factor correction), the inverter CUTi 35 draws its maximum power from the single-phase 230 V mains.


CUTi series stands for mobility in practice

**Advantages**

- Light, portable, easy to handle
- Productive due to high cutting speed
- Energy saving due to modern inverter technique
- High cut quality
- Versatile use due to a large variety of accessories
- Safe working due to safety shut-down, also at workplaces with increased electrical endangerment
- Maintenance unit for trouble-free cutting

## CUTLINE – Strong and reliable

The robust units of the CUTLINE series cut all electrically conductive materials with the plasma gas air and the liquid-cooled plasma torches PHT.

**Advantages**

- Low operating costs with liquid-cooled plasma torches
- Low material loss and reduced toxic emissions due to narrow kerfs
- Cut surfaces usable on both sides
- Plasma gouging without after-treatment
- Cutting start from the outside with burning pilot arc


CUTLINE series with liquid-cooled plasma torches

## Application Areas

Plasma gouging does not require after-treatment and produces less smoke compared to gouging with carbon electrodes.

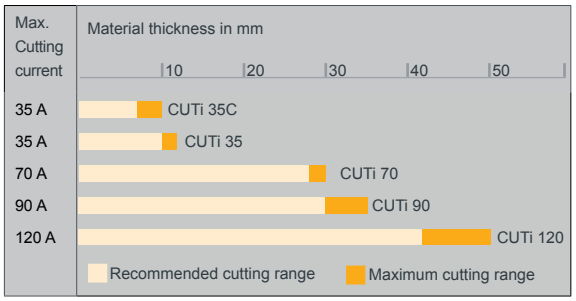
### Suitable for industry and craft

- In workshops and training centres
- For repairing and servicing
- At assembly workplaces, on construction sites

### Application areas of the manual units

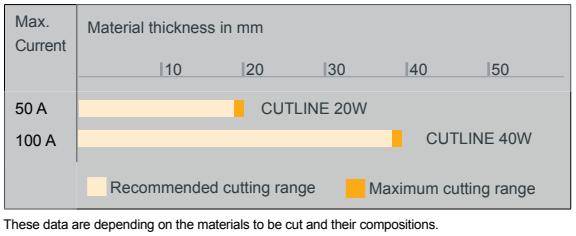
- Straight, profile and contour cutting, also with templates
- For piercing and hole cutting
- Bevel cutting at any angle for weld preparation, possible with appropriate accessories
- Plasma gouging in preparation of weld joints, fettling, removal of welding mistakes and surface deffects with CUTLINE, CUTi 90 and CUTi 120

## Cutting Ranges CUTi




These data are depending on the materials to be cut and their compositions.

## Cutting Ranges CUTLINE




These data are depending on the materials to be cut and their compositions.

## Convenient Hand Torches

Thanks to the ergonomic handle design and the low weight of the KjellCut plasma torches work is easy. In addition to the convenient operation, safety is also of prime importance here.

A switch-on protection prevents the unwanted ignition of the plasma arc.

Ergonomically designed plasma hand torch KjellCut

## Accessories for CUTi and CUTLINE

A large variety of accessories is available for the flexible use of the CUTi and CUTLINE units.

Contact cap

Spacer spring

Bevelling cap

Bevel cutting device

Wheel guide

Circle cutting device

Template cuts

Long consumables

# Technical Data

## CUTi Series

| | CUTi 35C | CUTi 35 | CUTi 70 | CUTi 90 | CUTi 120 |
|---|---|---|---|---|---|
| Mains voltage | 1 x 230 V | 1 x 230 V | 3 x 400 V | 3 x 400 V | 3 x 400 V |
| Fuse, slow | 16 A | 16 A | 16 A | 25 A | 32 A |
| Connected load, max. | 3.3[4.8[1]] kVA | 3.7 kVA | 11.1 kVA | 15 kVA | 16.7 kVA |
| Protection class | IP 23 | IP 21 | IP 21 | IP 21 | IP 23 |
| Cutting current | 12-25 [35[1]] A | 5-35 A | 26-70 A | 26-90 A | 25-120 A |
| Duty cycle | 25 % I 35 A<br>35 % I 25 A<br>100 % I 20 A | 40 % I 35 A<br>60 % I 28 A<br>100 % I 22 A | 35 % I 70 A<br>60 % I 60 A<br>100 % I 50 A | 40 % I 90 A<br>60 % I 74 A<br>100 % I 55 A | 35 % I 120 A<br>60 % I 95 A<br>100 % I 80 A |
| Cutting range | 6[10[1]] mm | 12 mm | 30 mm | 35 mm | 50 mm |
| Ignition | Drawn arc | Drawn arc | High voltage | High voltage | High voltage |
| Plasma gas | Air | Air | Air | Air | Air |
| Pressure | 0.4 MPa[1] | 0.4 MPa | 0.5 MPa | 0.5 MPa | 0.5 MPa |
| Air consumption | 115 l/min | 70 l/min | 140 l/min | 195 l/min | 195 l/min |
| Dimensions (L x W x H) | 550 x 150 x 245 mm | 480 x 150 x 225 mm | 470 x 180 x 250 mm | 470 x 180 x 270 mm | 610 x 230 x 410 mm |
| Weight | 12.5 kg | 10 kg | 16.4 kg | 17 kg | 28.5 kg |

[1] With external compressed air supply

## CUTLINE Series

| | CUTLINE 20W | CUTLINE 40W |
|---|---|---|
| Mains voltage | 3 x 230/400 V | 3 x 400 V |
| Fuse, slow | 32/25 A | 32 A |
| Connected load, max. | 16 kVA | 24 kVA |
| Protection class | IP 22 | IP 22 |
| Cutting current | 25/50 A | 50/100 A |
| Duty cycle | 60 % | 60 % |
| Cutting range | 20 mm | 40 mm |
| Ignition | High voltage | High voltage |
| Plasma gas | Air | Air |
| Cooling | Kjellfrost | Kjellfrost |
| Pressure | 0.5 MPa | 0.5 MPa |
| Air consumption | 25 l/min | 25 l/min |
| Dimensions (L x W x H) | 670 x 490 x 880 mm | 820 x 490 x 880 |
| Weight | 84 kg | 132 kg |

Kjellberg Finsterwalde Group

Welding Electrodes
Welding Equipment
Cutting Equipment
Mechanical Engineering

**Kjellberg Finsterwalde Plasma und Maschinen GmbH**

Oscar-Kjellberg-Str. 20 | 03238 Finsterwalde | Germany
Phone.: +49 3531 500-0 I Fax: +49 3531-8510
plasma@kjellberg.de I www.kjellberg.de

The plasma cutting units are CE conform and meet the current European CE directives. The development and manufacture takes place according to the following standards: EN 60974 (VDE 0544). All Kjellberg plasma cutting units have the S sign and are therefore applicable in workplaces with increased electrical endangerment. The manufacture takes place according to DIN EN ISO 9001. Our in-house quality management includes individual testing proved by certificates and product-related test records.

Our products represent a high level of quality and reliability. We reserve the right to change the design and/or technical specification during the serial production. Claims of any kind cannot be derived from this brochure.



13-12-02