

Hypertherm
HT4001

***Water-injection plasma arc
cutting system***

ISO 9001

- Optional beveling consumables allow you to bevel cut at angles of up to 45° with a simple parts change. Maximum thickness depends upon bevel angle.
- The HT4001 may be mounted on a wide variety of X-Y cutting systems, punch presses or robots. It can cut material above, on, or under water. Use it with oxygen or nitrogen to give you the flexibility of maximum cut quality on any metal.
- A Remote High Frequency console lets you locate the power supply up to 200 feet (61 m) from the torch with minimal high frequency interference.
- Optional Torch Height Control and Initial Height Sensing systems provide the ability to automatically position the torch which ensures optimal operation.

HT4001 system components

- HT4001 Power Supply
- PAC620 Water-Injection Torch Assembly
- Torch Leads
- Work Cable
- Gas Console
- Motor Valve Console
- Remote High Frequency (RHF) Console
- Leads and Cables
- Optional Initial Height Sensor and Torch Height Control
- Optional Remote Voltage Control
- Optional Water Muffler and Pump
- Optional Water Chiller
- Optional H-401 or H-601 Power Supply Slave

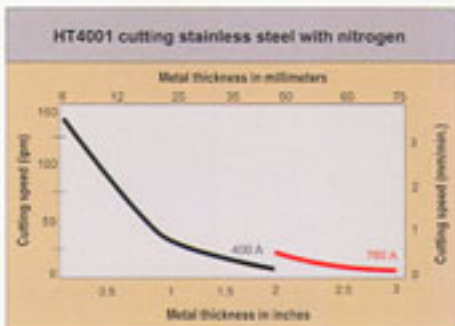
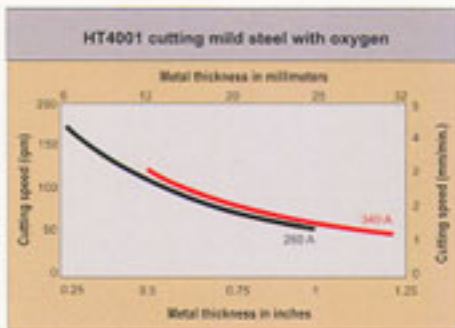


Power output ranges

- 260-Amp: For dross-free oxygen cutting of mild steel up to 1 inch (25 mm) thick with maximum parts life.
- 340-Amp: Highest power oxygen cutting of mild steel up to 1 1/4 inch (32 mm) thick with superior cut speed and quality.
- 400-Amp: Base system power output up to 400 amps for nitrogen cutting of stainless steel and aluminum up to 2 inches (50 mm) thick.
- 760-Amp: Power output with H-401 slave power supply up to 760 amps for nitrogen cutting of stainless steel and aluminum up to 3 inches (75 mm) thick.

Optimize performance

Genuine Hypertherm parts are designed to optimize performance for each torch, power supply and application. Using anything other than genuine Hypertherm parts poses a risk to your cutting system's reliability. Imperfect dimensioning may lead to expensive problems such as torch shorting, overheating and system failure. Using only Hypertherm consumables will safeguard your system, reduce rework costs and save time spent changing parts.



Genuine Hypertherm Consumables

The only way to ensure maximum performance

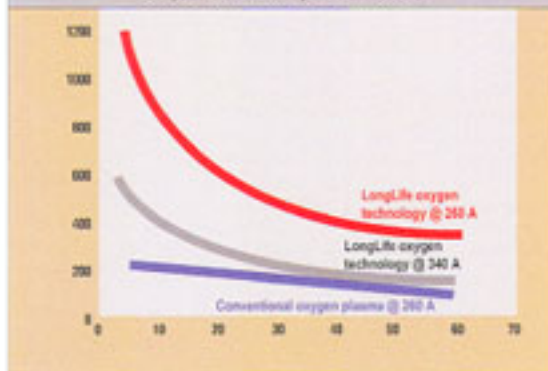
HT4001

The HT4001 water-injection system provides superior cut quality, high productivity, extended parts life and expansion flexibility

The ideal combination of quality, productivity and flexibility

HT4001 water injection system LongLife oxygen technology

Compared to conventional plasma electrode life*



- 340-amp oxygen capability pierces and cuts mild steel up to 1-1/4 inch (32 mm) at 90°, approximately 3/4-inch at 45° bevel
- LongLife™ oxygen technology reduces costs
- 400-amp base system expandable to 760 amps

Powerful flexible system

The Hypertherm HT4001 introduces 340-amp oxygen capability to provide clean, fast production cutting of mild steel up to 1-1/4 inch (32 mm) thick with no dross under most conditions. By using oxygen as the plasma gas, nitriding is virtually eliminated - and so is the need for expensive grinding operations.

The system also operates with nitrogen, delivering cuts on stainless steel or aluminum up to 2 inches (50 mm) thick. Patented LongLife oxygen parts technology greatly increases the life of parts through microprocessor control of power and flow parameters, keeping your costs down.

As an option, the HT4001 may be paralleled with a slave power supply for cutting aluminum or stainless steel up to 3 inches (75 mm) thick.

It's a powerful, flexible system designed for high volume production applications where reliability is vital.

Superior cut quality

- 340-amp oxygen capability delivers dross free cuts up to 1-1/4 inch (32 mm) thick at 90°, approximately 3/4-inch at 45° bevel.
- Oxygen plasma is the optimal choice for cutting mild steel. It eliminates dross across a wide cut range. You get faster cut speeds at lower power levels.
- Oxygen plasma improves weldability of the cut face because it virtually eliminates nitriding on mild steel. Cut edge surfaces are exceptionally smooth.

- Using nitrogen, the HT4001 delivers 400 amps of power to slice cleanly through 2 inches (50 mm) of stainless steel or aluminum.

Highest productivity

- The HT4001 is designed for 100% duty cycle at 80 kw output to give you maximum uptime.
- Longer parts life means less downtime for nozzle consumable replacement and more cutting time.
- Superior system reliability ensures that the HT4001 will be running when you need it.
- The HT4001 delivers excellent cut speed. For example, at 340 amps you'll cut 110 inches (2.8 m) of 1/2-inch (12 mm) mild steel per minute - with virtually no clean-up needed.

Lower costs

- Hypertherm's patented LongLife parts technology greatly extends the life of consumables while using oxygen, yielding impressive cost savings.
- Superior cut quality means minimal clean-up. That reduces your labor costs and makes your operation more efficient.

Maximum flexibility

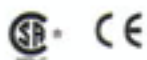
- Available power of 260 or 340 amps for oxygen cutting and up to 760 amps for nitrogen cutting.
- You can add a slave power supply at any time to provide output current up to 760 amps. This extends the cutting range of your HT4001 to 3-inch (75 mm) stainless steel or aluminum.



HT4001

Operating data

Specifications



HT4001 without slave

Input Voltage	200/220 V, 3PH, 50-60 Hz @ 275/234 A
Input Current	380/400/415 V, 3PH, 50-60 Hz @ 135/128/124 A 240/480 V, 3PH, 60 Hz @ 214/107 A 575/600 V, 3PH, 60 Hz @ 89/86 A
Output Voltage	80-200 VDC
Max Output Current	400 A
Maximum OCV	325 VDC
Duty Cycle	100% @ 104° F (40° C) @ 80 kw (The HT4001 operates at 100% duty cycle throughout its cutting range.)
Dimensions	34" (863 mm) Width 51" (1295 mm) Height 48 11/16" (1236 mm) Depth
Weight	1800 lb (817 kg)
Gas Supply:	
Plasma gas types	Oxygen (99.5% pure), Nitrogen (99.995% pure)
Oxygen inlet pressure	120 psig (8.3 bar)
Nitrogen inlet pressure	150 psig (10.3 bar)
Water Supply:	
Water to RHF	2.5 gpm (9.5 l/m) at 150 psig (10.3 bar) @ 70° F (21° C) Max.
Water to Chiller	0.5 gpm (1.9 l/m) at 35 psig (2.4 bar)

H-401 slave power supply

Input Voltage	200 V, 3PH, 50-60 Hz @ 360 A
Input Current	380/415 V, 3PH, 50-60 Hz @ 180 A 230 V, 3PH, 60 Hz @ 310 A 460 V, 3PH, 60 Hz @ 155 A 575 V, 3PH, 60 Hz @ 125 A
Output Voltage	80-200 VDC
Max Output Current	760 A (in parallel with base HT4001)
Maximum OCV	400 VDC
Duty Cycle	100% @ 104° F (40° C) @ 152 kw (in parallel with base HT4001)
Dimensions	27-1/4" (690 mm) Width 43" (1090 mm) Height 46" (1170 mm) Depth
Weight	1905 lb (866 kg)

For additional information, call:
TOLL-FREE IN THE USA & CANADA: 1-800-643-0030

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HT4001 without slave

Material	Current (Amps)	Thickness (Inches)	Cutting speed (ipm)	Thickness (mm)	Cutting speed (mm/min.)		
Mild steel O ₂ plasma	280	1/4	170	8	3850		
		1/2	100	12	2730		
		3/4	70	20	1700		
		1	50	25	1300		
	340	1/2	110	15	2570		
		3/4	85	20	2080		
1		65	25	1680			
1-1/4		45	30	1280			
Stainless steel N ₂ plasma	280	.035	450	.889	11430		
		.075	300	.191	7620		
		1/8	200	3	3950		
		1/4	150	6	3810		
	380	3/8	125	10	3170		
		1/2	100	10	3070		
		3/4	80	15	2080		
		1	30	20	1200		
	400	1-1/8	20	25	790		
		1-1/2	12	50	310		
		Aluminum N ₂ plasma	200	.035	540	.889	13700
				.075	360	.191	9140
1/8	240			3	6100		
1/4	180			6	4730		
380	3/8	150	10	3810			
	1/2	120	12	3050			
	400	3/4	80	10	3700		
		1	35	15	2500		
1-1/8		30	20	1420			
1-1/2		15	25	940			
2	15	50	400				

HT4001 with H-401 slave power supply

Material	Current (Amps)	Thickness (Inches)	Cutting speed (ipm)	Thickness (mm)	Cutting speed (mm/min.)
Mild steel N ₂ plasma	480	1/2	110	12	2800
		3/4	70	20	1780
		1	60	25	1520
		600	1-1/2	30	15
	20			20	1750
	15			25	1540
	9			35	950
	700	2	20	50	520
			25	50	635
			12	60	510
			8	75	320
	Stainless steel N ₂ plasma	480	1/2	110	12
3/4			70	20	1780
1			60	25	1520
600			1-1/2	20	15
		15		20	1750
		10		25	1540
		6		35	950
700		2	20	50	520
			25	50	630
			12	60	510
			8	75	320
Aluminum N ₂ plasma		500	1	80	25
	1-1/2		45	38	1150
	2		30	30	1710
	15		40	1090	
	700	2	30	50	780
			25	50	760
			15	60	620
			10	75	380

Note: Bevel speeds should be reduced by at least 5%.

Hypertherm

The world leader in
plasma cutting technology™

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