

THERMAL DYNAMICS®

Thermal Dynamics®

ULTRA-CUT® 130 XT PRECISION PLASMA SYSTEM



The Ultra-Cut® 130 XT for cutting up to 3/4" (20 mm) on mild steel is the latest addition to the successful Ultra-Cut Series of high precision plasma cutting systems. It provides superior quality, higher productivity and low cutting cost.



Bring Performance to the Table.

Thermal Dynamics®

ULTRA-CUT® 130 XT

The new Ultra-Cut 130 XT is the latest addition to the successful range of Ultra-Cut XT systems. With outstanding parts performance, speed and low gas consumption, this is the perfect system for up to 3/4" (20 mm).

Superior Cut Quality up to 3/4" (20 mm)

The Ultra-Cut XT system's superior cut quality means that parts can go directly from the cutting table to welding, painting or assembly without expensive secondary operations.

Ultra-Cut XT high precision plasma systems feature:

- Excellent dross-free cuts using oxygen (O₂) plasma on mild steel up to 3/4" (20 mm).
- Outstanding cut quality on non-ferrous metals using Water Mist Secondary (WMS®) process. The WMS process is a standard feature - no other gas-console needed.
- ISO 9013:2002 (E). Class 2 and 3 or better cut angles for true High Precision cuts.

Best Productivity with Maximum Cut Speed at 3/4" (20 mm)

Ultra-Cut XT high precision systems deliver superior cut quality at superior cutting speeds.

- Best cut speeds on 3/4" (20 mm) mild steel
- Outstanding parts life, speed and reduced gas consumption reduces down time and lower the overall cost of ownership.
- Reduced downtime during parts changes with the Speedlok cartridge design.

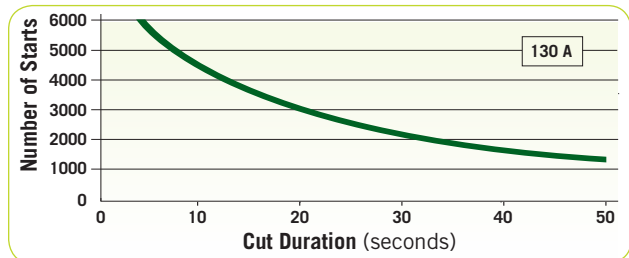
Manual 1Torch® ScrapCutter Option

There's no longer a need for an external manual plasma cutter or oxy-fuel torch to cut the leftover metal skeleton into manageable pieces. Just connect the manual TD 1Torch.

- Consistent 100A output.
- Torch length up to 100 ft (30 m) including extensions.
- Activated by torch trigger only. No need to go back to XT power supply to switch the function on or off.



Longer Parts Life with XTremeLife™ Consumables



Note: 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.

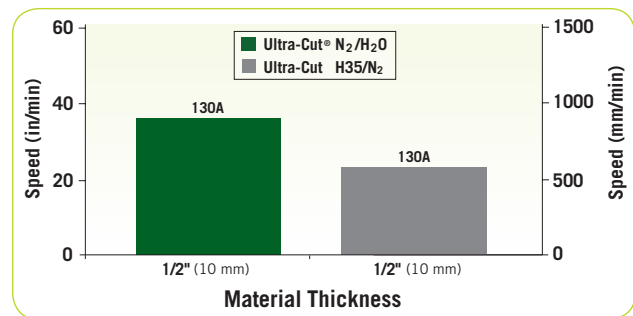
High Quality Holes with Diameter PRO™

Diameter PRO produces precise "Bolt Ready" holes optimized for a diameter-to-thickness ratio of 1:1 or greater. It is the ideal process for a precision hole or radius with minimal-to-no taper on mild steel from 10 gauge (3 mm) to 3/4" (20 mm).



Use it with Thermal Dynamics iCNC Performance or any CNC configured with the Thermal Dynamics Optihole process data.

Stainless Steel Cutting Speed Comparison

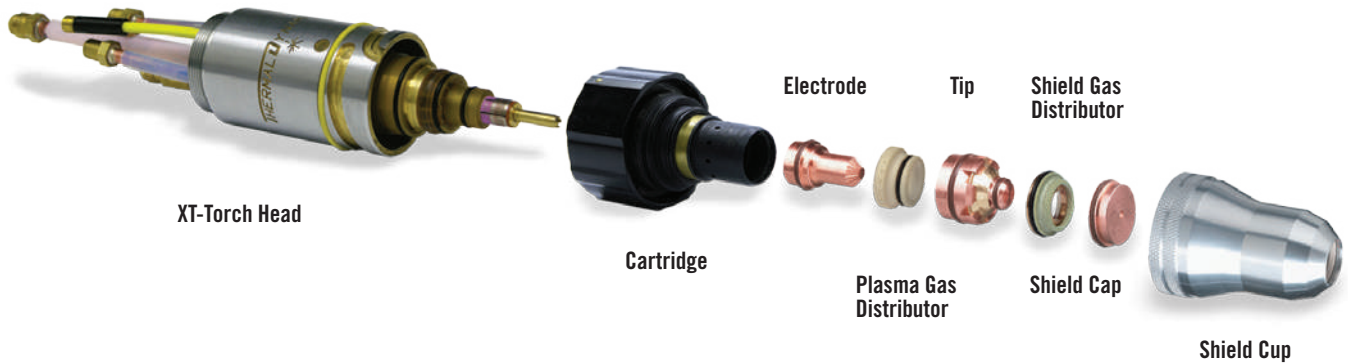


World-class quality, maximum cut speed and lower costs on non-ferrous metals (standard feature)

- The Water Mist Secondary (WMS) process produces an excellent cut quality on non-ferrous (Stainless steel, Aluminum) using N₂ as plasma gas and (filtered) tap water as secondary.
- Low operating cost (not using expensive industrial gas).
- Dross-free cutting from gauge (1 mm) to 3/4" (20 mm).
- Significantly higher cut speeds compared to H35 cutting.
- The WMS process comes as a standard feature; there is no need of a more expensive gas console.

Bring Performance to the Table.™

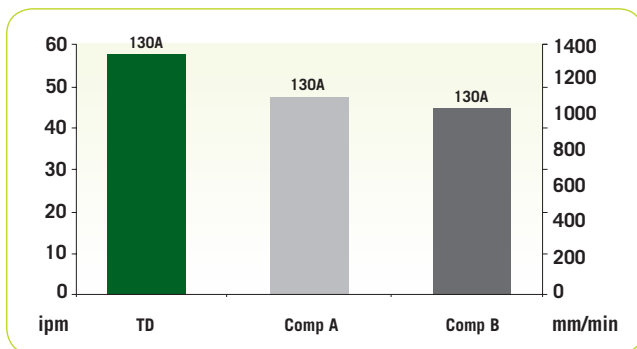
XT™ Torch Technology – The Standard for High Precision Plasma Cutting Systems



- No Tools Required
- Self-Centering Components
- Precision Cuts on All Metals
- ‘Leakless’ Torch Head Design
- Superior Warranty
- Relaxed Cutting Parameters

Highest Cut Speed on 3/4" (20 mm)

Outstanding cut speeds ensure the highest productivity and lowest cost of operation.



ONE gas control for ALL applications.

Automatic gas console with built-in Water Mist Secondary (WMS) process for **ALL** materials at the best possible quality. Pairing with the iCNC Performance achieves the best level of cut quality control by instantly setting and controlling gas pressures. This leads to faster cycle times and more productive cutting and marking.

Increase cut power as your business grows

With StepUp™ Modular Power Technology, your system has the flexibility to grow with your business. You can start with an Ultra-Cut 130 XT, and, when you are ready, expand to a 200, 300 or 400 Amp system. With the Ultra-Cut XT, you never have to worry about choosing the right system.



Thermal Dynamics®

ULTRA-CUT® 130 XT

System Capabilities

		Ultra-Cut® 130 XT
MILD STEEL	Production Pierce	3/4" (20 mm)
	Maximum Pierce	1" (25 mm)
	Edge Start	1-1/2" (40 mm)
STAINLESS STEEL	Production Pierce	5/8" (15 mm)
	Maximum Pierce	3/4" (20 mm)
	Edge Start	1-1/2" (40 mm)
ALUMINUM	Production Pierce	3/4" (20 mm)
	Maximum Pierce	7/8" (22 mm)
	Edge Start	1-1/2" (40 mm)

Unit Specifications*

Rated Output (Amps)	130 A
Output Range (Amps)	5-130 A
Output (Volts)	180 V
Input Volts (Volts, Phase, Hertz)	230 V, 3 ph, 50-60 Hz, 380 V, 3 ph, 50-60 Hz, 400 V, 3 ph, 50-60 Hz 480 V, 3 ph, 50-60 Hz 600 V, 3 ph, 50-60 Hz
Input Amps (Amps, Volts)	78 A @ 230V 43 A @ 380 V 41 A @ 400 V 34 A @ 480 V 30 A @ 600 V
Duty Cycle (@ 104°F / 40° C)	100% (23.4 kW)
Max OCV	425 V
Plasma Gas	Air, O ₂ , Ar-H ₂ , N ₂ @ 120 psi (8.3 bar) and Ar for marking with DFC 3000
Shield Gas	Air, N ₂ , O ₂ @ 120 psi (8.3 bar), H ₂ O @ 10 GPH (0.6 l/min)
Power Supply Weight	740 lbs (336 kg) for 230V 410 lbs (186 kg) for 380, 400, 480V 652 lbs (296 kg) for 600V
Dimensions (H x W x D)	48.0" x 27.5" x 40.6" (1219 mm x 698 mm x 1031 mm) H + 17.5" 445 mm 230V / 600V units
Certifications	CSA, CE, CCC

* Subject to change without notice



Cutting Speed Chart For Ultra-Cut® XT Systems

Material	Thickness (in)	Speed (IPM)	Amps	Plasma/ Shield	Thickness (mm)	Speed mm/min.
Mild Steel	10 ga.	50	30	O ₂ /O ₂	3	1340
	1/4	100	70	O ₂ /Air	6	2710
	1/4	160	130	O ₂ /Air	6	4300
	1/2	77			12	2160
	3/4	52			20	1321
Stainless Steel	16 ga.	205	30	N ₂ /H ₂ O	1.5	5500
	14 ga.	170	50	N ₂ /H ₂ O	2	4310
	3/16	50			4	2410
	1/4	50	70	N ₂ /H ₂ O	6	1490
	1/4	110	130	N ₂ /H ₂ O	6	2896
Aluminum	1/2	50			12	1346
	0.052	150	30	N ₂ /H ₂ O	1.5	3210
	1/4	70	70	N ₂ /H ₂ O	6	2060
	1/4	105	130	N ₂ /H ₂ O	6	2896
	1/2	55			12	1473

Note: The cutting speed chart includes preliminary data and is subject to change without notice. Take care in comparison. The speeds noted above are best cut quality 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 Ultra-Cut XT systems. Please contact Thermal Dynamics® for more information.

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