

Automated Plasma Cutting



Auto-Cut™ 200₂

Automated Plasma Cutting System

Specifications (subject to change without notice)

Rated Output	200 Amps
Output Range (A)	10 - 200 Amps
Output (V)	80 - 180 VDC
Input Volts	208-230/460V, 3 ph, 50-60 Hz, 400V, 3 ph, 50-60 Hz, 600V, 3 ph, 50-60 Hz
Input Amps @ Rated Output	130A @ 208V 125A @ 230V 77A @ 400V 75A @ 460V 58A @ 600V
Duty Cycle (@ 104° F / 40° C)	100% @ 200A @ 180V (36kW)
MAX OCV	380 VDC
Plasma Gas	Air, O ₂ , Ar-H ₂ , N ₂ @ 120 psi (8.3 bar)
Shield Gas	Air, N ₂ @ 120 psi (8.3 bar), H ₂ O @ 10 GPH (0.6 liters/min.)
Weight	Power Supply – 433 lbs. (197kg) Torch Assy & Mounting Tube – 3 lbs. (1.3kg) Lead Set (15 ft./4.6m) – 12 lbs. (5.4kg) Torch Leads (per ft.) – 0.8 lb. (0.36kg)
Dimensions	41.5" (1054 mm) H x 27.5" (700 mm) W x 38.5" (978 mm) D (Fully Assembled Power Supply)
Warranty	Two Years Power Supply & One Year Torch
Certifications	CE, CCC

AUTO-CUT™ 200₂ Automated Systems include:

- 200A Power Supply
- XT™ - 301 Torch and leads
- Torch Parts Kit
- GCM-2000
- RAS-1000

Options & Accessories:

- Spare Parts Kit
- Wheel Kit

For complete ordering information contact Thermal Dynamics or your local Thermal Dynamics Automation Distributor.

DISTRIBUTED BY:

Cutting Speed Chart

This cutting speed chart includes preliminary data and is subject to change without notice

Torch Model		XT™-301					
Production Piercing & Cutting Capacity		1" (25 mm)					
Maximum Piercing & Cutting Capacity		1.5" (38 mm)					
Maximum Edge Start		2" (50 mm)					
Material	Thickness Inch	Speed IPM	Amps	Plasma/Shield	Thickness mm	Speed mm/min.	
Mild Steel							
	21 ga.	500	55	Air/Air	1	11500	
	10 ga.	190			3	5460	
	3/16	130			5	3180	
	21 ga.	600	55	O ₂ /Air	1	14040	
	10 ga.	180			3	5830	
	3/16	120			5	2920	
	1/4	150	100	Air/Air	6	4150	
	3/8	85			10	2120	
	1/2	75			12	1960	
	3/4	30			20	720	
	1	20			25	520	
	1/4	130	100	O ₂ /Air	6	3610	
	1/2	57			12	1580	
	3/4	25			20	580	
	1	10			25	280	
	3/8	130	200	Air/Air	10	3190	
	1/2	100			12	2710	
	3/4	60			20	1430	
	1	35			25	920	
	3/8	160	200	O ₂ /Air	10	390	
	1/2	125			12	340	
	3/4	75			20	180	
	1	50			25	130	
	1 1/4	30			35	80	
Stainless Steel							
	16 ga.	350	55	Air/Air	1.5	9750	
	10 ga.	100			4	2180	
	3/16	60			5	1450	
	1/4	100	100	Air/Air	6	3020	
	3/8	65			10	1580	
	1/2	45			12	1260	
	1/4	60	100	N ₂ /H ₂ O	6	1750	
	3/8	50			10	1210	
	1/2	35			12	970	
	3/8	50	100	Ar-H ₂ /N ₂	10	1220	
	1/2	37			12	1010	
Aluminum							
	16 ga.	400	55	Air/Air	2	8790	
	3/16	100			5	2360	
	1/4	100	100	Air/Air	6	2650	
	1/2	45			12	1310	
	3/4	35			20	890	
	1/4	60	100	N ₂ /H ₂ O	6	1640	
	3/8	50			10	1210	
	1/2	35			12	970	
	3/8	60	100	Ar-H ₂ /N ₂	10	1450	
	1/2	40			12	1130	

Note: Take care in comparison. The speeds noted above are best cut speeds. Often, competitors show maximum cutting speeds. Although much higher speeds can be achieved, edge quality and bevel angle may be compromised. The capabilities shown in this table were obtained by using new consumables, correct gas and current settings, accurate torch height control and with the torch perpendicular to the workpiece. The operating chart does not list all processes available for the Auto-Cut 200₂. Please contact Thermal Dynamics for more information.

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THERMAL DYNAMICS



AUTOMATION

Auto-Cut 200₂

Automated Plasma Cutting System

- **MaximumLife™ Consumables - Best Parts Life in its Class**
- **High Speed Oxygen Cutting**
- **XT™-301 Torch**
- **Water Mist Secondary (WMS™)**



Automated Plasma Cutting System

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Auto-Cut™ 200₂

Automated Plasma Cutting System

Quality

- Excellent, virtually dross-free cuts using Oxygen (O₂) plasma.
- Unmatched cut quality on non-ferrous materials to 3/4" (20 mm) using our unique Water Mist Secondary system (WMS™)

Ease of Use

- Fast and easy installation.
- Simple set-up and user-friendly gas console.
- Quick-change, consumable design.
- Easy to identify and troubleshoot problems.

Productivity

- Highest cut speed in its class.
- Best parts life in its class.
- Reduced downtime during parts changes due to the revolutionary cartridge design of the XT-301 torch.

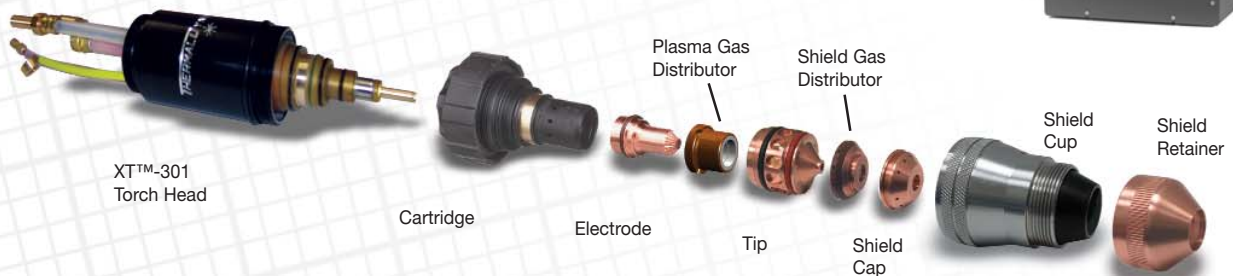
Technology

- Microprocessor controlled to produce the best cut quality every cut.
- Fiber optic communication means less HF interference.
- Precision torch design for the best cut quality in its class.

Reliability

- Advanced testing in lab and field trials ensures ongoing performance and reliability.

XT™ Torch Technology for Maximum Performance



Auto-Cut 200₂
Power Supply

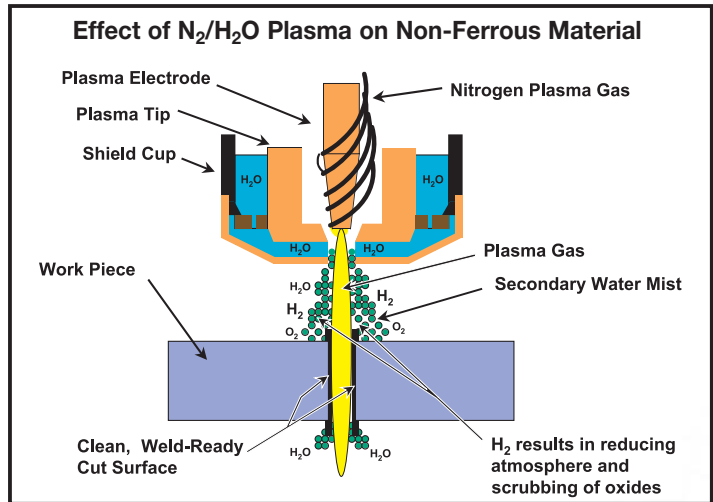
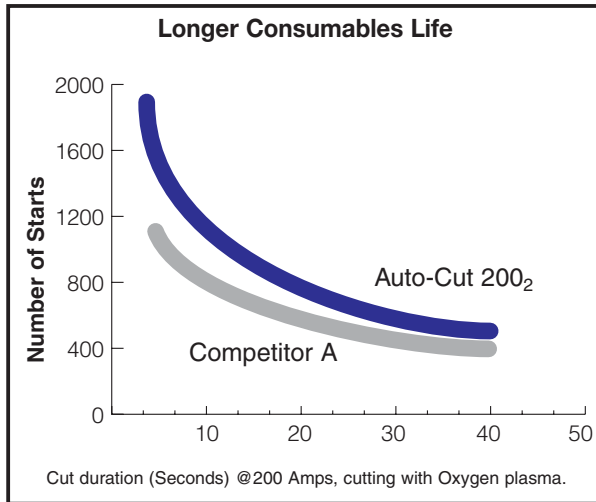


GCM-2000
Gas Control
Console



RAS-1000
Remote Arc
Starter

XT™-301 Torch Technology



Thermal Dynamics' patented XT™ Torch Technology delivers productivity and performance you can measure.

- Keyless Consumable Cartridge for Rapid Process Changes
- Precision Construction Insuring Accurate Re-Centering of Consumable Cartridge After Parts Change
- Rapid Engagement Retaining Collar Threads
- Spring Loaded Leak-Less Coolant Tube Design

Water Mist Secondary (WMS™) optimizes non-ferrous cutting.

WMS delivers excellent cut quality on non-ferrous materials with low cost of operation by using N₂ as plasma gas and ordinary tap water as the secondary. A reducing atmosphere is produced in the cut by the release of hydrogen from the secondary water. This reducing atmosphere decreases oxidation on the cut face surface. WMS is recommended for materials up to 3/4" (20 mm) thick.

Competitive Comparison

Thermal Dynamics' patented XT Torch Consumable Technology is ideal for cutting from gauge (1.5 mm) to 1 inch (25 mm). Excellent quality cuts will be achieved on both ferrous and non-ferrous materials at higher speeds.

- Small Heat Affected Zone, Smooth Cutting Edge Surface
- Wide, Virtually Dress-free Parameter Windows
- Higher Arc Density for Faster Cut Speeds



3/4" (20 mm) Mild Steel Cut

