

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

FLEXCUT® 200 - TECHNICAL SPECIFICATIONS

Product Name	Product Number	Input Power Voltage/Phase/ Hertz	Rated Output: Current/ Voltage/Duty Cycle	Input Current @ Rated Output	Output Range	Plasma Gas Maximum Flow Rate	Shield Gas Maximum Flow Rate	Inlet Gas	H x W x D in. (mm)	Net Wt. lb (kg)
FlexCut 200 System One-Pak	K4328-1	380-400-415V/460/575V/3Ph/50/60Hz	200A/190/100%	3PH/100%/71/63/55	20-200A	67 SCFH (1897 LPH) Oxygen or Air	19 SCFH (538LPH) Oxygen 225 SCFH (6371LPH) Air or Nitrogen	90-130 PSI (6.2-9.0 Bar)	23.66 in. X 15.97 in. X 32.19 in. (600.96 mm X 405.64 mm X 2077.72 mm) Power Supply Only	190 lb (86.2 kg) Power Supply Only
FlexCut 200 CE System One-Pak	K4328-2	380-400-415V/3Ph/50/60Hz	200A/190/100%	3PH/100%/71						

CUTTING CAPACITY AT MAX OUTPUT 200A

Material	Cutting Capacity in (mm)	Cutting Gas (plasma/shield)	Marking Gas (plasma/shield)
Mild Steel	Recommended Cut Capacity (pierce start) Maximum Cut Capacity (edge start)	1-1/4 in. (32 mm) 2 in. (50 mm)	Air /Air Oxygen/Air
Stainless Steel	Recommended Cut Capacity (pierce start) Maximum Cut Capacity (edge start)	3/4 in. (20 mm) 2 in. (50 mm)	Air/Air Air/Nitrogen
Aluminum	Recommended Cut Capacity (pierce start) Maximum Cut Capacity (edge start)	3/4 in. (20 mm) 1-1/2 in. (38 mm)	Air/Air Air/Nitrogen

MAXIMUM CUT SPEEDS AT MAX OUTPUT 200A

Material	Material Thickness in. (mm)	Travel Speed ipm (mm/min)	Cutting Gas (plasma/shield)	Material	Material Thickness in. (mm)	Travel Speed ipm (mm/min)	Cutting Gas (plasma/shield)
Mild Steel	1/4 in. (6 mm)	200 ipm (5250 mm/min)	Air/Air	Mild Steel	1/4 in. (6 mm)	230 ipm (6100 mm/min)	Oxygen/Air
	1/2 in. (12 mm)	110 ipm (2950 mm/min)			1/2 in. (12 mm)	120 ipm (3160 mm/min)	
	3/4 in. (20 mm)	65 ipm (1550 mm/min)			3/4 in. (20 mm)	75 ipm (1810 mm/min)	
	1 in. (25 mm)	40 ipm (1050 mm/min)			1 in. (25 mm)	50 ipm (1310 mm/min)	
	1-1/4 in. (32 mm)	25 ipm (625 mm/min)			1-1/4 in. (32 mm)	25 ipm (610 mm/min)	
	1-1/2 in. (38 mm)*	16 ipm (400 mm/min)			1-1/2 in. (38 mm)*	17 ipm (435 mm/min)	
	2 in. (50 mm)*	8 ipm (200 mm/min)			2 in. (50 mm)*	7 ipm (195 mm/min)	

*Using edge start

CUSTOMER ASSISTANCE POLICY

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