ESAB
ALL DAY.
EVERY DAY.
NO EXCEPTIONS.
ESAB
CUTMASTER® TRUE™ SERIES

MORE PUNCH
WHEN YOU NEED IT.

ESAB® CUTMASTER® TRUE™ SERIES HAS BEEN DESIGNED WITH THE IDEA THAT RECOMMENDED CUT CAPACITY SHOULD ALSO BE THE TRUE CUT CAPACITY. THE TRUE CUT SERIES ELIMINATES THE CONCEPT OF HAVING TO "BUY UP", PURCHASING A MACHINE LARGER THAN YOU ACTUALLY NEED. WITH THE INTRODUCTION OF THE ESAB CUTMASTER TRUE SERIES, A 25 MM RECOMMENDED CAPACITY MACHINE WILL CUT 25 MM MATERIAL ALL DAY LONG.

TRUTH #1

TRUE CONFIDENCE – The ESAB Cutmaster TRUE Series micro-processor controlled front panel LED's assure extreme operator confidence and error free use from setup to clean up.

TRUTH #2

TRUE STRENGTH – The ESAB Cutmaster TRUE Series allows you to work all day at our recommended cut capacity. But when you need that extra punch, you can be confident that it's there.

TRUTH #3

TRUE PROTECTION – As if a 3 year unlimited power supply warranty wasn't enough, the ESAB Cutmaster TRUE Series is the only line of plasma cutting machines that features TRUE GUARD™ – a rugged roll bar for added durability on our larger plasma systems.*

TRUTH #4

TRUE TIP™ – The ESAB Cutmaster TRUE Series plasma system offers the only 60 Amp drag cutting tip on the market today.*

TRUTH #5

TRUE FLEXIBILITY – The new ESAB Cutmaster TRUE Series features the versatile and patented 1Torch® with SureLok® technology giving you the confidence the electrode is locked into position at every start. Consumable parts; lead extensions provide cutting up to 100' (30.5 m) from power supply; and the flexibility to move quickly from hand to mechanised cutting all with the change of a torch. (Add PCB for CNC interface.)

TRUTH #6

TRUE PORTABILITY – The ESAB Cutmaster TRUE Series offers lighter, more portable machines without compromising performance.

* Not available on the ESAB Cutmaster 40

FEATURES

TRUE GUARD™ roll bar

Provides easy transportation, protects the front and rear of the power supply for unmatched durability.

User Controls

All user controls are conveniently located on the front panel.

Color Coded LED's

Indicate pressure status and setup errors.

Mobility

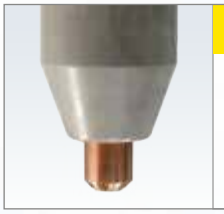
Lightweight design improves portability (Reduced nearly 50%).

Auto Pilot Restart

This feature instantly reignites the pilot arc while cutting expanded metals.

Storage

Convenient storage compartment for spare and consumable parts.



60 Amp Tip

The industry's only 60 Amp Drag Tip.

Flexibility

Multiple torch capability (Hand, Mechanised and Automation).

Quick Connect

ATC® (Advanced Torch Connector) quick torch connect/disconnect with no tools required.

1TORCH® FEATURES.

Ergonomic Torch Handle
Hand Torches offer ergonomic handles with easy-to-use trigger release that provides comfort during prolonged use. 75° and 90° heads offer operators a choice of positions.

New Phenolic Position Tube
With an innovative, easy-to-remove 32 pitch gear rack, the phenolic positioning tube can easily be adapted to any 1⅜" (35 mm) torch holder. If manual torch position is required, the use of the gear rack will complete the task. Simply remove the gear rack from the positioning tube if not needed.

Extended or Protected Consumable Parts
1Torch consumable parts are designed to adapt to your cutting style. By simply changing the shield cup, you can either have:

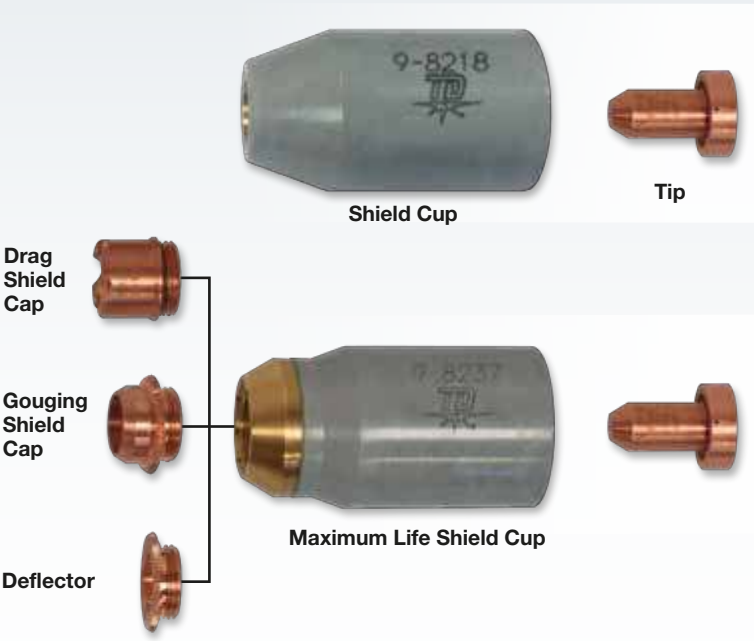
- An extended tip for greater visibility and control and precision drag cutting at low power.
- A protected tip for on the plate drag cutting at high power up to 120 Amps.

Lower Consumable Parts Inventories and Costs
Only 34 consumable parts cover the full range of cutting and gouging up to 120 Amps. Inventorying parts for a fleet of plasma units can be simplified using the 1Torch®.

Improved Leads
1Torch leads are lightweight, extremely flexible, and rugged enough to withstand years of use.

ATC® (Advanced Torch Connector) Quick Disconnect Option
The ATC quick disconnect design brings extra flexibility to almost any plasma system. Switching to a machine torch, swapping out a damaged unit, or simply changing lead lengths is done quickly and requires no tools.

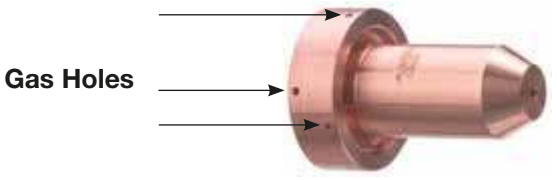
ATC Lead Extensions
ATC Lead extensions offer the flexibility of working up to 100' (30.4 m) away from the power supply. Extensions are offered in 15' (4.5 m), 25' (7.6 m), and 50' (15.2 m) lengths. The ATC makes it easy to add or subtract total torch lead length as requirements change.



Patented SureLok® Electrode Technology
Eliminates the need for an installation tool and ensures precise electrode and tip alignment which results in a highly defined arc and precise cuts. SureLok alignment also means longer tip and electrode life and reduced operating costs.

Total Gas Management™ eliminates the need for a separate plasma gas baffle. Each tip includes plasma gas ports uniquely tuned to optimise cutting performance at its rated current. Precision gas control, longer consumable parts life and better cut performance.

Advanced Consumables Design with Total Gas Management: Cutmaster® systems incorporate the gas baffle into the tip, which eliminates the need for a separate plasma gas baffle, prevents gas distributor deterioration, and ensures that the user is getting consistent, high quality cuts without compromising parts life.



Powered by Thermal Dynamics®
- **Excellent at High Cut Speeds:** Excellent cutting ratios (mm/min.) ensure that high quality cuts are achievable even at higher cutting speeds.

Start Cartridge

Electrode

Cutmaster Black Series Consumables

Designed to operate 60% longer than standard consumables.

75° TORCH HEAD

90° TORCH HEAD

180° TORCH HEAD

- **Stainless Steel:** Cutmaster systems offer excellent performance for cutting stainless steel.
- **Lower Thicknesses:** Cutmaster systems offer superior cut quality on thinner metals (Less than 3mm).
- **No Dross:** When operated correctly, Cutmaster TRUE™ systems can cut with little-to-no dross.
- **High Cut Capacities:** Cutmaster TRUE systems offer high TRUE cut capacities.

Trigger Latch

This feature prevents hand fatigue during long cuts.

Quick Connect

ATC® (Advanced Torch Connector) Quick Torch Connect/Disconnect With No Tools Required.

Improved Leads

Lightweight, flexible, and durable for years of use.

1TORCH® CONSUMABLE PARTS APPLICATION GUIDE.

For SL60® and SL100® Manual Cutting and Gouging Operations

DRAG TIP CUTTING

The preferred method of cutting light gauge metal up to 1/4" (6 mm) thickness. Produces the best cut quality narrowest kerf width, fastest cutting speeds, and with little to no distortion. Traditional drag cutting was limited to 40 Amps or less; now with Thermal Dynamics® TRUE™ Cut Drag Tip Series™ technology, it is possible to cut up to 60 Amps. For best results, use the Shield Cup with the torch tip in direct contact with the work (up to 60 Amps).

STANDOFF CUTTING

The preferred method of cutting metal thicker than 1/4" (6 mm) and at current levels above 60 Amps. Provides maximum visibility and accessibility. Shield cup for 'standoff' cutting (with the torch tip 1/8" (3 mm) to 1/4" (6 mm) from the work piece). Use the shield cup body together with the deflector for extended parts life and improved resistance to reflect heat. This combination provides cutting results similar to the single piece shield cup, as well as easy changeover to gouging or drag shield cutting.

DRAG SHIELD CUTTING

This is an operator-friendly method of cutting between 70 to 120 Amps while maintaining a constant standoff distance. For metal thickness greater than 1/4" (6 mm), simply drag the shield cap in contact with the work piece. Use the shield cup body with the appropriate drag shield cap matching the current level being used. This method is not recommended for cutting light-gauge sheet metal.

GOUGING

A simple method of metal removal by angling the torch to a lead angle of 35°- 45°, and using a gouging tip. While maintaining a constant standoff distance, this allows for only a partial penetration into the work, thus removing metal from the surface. The amount of current, travel speed, standoff distance, lead angle, and tip size will determine the deflector. Also, you can use the single piece shield cup.

GOUGING PROFILES

	Output Range	Depth	Width	Profile
Tip A	40 Amps (MAX)	Shallow	Narrow	
Tip B	50-100 Amps	Deep	Narrow	
Tip C	60-120 Amps	Moderate	Moderate	
Tip D	60-120 Amps	Shallow	Wide	
Tip E	120 Amps	Moderate	Wide	

DRAG SHIELD CUTTING

MECHANISED CUTTING

GOUGING

ACCESSORIES.

Cutting Guide Kit (Deluxe)

PART NO. 7-8910

PCH 10, 25, 26, 28, 35, 40, 42, 60, 62, 75, 76, 80, 100XL, 102, RPT 28, 100R(ER) 1Torch

Cuts circles from 54 mm (2⅛") to 1054 mm (41½") with proper cutting attachments. This kit includes easy add-on attachments to fit most Thermal Dynamics® torches for precise straight line, circle cutting and beveling. Includes Carrying Case, Radius/Roller Kit (7-7501), Circle Cutting Guide (7-3291), Magnetic Pivot, Suction Pivot.

Circle Cutting Guide Kit

PART NO: OTD7/3291

PCH 10, 25, 26, 28, 35, 40, 42, 60, 62, 75, 76, 80, 100XL, 102, RPT 28, 100R(ER) 1Torch

Cuts 54 mm (2⅛") to 705 mm (27¾") circles (using magnetic attachment) when cutting or beveling is required. For use with most Thermal Dynamics torches. Guide shown with optional pivot (7-3148).

Radius/Roller Cutting Guide Kit

PART NO: OTD7/7501

PCH 10, 25, 26, 28, 35, 40, 42, 60, 62, 75, 76, 80, 100XL, 102, RPT 28, 100R(ER) 1Torch® (not cirlces, only radius)

This easy-to-use guide cuts circles from 76 mm (3") up to 730 mm (28¾"). Maintains a consistent height off the work piece whether you are using the circle cutting attachment for cutting circles or the roller guide feature to improve your straight-line cutting. Both novices and experts will see noticeable improvement in quality, speed, and parts life. Can be used with most Thermal Dynamics torches.

Straight Line Cutting Guide

PART NO. 7-8911

Introducing a new cutting guide accessory suitable for all hand torches, PCH-10 through PCH-102 and the 1Torch. This versatile, straight line cutter is for hand held systems and it cuts vertical, 90° or bevel cuts. Its consistent standoff improves cut quality and maximizes overall performance. Produces more efficient straight line cuts.

Lightweight, minimum set up time, and no power required. Magnetic mounts ensure placement and ease of use. Optional suction plates available for non-magnetic applications (i.e. aluminum and stainless steel). The Cutting Guide Kit includes: 1.2 m (4 ft) standard rail Torch Holder and Bushing Heavy Duty Magnets (2 ea.) Slide Assembly Wheels and Fasteners. Optional 1.2 m (4 ft) extensions (9-7971) available.

Standoff Cutting Guides

PART NO: OTD9/8422 For use with 40A tips on the SL60/SL100 Torch

PART NO. 9-8281 For use with 60-100A tips on the SL60/SL100 Torch

Leather Lead Covers

PART NO. 9-1260 20 ft (6.1 m)

PART NO. 9-1280 50 ft (15.2 m)

These lead covers are suitable for both 1Torch and SureLok® leads. Snaps make it easy to install. For wider torches, consider snapping two covers together width wise.

ATC® Lead Extensions

7-7544 4.6 m (15 ft)

7-7545 7.6 m (25 ft)

7-7552 15.2 m (50 ft)

Available for any system using 1Torch with ATC Quick Disconnect. Leads Extensions enable you to customize your lead length to suit the cutting job up to 30.5 m.

Trigger Guard Guides 1Torch (SL60 and SL100)

PART NO. 9-8420 Short Trigger Guard

This guard offers additional protection from accidental activation or damage to the torch switch.

Remote Pendant Control

PART NO. 7-3460 20 ft (6.1 m)

Remote Pendant Control for your mechanised applications.

Hand Pendant Extension

PART NO. 7-7744 25 ft (7.6 m)

Extension cable for 7-3460 Remote Pendant Control

Air Filter/Air Filter Kits

For improved consumable parts life and overall performance, Thermal Dynamics recommends Air Filter Kits be used on all plasma cutting systems.

Single Stage Air Filter Kit

PART NO. 7-7507

(Filter Body 9-7740, Hose 9-7742, Filter Element 9-7741)

For use with shop compressed air systems, this in-line filter will not allow moisture or water to pass through the filter element even if it becomes completely saturated. This hi-tech filter element actually blocks the absorption of water to increase performance and improve consumable parts life.

Two Stage Air Filter

PART NO. 9-9387

For Cutmaster® TRUE™

The Two Stage Air Filter will remove moisture and contaminants from the air stream when using compressed air. The filter is capable of filtering to at least 5 microns. The filter assembly is pre-assembled and need only be installed on the power supply.

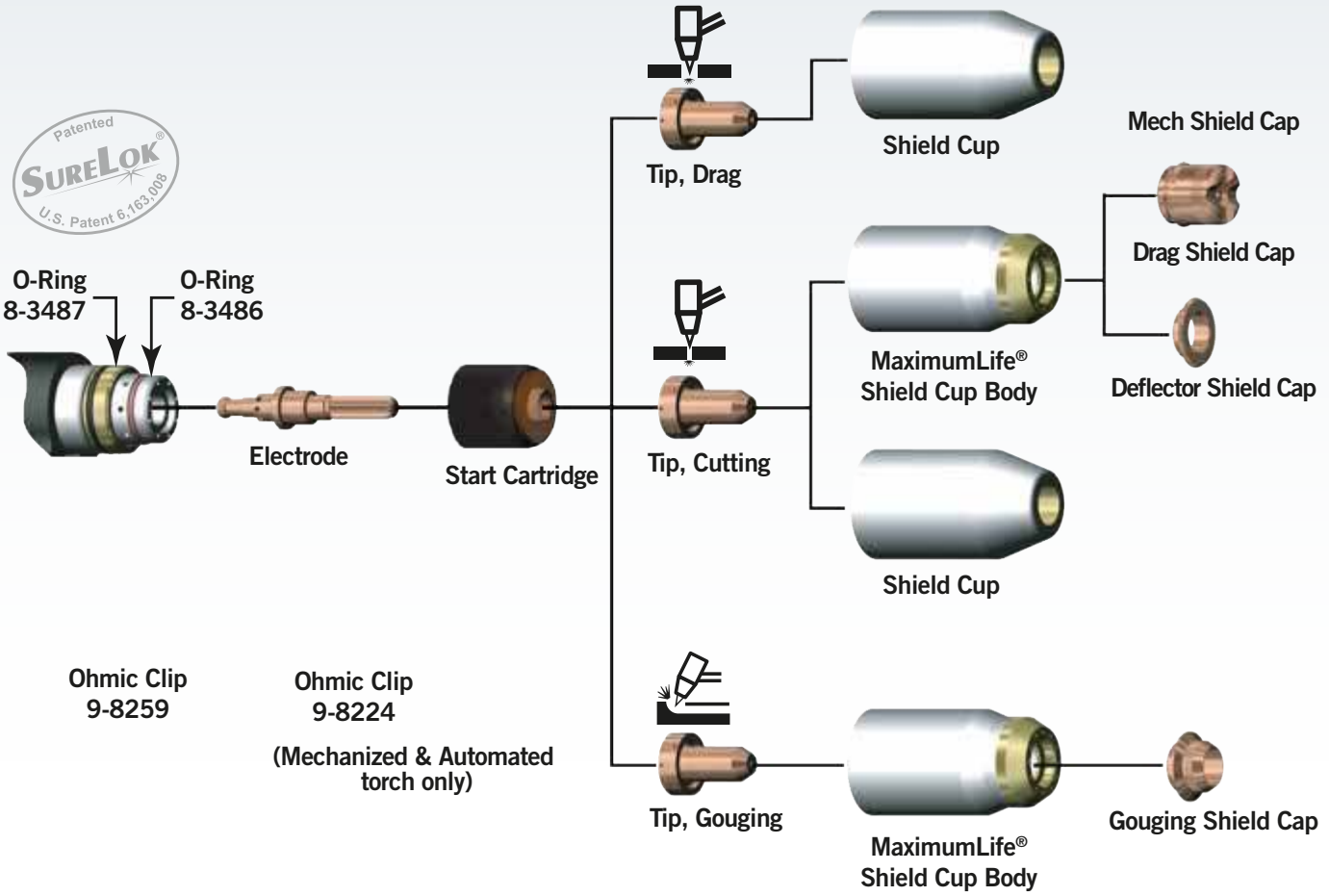
Multi-Purpose Cart

PART NO. 7-8888

Designed for most portable manual cutting systems such as the PakMaster® or Cutmaster, or any similar sized systems.

This rugged steel cart has easy rolling 203 mm (8") diameter wheels along with 76 mm (3") front mounted casters. This cart also serves as an excellent showroom display stand.

1TORCH® CONSUMABLES.



DESCRIPTION		PART NO.
O-RINGS		
O-Ring		OTD8/3486
O-Ring		OTD8/3487
O-Ring Lubricant		OTD8/4025
ELECTRODES		
Electrode Black Series		9-8214
Electrode 120A Automated		9-8232
Electrode		OTD9/8215
START CARTRIDGES		
Start Cartridge		OTD9/8213
Heavy Duty Start Cartridge (Non HF Systems only)		9-8277
TIPS		
Drag	Tip, Drag 20A	OTD9/8205
	Tip, Drag 30A	OTD9/8206
	Tip, Drag 40A	OTD9/8207
	Tip, Drag 60A	9-8252
Standoff	Tip, Standoff 40A	OTD9/8208
	Tip, Standoff 50/55A	OTD9/8209
	Tip, Standoff 60A	OTD9/8210
	Tip, Standoff 70A	OTD9/8231
	Tip, Standoff 80A	OTD9/8211
	Tip, Standoff 90/100A	OTD9/8212
	Tip, Standoff 120A	9-8252
	Tip, Standoff 120A (Automated)	9-8233
Gouge	Tip, Gouging, A	OTD9/8225
	Tip, Gouging, B	OTD9/8226
	Tip, Gouging, C	OTD9/8227
	Tip, Gouging, D	OTD9/8228
STAND OFF GUIDE		
Stand Off Cutting Guide		OTD9/8281
Stand Off Cutting Guide (Adjustable)		OTD9/8422

DESCRIPTION		PART NO.
SHIELD CUPS		
Shield Cup		OTD9/8218
Shield Cup Body, MaximumLife®		OTD9/8237
SHIELD CAPS		
Drag	Shield Cap, Drag, 40A	OTD9/8244
	Shield Cap, Drag, 50-60A	OTD9/8235
	Shield Cap, Drag, 70-100A	OTD9/8236
	Shield Cap, Drag, 120A	9-8258
Mechanised	Shield Cap, Mechanised, 40A	OTD9/8245
	Shield Cap, Mechanised, 50-60A	OTD9/8238
	Shield Cap, Mechanised, 70-100A	OTD9/8239
	Shield Cap, Mechanised, 120A	OTD9/8256
Deflector	Shield Cap, Deflector	OTD9/8243
Gouging	Shield Cap, Gouging	OTD9/8241
OHMIC CLIPS		
Tip, Standoff 50/55A		OTD9/8224
SPARE PARTS KITS		
Spare Parts Kit 30 Amp		5-2550
Spare Parts Kit 40 Amp		5-2551
Spare Parts Kit 50/55 Amp		5-2552
Spare Parts Kit 60 Amp		5-2553
Spare Parts Kit 70 Amp		5-2554
Spare Parts Kit 80 Amp		5-2555
Spare Parts Kit 90/100 Amp		5-2556
TORCHES		
1 Torch SL60 with 6M lead ATC		OTD7/5204
1 Torch SL100 with 6M lead ATC		OTD7/5206
1 Torch SL100, 180 Degree Machine, 7.6M ATC, Suits Cutmaster		OTD7/5215
1 Torch SL100/SL60 Extension Lead Kit, ATC, 7.6M		OTD7/7545

Note: All Spare Parts Kits include ten (10) Tips, five (5) Electrodes and one (1) Start Cartridge.

ESAB Cutmaster 40 **ESAB Cutmaster 60i** **ESAB Cutmaster 80** **ESAB Cutmaster 100** **ESAB Cutmaster 120**

ESAB Cutmaster® TRUE™ Series System Specifications*

	ESAB Cutmaster 40	ESAB Cutmaster 60i	ESAB Cutmaster 80	ESAB Cutmaster 100	ESAB Cutmaster 120
P/N	**0559140006**	**0559156304**	**0559113304**	**0559117304**	**0559119304**
Maximum Amperage Output	40 Amps	60 Amps	80 Amps	100 Amps	120 Amps
Kilowatt Output	3.8 kW	7.6 kW	9 kW	12 kW	15.4 kW
Recommended Cut	12 mm (1/2") @ 230V 6 mm (1/4") @ 110V	20 mm (3/4")	25 mm (1")	35 mm (1⅜")	40 mm (1½")
Maximum Cut	22.2 mm (7/8") 15.8 mm (5/8")	32 mm (1¼")	38 mm (1½")	45 mm (1¾")	55 mm (2⅛")
Pierce Rating	6 mm	20 mm	15 mm	20 mm	25 mm
Input Voltage	240V/15A 1 Ph 50/60 Hz	415V/14A 3Ph 50/60Hz	415V/20A 3Ph 50/60Hz	415V/27A 3Ph 50/60Hz	415V/32A 3Ph 50/60Hz
Duty Cycle (@ 40° C)	40% @ 40A	40% @ 60A	40% @ 80A	80% @ 100A	40% @ 120A
Work Cable	5 m (16.4')	6.1 m (20')	(6.1 m) (20')	(6.1 m) (20')	(6.1 m) (20')
Dimensions H W D	228 mm (9") 117 mm (7") 470 mm (18.5")	381 mm (15") 305 mm (12") 610 mm (24")	381 mm (15") 305 mm (12") 610 mm (24")	381 mm (15") 305 mm (12") 762 mm (30")	381 mm (15") 305 mm (12") 762 mm (30")
Weight	11.8 kg (26 lbs)	16.8kg (37 lbs)	19.5 kg (43 lbs)	28.1 kg (62 lbs)	28.1 kg (62 lbs)
Warranty (Parts & Labor)	3 Year Power Supply, 1 year Torch	3 Year Power Supply, 1 year Torch	3 Year Power Supply, 1 year Torch	3 Year Power Supply, 1 year Torch	3 Year Power Supply, 1 year Torch
Certifications	IP-23C, NTRL/C, CE	IP-23C, NTRL/C, CE, CCC	IP-23C, NTRL/C, CE, CCC	IP-23C, NTRL/C, CE, CCC	IP-23C, NTRL/C, CE, CCC
Torch Configuration					
Hand Torch (Supplied)	SL60 w/ATC, 75° hand torch, 6.1 m (20') P/N: OTD7/5204			SL100 w/ATC, 75° hand torch, 6.1 m (20') P/N: OTD7/5206	
Automated & Mechanised Torch	–	SL100 (Optional)	SL100 (Optional)	SL100 (Optional)	SL100 (Optional)
Air Pressure	5.2 bar (75 psi)	5.2 bar (75 psi)	5.2 bar (75 psi)	4.8 bar (70 psi)	4.8 bar (70 psi)
Flow	190 l/m (6.7 cfm)	190 l/m (6.7 cfm)	190 l/m (6.7 cfm)	212 l/m (7.5 cfm)	212 l/m (7.5 cfm)

* Subject to change without notice

UNRIVALED SERVICE AND SUPPORT.

Cutmaster, like all ESAB products, is backed by our commitment to superior customer service and support. Our skilled customer service department is prepared to quickly answer any questions, address problems, and help with the maintenance and upgrading of your machines. And our products are backed with the most comprehensive warranty in the business.

With ESAB, you can be sure you purchased a machine that will meet your needs today and in the future. Product and process training is also available. Ask your ESAB sales representative or distributor for a complete ESAB solution.

For more information visit **esab.com.au**

3-Year Warranty.

ESAB's industry-leading service and support means that if you do need help, you'll be protected by the most comprehensive warranty in the business.

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Tel: 1300 654 674
Email: enquiries@cigweld.com.au
CIGWELD.COM.AU | ESAB.COM.AU

CIGWELD ARCAIR STOODY TWECO THERMAL DYNAMICS

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