



ALL DAY.
EVERY DAY.
NO EXCEPTIONS.



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 1 3/8" (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

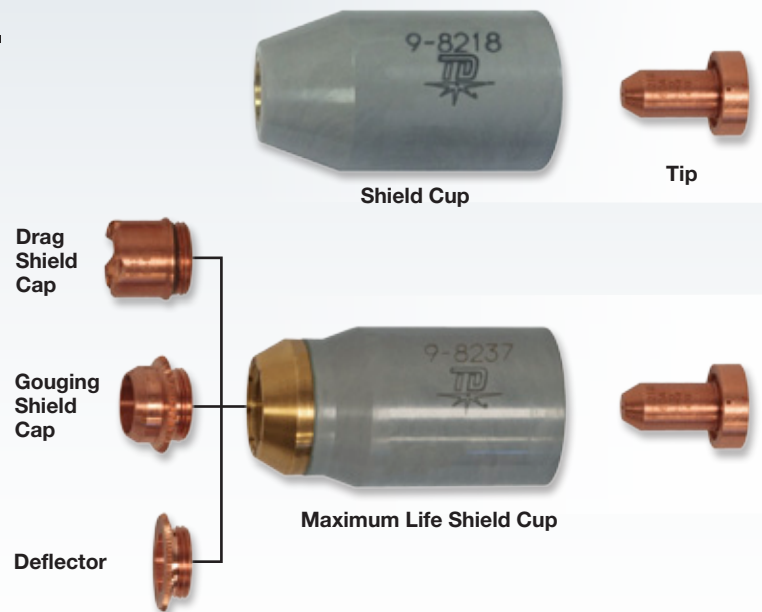
1Torch leads are lightweight, extremely flexible, and rugged enough to withstand years of use.

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.



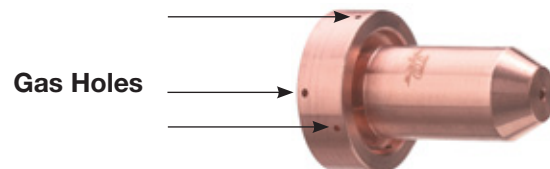
Patented SureLok® Electrode Technology

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



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

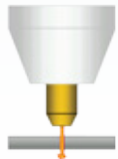
DRAG TIP CUTTING

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.



DRAG SHIELD CUTTING



MECHANISED CUTTING



GOUGING

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	

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 (2 1/8") to 1054 mm (41 1/2") 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. 7-3291

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

Cuts 54 mm (2 1/8") to 705 mm (27 3/4") 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. 7-7501

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

This easy-to-use guide cuts circles from 76 mm (3") up to 730 mm (28 3/4"). 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 maximises 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. 9-8251 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 customise 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

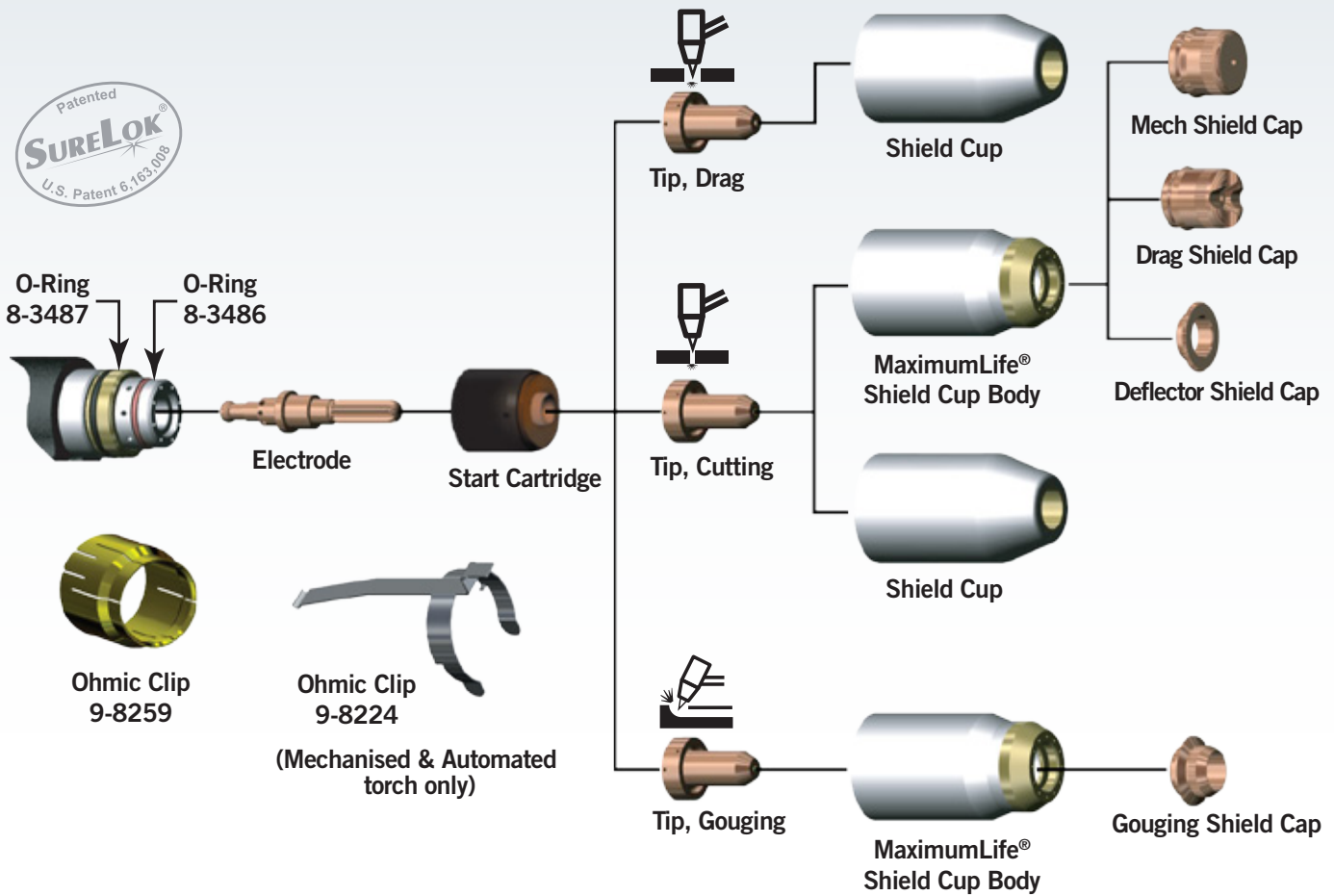
PART NO. 7-8888

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	8-3487	
O-Ring	8-3486	
O-Ring Lubricant	8-4025	
ELECTRODES		
Electrode	9-8215	
START CARTRIDGES		
Start Cartridge	9-8213	
Heavy Duty Start Cartridge (Non HF Systems only)	9-8277	
TIPS		
Drag	Tip, Drag, 20A	9-8205
	Tip, Drag, 30A	9-8206
	Tip, Drag, 40A	9-8207
	Tip, Drag, 60A	9-8252
	Tip, Standoff, 40A	9-8208
Standoff	Tip, Standoff, 50/55A	9-8209
	Tip, Standoff, 60A	9-8210
	Tip, Standoff, 70A	9-8231
	Tip, Standoff, 80A	9-8211
	Tip, Standoff, 90/100A	9-8212
Gouge	Tip, Standoff, 120A	9-8253
	Tip, Gouging, A	9-8225
	Tip, Gouging, B	9-8226
	Tip, Gouging, C	9-8227
	Tip, Gouging, D	9-8228
Tip, Gouging, E	9-8254	

DESCRIPTION	PART NO.	
SHIELD CUPS		
Shield Cup	9-8218	
Shield Cup Body, MaximumLife®	9-8237	
SHIELD CAPS		
Drag	Shield Cap, Drag, 40A	9-8244
	Shield Cap, Drag, 50-60A	9-8235
	Shield Cap, Drag, 70-100A	9-8236
	Shield Cap, Drag, 120A	9-8258
	Shield Cap, Mechanised, 40A	9-8245
Mechanised	Shield Cap, Mechanised, 50-60A	9-8238
	Shield Cap, Mechanised, 70-100A	9-8239
	Shield Cap, Mechanised, 120A	9-8256
Deflector	Shield Cap, Deflector	9-8243
Gouging	Shield Cap, Gouging	9-8241
OHMIC CLIPS		
Ohmic Clip	9-8224	
Ohmic Clip for manual torches	9-8259	
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	

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



ESAB Cutmaster 40 ESAB Cutmaster 60 ESAB Cutmaster 80 ESAB Cutmaster 100 ESAB Cutmaster 120

ESAB Cutmaster® TRUE™ Series System Specifications*

	ESAB Cutmaster 40	ESAB Cutmaster 60	ESAB Cutmaster 80	ESAB Cutmaster 100	ESAB Cutmaster 120
Maximum Amperage Output	40 Amps	60 Amps	80 Amps	100 Amps	120 Amps
Kilowatt Output	3.8 kW	6.2 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 (1 3/8")	40 mm (1 1/2")
Maximum Cut	22.2 mm (7/8") 15.8 mm (5/8")	32 mm (1 1/4")	38 mm (1 1/2")	45 mm (1 3/4")	55 mm (2 1/8")
Pierce Rating	6 mm	12 mm	15 mm	20 mm	25 mm
Input Voltage	230V/13.5A/110V/16.3A 1 Ph 50/60 Hz	400V/16A 3Ph 50/60Hz	400V/20A 3Ph 50/60Hz	400V/27A 3Ph 50/60Hz	400V/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 228 mm (9") W 117 mm (7") D 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)	19.5 kg (43 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')			SL100 w/ATC, 75° hand torch, 6.1 m (20')	
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/cutmaster or scan the QR Code.



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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