

## Technical Data

Power Source	HiFocus 280i	HiFocus 360i	HiFocus 440i
Mains voltage <sup>1)</sup>	3x 400 V, 50 Hz	3x 400 V, 50 Hz	3x 400 V, 50 Hz
Fuse, slow	100 A	125 A	200 A
Connected load, max.	67 kVA	87 kVA	127 kVA
Cutting current at 100 % d.c.	280 A	360 A	440 A
Marking current	5 - 50 A	5 - 50 A	5 - 50 A
Dimensions (L x W x H)	1030 x 680 x 1450 mm	1030 x 680 x 1450 mm	1030 x 680 x 1450 mm
Weight	505 kg	517 kg	589 kg

<sup>1)</sup> other voltages and frequencies on request

Plasma torches	PerCut 441/451
Maschine torch	PerCut 441
Quick-change torch	PerCut 451A
Quick-change torch	PerCut 451M
Max. cutting range	0.5 up to 120 mm
Clamping diameter	50.8 mm
Plasma gases	O <sub>2</sub> , Ar, H <sub>2</sub> , F5*
Marking gas	Ar
Swirl gases	O <sub>2</sub> , N <sub>2</sub> , Air

<sup>\*</sup>) Forming gas F5 (95% N<sub>2</sub>/5% H<sub>2</sub>)

### Operating Data HiFocus 280i - 440i<sup>1)</sup>

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)
0,5	20	8000	-	-	-	-
1	20	5500	60	8000	35	6000
2	35	2800	60	7000	35	6000
4	60	4100	60	5000	60	3300
6	90	3700	130	1600	130	3500
8	130	3700	130	1500	130	1400
10	130	3400	130	1400	130	1300
12	160	3400	130	1200	130	1200
15	200	2800	280	1900	280	4300

### Operating Data Mild steel from 20 mm<sup>1)</sup>

Material thickness (mm)	HiFocus 280i		HiFocus 360i		HiFocus 440i	
	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)
20	280	2600	360	3300	400	3600
30	280	1500	360	1900	400	2100
40	280	800	360	1300	400	1400
50	280	500	360	850	400	950
60	280	300	360	480	400	600
70	280	150	360	170	400	360
80			360	120	440	280
100					440	150
120					440	100

### Operating Data Stainless steel from 20 mm<sup>1)</sup>

Material thickness (mm)	HiFocus 280i		HiFocus 360i		HiFocus 440i	
	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)
20	280	1500	360	1700	440	2100
30	280	1000	360	1200	440	1300
40	280	670	360	850	440	1000
50	280	570	360	600	440	750
60	280	430	360	530	440	630
70	280	280	360	420	440	480
80			360	330	440	440
100					440	190
120					440	100

### Operating Data Aluminium from 20 mm<sup>1)</sup>

Material thickness (mm)	HiFocus 280i		HiFocus 360i		HiFocus 440i	
	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)	Cutting current (A)	Cutting speed (mm/min)
20	280	3800	360	4000	440	4500
30	280	2200	360	3000	440	2800
40	280	1550	360	1800	440	2400
50	280	1200	360	1500	440	1700
60	280	800	360	1300	440	1300
70	280	450	360	1000	440	1000
80			360	750	440	850
100					440	300
120					440	150

<sup>1)</sup> Listed cutting speeds are depending on material characteristics, gas parameter, guiding system as well as proper consumables. According to quality requirements cutting speeds may differ.

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 can not be derived from this brochure.

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