FLEXCUT® 200
Mechanized Dual Gas Plasma Cutting System

Premium Cut Performance
- 200A, 100% Duty Cycle maximizes production efficiency
- Operates using air or oxygen plasma gas
- Production piercing of 1-1/4 in. (32 mm), edge start cut of 2 in. (50 mm)

Ease of Use
- Full color graphic display with one-knob selection process
- Reliable arc starting with CleanStrike® Technology

Low Operating Costs
- Liquid-cooled plasma torch for more consistent cuts and longer-lasting consumable life
- Less dross reduces need for secondary operations
- Inverter technology reduces energy demand

Processes
Plasma Cutting, Grid, and Marking

Cutting Type
Mechanized Cutting

Output
Input

Applications
- Steel Fabrication
- Pipe Cutting
- Structural Steel Fabrication
- Automotive/Transportation
- Shipbuilding
- Steel Service Center

What's Included
K4328-1 FlexCut 200 System One-Pak®
  - FlexCut 200
  - FlexCool® 35 Cooler
  - FlexStart® Arc Start Console

K4328-2 FlexCut 200CE System One-Pak
  - FlexCut 200CE
  - FlexCool 35 cooler
  - FlexStart arc start console

For Use With
- Primarily designed to interface with Lincoln Electric's CNC cutting tables & pipe cutters
- Ability to interface with most systems using an integrated built-in voltage divider card

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FLEXCUT® 200 - TECHNICAL SPECIFICATIONS

<table>
<thead>
<tr>
<th>Product Name</th>
<th>Product Number</th>
<th>Input Power Voltage/Phase/ Hertz</th>
<th>Rated Output: Current/ Voltage/Duty Cycle</th>
<th>Input Current @ Rated Output</th>
<th>Output Range</th>
<th>Plasma Gas Maximum Flow Rate</th>
<th>Shield Gas Maximum Flow Rate</th>
<th>Inlet Gas</th>
<th>H x W x D in. (mm)</th>
<th>Net Wt. lb (kg)</th>
</tr>
</thead>
<tbody>
<tr>
<td>FlexCut 200 System One-Pak</td>
<td>K4328-1</td>
<td>380-400-415V/460/575V/3Ph/50/60Hz</td>
<td>200A/190/100%</td>
<td>3PH/100%/71/63/55</td>
<td>20-200A</td>
<td>67 SCFH (1897 LPH) Oxygen or Air</td>
<td>19 SCFH (538LPH) Oxygen</td>
<td>90-130 PSI (6.2-9.0 Bar)</td>
<td>23.66 in. X 15.97 in. X 32.19 in.</td>
<td>190 lb (86.2 kg)</td>
</tr>
<tr>
<td>FlexCut 200 CE System One-Pak</td>
<td>K4328-2</td>
<td>380-400-415V/3Ph/50/60Hz</td>
<td>200A/190/100%</td>
<td>3PH/100%/71</td>
<td>Power Supply Only</td>
<td>Power Supply Only</td>
<td>Power Supply Only</td>
<td>Power Supply Only</td>
<td>Power Supply Only</td>
<td>Power Supply Only</td>
</tr>
</tbody>
</table>

CUTTING CAPACITY AT MAX OUTPUT 200A

<table>
<thead>
<tr>
<th>Material</th>
<th>Cutting Capacity</th>
<th>Cutting Gas (plasma/shield)</th>
<th>Marking Gas (plasma/shield)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mild Steel</td>
<td>Recommended Cut Capacity (pierce start)</td>
<td>Air /Air</td>
<td>Air /Air</td>
</tr>
<tr>
<td></td>
<td>Maximum Cut Capacity (edge start)</td>
<td>Oxygen/Air</td>
<td>Oxygen/Air</td>
</tr>
<tr>
<td>Stainless Steel</td>
<td>Recommended Cut Capacity (pierce start)</td>
<td>Air /Air</td>
<td>Air /Air</td>
</tr>
<tr>
<td></td>
<td>Maximum Cut Capacity (edge start)</td>
<td>Air /Air</td>
<td>Air /Air</td>
</tr>
<tr>
<td>Aluminum</td>
<td>Recommended Cut Capacity (pierce start)</td>
<td>Air /Air</td>
<td>Air /Air</td>
</tr>
<tr>
<td></td>
<td>Maximum Cut Capacity (edge start)</td>
<td>Air /Air</td>
<td>Air /Air</td>
</tr>
</tbody>
</table>

MAXIMUM CUT SPEEDS AT MAX OUTPUT 200A

<table>
<thead>
<tr>
<th>Material</th>
<th>Thickness in. (mm)</th>
<th>Travel Speed ipm (mm/min)</th>
<th>Cutting Gas (plasma/shield)</th>
<th>Material</th>
<th>Thickness in. (mm)</th>
<th>Travel Speed ipm (mm/min)</th>
<th>Cutting Gas (plasma/shield)</th>
</tr>
</thead>
<tbody>
<tr>
<td>Mild Steel</td>
<td>1/4 in. (6 mm)</td>
<td>200 ipm (5250 mm/min)</td>
<td>Air /Air</td>
<td>Mild Steel</td>
<td>1/4 in. (6 mm)</td>
<td>230 ipm (6100 mm/min)</td>
<td>Oxygen/Air</td>
</tr>
<tr>
<td></td>
<td>1/2 in. (12 mm)</td>
<td>110 ipm (2950 mm/min)</td>
<td>Air /Air</td>
<td></td>
<td>1/2 in. (12 mm)</td>
<td>120 ipm (3160 mm/min)</td>
<td>Oxygen/Air</td>
</tr>
<tr>
<td></td>
<td>3/4 in. (20 mm)</td>
<td>65 ipm (1650 mm/min)</td>
<td>Air /Air</td>
<td></td>
<td>3/4 in. (20 mm)</td>
<td>75 ipm (1810 mm/min)</td>
<td>Oxygen/Air</td>
</tr>
<tr>
<td></td>
<td>1 in. (25 mm)</td>
<td>40 ipm (1050 mm/min)</td>
<td>Air /Air</td>
<td></td>
<td>1 in. (25 mm)</td>
<td>50 ipm (1310 mm/min)</td>
<td>Oxygen/Air</td>
</tr>
<tr>
<td></td>
<td>1-1/4 in. (32 mm)</td>
<td>25 ipm (625 mm/min)</td>
<td>Air /Air</td>
<td></td>
<td>1-1/4 in. (32 mm)</td>
<td>25 ipm (610 mm/min)</td>
<td>Oxygen/Air</td>
</tr>
<tr>
<td></td>
<td>1-1/2 in. (38 mm)*</td>
<td>16 ipm (400 mm/min)</td>
<td>Air /Air</td>
<td></td>
<td>1-1/2 in. (38 mm)*</td>
<td>17 ipm (435 mm/min)</td>
<td>Oxygen/Air</td>
</tr>
<tr>
<td></td>
<td>2 in. (50 mm)*</td>
<td>8 ipm (200 mm/min)</td>
<td>Air /Air</td>
<td></td>
<td>2 in. (50 mm)*</td>
<td>7 ipm (195 mm/min)</td>
<td>Oxygen/Air</td>
</tr>
</tbody>
</table>

*Using edge start

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