



***Torch and Consumables  
Cross-reference Guide  
for Mechanized Systems***

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## ***How to use this Guide***

This cross-reference guide includes all the relevant information for our mechanized system torches and consumables in one, easy-to-use reference. We hope that it will help channel partners provide correct information to their customers who may be using a system that is no longer being sold or who may not know which parts are needed for specific applications.

The table of contents lists the first page of the section dealing with a particular system. It includes a picture of the system (if available) to help customers who cannot recall which system they are using. It also includes the name of the torch.










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# Hypertherm®

## HyPerformance™ Plasma

### HPR260™

### Consumables



HPR260



HPR260 torch

#### Mild steel

	Shield cap	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
<b>30 A</b>	220173	220194	220313	220193	220180	220192-Standard
<b>50 A</b>	220173	220555	220313	220554	220553	220552-Standard
<b>80 A</b>	220173	220189	220176	220188	220179	220187-Standard
<b>130 A</b>	220173	220183	220176	220182	220179	220181-Standard 220665-SilverPlus
<b>200 A</b>		220356	220355	220354	220353	220352-Standard 220666-SilverPlus
<b>260 A</b>	220398	220440	220433	220439	220436	220435-Standard 220668-SilverPlus
<b>130 A bevel</b>	220398	220645	220603	220646	220179	220649
<b>260 A bevel</b>	220398	220545	220603	220542	220436	220541

#### Stainless steel

	Shield cap	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
<b>45 A</b>	220173	220202	220304	220201	220180	220308
<b>80 A</b>	220173	220338	220304	220337	220179	220339
<b>130 A</b>	220173	220198	220304 (H35) 220176 (N <sub>2</sub> )	220197	220179	220307
<b>200 A</b>		220345	220344	220343	220342	220307
<b>260 A</b>	220398	220407	220344	220406	220405	220307
<b>130 A bevel</b>	220398	220609	220608	220656	220179	220606
<b>260 A bevel</b>	220398	220609	220608	220607	220405	220606

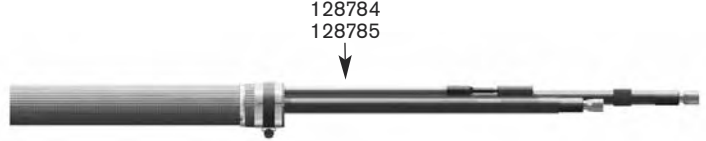
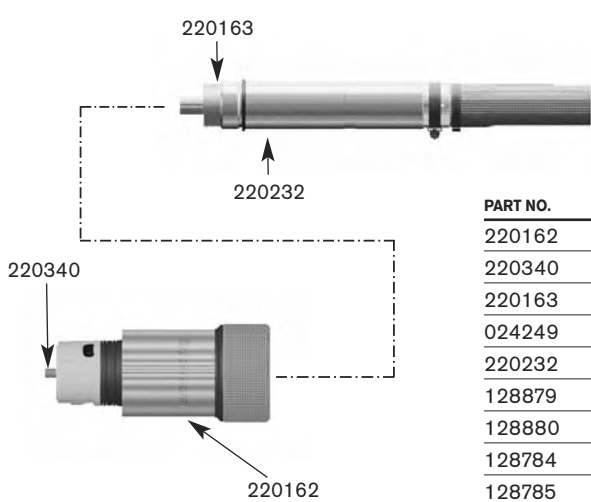
#### Aluminum

	Shield cap	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
<b>45 A</b>		220202	220176	220201	220180	220308
<b>130 A</b>	220173	220198	220304 (H35) 220176 (Air)	220197	220179	220307 (H35) 220181 (Air)
<b>200 A</b>		220345	220347	220346	220342	220307
<b>260 A</b>	220398	220407	220344	220406	220405	220307

# HPR260 consumables

MATERIAL	CONSUMABLE DESCRIPTION	Bevel cutting								
		260 A	200 A	130 A	80 A	50 A	45 A	30 A	130 A	260 A
Mild steel	Standard electrode	220435	220352	220181	220187	220552	-----	220192	220649	220541
	SilverPlus electrode	220668	220666	220665	-----	-----	-----	-----	-----	-----
	Swirl ring	220436	220353	220179	220179	220553	-----	220180	220179	220436
	Nozzle	220439	220354	220182	220188	220554	-----	220193	220646	220542
	Inner retaining cap	220433	220355	220176	220176	220313	-----	220313	220603	220603
	Shield	220440	220356	220183	220189	220555	-----	220194	220645	220545
	Shield cap	220398	220398	220173	220173	220173	-----	220173	220398	220398
Stainless steel	Electrode	220307	220307	220307	220339	-----	220308	-----	220606	220606
	Swirl ring	220405	220342	220179	220179	-----	220180	-----	220179	220405
	Nozzle	220406	220343	220197	220337	-----	220201	-----	220656	220607
	Inner retaining cap	220344	220344	220304 (H35)	220304	-----	220304	-----	220608	220608
	-----	-----	-----	220176 (N <sub>2</sub> )	-----	-----	-----	-----	-----	-----
	Shield	220407	220345	220198	220338	-----	220202	-----	220609	220609
	Shield cap	220398	220398	220173	220173	-----	220173	-----	220398	220398
Aluminum	Electrode	220307	220307	220307 (H35)	-----	-----	220308	-----	-----	-----
	-----	-----	-----	220181 (Air)	-----	-----	-----	-----	-----	-----
	Swirl ring	220405	220342	220179	-----	-----	220180	-----	-----	-----
	Nozzle	220432	220346	220197	-----	-----	220201	-----	-----	-----
	Inner retaining cap	220344	220347	220304 (H35)	-----	-----	220176	-----	-----	-----
	-----	-----	-----	220176 (Air)	-----	-----	-----	-----	-----	-----
	Shield	220407	220345	220198	-----	-----	220202	-----	-----	-----
Shield cap	220398	220398	220173	-----	-----	220173	-----	-----	-----	

## HyPerformance Plasma HPR260 torch assembly



PART NO.	DESCRIPTION
220162	Quick-disconnect torch
220340	Water tube with O-Ring
220163	Quick-disconnect receptacle
024249	Insulating sleeve
220232	Torch mounting sleeve assembly
128879	Torch kit: Bullet plugs, O-Rings, water tube and seal (not shown)
128880	Quick-disconnect kit: O-Ring and connector (not shown)
128784	25' (7.5 m) Leads
128785	50' (15 m) Leads
220700	Bevel water tube (mild steel – 130 A)
220571	Bevel water tube (stainless steel – 130/260 A)



# Hypertherm®

## HyPerformance™ Plasma

### HPR130™

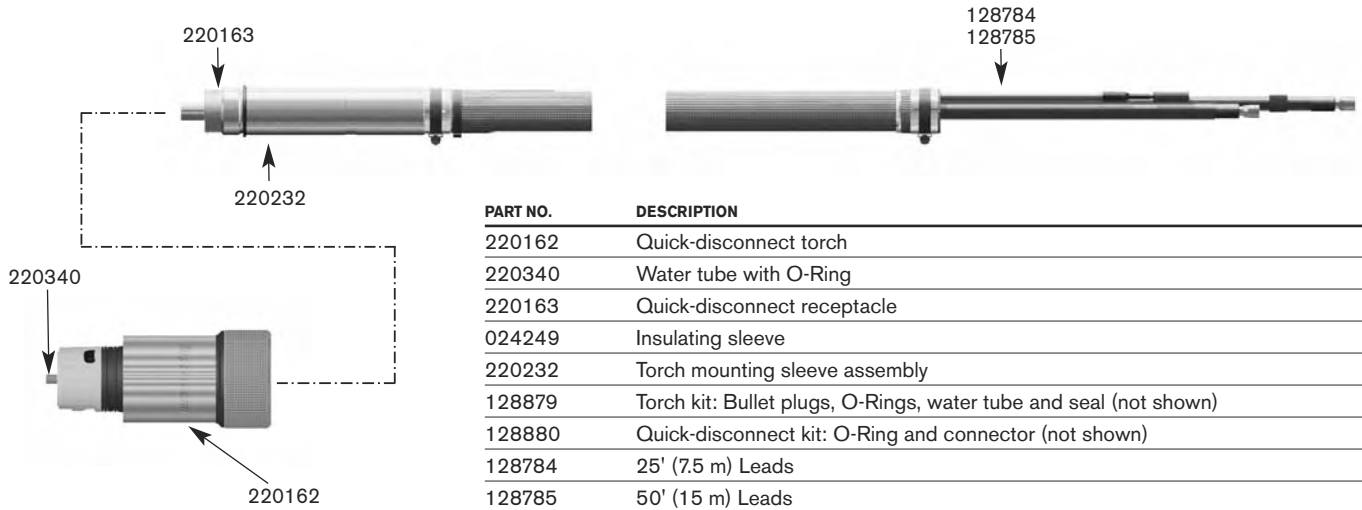
## Consumables



	Shield cap	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
<b>Mild steel</b>						
<b>30 A</b>	220173	220194	220313	220193	220180	220192-Standard
<b>50 A</b>	220173	220555	220313	220554	220553	220552-Standard
<b>80 A</b>	220173	220189	220176	220188	220179	220187-Standard
<b>130 A</b>	220173	220183	220176	220182	220179	220181-Standard 220665-SilverPlus
<b>130 A bevel</b>	220398	220645	220603	220646	220179	220649
<b>Stainless steel</b>						
<b>45 A</b>	220173	220202	220304	220201	220180	220308
<b>80 A</b>	220173	220338	220304	220337	220179	220339
<b>130 A</b>	220173	220198	220304 (H35) 220176 (N <sub>2</sub> )	220197	220179	220307
<b>130 A bevel</b>	220398	220609	220608	220656	220179	220606
<b>Aluminum</b>						
<b>45 A</b>		220202	220304	220201	220180	220308
<b>130 A</b>	220173	220198	220304 (H35) 220176 (Air)	220197	220179	220307 (H35) 220181 (Bevel cutting)

MATERIAL	CONSUMABLE DESCRIPTION	130 A	80 A	50 A	45 A	30 A	Bevel cutting 130 A
Mild steel	Standard electrode	220181	220187	220552	-----	220192	220649
	SilverPlus electrode	220655	-----	-----	-----	-----	-----
	Swirl ring	220179	220179	220553	-----	220180	220179
	Nozzle	220182	220188	220554	-----	220193	220646
	Inner retaining cap	220176	220176	220313	-----	220313	220603
	Shield	220183	220189	220555	-----	220194	220645
	Shield cap	220173	220173	220173	-----	220173	220398
Stainless steel	Electrode	220307	220339	-----	220308	-----	220606
	Swirl ring	220179	220179	-----	220180	-----	220179
	Nozzle	220197	220337	-----	220201	-----	220656
	Inner retaining cap	220304 (H35) 220176 (N <sub>2</sub> )	220304	-----	220304	-----	220608
	Shield	220198	220338	-----	220202	-----	220609
	Shield cap	220173	220173	-----	220173	-----	220398
Aluminum	Electrode	220307 (H35) 220181 (Air)	-----	-----	220308	-----	-----
	Swirl ring	220179	-----	-----	220180	-----	-----
	Nozzle	220197	-----	-----	220201	-----	-----
	Inner retaining cap	220304 (H35) 220176 (Air)	-----	-----	220304	-----	-----
	Shield	220198	-----	-----	220202	-----	-----
	Shield cap	220173	-----	-----	220173	-----	-----

# HyPerformance Plasma HPR130 Torch Assembly



PART NO.	DESCRIPTION
220162	Quick-disconnect torch
220340	Water tube with O-Ring
220163	Quick-disconnect receptacle
024249	Insulating sleeve
220232	Torch mounting sleeve assembly
128879	Torch kit: Bullet plugs, O-Rings, water tube and seal (not shown)
128880	Quick-disconnect kit: O-Ring and connector (not shown)
128784	25' (7.5 m) Leads
128785	50' (15 m) Leads
220700	Bevel water tube (mild steel – 130 A)
220571	Bevel water tube (stainless steel – 130/260 A)

# Hypertherm®

## HyPerformance® HD4070®

### Consumables



HD4070



HyPerformance HD4070 torch

### Mild steel

	Retaining cap	Shield	Inner retaining cap	Nozzle	Swirl ring	Electrode
30A		220194	220313	220193	220180	220192
50A	220173	220555	220313	220554	220553	220552
80A		220189	220176	220188	220179	220187
130A		220183	220176	220182	220179	220181
200A	220398	220356	220355	220354	220353	220352

### Stainless steel

	Retaining cap	Shield	Inner retaining cap	Nozzle	Swirl ring	Electrode
45A		220202	220304	220201	220180	220308
80A	220173	220338	220304	220337	220179	220339
130A		220198	220304	220197	220179	220307
200A	220398	220345	220344	220343	220342	220307

### Aluminum

	Retaining cap	Shield	Inner retaining cap	Nozzle	Swirl ring	Electrode
45A		220202	220176	220201	220180	220308
130A	220173	220198	220304	220197	220179	220307
200A	220398	220345	220347	220346	220342	220307

## HyPerformance HD4070 consumables

MATERIAL	CONSUMABLE DESCRIPTION	200 AMPS	130 AMPS	80 AMPS	50 AMPS	45 AMPS	30 AMPS
Mild steel	Electrode	220352	220181	220187	220552	-----	220192
	Swirl ring	220353	220179	220179	220553	-----	220180
	Nozzle	220354	220182	220188	220554	-----	220193
	Inner retaining cap	220355	220176	220176	220313	-----	220313
	Shield	220356	220183	220189	220555	-----	220194
	Shield cap	220398	220173	220173	220173	-----	-----
	-----	-----	-----	-----	-----	-----	-----
Stainless steel	Electrode	220307	220307	220339	-----	220308	-----
	Swirl ring	220342	220179	220179	-----	220180	-----
	Nozzle	220343	220197	220337	-----	220201	-----
	Inner retaining cap	220344	220304 (H35) ----- 220176 (N <sub>2</sub> )	220304	-----	220304	-----
	Shield	220345	220198	220338	-----	220202	-----
	Shield cap	220398	220173	220173	-----	220173	-----
	-----	-----	-----	-----	-----	-----	-----
Aluminum	Electrode	220307	220307 (H35) ----- 220181 (Air)	-----	-----	220308	-----
	Swirl ring	220342	220179	-----	-----	220180	-----
	Nozzle	220346	220197	-----	-----	220201	-----
	Inner retaining cap	220347	220304 (H35) ----- 220176 (Air)	-----	-----	220176	-----
	Shield	220345	220198	-----	-----	220202	-----
	Shield cap	220398	220173	-----	-----	220173	-----
	-----	-----	-----	-----	-----	-----	-----

## HyPerformance HD4070 Plasma torch assembly

PART NO.	DESCRIPTION
220162	Quick-disconnect torch
220340	Water tube with O-Ring
220163	Quick-disconnect receptacle
220516	Torch mounting sleeve
128879	Torch kit: Bullet plugs, O-Rings, water tube and seal
128880	Quick-disconnect kit: O-Ring and connector

### RETROFIT KITS:

PART NO.	DESCRIPTION
128943	Kit:HPR/HD4070 Upgrade with 6' torch leads
128944	Kit:HPR/HD4070 Upgrade with 10' torch leads
128945	Kit:HPR/HD4070 Upgrade with 15' torch leads

# Hypertherm®

## HyPerformance® HD3070®

### Consumables



HD3070



HyperPerformance HD3070 torch

### Mild steel

	Retaining cap	Shield	Inner retaining cap	Nozzle	Swirl ring	Electrode
30A						
		220194	220313	220193	220180	220192
50A						
		220555	220313	220554	220553	220552
80A						
		220189	220176	220188	220179	220187
100A						
		220183	220176	220510	220179	220181

### Stainless steel

	Retaining cap	Shield	Inner retaining cap	Nozzle	Swirl ring	Electrode
45A						
		220202	220304	220201	220180	220308
70A						
		220189	220176	220188	220179	220187
80A						
		220338	220304	220337	220179	220339
100A						
		220627	220644	220626	220640	220641

### Aluminum

	Retaining cap	Shield	Inner retaining cap	Nozzle	Swirl ring	Electrode
45A						
		220202	220176	220201	220180	220308
70A						
		220189	220176	220188	220179	220187
100A						
		220627	220664	220626	220640	220641

## HyPerformance HD3070 consumables

MATERIAL	CONSUMABLE DESCRIPTION	100 AMPS	80 AMPS	70 AMPS	50 AMPS	45 AMPS	30 AMPS
Mild steel	Electrode	220181	220187	-----	220552	-----	220192
	Swirl ring	220179	220179	-----	220553	-----	220180
	Nozzle	220510	220188	-----	220554	-----	220193
	Inner retaining cap	220176	220176	-----	220313	-----	220313
	Shield	220183	220189	-----	220555	-----	220194
	Shield cap	220173	220173	-----	220173	-----	-----
Stainless steel	Electrode	220641	220339	220187	-----	220308	-----
	Swirl ring	220640	220179	220179	-----	220180	-----
	Nozzle	220626	220337	220188	-----	220201	-----
	Inner retaining cap	220644	220304	220176	-----	220304	-----
	Shield	220627	220338	220189	-----	220202	-----
	Shield cap	220173	220173	220173	-----	220173	-----
Aluminum	Electrode	220641	-----	220187	-----	220308	-----
	Swirl ring	220640	-----	220179	-----	220180	-----
	Nozzle	220626	-----	220188	-----	220201	-----
	Inner retaining cap	220644	-----	220176	-----	220176	-----
	Shield	220627	-----	220189	-----	220202	-----
	Shield cap	220173	-----	220173	-----	220173	-----

## HyPerformance HD3070 Plasma torch assembly

PART NO.	<None>DESCRIPTION
220162	Quick-disconnect torch
220340	Water tube with O-Ring
220163	Quick-disconnect receptacle
220624	Torch mounting sleeve
128879	Torch kit: Bullet plugs, O-Rings, water tube and seal
128880	Quick-disconnect kit: O-Ring and connector

RETROFIT KIT:	
PART NO.	DESCRIPTION
228132	Kit: HPR/HD3070 upgrade

# Hypertherm®

## HySpeed® HT4400®

### Machine torch parts

#### HT4400 consumables



HySpeedHT4400 with accessories



HT4400 torch

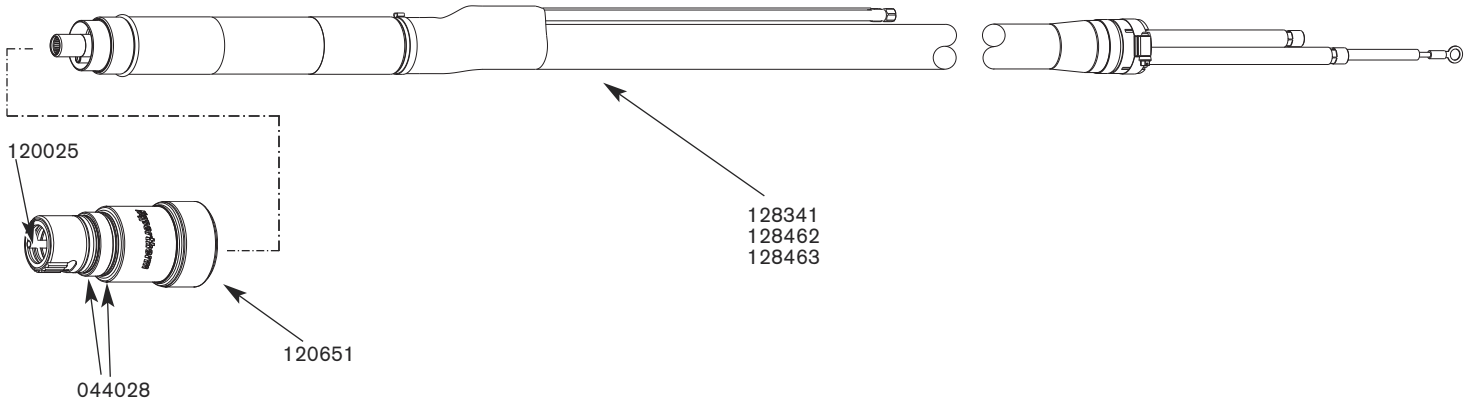
	Retaining cap	Nozzle	Swirl ring	Electrode	
<b>Oxygen plasma</b>					
<b>400 Amp</b>	120786 120907 (With IHS Tab) 120984 (Underwater)	120934 120935 (CCW)	120939 120940 (CCW)	120810 - Standard 220412 - SilverPlus	
<b>300 Amp</b>	120786 120907 (With IHS Tab) 120984 (Underwater)	120794 120795 (CCW)	120913 120914 (CCW)	120802 - Standard 220412 - SilverPlus	
<b>200 Amp</b>	120786 120907 (With IHS Tab) 120984 (Underwater)	120787 120788 (CCW)	120791 120792 (CCW)	120793	
<b>100 Amp</b>	120786 120907 (With IHS Tab) 120984 (Underwater)	120777 120778 (CCW)	120783 120784 (CCW)	120785	
<b>Nitrogen plasma</b>					
<b>400 Amp</b>	120786 120907 (With IHS Tab) 120984 (Underwater)	120856 120857 (CCW)	120853 120854 (CCW)	120855	
<b>200 Amp</b>	120786 120907 (With IHS Tab) 120984 (Underwater)	120794 120795 (CCW)	120853 120854 (CCW)	120855	

APPLICATION	PLASMA GAS	CONSUMABLE DESCRIPTION	400 AMPS BEVEL	400 AMPS	300 AMPS	200 AMPS	100 AMPS
CUTTING	Oxygen	Electrode - Standard	120810*	120810*	120802*	120793**	120785**
		Electrode - SilverPlus	220412	220412	220412	-----	-----
		Swirl ring	120939	120939	120913	120791	120783
		Nozzle	120934	120934	120794	120787	120777
		Retaining cap	120786	120786	120786	120786	120786
		Retaining cap (with IHS tab)	120907	120907	120907	120907	120907
		Retaining cap (underwater)	120984	120984	120984	120984	120984
	Nitrogen	Electrode	-----	120855	-----	120855	-----
		Swirl ring	-----	120853	-----	120853	-----
		Nozzle	-----	120856	-----	120794	-----
		Retaining cap	-----	120786	-----	120786	-----
		Retaining cap (underwater)	-----	120984	-----	120984	-----
Cutting with counterclockwise gas swirl (substitute designated parts)	Oxygen	Swirl ring	120940	120940	120914	120792	120784
		Nozzle	120935	120935	120795	120788	120778
	Nitrogen	Swirl ring	-----	120854	-----	120854	-----
		Nozzle	-----	120857	-----	120795	-----

\* CoolCore™ technology

\*\* HyLife® technology

## HT4400 torch assembly



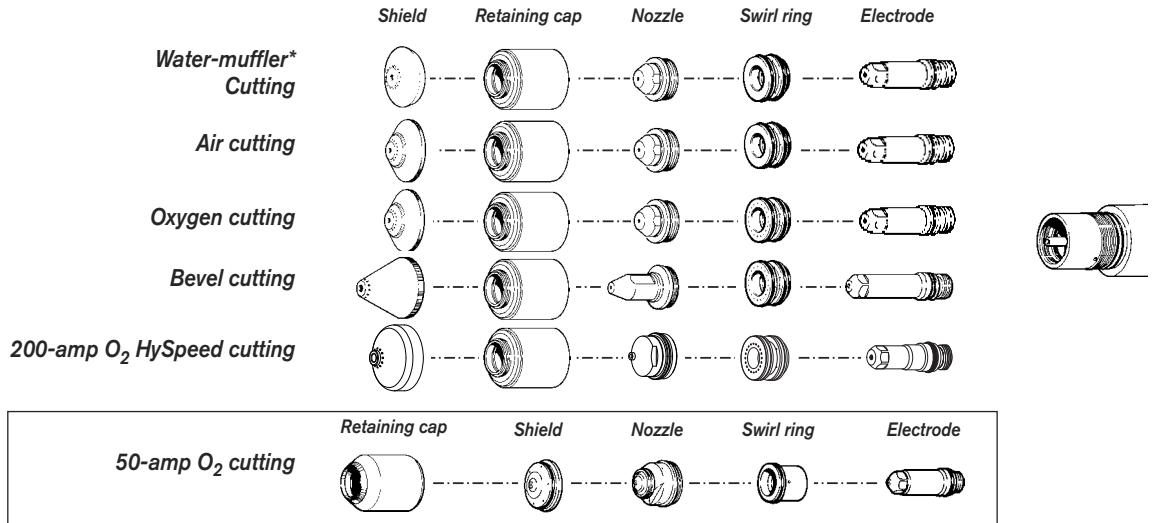
PART NO.	DESCRIPTION
120651	HT4400 torch main body
128462	HT4400 torch adapter with 6' leads
128463	HT4400 torch adapter with 10' leads
128341	HT4400 torch adapter with 15' leads
128430	HT4400 torch assembly with 6' leads
128431	HT4400 torch assembly with 10' leads
128342	HT4400 torch assembly with 15' leads
120025	Water cooling tube
044028	O-ring



# Hypertherm®

## HySpeed® HT2000®

### Consumables



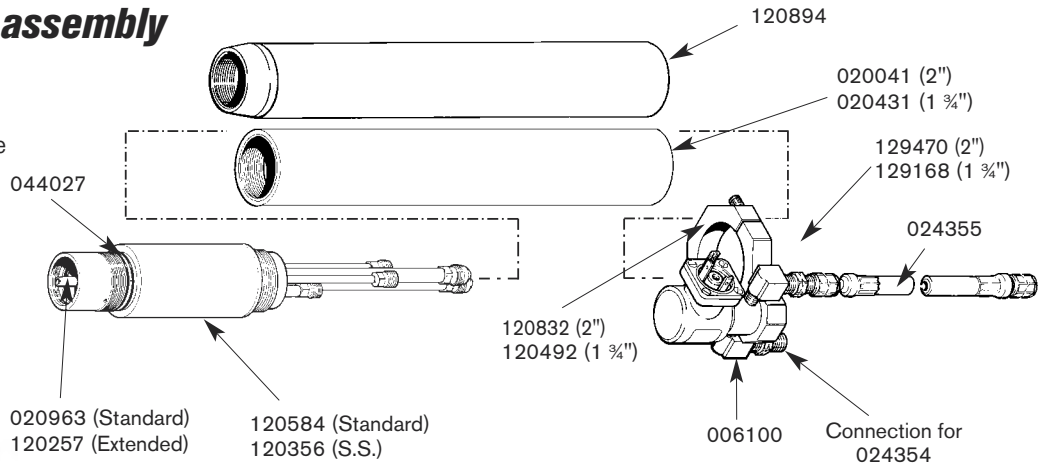
		PART NUMBER							
APPLICATION	PLASMA GAS	CONSUMABLE DESCRIPTION	200 AMP HySpeed	200 AMP BEVEL	200 AMPS	100 AMPS	50 AMPS	40 AMPS	
<b>CUTTING</b>	Oxygen	Electrode	220235	120258	120667	120547	120178	-----	
		Electrode SilverPlus	-----	-----	220084	-----	-----	-----	
		Swirl Ring	220236	120833	120833	020613	120179	-----	
		Nozzle	220237	120259	020605	020690	120182	-----	
		Retaining Cap*	220238	020423	020423	020423	120185	-----	
		Shield	220239	120260	020424	020424	120186	-----	
		(Water Muffler**) Shield	220295	-----	020566	020566	-----	-----	
		Air	Electrode	-----	-----	120667	120547	-----	120667
			Swirl Ring	-----	-----	020679	020607	-----	020613
			Nozzle	-----	-----	020608	020611	-----	020689
	Retaining Cap*		-----	-----	020423	020423	-----	020423	
	Shield		-----	-----	020424	020448	-----	020688	
	(Water Muffler**) Shield	-----	-----	020566	020618	-----	-----		
	Argon/Hydrogen	Electrode	-----	-----	020415	020415	-----	-----	
		Swirl Ring	-----	-----	020607	020607	-----	-----	
		Nozzle	-----	-----	020608	020611	-----	-----	
		Retaining Cap*	-----	-----	020423	020423	-----	-----	
	Nitrogen	Electrode	-----	-----	020415	-----	-----	-----	
		Swirl Ring	-----	-----	020607	-----	-----	-----	
		Nozzle	-----	-----	020608	-----	-----	-----	
Retaining Cap*		-----	-----	020423	-----	-----	-----		
Shield		-----	-----	020424	-----	-----	-----		
(Water Muffler*) Shield	-----	-----	020566	-----	-----	-----			
Cutting with counterclockwise gas swirl (substitute designated parts)	Oxygen	Swirl Ring	220244	120834	120834	120252	-----	-----	
		Retaining Cap*	220241	020955	020955	020955	-----	-----	
	Air	Swirl Ring	-----	-----	-----	020956	-----	-----	
		Retaining Cap*	-----	-----	-----	020955	-----	-----	
Argon/Hydrogen	Swirl Ring	-----	-----	020956	020956	-----	-----		
	Retaining Cap*	-----	-----	020955	020955	-----	-----		
	Nitrogen	Swirl Ring	-----	-----	020956	-----	-----	-----	
		Retaining Cap*	-----	-----	020955	-----	-----	-----	
<b>GOUGING</b>	Air	Electrode	-----	-----	120667	-----	-----	-----	
		Swirl Ring	-----	-----	020607	-----	-----	-----	
		Nozzle	-----	-----	020615	-----	-----	-----	
		Retaining Cap	-----	-----	020423	-----	-----	-----	
		Shield	-----	-----	020485	-----	-----	-----	
	Argon/Hydrogen	Electrode	-----	-----	020415	-----	-----	-----	
		Swirl Ring	-----	-----	020607	-----	-----	-----	
		Nozzle	-----	-----	020615	-----	-----	-----	
		Retaining Cap	-----	-----	020423	-----	-----	-----	
		Shield	-----	-----	020485	-----	-----	-----	

\* If using the Command THC or other ohmic sensing device, use retaining caps with an IHS tab: for standard cutting -120837 clockwise; 120838 counter clockwise for all cutting currents except 50 A; 120185 for 50 A only. For HySpeed use 220242 clockwise; 220243 counter clockwise.

\*\* Water Muffler cannot be used with 2" 120356 Stainless Steel Torch.

## HySpeed HT2000 torch assembly

- 128381 Standard body, 2" sleeve;
- 128367 Stainless steel body, 2" sleeve
- 128141 Standard body, optional 1 3/4" sleeve



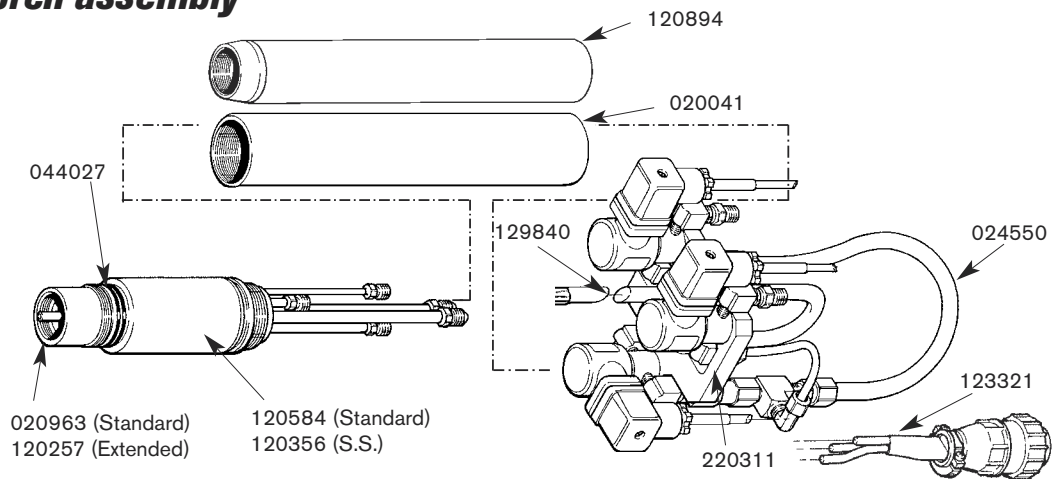
STANDARD BODY PART NO.	DESCRIPTION	STAINLESS STEEL BODY PART NO.
128381	HT2000 Torch Assembly with Valve	128367
120584	MAX200/HT2000 Machine Torch Main Body	120356
020963	Water Tube, Electrode Cooling, Standard	020963
120257	Water Tube, Electrode Cooling, Extended	120257
044027	O-Ring: Buna 70 Duro 1.301 x .070	044027
129470/129168*	HT2000 Off-Valve Assembly	129470
006100	Solenoid Valve, 120# 1/8" FPT	006100
024355	Hose, Off-Valve Assembly to Torch Main Body, 1'	024355
120894/020431	Torch Mounting Sleeve	020041
020407	Adapter: 1 3/4" - 2" Torch Mounting Sleeve	Not Needed
120832/120492**	Valve Mounting Bracket	120832
123185	Torch Off-Valve Cable (not shown)	123185
024354	Hose, Motor-Valve Box to Off-Valve Assembly, 10.25'	024354

\*129168 Off-Valve Assembly is required with the optional 020431 1-3/4" Mounting Sleeve.

\*\* 120492 Valve Mounting Bracket is required with the 020431 Mounting Sleeve.

## HySpeed HT2000LHF torch assembly

- 128255 Standard body - 2" sleeve
- 128369 Stainless steel body - 2" sleeve



STANDARD BODY PART NO.	DESCRIPTION	STAINLESS STEEL BODY PART NO.
128255	HT2000 Torch Assembly with Valve	128369
120584	MAX200/HT2000 Machine Torch Main Body	120356
120894	Torch Mounting Sleeve: 2"	020041
020963	Water Tube: Electrode Cooling, Standard	020963
120257	Water Tube: Electrode Cooling, Extended	120257
044027	O-Ring: Buna 70 Duro 1.301 x .070	044027
024550	Hose, Off-Valve Assembly to Torch Main Body	024550
123321	Cable: HT2000LHF Torch Off-Valve 24"	123321
129290	Off-Valve Sub Assembly	129840
220311	Bracket: HT2000LHF Off-Valve	220311

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# Hypertherm®

## MAX200

### Machine torch parts

#### MAX200 consumables



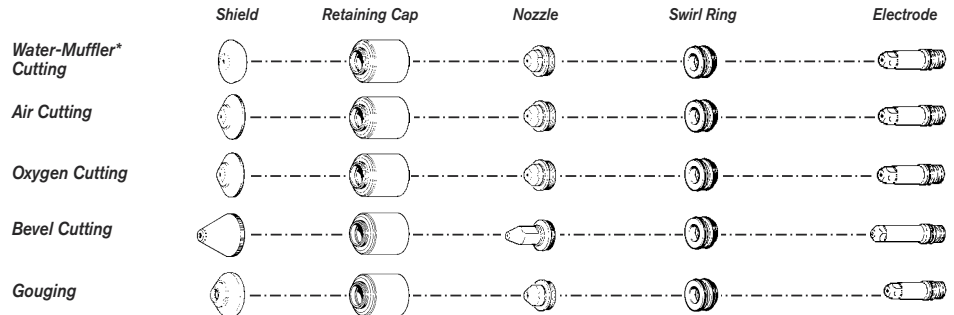
MAX200



128380 - Standard body - 2" sleeve



128365 - Stainless steel body

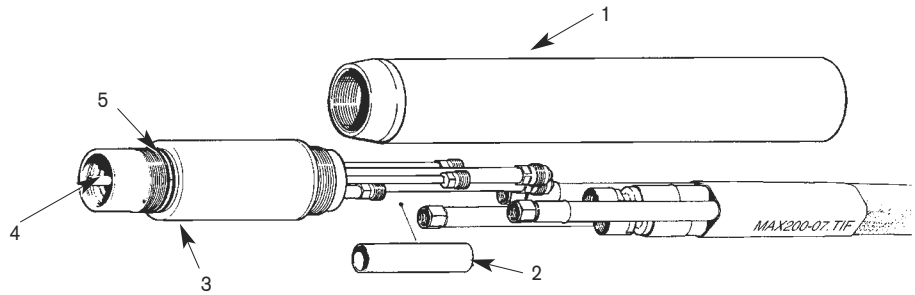


APPLICATION	PLASMA GAS	CONSUMABLE DESCRIPTION	PART NUMBER				QUANTITY PER PACKAGE	
			200 AMP BEVEL	200 AMPS	100 AMPS	40 AMPS		
CUTTING	Oxygen	Electrode-Standard	120258	220021	120547	-----	5	
		Electrode-SilverPlus	-----	220083	-----	-----	5	
		Swirl Ring	120833	020604	020617	-----	1	
		Nozzle	120259	020605	020616	-----	5	
		Retaining Cap	020423	020423	020423	-----	1	
		Retaining Cap, Ohmic	120837	120837	120837	-----	1	
		Shield	120260	020424	020448	-----	1	
		(Water Muffler*)	Shield	-----	020566	020618	-----	1
	Air	Electrode	-----	220021	120547	120667	5	
		Swirl Ring	-----	020607	020607	020613	1	
		Nozzle	-----	020608	020611	020689	5	
		Retaining Cap	-----	020423	020423	020423	1	
		Retaining Cap, Ohmic	-----	120837	120837	120837	1	
		Shield	-----	020424	020448	020688	1	
		(Water Muffler*)	Shield	-----	020566	020618	-----	1
		Argon/Hydrogen	Electrode	-----	020415	020415	-----	5
	Swirl Ring		-----	020607	020607	-----	1	
	Nozzle		-----	020608	020611	-----	5	
	Retaining Cap		-----	020423	020423	-----	1	
	Retaining Cap, Ohmic		-----	120837	120837	-----	1	
Shield	-----		020602	020448	-----	1		
Nitrogen	Electrode		-----	020415	-----	-----	5	
	Swirl Ring		-----	020607	-----	-----	1	
	Nozzle	-----	020608	-----	-----	5		
	Retaining Cap	-----	020423	-----	-----	1		
	Retaining Cap, Ohmic	-----	120837	-----	-----	1		
	Shield	-----	020424	-----	-----	1		
	(Water Muffler*)	Shield	-----	020566	-----	-----	1	
	GOUGING	Air	Electrode	-----	220021	-----	-----	5
Swirl Ring			-----	020607	-----	-----	1	
Nozzle			-----	020615	-----	-----	5	
Retaining Cap			-----	020423	-----	-----	1	
Shield			-----	020485	-----	-----	1	
Argon/Hydrogen			Electrode	-----	020415	-----	-----	5
		Swirl Ring	-----	020607	-----	-----	1	
		Nozzle	-----	020615	-----	-----	5	
		Retaining Cap	-----	020423	-----	-----	1	
		Shield	-----	020485	-----	-----	1	

\* Water muffler cannot be used with 2" 120356 stainless steel torch or with Ohmic height sensing.

# MAX200 machine torch assembly

128380 - Standard body - 2" sleeve  
 128364 - Optional body - 1 3/4" sleeve



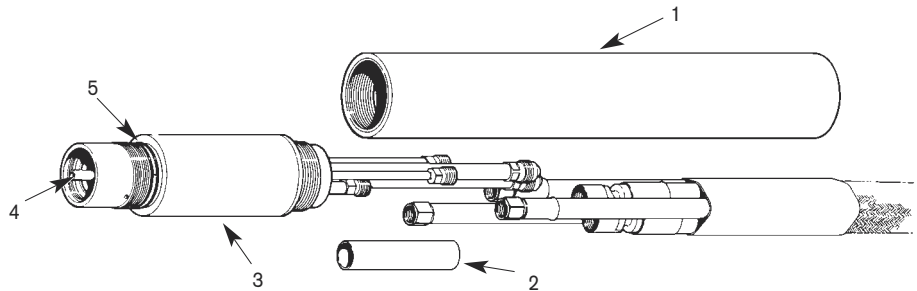
**128380 - Standard body - 2" sleeve**

ITEM NUMBER	STANDARD BODY (2") PART NO.	DESCRIPTION	OPTIONAL BODY (1 3/4") PART NO.
	128380^	MAX200 Machine Torch Assembly	128364
	028383*	Leads, Torch, 25' / 7.6 m	028383
	028384*	Leads, Torch, 50' / 15.2 m	028384
1	120894	Torch Mounting Sleeve	020431
2	020536	Lead Insulator, 5/8 x 2.5"	020536
3	120584	MAX200/HT2000 Machine Torch Main Body	120584
4	020963	Water Tube, Electrode Cooling, Standard	020963
4	120257	Water Tube, Electrode Cooling, Extended	120257
5	044027	O-Ring: Buna 70 Duro 1.301 x .070	044027^

**^ Assembly includes consumables**

\* Other lead lengths available.  
 Consult your Operating Manual.

128365 - Stainless steel body



**128365 - Stainless steel body**

ITEM NUMBER	PART NO.	DESCRIPTION
	128365^	MAX200 Machine Torch Assembly
	120356	MAX200/HT2000 Machine Torch Main Body
	028384*	Leads, Torch, 50' / 15.2 m
1	020041	Torch Mounting Sleeve
2	020536	Lead Insulator, 5/8 x 2.5"
3	028383*	Leads, Torch, 25' / 7.6 m
4	020963	Water Tube, Electrode Cooling, Standard
4	120257	Water Tube, Electrode Cooling, Extended
5	044027	O-Ring: Buna 70 Duro 1.301 x .070

**^ Assembly includes consumables**

\* Other lead lengths available.  
 Consult your Operating Manual.

# Hypertherm®

## HySpeed Plasma HSD130™

### Consumables



HySpeed Plasma  
HSD130



HySpeed Plasma  
HSD130 torch

#### Mild steel

	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
45A (Air)					
	220532	220578	220525	220529	220528
50A (O <sub>2</sub> )					
	220532	220578	220530	220529	220528
130A (Air)					
	220536	220578	220492	220488	220487
130A (O <sub>2</sub> )					
	220491	220578	220489	220488	220487

#### Stainless steel

	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
45A (Air)					
	220532	220578	220525	220529	220528
45A (N <sub>2</sub> and F5)					
	220532	220534	220525	220529	220528
130A (Air)					
	220536	220578	220492	220488	220487
130A (N <sub>2</sub> )					
	220536	220578	220535	220488	020415
130A (H35)					
	220536	220534	220535	220529	020415

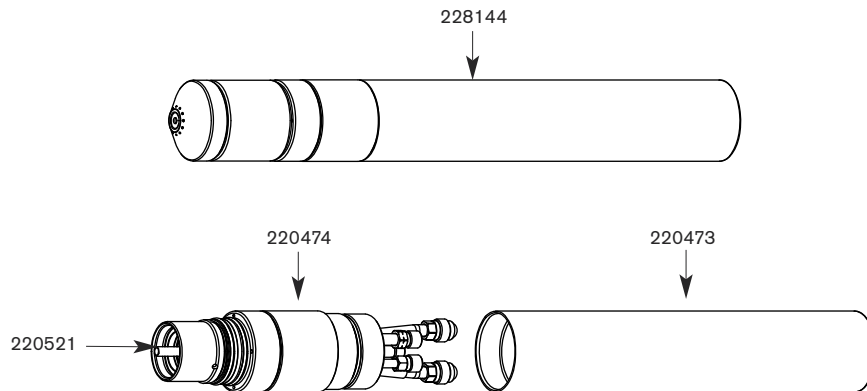
#### Aluminum

	Shield	Retaining cap	Nozzle	Swirl ring	Electrode
45A (Air)					
	220532	220578	220525	220529	220528
130A (Air)					
	220536	220578	220492	220488	220487
130A (H35)					
	220536	220534	220535	220529	020415

## ***HSD130 consumables***

<b>MATERIAL</b>	<b>CONSUMABLE DESCRIPTION</b>	<b>45 AMPS</b>	<b>50 AMPS</b>	<b>130 AMPS</b>
Mild steel	Electrode	220528	220528	220487
	Swirl ring	220529	220529	220488
	Nozzle	220525	220530	220489 (O <sub>2</sub> )
	-----	-----	-----	220492 (Air)
	Shield	220532	220532	220491 (O <sub>2</sub> )
	-----	-----	-----	220536 (Air)
Stainless steel	Retaining Cap	220578	220578	220578
	Electrode	220528	-----	220487 (Air)
	-----	-----	-----	020415 (N <sub>2</sub> , H35)
	Swirl ring	220529	-----	220488 (Air)
	-----	-----	-----	220488 (N <sub>2</sub> )
	-----	-----	-----	220529 (H35)
Nozzle	220525	-----	220492 (Air)	
-----	-----	-----	220535 (N <sub>2</sub> , H35)	
Shield	220532	-----	220536 (Air)	
-----	-----	-----	220536 (N <sub>2</sub> , H35)	
Retaining Cap	220578 (Air)	-----	220578 (Air)	
-----	220534 (N <sub>2</sub> , F5)	-----	220534 (H35)	
-----	-----	-----	220578 (N <sub>2</sub> )	
Aluminum	Electrode	220528	-----	220487 (Air)
	-----	-----	-----	020415 (H35)
	Swirl ring	220529	-----	220488 (Air)
	-----	-----	-----	220529 (H35)
	Nozzle	220525	-----	220492 (Air)
	-----	-----	-----	220535 (H35)
Shield	220532	-----	220536 (Air)	
-----	-----	-----	220536 (H35)	
Retaining Cap	220578	-----	220578 (Air)	
-----	-----	-----	220534 (H35)	

## ***HSD130 torch assembly***



<b>PART NO.</b>	<b>DESCRIPTION</b>
228144	Torch assembly (includes consumables and sleeve)
220521	Water tube
220474	Torch main body
220473	Torch mounting sleeve

# Hypertherm®

## MAX70/100

### 70/100 consumables



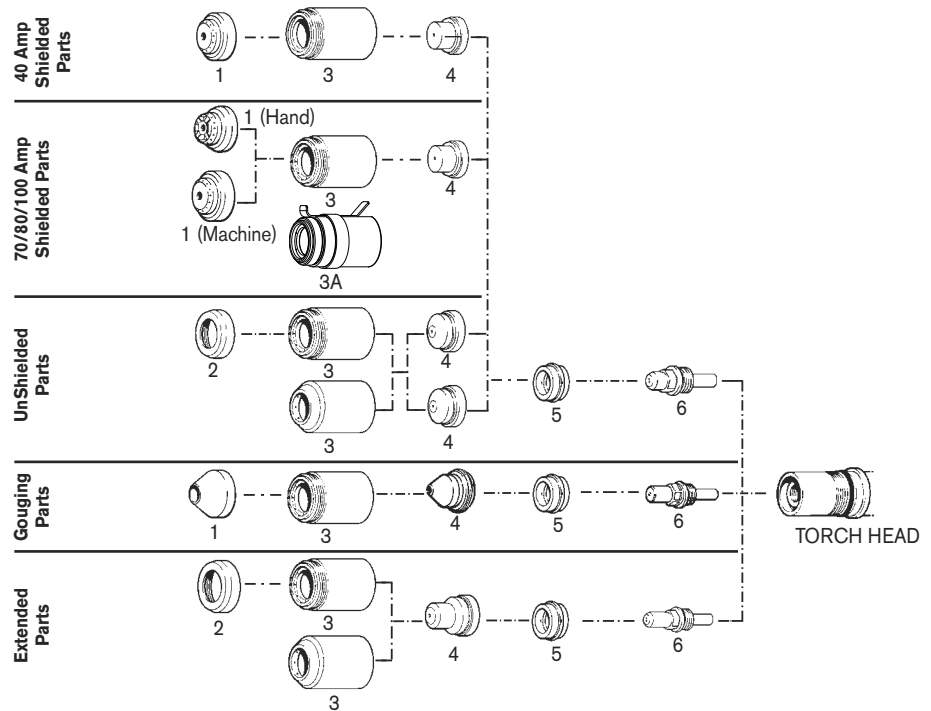
MAX70



MAX100



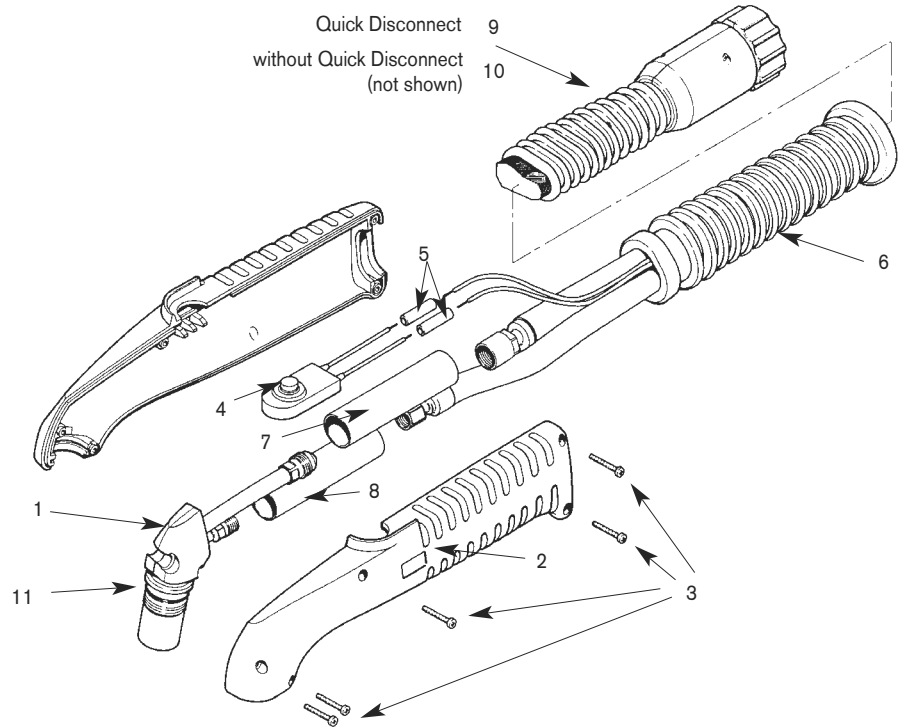
PAC130 Torch



	DESCRIPTION	PART NUMBER CURRENT RATING				QUANTITY PER PACKAGE
		100 AMPS	80 AMPS	70 AMPS	40 AMPS	
Cutting Parts Shielded	6 Electrode, Air, HyLife	120433	120433	120433	120433	5
	6 Electrode, Nitrogen	020193	020193	020193	020193	5
	5 Swirl Ring	020194	020194	020194	020194	1
	4 Nozzle	020337	020397	020397	020396	5
	3 Retaining Cap	020336	020336	020336	020490	1
	3A Retaining Cap, Ohmic	120966	120966	120966	-----	1
	1 Shield, Hand	020335	020335	020335	-----	1
	1 Shield, Machine	020334	020334	020334	020492	1
Unshielded Parts	6 Electrode, Air, HyLife	120433	120433	120433	120433	5
	6 Electrode, Nitrogen	020193	020193	020193	020193	5
	5 Swirl Ring	020194	020194	020194	020194	1
	4 Nozzle	020195	020345	020345	020203	5
	3 Retaining Cap*	020184	020184	020184	020184	1
	1 Shield Cap*	020336	020336	020336	020336	1
	2 Deflector*	020333	020333	020333	020333	1
Gouging Parts	6 Electrode	020744	-----	020744	-----	5
	5 Swirl Ring	020194	-----	020194	-----	1
	4 Nozzle	120459	-----	020878	-----	5
	3 Retaining Cap	020336	-----	020336	-----	1
1 Shield	020712	-----	020712	-----	1	
Cutting Parts Extended	6 Electrode, Air, HyLife, Extended	-----	120444	120444	-----	5
	6 Electrode, Nitrogen, Extended	-----	020886	020886	-----	5
	5 Swirl Ring	-----	020194	020194	-----	1
	4 Nozzle	-----	020563	020563	-----	5
	3 Retaining Cap*	-----	020184	020184	-----	1
	1 Shield Cap*	-----	020336	020336	-----	1
2 Deflector*	-----	020333	020333	-----	1	

\* Non-shielded cutting may use a retaining cap **or** a combination shield cap/deflector.

# MAX70/100 PAC130 hand torch assembly



**PAC130 Torch**

ITEM NUMBER	PART NUMBER	DESCRIPTION
<b>Torch Leads with Quick Disconnect</b>		
	059093^	Torch Assembly, 25' / 7.6 m, with QD
	059094^	Torch Assembly, 50' / 15.2 m, with QD
	059095^	Torch Assembly, 75' / 22.9 m, with QD
<b>Torch Leads without Quick Disconnect</b>		
10	029198	Leads, Hand Torch, 25' / 7.6 m, without QD
10	029199	Leads, Hand Torch, 50' / 15.2 m, without QD
10	029229	Leads, Hand Torch, 75' / 22.9 m, without QD
1	020461	Torch Main Body, PAC130
2	001214	Handle, PAC130 (both halves included)
3	075365	Screw, #6 x 3/4" (five required)
4	005094	Switch, Pushbutton, Torch
5	074069	Splice, Butt, Insulated (two required)
6	001217	Boot, PAC130
7	024249	Negative Lead Insulator, 1 1/16 x 3 1/2"
8	020536	Pilot Arc Lead Insulator, 5/16 x 2 1/2"
9	029667	Leads, Hand Torch, 25' / 7.6 m, with QD
9	029668	Leads, Hand Torch, 50' / 15.2 m, with QD
9	029669	Leads, Hand Torch, 75' / 22.9 m, with QD
11	026018	O-ring, Silico

^ Assembly includes consumables



# Hypertherm®

## MAX100D Machine torch parts

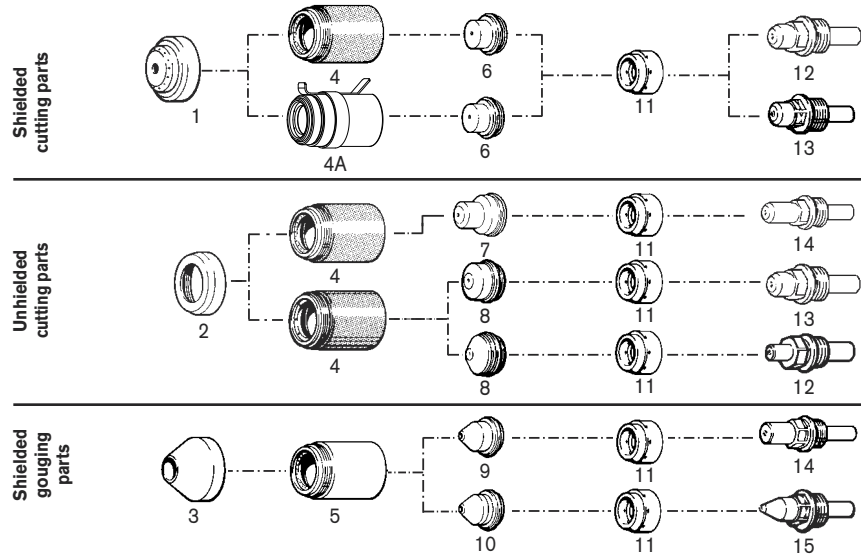
### PAC160 consumables



MAX100D

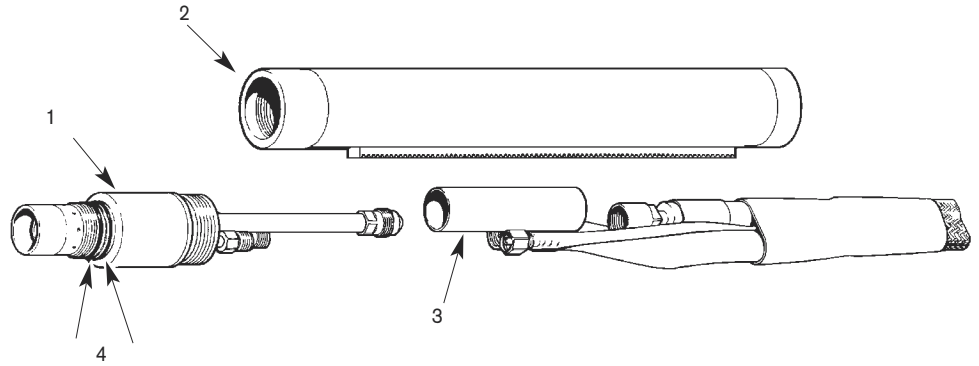


MAX100D machine torch



	DESCRIPTION	PART NUMBER CURRENT RATING			QUANTITY PER PACKAGE
		100 AMPS	60 AMPS	30/40 AMPS	
Shielded cutting parts	12 Electrode, Air,	120433	120433	-----	5
	13 Electrode, N <sub>2</sub>	020193	020193	-----	5
	11 Swirl Ring	020706	020706	-----	1
	6 Nozzle	020705	120336	-----	5
	4 Retaining Cap	020846	020756	-----	1
	4A Retaining Cap, Ohmic	120969	-----	-----	1
	1 Shield	020334	020492	-----	1
Unshielded cutting parts	12 Electrode, Air	-----	120433**	020951	5
	13 Electrode, N <sub>2</sub>	-----	020193	-----	5
	11 Swirl Ring	-----	020706	020950	1
	8 Nozzle	-----	020922	020921	5
	4 Retaining Cap	-----	020756	020756	1
	2 Deflector	-----	020333	020333	1
	14 Electrode, Air, Extended	120444**	-----	-----	1
14 Electrode, N <sub>2</sub> , Extended	020887	-----	-----	1	
11 Swirl Ring	020706	-----	-----	1	
7 Nozzle, Extended	020754	-----	-----	1	
4 Retaining Cap	020846	-----	-----	1	
2 Deflector	020333	-----	-----	1	
Shielded gouging parts	14 Electrode, Air, Extended	020744	-----	-----	5
	15 Electrode, H <sub>35</sub>	020703	-----	-----	5
	11 Swirl Ring	020750	-----	-----	1
	9 Nozzle, Air	020745	-----	-----	5
	10 Nozzle, H <sub>35</sub>	020704	-----	-----	5
	5 Retaining Cap	020699	-----	-----	1
	3 Shield	020712	-----	-----	1

## MAX100D PAC160/E machine torch assembly



MAX100D machine torch

ITEM NUMBER	PART NUMBER	DESCRIPTION
	028596^	MAX100D Machine Torch Assembly
1	020713	MAX100D Machine Torch Main Body
2	020243	MAX100D Torch Positioning Sleeve
3	020468	Negative Lead Insulator, 1 1/8 x 3 1/2"
4	058019	O-Ring: Viton .801 x .071 (two required)
	059115^	MAX100D Machine Torch Assembly, 25' / 7.6 m Leads
	059116^	MAX100D Machine Torch Assembly, 50' / 15.2 m Leads
	059117^	MAX100D Machine Torch Assembly, 75' / 22.9 m Leads
	028555	MAX100D Machine Torch Leads, 25' / 7.6 m
	028556	MAX100D Machine Torch Leads, 50' / 15.2 m
	028557	MAX100D Machine Torch Leads, 75' / 22.9 m
	028910	MAX100D Quick Disconnect Assembly
	002190	Boot, 80/100 Amp Quick Disconnect

^ Assembly includes consumables

# Hypertherm®

## powermax1650® G3 SERIES

### Machine torch parts

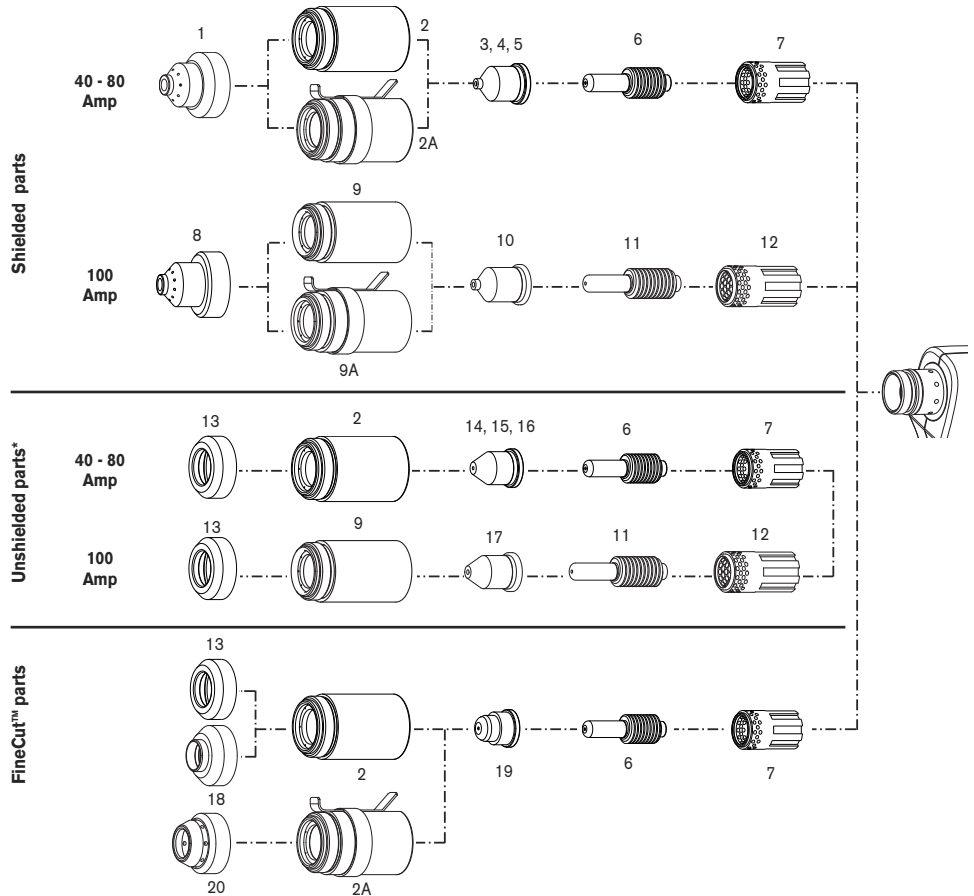
#### T100 consumables



Powermax1650

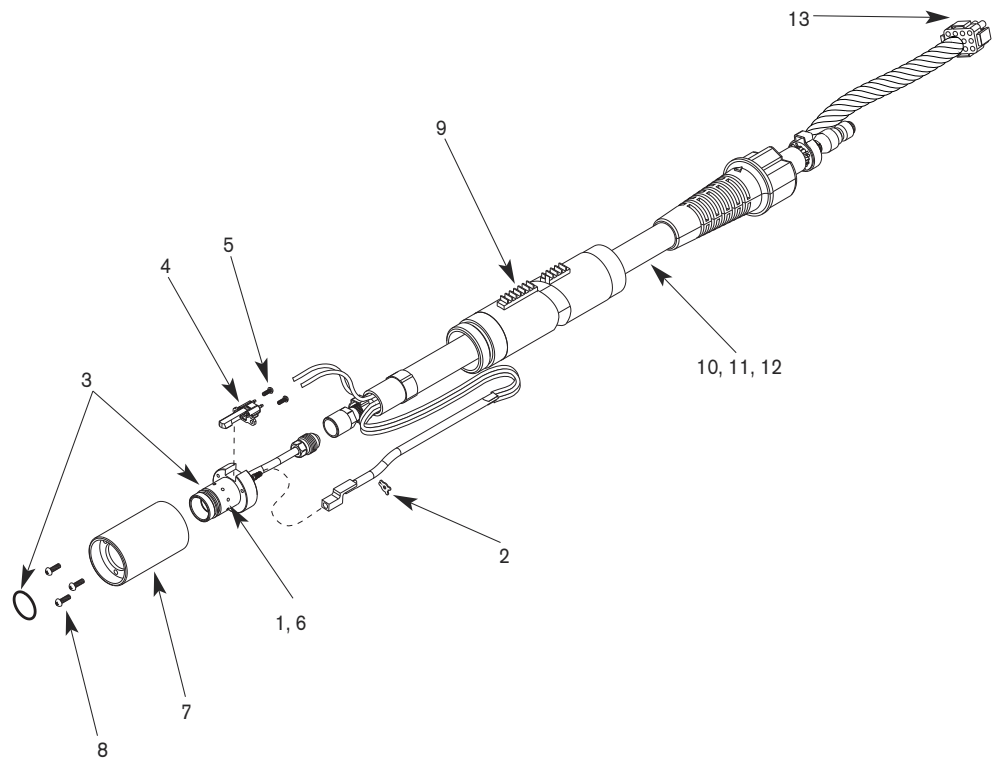


T100M torch



	DESCRIPTION	100 AMP		80 AMP		60 AMP		40 AMP		QUANTITY PER PACKAGE
		ITEM NUMBER	PART NUMBER	ITEM NUMBER	PART NUMBER	ITEM NUMBER	PART NUMBER	ITEM NUMBER	PART NUMBER	
Shielded parts	Shield	8	220047	1	120930	1	120930	1	120930	1
	Retaining Cap	9	220048	2	120928	2	120928	2	120928	1
	Retaining Cap, Ohmic9A		220206	2A	220061	2A	220061	2A	220061	1
	Nozzle	10	220011	5	120927	4	120931	3	120932	5
	Electrode	11	220037	6	120926	6	120926	6	120926	5
	Swirl Ring	12	220051	7	120925	7	120925	7	120925	1
Unshielded parts*	Deflector	13	120979	13	120979	13	120979	13	120979	1
	Retaining Cap	9	220048	2	120928	2	120928	2	120928	1
	Nozzle	17	220064	16	120980	15	220007	14	220006	5
	Electrode	11	220037	6	120926	6	120926	6	120926	5
	Swirl Ring	12	220051	7	120925	7	120925	7	120925	1
FineCut™ parts	Deflector	—	—	—	—	—	—	13	120979	1
	Deflector, CE	—	—	—	—	—	—	18	220325	1
	Shield, Ohmic	—	—	—	—	—	—	20	220404	1
	Retaining Cap	—	—	—	—	—	—	2	120928	1
	Retaining Cap, Ohmic	—	—	—	—	—	—	2A	220061	1
	Nozzle	—	—	—	—	—	—	19	220329	5
	Electrode	—	—	—	—	—	—	6	120926	5
Swirl Ring	—	—	—	—	—	—	7	120925	1	

## Powermax 1650 T100M machine torch assembly



**T100M torch**

ITEM NUMBER	PART NUMBER	DESCRIPTION	QUANTITY PER PACKAGE
	059265^	T100M Machine Torch Assembly with 25 ft (7.6 m) Lead	
	059268^	T100M Machine Torch Assembly with 35 ft (10.7 m) Lead	
	059272^	T100M Machine Torch Assembly with 50 ft (15.2 m) Lead	
1	128754	T100M Torch Main Body Replacement Kit	1
2	027889	Retaining Clip	1
3	058519	O-ring	1
4	128639	Cap-off Sensor Replacement Kit	1
5	075571	Cap-off Sensor Screws	2
6	128768	T100/T100M Torch Head Repair Kit	1
7	128643	Torch Mounting Sleeve Replacement Kit	1
8	075004	Torch Mounting Screws	3
9	128710	Torch Positioning Sleeve (With Rack)	1
9	220070	Torch Positioning Sleeve (Without Rack)	1
10	128753	25 ft (7.6 m) Torch Lead Replacement Kit	1
11	128751	35 ft (10.7 m) Torch Lead Replacement Kit	1
12	128759	50 ft (15.2 m) Torch Lead Replacement Kit	1
13	128638	ETR Repair Kit (Regional Repair Centers only)	1
	128645	Torch Mounting Kit (for reassembly after installation)	1

^ Assembly includes consumables

# Hypertherm®

## powermax1250® G3 SERIES™

### Machine torch parts

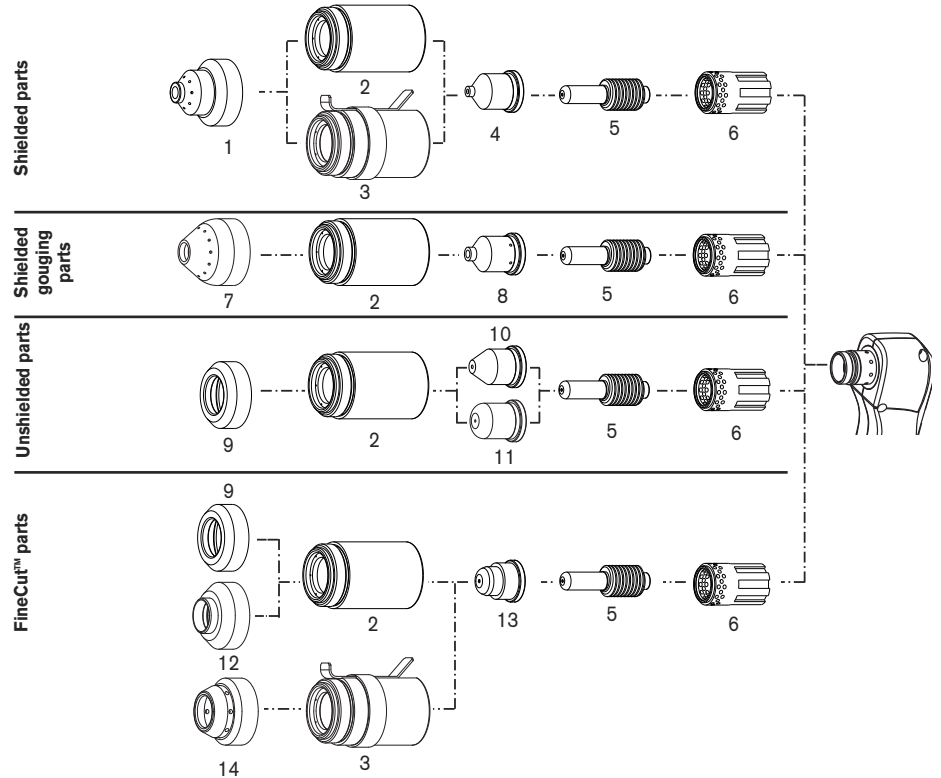
#### T80 consumables



Powermax1250

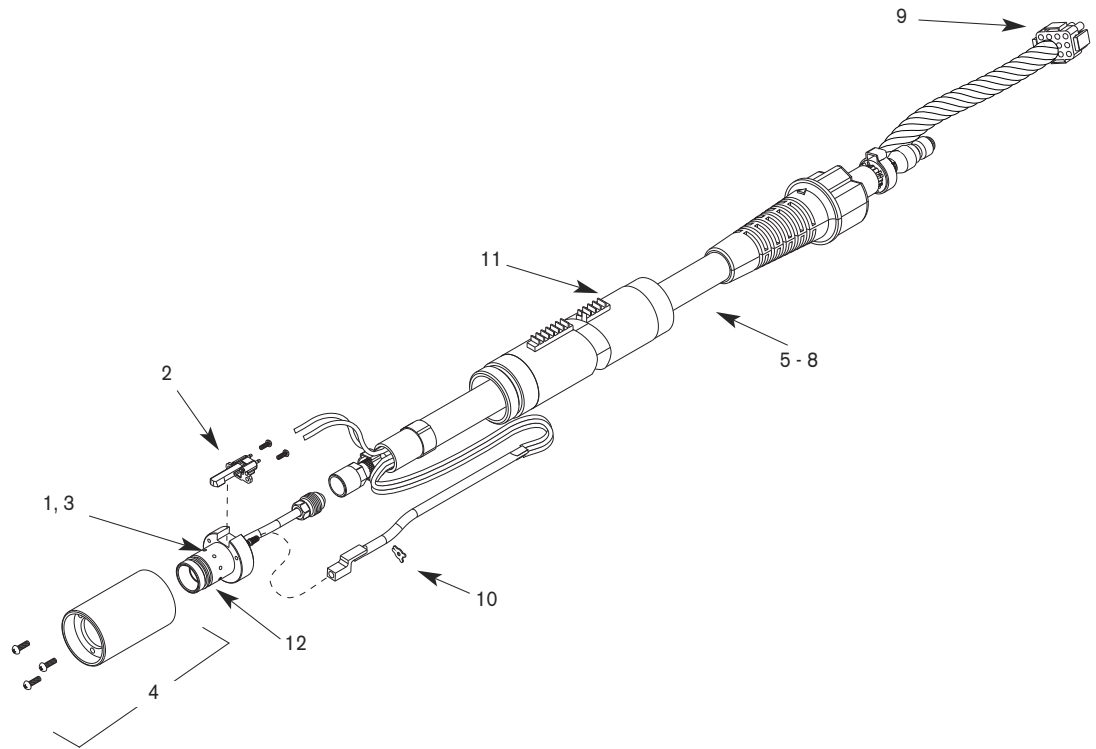


T80M torch



	ITEM NUMBER	PART NUMBER	DESCRIPTION	QUANTITY PER PACKAGE
Shielded parts	1	120930	Shield	1
	2	120928	Retaining Cap	1
	3	220061	Retaining Cap, Ohmic	1
	4	120927	Nozzle, 80 Amp	5
	4	120931	Nozzle, 60 Amp	5
	4	120932	Nozzle, 40 Amp	5
	5	120926	Electrode	5
	6	120925	Swirl Ring	1
Shielded gouging parts	7	120977	Shield, Gouging	1
	2	120928	Retaining Cap	1
	8	220059	Nozzle, Gouging	5
	5	120926	Electrode	5
	6	120925	Swirl Ring	1
Unshielded parts	9	120979	Deflector	1
	2	120928	Retaining Cap	1
	10	120980	Nozzle, Extended, 80 Amp	5
	10	220007	Nozzle, Extended, 60 Amp	5
	11	220006	Nozzle, Extended, 40 Amp	5
	5	120926	Electrode	5
	6	120925	Swirl Ring	1
FineCut™ parts	9	120979	Deflector	1
	12	220325	Deflector, CE	1
	14	220404	Shield, Ohmic	1
	2	120928	Retaining Cap	1
	3	220061	Retaining Ring, Ohmic	1
	13	220329	Nozzle	5
	5	120926	Electrode	5
6	120925	Swirl Ring	1	

# Powermax1250 T80M torch assembly



**T80M torch**

ITEM NUMBER	PART NUMBER	DESCRIPTION
	087003^	T80M Machine Torch Assembly, 15' / 4.6 m
	087004^	T80M Machine Torch Assembly, 25' / 7.6 m
	087005^	T80M Machine Torch Assembly, 35' / 10.7 m
	087006^	T80M Machine Torch Assembly, 50' / 15.2 m
	128645	Kit: Torch Mounting
1	128640	Kit: T80M Torch Main Body Replacement
2	128639	Kit: Cap Sensor Switch Replacement
3	128521	Kit: T60/T80/T60M/T80M Torch Head Repair
4	128643	Kit: T60M/T80M Mounting Sleeve Replacement
5	128634	Kit: T80M Lead Replacement, 15' / 4.6 m
6	128633	Kit: T80M Lead Replacement, 25' / 7.6 m
7	128635	Kit: T80M Lead Replacement, 35' / 10.7 m
8	128641	Kit: T80M Lead Replacement, 50' / 15.2 m
9	128638	Kit: ETR Connector Repair (Regional Repair Centers Only)
10	027889	Retaining Clip
11	128710	T60M/T80M Positioning Sleeve Replacement (With Rack)
11	220070	T60M/T80M Positioning Sleeve Replacement (Without Rack)
12	058519	Torch o-ring

^ Assembly includes consumables

# Hypertherm®

## powermax1000® G3 SERIES™

### Machine torch parts

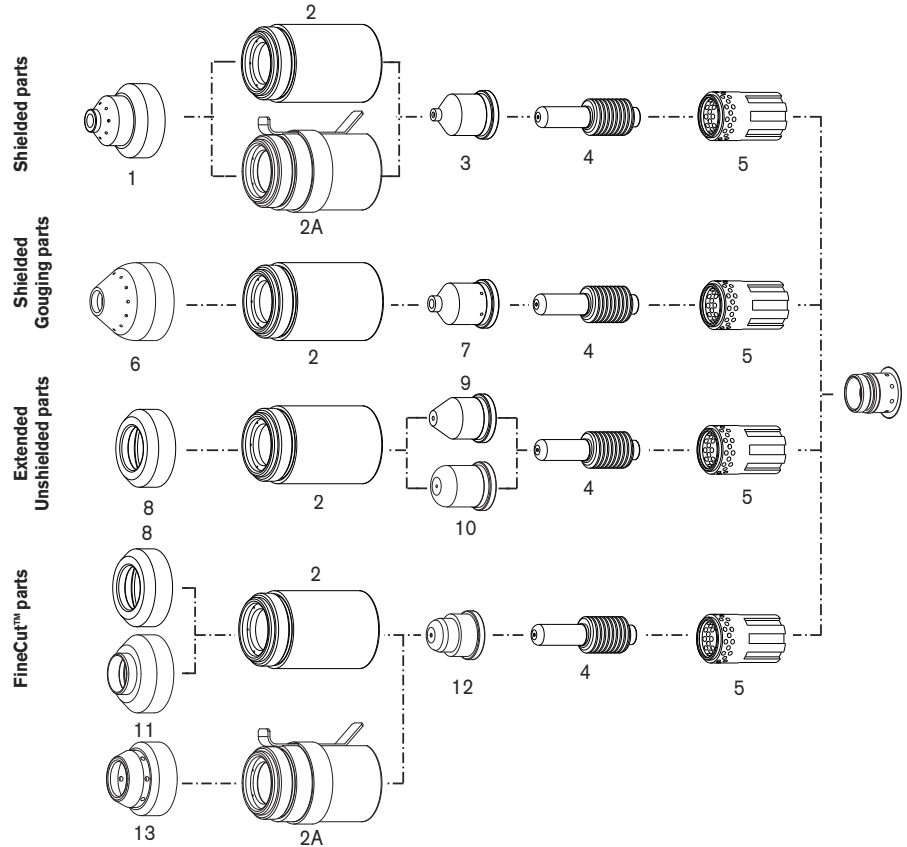
#### T60M consumables



Powermax1000

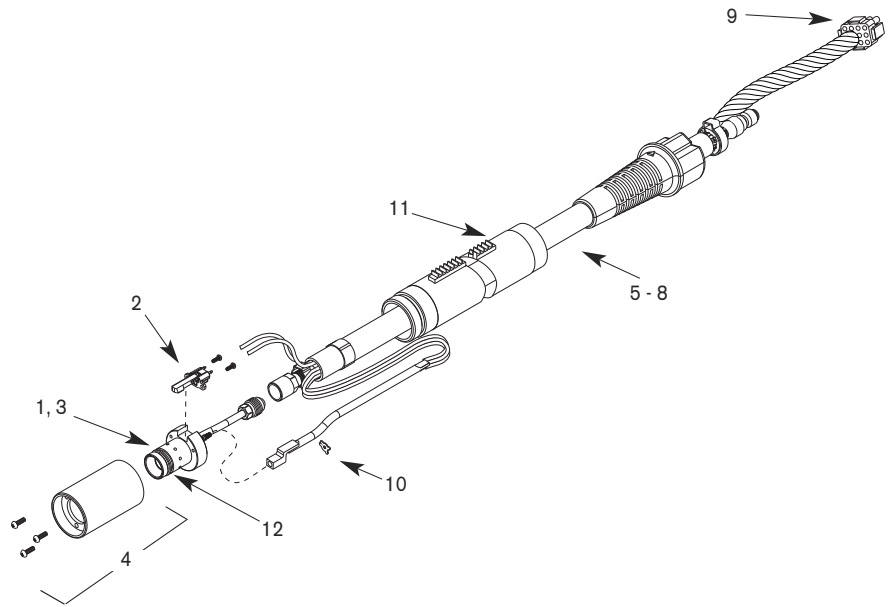


T60M Torch



	ITEM NUMBER	PART NUMBER	DESCRIPTION	QUANTITY PER PACKAGE
Shielded parts	1	120930	Shield	1
	2	120928	Retaining Cap	1
	2A	220061	Retaining Cap, ohmic	1
	3	120931	Nozzle, 60 Amp	5
	3	120932	Nozzle, 40 Amp	5
	4	120926	Electrode	5
Shielded Gouging parts	5	120925	Swirl Ring	1
	6	120977	Shield, Gouging	1
	2	120928	Retaining Cap	1
	7	220059	Nozzle, Gouging	5
	4	120926	Electrode	5
Extended Unshielded parts	5	120925	Swirl Ring	1
	8	120979	Deflector	1
	2	120928	Retaining Cap	1
	9	220007	Nozzle, Extended, 60 Amp	5
	10	220006	Nozzle, Extended, 40 Amp	5
FineCut™ parts	4	120926	Electrode	5
	5	120925	Swirl Ring	1
	8	120979	Deflector	1
	11	220325	Deflector, CE	1
	13	220404	Shield, Ohmic	1
	2	120928	Retaining Cap	1
	2A	220061	Retaining Cap, Ohmic	1
	12	220329	Nozzle, T60/T80/T100	5
	4	120926	Electrode	5
	5	120925	Swirl Ring	1

## Powermax1000 T60M torch assembly



**T60M Torch**

ITEM NUMBER	PART NUMBER	DESCRIPTION
	083175^	T60M Machine torch assembly 15' (4.6m)
	083174^	T60M Machine torch assembly 25' (7.6m)
	083176^	T60M Machine torch assembly 35' (10.7m)
	083177^	T60M Machine torch assembly 50' (15.2m)
	128645	Kit: Torch Mounting
1	128640	Kit: T60M/T80M torch main body replacement
2	128639	Kit: Cap sensor switch replacement
3	128521	Kit: T60/T80, T60M/T80M torch head repair
4	128643	Kit: T60M/T80M mounting sleeve replacement
5	128634	Kit: T60M/T80M lead replacement 15' (4.6m)
6	128633	Kit: T60M/T80M lead replacement 25' (7.6m)
7	128635	Kit: T60M/T80M lead replacement 35' (10.7m)
8	128641	Kit: T60M/T80M lead replacement 50' (15.2m)
9	128638	Kit: ETR connector repair (Regional Repair Centers only)
10	027889	Retaining Clip
11	128710	Kit: T60/T80M Positioning Sleeve Replacement (with rack)
11	220070	Kit: T60/T80M Positioning Sleeve Replacement (without rack)
12	058519	Torch o-ring

^ Assembly includes consumables



# Hypertherm®

## powermax600

### Machine torch parts

#### PAC123M consumables

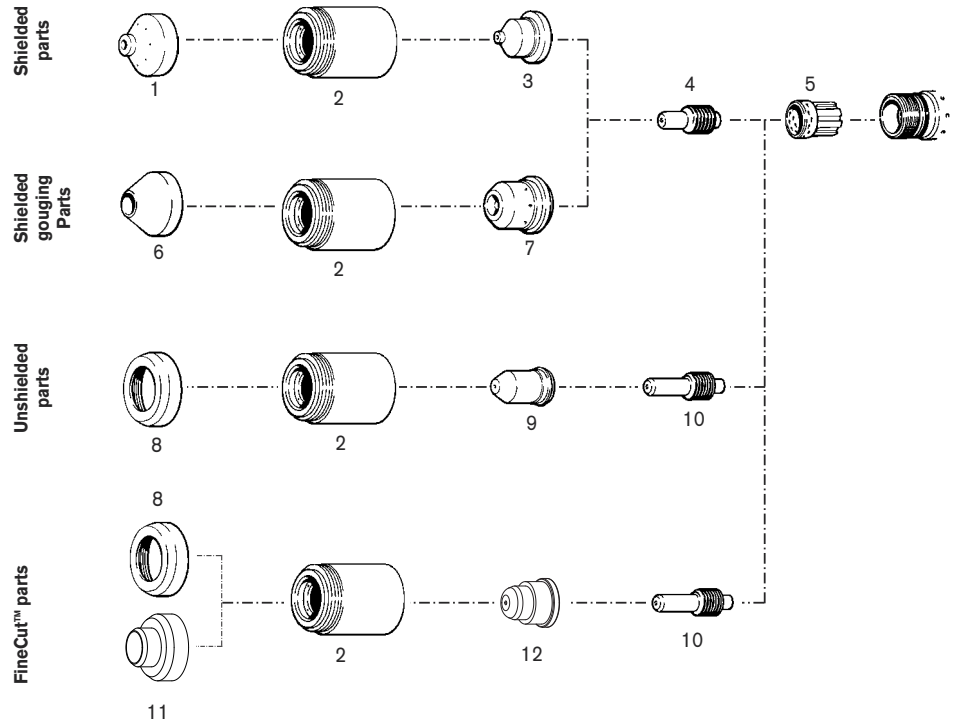


Powermax600



PAC123M torch

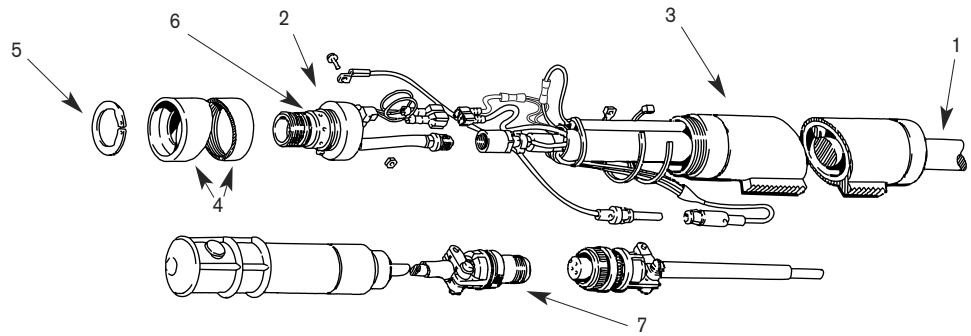
For improved performance,  
we recommend retrofitting  
with the RT60 torch  
(see page 37).



	ITEM NUMBER	PART NUMBER	DESCRIPTION	QUANTITY PER PACKAGE
Shielded parts	1	120827	Shield	1
	2	120600	Retaining Cap	1
	3	120826	Nozzle	5
	4	120573	Electrode	5
	5	120576	Swirl Ring	1
Shielded gouging parts	6	120608	Shield, Gouging	1
	2	120600	Retaining Cap	1
	7	120831	Nozzle, Gouging	5
	4	120573	Electrode	5
	5	120576	Swirl Ring	1
Unshielded parts	8	120303	Deflector	1
	2	120600	Retaining Cap	1
	9	120606	Nozzle, Pipe Saddle, 35 Amp	5
	10	120574	Electrode, Extended	5
	5	120576	Swirl Ring	1
FineCut™ parts	8	120303	Deflector	1
	11	220326	Deflector, CE	1
	2	120600	Retaining Cap	1
	12	220330	Nozzle	5
	10	120574	Electrode	5
	5	120576	Swirl Ring	1

**Note:** The nozzles and swirl rings shown must be used as a set.

## Powermax600 PAC123M torch assembly



For improved performance,  
we recommend retrofitting  
with the RT60 torch  
(see page 37).



PAC123M torch

ITEM NUMBER	PART NUMBER	DESCRIPTION
<b>Torch Assemblies with Quick Disconnects only for use with 208-240V and 480V systems</b>		
	086026^	PAC123M Torch Assembly, with pigtail and QD 15' / 4.6 m
	086027^	PAC123M Torch Assembly, with pigtail and QD 25' / 7.6 m
	086029^	PAC123M Torch Assembly, with pigtail and QD 50' / 15.2 m
1	128572	Torch Lead, with pigtail and QD 15' / 4.6 m
1	128573	Torch Lead, with pigtail and QD 25' / 7.6 m
1	128574	Torch Lead, with pigtail and QD 50' / 15.2 m
<b>Torch Assemblies without Quick Disconnects only for use with 230V and 400V systems</b>		
	086004^	PAC123M Torch Assembly, with pigtail, without QD 15' / 4.6 m
	086005^	PAC123M Torch Assembly, with pigtail, without QD 25' / 7.6 m
	086006^	PAC123M Torch Assembly, with pigtail, without QD 50' / 15.2 m
1	128374	Torch Lead, with pigtail, without QD 15' / 4.6 m
1	128375	Torch Lead, with pigtail, without QD 25' / 7.6 m
1	128376	Torch Lead, with pigtail, without QD 50' / 15.2 m
2	120583	Torch Main Body with Switch
3	020620	Torch Position Sleeve
4	120613	Torch Sleeve
5	027599	Snap Ring
6	044016	O-Ring, Buna - N 90 Duro
7	028714	On/Off Pendant, 25' / 7.6 m
7	128061	On/Off Pendant, 50' / 15.2 m
7	128062	On/Off Pendant, 75' / 22.9 m

^ Assembly includes consumables

# Hypertherm®

## HyDefinition® HD4070®

### Consumables



HyDefinition HD4070

#### Mild Steel



120692  
220081 (CCW)



120691  
220080 (CCW)



120690

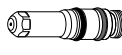
200 Amp



120660



120655



120654

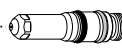
100 Amp



120685



120684



120683

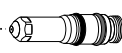
70 Amp



120678



120677



120676

30 Amp

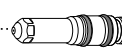
#### Stainless Steel



120727



120726



120725

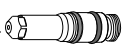
200 Amp



120720

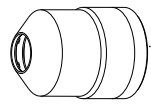


120719



120718

100 Amp



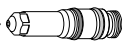
120786  
120907 (With IHS Tab)



120713

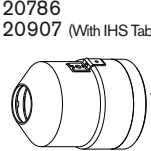


120712



120711

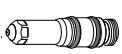
70 Amp



120706

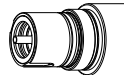


120705



120704

45 Amp



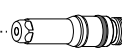
#### Aluminum



120762



120761



120760

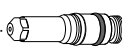
200 Amp



120755



120754



120753

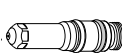
100 Amp



120748



120747



120746

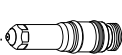
70 Amp



120741



120740



120739

30 Amp

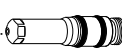
#### Marking



120671



120670



120669

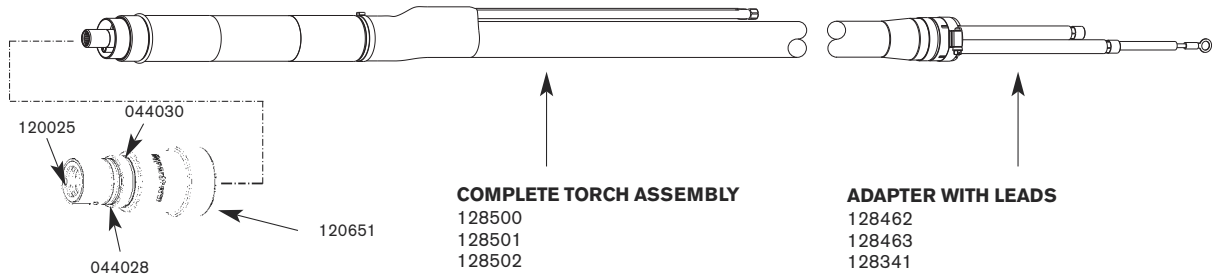


HD4070 Torch

# HD4070 Consumables

APPLICATION	MATERIAL	CONSUMABLE DESCRIPTION	200 AMPS CCW	200 AMPS	100 AMPS	70 AMPS	30/45* AMPS
<b>CUTTING</b>	Mild Steel	Electrode	120690	120690	120654	120683	120676
		Swirl Ring	220080	120691	120655	120684	120677
		Nozzle	220081	120692	120660	120685	120678
		Retaining Cap	120786	120786	120786	120786	120786
		Retaining Cap (With IHS Tab)	120907	120907	120907	120907	120907
	Stainless Steel	Electrode		120725	120718	120711	120704*
		Swirl Ring		120726	120719	120712	120705*
		Nozzle		120727	120720	120713	120706*
		Retaining Cap		120786	120786	120786	120786*
		Retaining Cap (With IHS Tab)		120907	120907	120907	120907*
	Aluminum	Electrode		120760	120753	120746	120739
		Swirl Ring		120761	120754	120747	120740
		Nozzle		120762	120755	120748	120741
		Retaining Cap		120786	120786	120786	120786
		Retaining Cap (With IHS Tab)		120907	120907	120907	120907
<b>MARKING</b>	All Materials	Electrode		120669			
		Swirl Ring		120670			
		Nozzle		120671			
		Retaining Cap		120786			
		Retaining Cap (With IHS Tab)		120907			

## HD4070 Torch Assembly



PART NO.	DESCRIPTION
120651	HD4070 Torch Main Body
128462	HD4070 Torch Adapter with 6' (2 m) Leads
128463	HD4070 Torch Adapter with 10' (3 m) Leads
128341	HD4070 Torch Adapter with 15' (4.5 m) Leads
128500	HD4070 Torch Assembly with 6' (2 m) Leads
128501	HD4070 Torch Assembly with 10' (3 m) Leads
128502	HD4070 Torch Assembly with 15' (4.5 m) Leads
120025	Water Cooling Tube
044028	O-Ring
044030	O-Ring

# Hypertherm®

## HyDefinition® HD3070®

### Consumables



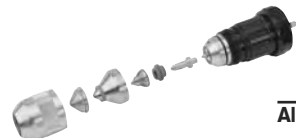
HyDefinition HD3070



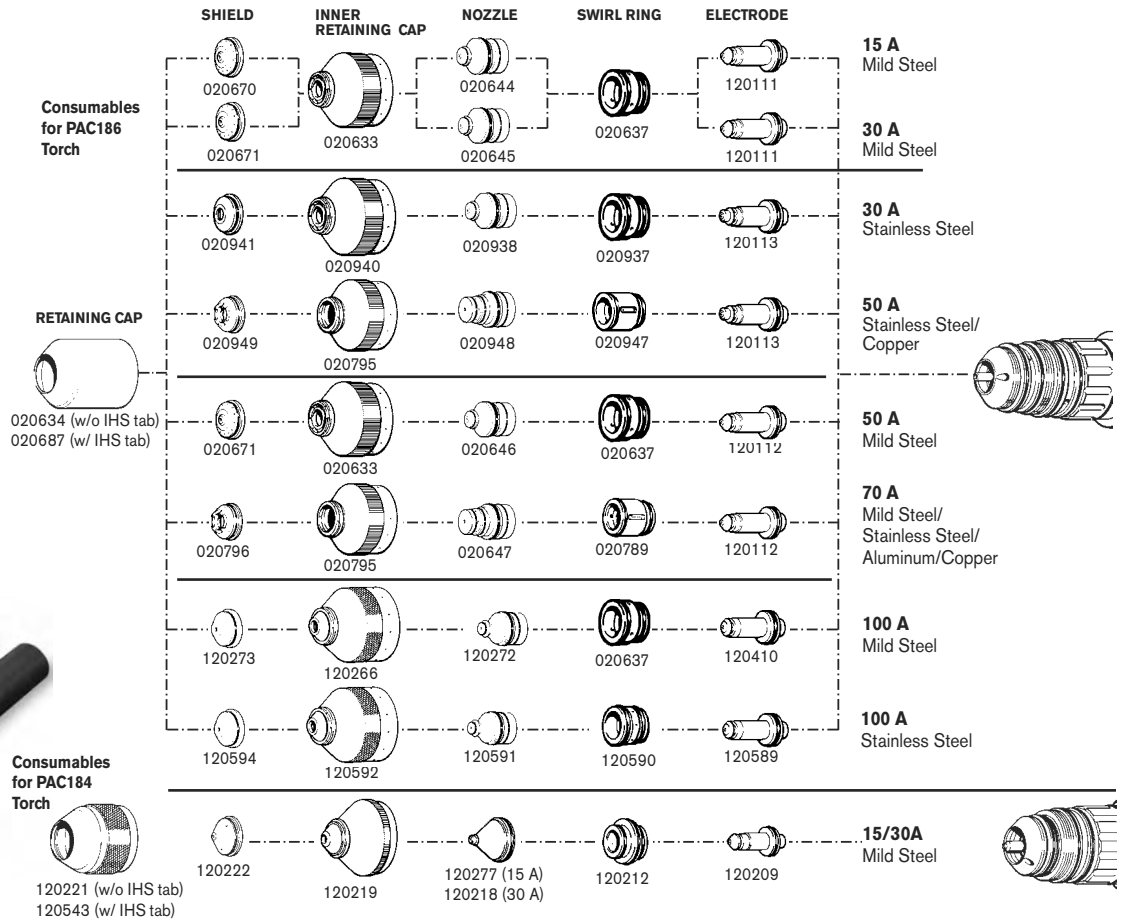
PAC184 Torch - left  
PAC186 Torch - right



PAC186 Consumables

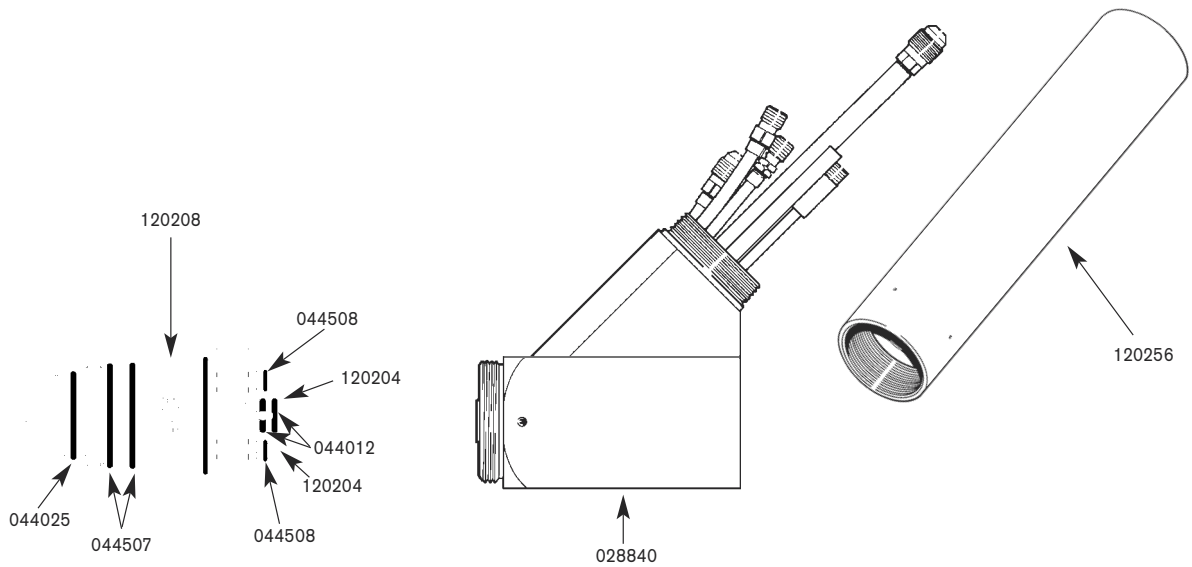


PAC184 Consumables

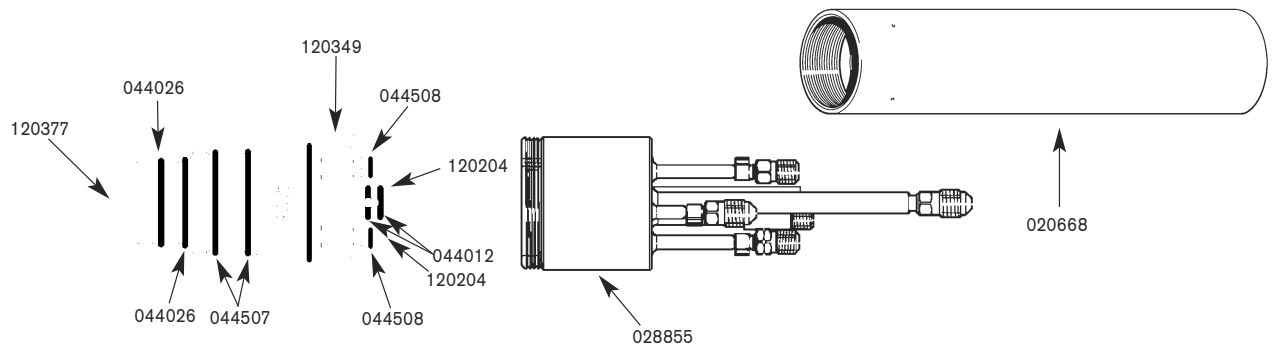


PART DESCRIPTION	PAC186 TORCH					PAC184 TORCH		
	15-AMP	30-AMP	50-AMP	70-AMP	100-AMP	15-AMP	30-AMP	
<b>Retaining Caps</b> (to be used with all applications listed below)	With IHS Tab	020687	020687	020687	020687	020687	120543	120543
	Without IHS Tab	020634	020634	020634	020634	020634	120221	120221
<b>Mild Steel Cutting</b>	Electrode	120111	120111	120112	120112	120410	120209	120209
	Swirl Ring	020637	020637	020637	020789	020637	120212	120212
	Nozzle	020644	020645	020646	020647	120272	120277	120218
	Inner Retaining Cap	020633	020633	020633	020795	120266	120219	120219
	Shield/Shield Adapter	020670	120671	020671	020796	120273	120222	120222
<b>Stainless Steel Cutting</b>	Electrode	-----	120113	120113	120112	120589	-----	-----
	Swirl Ring	-----	020937	020947	020789	120590	-----	-----
	Nozzle	-----	020938	020948	020647	120591	-----	-----
	Inner Retaining Cap	-----	020940	020795	020795	120592	-----	-----
	Shield/Shield Adapter	-----	120941	020949	020796	120594	-----	-----
<b>Aluminum Cutting</b>	Electrode	-----	-----	-----	120112	-----	-----	-----
	Swirl Ring	-----	-----	-----	020789	-----	-----	-----
	Nozzle	-----	-----	-----	020647	-----	-----	-----
	Inner Retaining Cap	-----	-----	-----	020795	-----	-----	-----
	Shield/Shield Adapter	-----	-----	-----	020796	-----	-----	-----

## HyDefinition HD 3070 PAC184 Torch Assembly



## HyDefinition HD 3070 PAC186 Torch Assembly




PART NUMBER	DESCRIPTION
120208	Torch Main Body, PAC184
120349	Torch Main Body, PAC186
120256	Sleeve, Mounting, PAC184
020668	Sleeve, Mounting, PAC186
044012	O-Ring, Buna, 70 Duro 0.364 x .070
044026	O-Ring, Buna, 70 Duro 1.239 x .070
044507	O-Ring, Buna, 70 Duro 1.424 x .070
044508	O-Ring, Buna, 70 Duro 0.216 x .053
028840	Assy, PAC184, 45° Torch Quick-Disconnect
028855	Assy, PAC185/186, Straight Quick Disconnect
120377	Tube, Water Electrode Cooling, PAC186
120204	Bullet Connector

# Hypertherm®

## HT4001

### Consumables HT4001 Without Slave

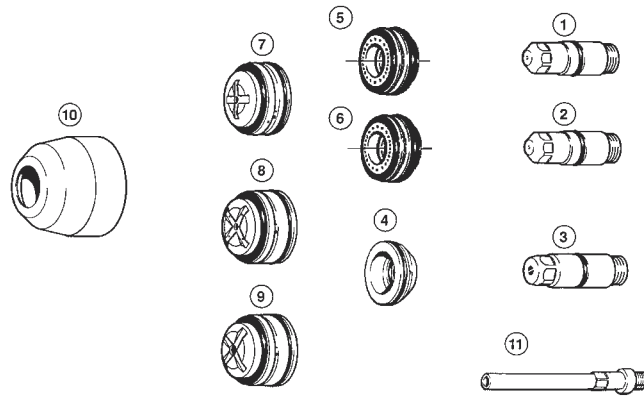
	<b>WARNING</b>
<p>CE countries must operate the PAC620 machine torch using a special CE retaining cap in order to comply with CE regulations. Cap removal tool (004732) must be used to put on and remove the retaining caps. Part numbers for the CE retaining caps are indicated in the cut charts.</p>	

METAL	PLASMA GAS	CONSUMABLE DESCRIPTION	260 AMPS STANDARD	260 AMPS BEVEL	340 AMPS STANDARD	340 AMPS BEVEL	400 AMPS STANDARD	400 AMPS BEVEL
Mild Steel	Oxygen	Electrode	020663	020975	120630	120836	-----	-----
		Swirl ring	020623	020623	120135	120460	-----	-----
		Nozzle	020086	120384	020086	120384	-----	-----
		Retaining cap	020579	120390	020579	120390	-----	-----
	Nitrogen	Electrode	020082	-----	-----	-----	020082	-----
		Swirl ring	020039	-----	-----	-----	020039	-----
		Nozzle	020089	-----	-----	-----	020084	-----
		Retaining cap	020579	-----	-----	-----	020579	-----
Mild/ Stainless	Nitrogen	Electrode	-----	020968	-----	-----	-----	020968
		Swirl ring	-----	020039	-----	-----	-----	020039
		Nozzle	-----	120386	-----	-----	-----	120387
		Retaining cap	-----	120390-	-----	-----	-----	120390
Stainless	Nitrogen	Electrode	020082	-----	-----	-----	020082	-----
		Swirl ring	020039	-----	-----	-----	020039	-----
		Nozzle	020089	-----	-----	-----	020084	-----
		Retaining cap	020579	-----	-----	-----	020579	-----
Aluminum	Nitrogen	Electrode	020082	020968	-----	-----	020082	020968
		Swirl ring	020039	020039	-----	-----	020039	020039
		Nozzle	020089	120386	-----	-----	020084	120387
		Retaining cap	020579	120390	-----	-----	020579	120390

\* Use standard consumables with the PAC620 if the torch will only be making cuts 90° to the work surface.

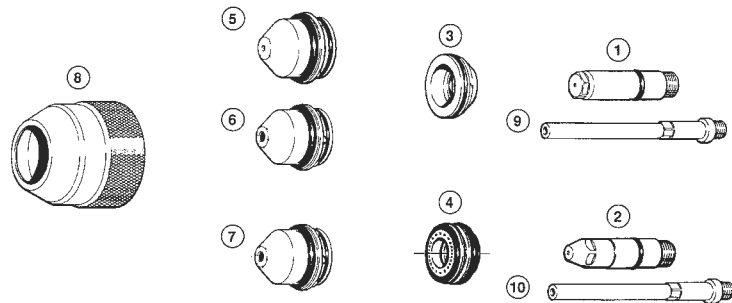
\*\* Use bevel consumables with the PAC620 if the torch will be making cuts between 45° and 90° to the work surface.

## HT4001 PAC620 Torch Assembly Standard without Slave



STANDARD ITEM	PART NUMBER	DESCRIPTION
1	020663	Electrode: Oxygen, 260A
2	120630	Electrode: Oxygen, 340A
3	020082	Electrode: Nitrogen, 400A
4	020039	Swirl Ring: Nitrogen, .120/.166/.187
5	020623	Swirl Ring: Oxygen
6	120135	Swirl Ring: Oxygen, 340A
7	020086	Nozzle: Oxygen
8	020089	Nozzle: Nitrogen, .120
9	020084	Nozzle: Nitrogen, .166
10	020579	Retaining Cap: Tprd Nozzle Standard (Vectra)
11	020990	Water Tube: 400/600/170

## HT4001 PAC620 Torch Assembly Bevel without Slave




BEVEL ITEM	PART NUMBER	DESCRIPTION
1	020968	Electrode: PAC620 Bevel Nitrogen
2	020975	Electrode: PAC620 Bevel Oxygen
3	020039	Swirl Ring: Nitrogen
4	020623	Swirl Ring: Oxygen
5	120386	Nozzle: PAC620 Bevel Nitrogen, .120
6	120387	Nozzle: PAC620 Bevel Nitrogen, .166
7	120384	Nozzle: PAC620 Bevel Oxygen, .099
8	120390	Retaining Cap: PAC620 Bevel (Vectra)
9	020991	Water Tube: PAC620 Bevel, Nitrogen
10	020992	Water Tube: PAC620 Bevel, Oxygen



# Hypertherm®

## HT4001

### Consumables HT4001 With Slave

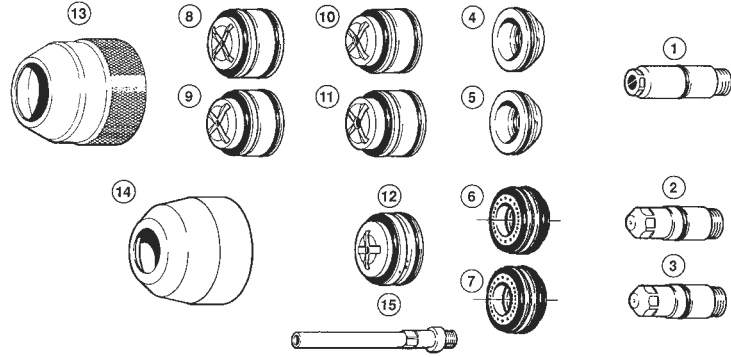
	<b>WARNING</b>
<p>CE countries must operate the PAC620 machine torch using a special CE retaining cap in order to comply with CE regulations. Cap removal tool (004732) must be used to put on and remove the retaining caps. Part numbers for the CE retaining caps are indicated in the cut charts.</p>	

METAL	PLASMA GAS	CONSUMABLE DESCRIPTION	260 AMPS STANDARD	260 AMPS BEVEL	400 AMPS STANDARD	400 AMPS BEVEL	600 AMPS STANDARD	600 AMPS BEVEL	760 AMPS STANDARD	760 AMPS BEVEL
Mild Stainless	Nitrogen	Electrode	020285	020968	020285	020968	020285	020968	020285	020968
		Swirl ring	020039	020039	020039	020039	020039	020039	020040	020040
		Nozzle	020281	120386	020282	120387	020283	120388	020284	120389
		Retaining cap	020580	120390	020580	120390	020580	120390	020580	120390
Aluminum	Nitrogen	Electrode	020285	020968	020285	020968	020285	020968	020285	020968
		Swirl ring	020039	020039	020039	020039	020039	020039	020040	020040
		Nozzle	020281	120386	020282	120387	020283	120388	020284	120389
		Retaining cap	020580	120390	020580	120390	020580	120390	020580	120390

\* Use standard consumables with the PAC620 if the torch will only be making cuts 90° to the work surface.

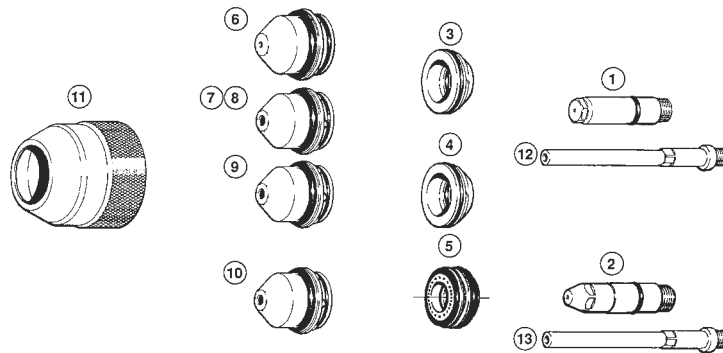
\*\* Use bevel consumables with the PAC620 if the torch will be making cuts between 45° and 90° to the work surface.

## HT4001 PAC620 Torch Assembly Standard with Slave



STANDARD ITEM	PART NUMBER	DESCRIPTION
1	020285	Electrode: Nitrogen
2	020663	Electrode: Oxygen, 260A
3	120630	Electrode: Oxygen, 340A
4	020039	Swirl Ring: Nitrogen, .120/.166/.187
5	020040	Swirl Ring: Nitrogen, .220
6	020623	Swirl Ring: Oxygen
7	120135	Swirl Ring: Oxygen, 340A
8	020281	Nozzle: Nitrogen, .120
9	020282	Nozzle: Nitrogen, .166
10	020283	Nozzle: Nitrogen, .187
11	020284	Nozzle: Nitrogen, .220
12	020086	Nozzle: Oxygen
13	020580	Retaining Cap: Nitrogen, Standard (Vectra)
14	020579	Retaining Cap: Tprd Nozzle Standard (Vectra)
15	020990	Water Tube: 400/600/170

## HT4001 PAC620 Torch Assembly Bevel with Slave



BEVEL ITEM	PART NUMBER	DESCRIPTION
1	020968	Electrode: PAC620 Bevel Nitrogen
2	020975	Electrode: PAC620 Bevel Oxygen
3	020039	Swirl Ring: Nitrogen, .120/.166/.187
4	020040	Swirl Ring: Nitrogen, .220
5	020623	Swirl Ring: Oxygen
6	120386	Nozzle: PAC620 Bevel Nitrogen, .120
7	120387	Nozzle: PAC620 Bevel Nitrogen, .166
8	120388	Nozzle: PAC620 Bevel Nitrogen, .187
9	120389	Nozzle: PAC620 Bevel, Nitrogen, .220
10	120384	Nozzle: PAC620 Bevel, Oxygen, .099
11	120390	Retaining Cap: PAC620 Bevel (Vectra)
12	020991	Water Tube: PAC620 Bevel, Nitrogen
13	020992	Water Tube: PAC620 Bevel, Oxygen

## ***HT4001 CE PAC620 Torch Assembly Standard without Slave***

<b>PART NUMBER</b>	<b>DESCRIPTION</b>
020663	Electrode: Oxygen, 260A
120630	Electrode: Oxygen, 340A
020082	Electrode: Nitrogen, 400A
020039	Swirl Ring: Nitrogen, .120/.166/.187
020623	Swirl Ring: Oxygen
120135	Swirl Ring: Oxygen, 340A
020086	Nozzle: Oxygen
020089	Nozzle: Nitrogen, .120
020084	Nozzle: Nitrogen, .166
120466	Retaining Cap CE: Tprd Nozzle Standard (Vectra)
020990	Water Tube: 400/600/170

## ***HT4001 CE PAC620 Torch Assembly Standard with Slave***

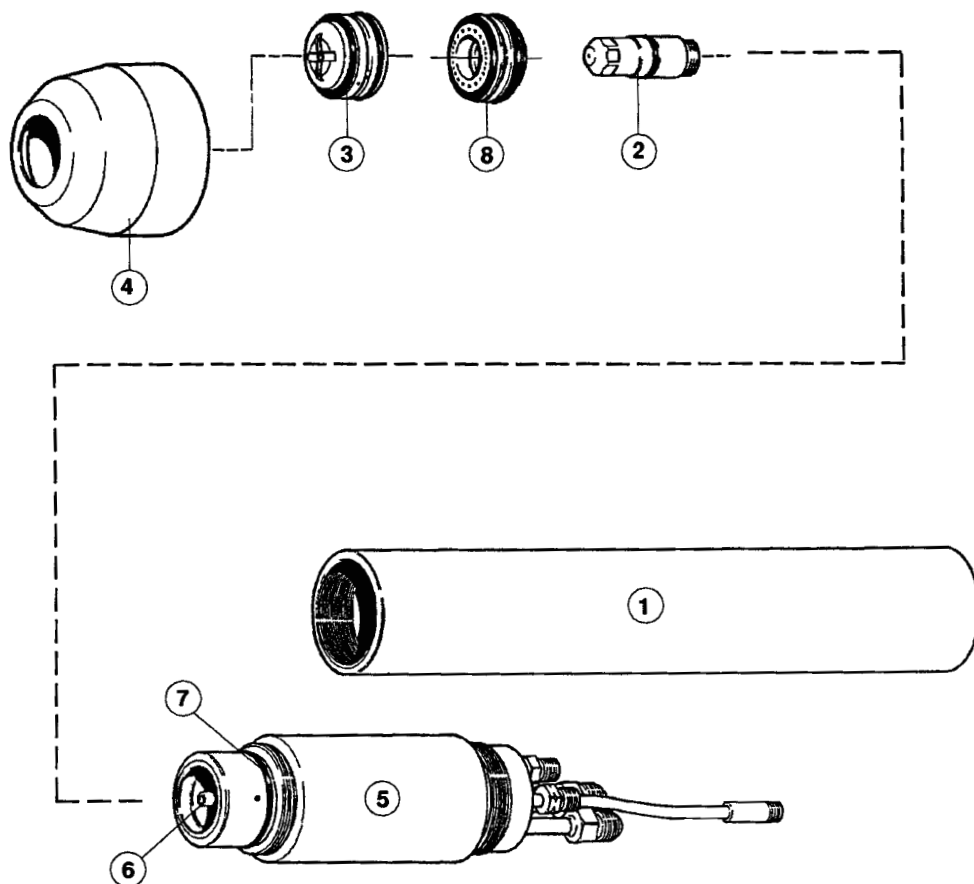
<b>PART NUMBER</b>	<b>DESCRIPTION</b>
020285	Electrode: Nitrogen
020663	Electrode: Oxygen, 260A
120630	Electrode: Oxygen, 340A
020039	Swirl Ring: Nitrogen, .120/.166/.187
020040	Swirl Ring: Nitrogen, .220
020623	Swirl Ring: Oxygen
120135	Swirl Ring: Oxygen, 340A
020281	Nozzle: Nitrogen, .120
020282	Nozzle: Nitrogen, .166
020283	Nozzle: Nitrogen, .187
020284	Nozzle: Nitrogen, .220
020086	Nozzle: Oxygen
120464	Retaining Cap CE: Nitrogen, Standard (Vectra)
120466	Retaining Cap CE: Tprd Nozzle Standard (Vectra)
020990	Water Tube: 400/600/170



# Hypertherm®

## HT4000

### Consumables PAC170



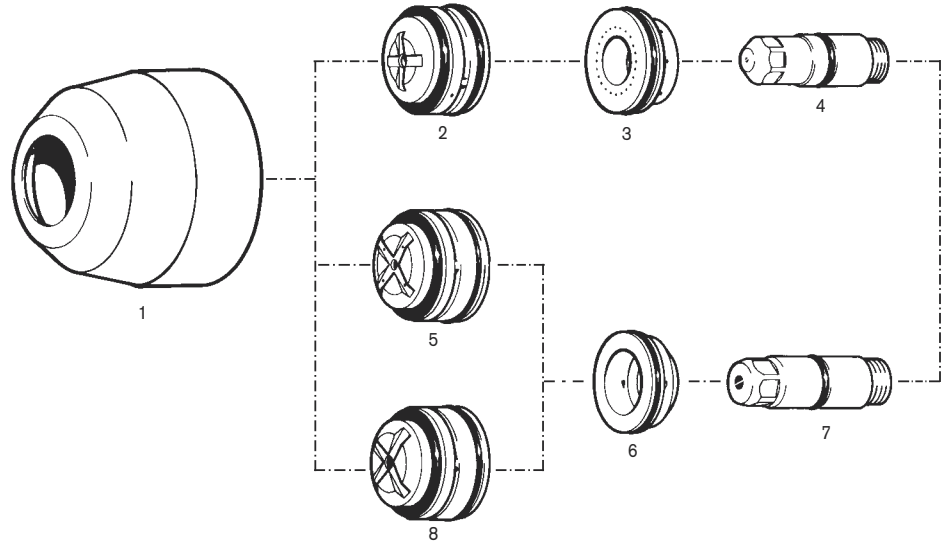
PART NUMBER	DESCRIPTION	QTY
020046	Brkt w/Clevis: 2" Tch Mtg (Standard)	1
029044	Tch Mtg SA:2" (for IHS system)	
020039	Swirl Ring, .120	2
020082	Electrode, Nitrogen	3
020084	Nozzle, .166, Nitrogen	5
020086	Nozzle, .099, Oxygen	5
020579	Cap, Nozzle Retaining	1
020089	Nozzle, .120, Nitrogen	3
020623	Swirl Ring, PAC170	3
020663	Electrode, PAC170. Oxygen	5
027001	Wrench, Electrode	1
027012	Lubricant, Silicon	1
027347	Water Tube Tool	1



# Hypertherm®

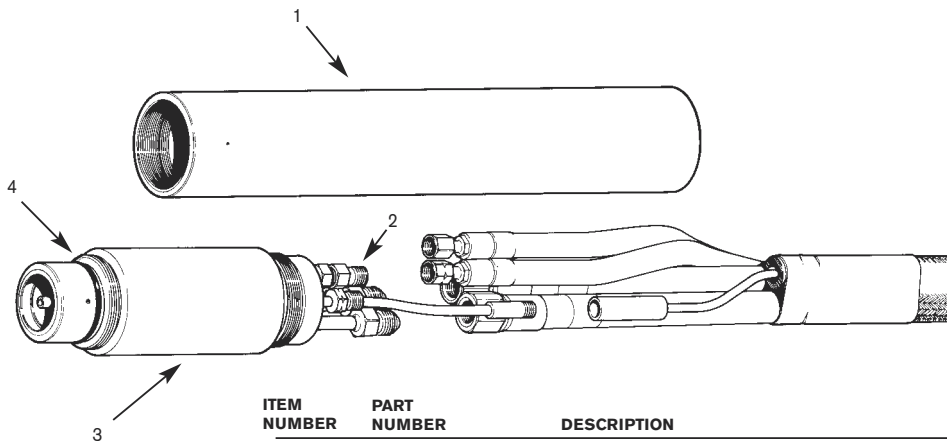
## HT400

### Consumables



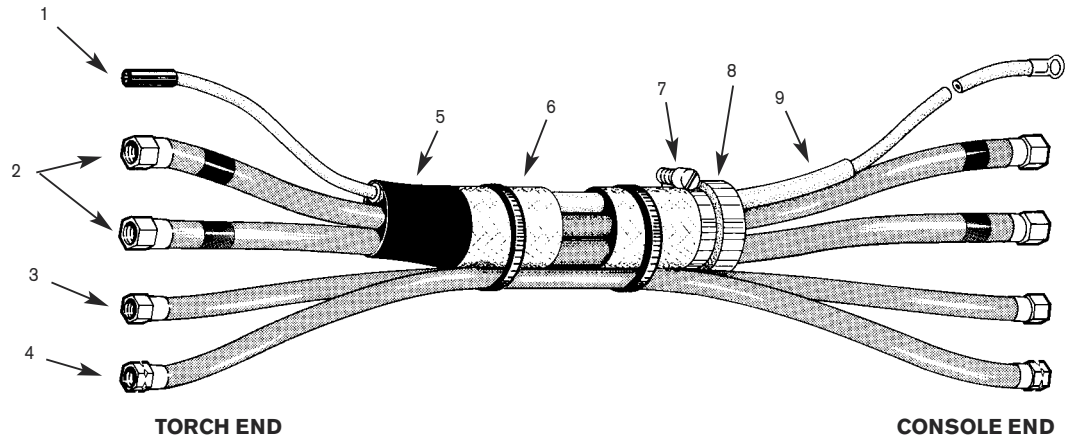
	ITEM NUMBER	PART NUMBER	DESCRIPTION
<b>Oxygen Parts</b>	1	020579	Cap, Nozzle Retaining
	2	020086	Nozzle, .099 Oxygen
	3	020096	Swirl Ring, Oxygen
	4	020081	Electrode, Oxygen
<b>Nitrogen Parts</b>	1	020579	Cap, Nozzle Retaining
	5	020089	Nozzle, .120 Nitrogen
	6	020039	Swirl Ring, Nitrogen
	7	020082	Electrode, Nitrogen
	8	020084	Nozzle, .166 Nitrogen

### HT400 Torch Assembly



ITEM NUMBER	PART NUMBER	DESCRIPTION
	028229	Torch Assembly
1	020041	Sleeve, Insulating
2	004146	Orifice, Critical
3	020080	Torch Main Body
4	044028	O-Ring, Buna

## HT400 Torch Leads Package



**PART  
NUMBER DESCRIPTION**

### \*20-FOOT SHIELDED TORCH LEADS PACKAGE COMPONENTS

PART NUMBER	DESCRIPTION
1	023036 Lead, High Frequency, 1 -Plug
2	023012 Cable, Water Cooled (Two Required)
3	024017 Hose Assembly, Torch Gas
4	024018 Hose Assembly, Torch Water
5	046026 Tubing, 1 1/2" Inner Diameter Shrink Black (3 Inches)
6	046010 Tubing, 1 1/8" Inner Diameter Tinned Braid (25 Feet)
7	015090 Clamp, Hose, 1 5/16"-2 1/4"
8	004080 Collar, Shield Torch Leads
9	046033 Tubing, 3/8" Inner Diameter Nylobrade (20 Feet)

### HT400 TORCH LEADS PACKAGES

028137	Leads, Torch, Shielded, 10'
028138	Leads, Torch, Shielded, 15'
028139	Leads, Torch, Shielded, 20'
028140	Leads, Torch, Shielded, 25'
028141	Leads, Torch, Shielded, 30'
028142	Leads, Torch, Shielded, 35'
028143	Leads, Torch, Shielded, 40'

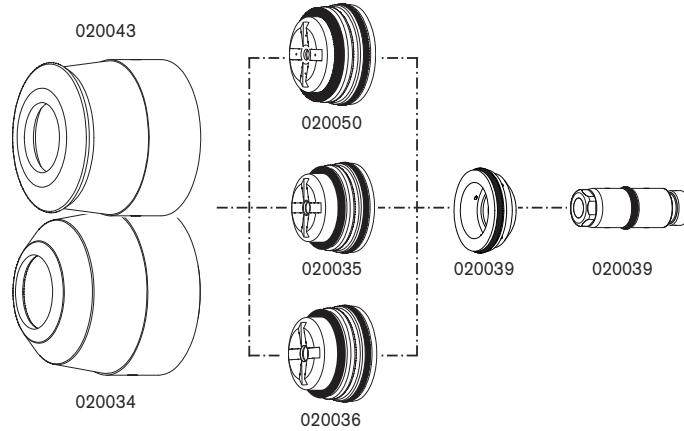


# Hypertherm®

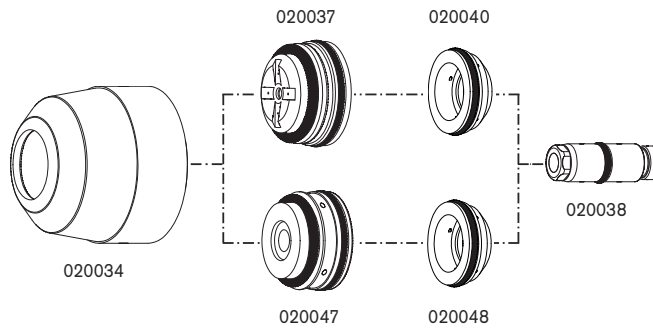
## PAC500®

### Consumables

Up to 600 Amps

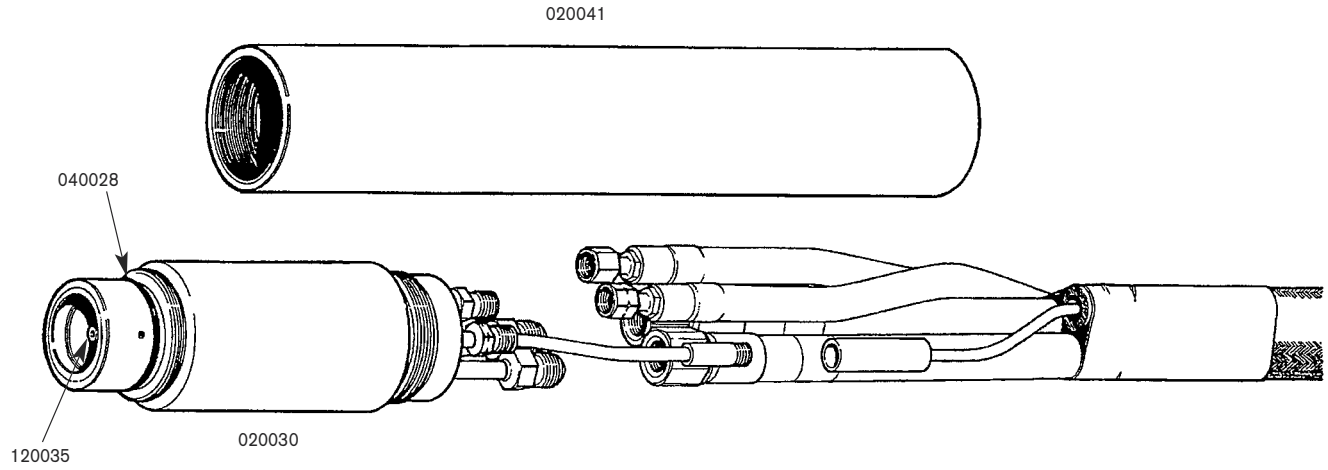


600 to 1000 Amps



	PART NUMBER	DESCRIPTION
Up to 600 Amps	020043	Cap, Nozzle Retaining, Flared
	020034	Cap, Nozzle Retaining, Tapered
	020050	Nozzle, .120
	020035	Nozzle, .166
	020036	Nozzle, .187
	020039	Swirl Ring, .120/.166/.187
	020038	Electrode
600 to 1000 Amps	020034	Cap, Nozzle Retaining, Tapered
	020037	Nozzle, .220
	020047	Nozzle, .250
	020040	Swirl Ring, .220
	020048	Swirl Ring, .250
	020038	Electrode

## **PAC500 Torch Assembly (028031, 028160)**



PART NUMBER	DESCRIPTION
028031	Torch Assembly, Flared Cap
028160	Torch Assembly, Tapered Cap
020030	Torch Main Body
020536	Lead Insulator, 9/16 x 2.5"
020041	Sleeve, Insulating
044028	O-Ring, Buna-N
120035	Water Tube

# The Hypertherm mechanized systems



HPR260



HPR130



HD4070 HyPerformance



HD3070 HyPerformance



HT4400 HySpeed



HT2000 HySpeed



Powermax200



HSD130 HySpeed Plasma



MAX 70/100



MAX 100D



Powermax1650



Powermax1250



Powermax1000



Powermax600



HD4070 HyDefinition



HD4070 HyDefinition

Not shown: HT4001, HT4000, HT400, PAC500