



Kjellberg[®]
FINSTERWALDE

CutFire 65i, CutFire 100i

Plasma Cutting from 1 to 20 mm



**Manual and
mechanised Use**

Made in Germany

**Powerful Plasma Cutting Inverters
at low Investment Costs**

www.kjellberg.de

CutFire – Plasma Units for manual and automated Use

For cutting electrically conductive materials with thicknesses from 1 to 20 mm Kjellberg offers the air-cooled plasma cutting inverters of the CutFire series. These plasma cutting units are particularly suited for simple and economic cutting tasks.

The CutFire 100i achieves a cutting current of 100A at 100% duty cycle and is thus suited for continuous operation. The CutFire 65i is characterised by its compact design and low weight.

The powerful and cost-efficient inverters can be used flexibly especially in heating, ventilation and pipeline engineering. Therefore the CutFire 65i and CutFire 100i can easily be adapted to CNC-guided and mechanical guiding systems.



CutFire 100i, CutFire 65i

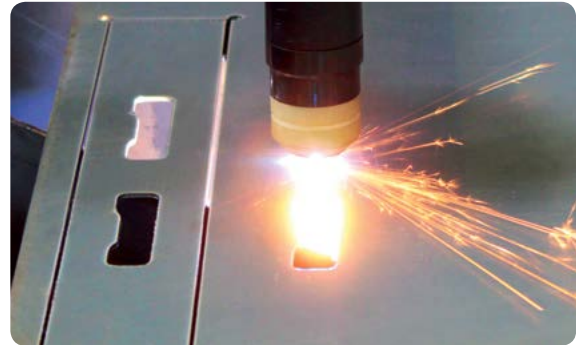
Usable with hand or machine torch the plasma cutting inverter CutFire 65i offers a wide range of applications.

Application Areas

- Heating, ventilation and air condition engineering
- Pipeline engineering
- Steel and mechanical engineering
- Craft businesses, production and industrial plants

Advantages

- Easy to use plasma cutting equipment
- Low consumable costs
- Use of air as plasma gas
- Easy pressure adjustment and monitoring
- Stepless setting of cutting current for optimal performance
- Straight and contour cutting



Automated plasma cutting of thin sheets

Cutting Ranges

Cutting current	Material thickness in mm				
	5	10	15	20	25
65 A	CutFire 65i				
100 A	CutFire 100i				

Recommended cutting range ⁽¹⁾
 Max. cutting range ⁽²⁾
 Piercing ^{(1), (2)}

⁽¹⁾ These data are depending on the materials to be cut and their compositions.

⁽²⁾ Observe piercing capability.



Manual plasma cutting of pipes

Air-cooled Torch Technique

Machine Torch Flash 100



Machine torch Flash 100 with 6 or 12 m hose parcel available

The air-cooled plasma machine torch Flash 100 is used for mechanised plasma cutting with the inverters of the CutFire series. The torch is equipped with a central connector for a quick torch change.

Due to the high-voltage ignition and soft start the pilot arc is started safely. Power increases automatically when the pilot arc touches the workpiece.

Hand Torch KjellCut 70



Plasma hand torch KjellCut 70 with ergonomic handle design

The plasma hand torch KjellCut 70 is used for cutting manually with the CutFire 65i.

The user benefits from its ergonomic handle design and low weight. A switch-on protection prevents the unwanted ignition of the plasma arc and ensures safety.

The hand torch KjellCut 70 is available with a range of accessories like circle and bevel cutting devices.

Accessories for Hand Torch



Contact cap



Spacer spring



Wheel guide



Circle cutting device



Bevelling cap



Bevel cutting device



Template cuts



Long consumables

Technical Data

CutFire 65i, 100i

Power source	CutFire 65i	CutFire 100i
Plasma torch	KjellCut 70 Flash 100 G/L	Flash 100 G/L
Mains voltage ⁽¹⁾	3x 400 V, 50 Hz	
Fuse, slow	25 A	25 A
Connected load, max.	9.8 kVA	166 kVA
Cutting current	65 A at 35 % d.c. 50 A at 100 % d.c.	100 A at 100 % d.c.
Dimensions (L x W x H)	470 x 180 x 270 mm	710 x 280 x 590 mm
Mass	17 kg	50 kg

⁽¹⁾ Other voltages and frequencies on request.

Plasma torch	KjellCut 70	Flash 100 G/L
Cutting range	1 to 12 mm	1 to 20 mm
Plasma gas	Air	
Torch cooling	Air cooled	
Air consumption	140 l/min	195 l/min 265 l/min
Pressure	5 bar	5.0 bar 6.5 bar
Torch shaft diameter	-	36 mm

Operating data (extract) ⁽²⁾

CutFire 100i

Material thickness (mm)	Mild steel		Stainless steel		Aluminium	
	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)
1	35	10200	35	6500	35	5500
3	70	7000	70	5000	70	5000
6	100	4300	70	2700	70	3000
8	100	3200	100	3000	100	3000
10	100	2000	100	1900	100	2200
12	100	1800	100	1300	100	1700
15	100	1200	100	700	100	1400
20	100	400	100	320	100	800

⁽²⁾ Listed cutting speeds are depending on material characteristics, gas parameters, guiding system as well as proper consumables. According to the quality requirements of the cutting task, the user may change the cutting speed.

Kjellberg Finsterwalde Group

Welding Electrodes
Welding Equipment
Cutting Equipment
Mechanical Engineering

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Kjellberg-plasma cutting units are CE-conform and correspond with the valid guidelines and instructions of the European Union. They are developed and fabricated on basis of the standard EN 60974 (VDE 0544). The plasma cutting units are labelled with the S-sign and therefore applicable to environments with increased hazard of electric shock. The fabrication takes place according to DIN EN ISO 9001. The factory-owned quality assurance comprises piece and cutting performance tests, documented by test certificate.

Our products represent a high level of quality and reliability. We reserve the rights to change design and/or technical specification during the series fabrication. Claims of any kind cannot be derived from this brochure.

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