



FACT SHEET : SPC 2500

Plasma and Oxyfuel cutting of round pipes up to Ø 2500mm					
Main drive with 3-jaw chuck, with cutting trolley. Pipes supported by pipe trolleys					
RANGE	Ø 200 - 2500mm (8"- 98" OD), max. load 30 tonnes				
MACHINE ACCURACY :					
			Positioning	Repeatability	
Main Drive Ø 2500			1.25 mm	0.63 mm	
Torch Rotation / Tilt Movement			0.5°	0.25°	
Main Drive Up / Down Movement			0.5 mm	0.25 mm	
Cutting Trolley Logitudinal Movement			0.5 mm	0.25 mm	
Torch - Material Distance			0.1 mm	0.05 mm	
OXYFUEL CUTTING		max. cutting length	min. cutting wall thk	max. cutting wall thk	max. bevel angle
Normal Volume		150 mm	3 mm	50 mm	70°
High Volume		300 mm	3 mm	150 mm	70°
OXYFUEL CUTTING ACCURACY			Tilt Angle in Degrees		
Cutting Length			0°	45°	70°
5 - 15 mm			0.5 mm	0.8 mm	1.0 mm
15 - 30 mm			0.5 mm	1.0 mm	1.3 mm
30 - 50 mm			0.5 mm	1.0 mm	1.5 mm
50 - 75 mm			1.0 mm	1.5 mm	2.0 mm
75 - 100 mm			1.0 mm	2.0 mm	2.0 mm
100 - 150 mm			1.0 mm	2.0 mm	3.0 mm
> 150mm - 300 mm : on request					
PLASMA CUTTING		max. cutting length	min. cutting wall thk	max. cutting wall thk	max. bevel angle
Kjellberg HiFocus 280i neo		50-70 mm	3 mm	40 mm	45°
PLASMA CUTTING ACCURACY			Tilt Angle in Degrees		
		standard plasma		high definition plasma	
Cutting Length		0°	45°	0°	45°
5 - 15 mm		0.5 mm	1.0 mm	0.5 mm	1.0 mm
15 - 30 mm		0.8 mm	1.5 mm	0.8 mm	1.5 mm
30 - 50 mm		2.0 mm	3.0 mm	1.5 mm	2.5 mm
50 - 75 mm		3.0 mm	-	2.0 mm	-
DOUBLE BEVELING : Constraints of thermal cutting process					
Wall thickness	= Double bevel : t ≥ 15 mm				
	= Single bevel with nose : t ≥ 15 mm				
	= Double bevel with nose : t ≥ 20 mm				
	= Nose : height ≥ 5 mm (smaller possible but result is not accurate)				
CUTTING HOLES :	= Minimum diameter hole: 2x wall thickness, min. 8 mm				