

# ELECTRODE PIT-DEPTH GAUGE



## WHY PURCHASE OUR ELECTRODE PIT-DEPTH GAUGE?

### Simply put, because it will save you money on electrode replacement!

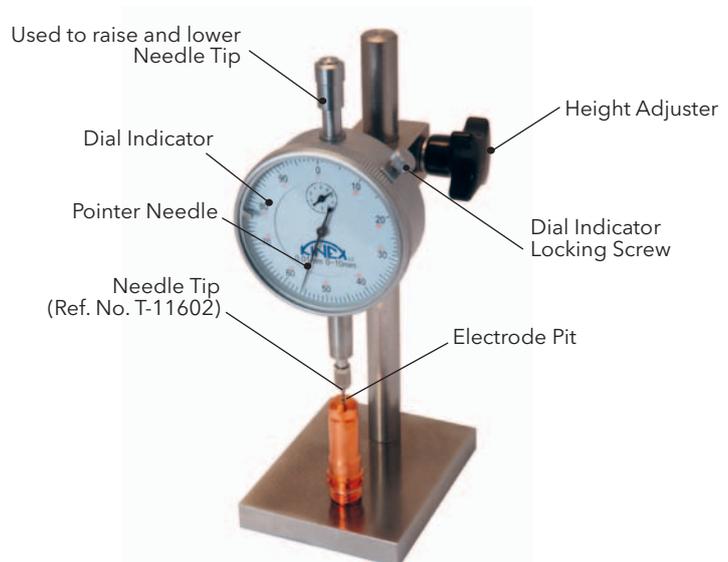
Prematurely replacing electrodes which still are working properly happens all too often during the plasma-cutting process. This is because many operators follow the rule of “better an hour earlier than a minute later” and automatically replace the electrode at the same time as the nozzle in an effort to avoid poor cut quality. Although there are times when the electrode should be replaced together with the nozzle, this is not always the case. Often, the nozzle will become damaged or worn out while the electrode still has life remaining. **Our Electrode Pit-Depth Gauge allows the operator to actually determine how much life remains in the electrode.**

## IS THIS INSTRUMENT A GOOD INVESTMENT?

**For many of our customers it will pay for itself in just a few weeks by checking and fully utilizing electrodes otherwise destined for the scrap pile.** Or, by going a step further, electrodes already in the scrap pile could be checked and possibly re-used! This instrument really pays during the training of new employees who are particularly prone to prematurely replace electrodes; but also with the veteran operators as well. Many experienced operators will listen for the sound of plasma gas whistling out of the nozzle orifice and use this as their “gauge” for replacing both the nozzle and electrode. In reality, the whistling sound only indicates nozzle wear while the electrode itself may still be perfectly usable. Our Electrode Pit-Depth Gauge removes the guesswork and allows operators to make an informed and cost-saving decision.

## HOW DO I USE IT?

1. Loosen the height adjuster and insert electrode as shown. Set the height and retighten the adjuster.
2. Place the needle tip on the flat surface of the electrode head next to the pit. Rotate the dial indicator and set the pointer needle at zero.
3. Raise the needle tip and carefully lower it into the pit. The resultant reading is the pit-depth.



Electrode Pit-Depth Gauge Ref. No. T-11600

**Note:** maximum pit-depth varies by electrode and/or system. To determine the maximum for your electrode, consult your operator’s manual or manufacturer’s website. Plasma system manufacturers often recommend a lower pit-depth maximum than what can actually be achieved. For example, an HPR®260 electrode has a manufacturer-recommended pit-depth height maximum of 1.0 mm; in our experience a pit-depth height of 1.6 mm can be achieved. **As a general rule, if the electrode pit is burned in the center of the electrode without being eccentric and the maximum pit-depth is not exceeded, the electrode may continue to be used.**

## ELECTRODE BURN LIMITS FOR COMMONLY USED SYSTEMS

### Hypertherm® HPR®130, HPR®130XD, HPR®260, HPR®260XD, HPR®400XD

	recommended by manufacturer	commonly reached
copper electrode	1,0 mm	1,6 mm
electrode with silver tip	1,0 mm	2,5 mm
electrode with silver insert	not known	2,5 mm
silver electrode	not known	2,5 mm

### Kjellberg® HiFocus® 80i, HiFocus® 100i, HiFocus® 160i, HiFocus® 280i, HiFocus® 360i, HiFocus® 440i

	recommended by manufacturer	maximum
S002X	1,65 mm	1,80 mm
S002Y	1,80 mm	2,20 mm
T012X	1,65 mm	1,80 mm
T012Y	1,80 mm	2,20 mm
T012	1,80 mm	2,20 mm
T051	1,50 mm	1,50 mm

### ESAB® PT-600™

	recommended by manufacturer
0558001624	2,20 mm
0558002516	2,20 mm

### ESAB® PT-19™

	recommended by manufacturer
35886	2,20 mm
34086	2,20 mm

### ESAB® PT-36™

	recommended by manufacturer
0558003914	2,20 mm

## THE THERMACUT DIFFERENCE:

### THERMACUT PROVIDES YOU WITH THE CARE YOU NEED FOR YOUR COMPLEX PLASMA CUTTING SYSTEM

Your plasma cutting system is a complex piece of equipment. Thermacut offers not only replacement consumables, but also replacement torches and leads. We also offer you advice and training from our experienced Thermacut specialists to help you get the most out of your equipment.

## OUR GOAL IS TO PROVIDE A COMPLETE CARE NETWORK FOR OUR CUSTOMERS, INCLUDING:

- Free consumable samples: put our consumables to the test on your plasma cutting system.
- **For more information please call: +49 2739 4033-0**
- Supply our customers with a complete range of consumables, torches, and leads
- Free introductory training for your plasma cutting operator
- Providing free inspections of your torches and lead assemblies
- Provide repairs for your damaged torches and lead assemblies
- Training based on the most commonly-used plasma cutting systems in our lab
- Additional products for use in the metal-cutting industry including laser and oxy-fuel

## REASONS TO BUY THERMACUT PARTS:

- Our quality is equal to OEM quality, but with a much more reasonable cost.
- Our Sales Representatives not only assist you with purchasing our products, but are also technically trained and able to provide troubleshooting help as well as advice be it over the phone or on-site.
- We are able to provide you with not just consumables, but also replacement torches and lead assemblies.
- We offer the ability to repair your worn or damaged torch and lead sets.
- We can provide technical training focused on the most commonly-used plasma cutting systems.