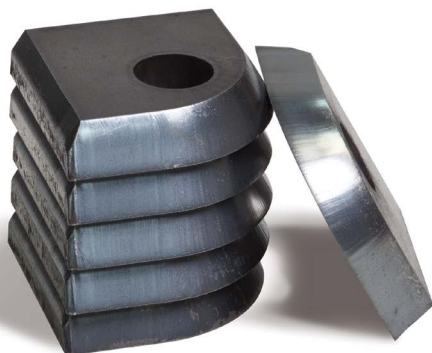


True Bevel technology for XPR

XPR



True Bevel, part of our SureCut™ technology, was launched in 2012 with the HPRXD® family of products. It is now also offered on Hypertherm XPR™ systems. Factory tested and easily implemented, True Bevel takes the guess work out of the plasma bevel-cutting process. With True Bevel, setups for new jobs are quick and results are accurate.



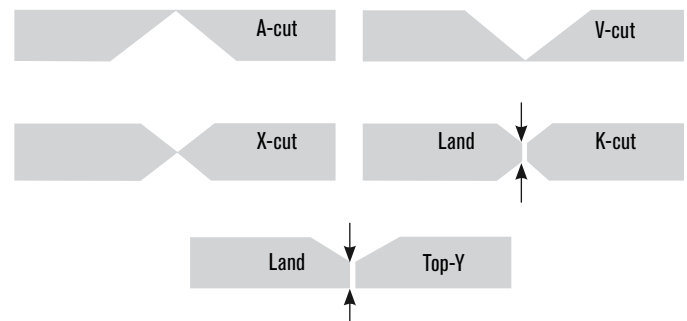
Available now from Hypertherm Associates and our partners.

 **SureCut™**
MAXIMIZING PERFORMANCE THROUGH
EMBEDDED EXPERTISE

Benefits

- Setup time and scrap material are greatly reduced for new job setup due to reduced trial and error.
- Bevel cut sequence recommendation is provided for improved accuracy and consistent quality.
- Scalable parameter tables with embedded equations allow users to add new angles with ease for V, A and Top-Y.

True Bevel technology works with all common bevel head designs and covers V, A, Top-Y, X and K style cuts for mild steel:



Thickness coverage – metric units (mm)

	6 mm	8 mm	10 mm	12 mm	15 mm	19 mm	20 mm	22 mm	25 mm	32 mm	38 mm
80 A	V, A, Y-top	V, A, Y-top	V, A, Y-top								
130 A		V, A, Y-top	V, A, Y-top	V, A, Y-top	V, A, Y-top						
170 A				V, A, Y-top, X	V, A, Y-top, X, K	V, A, Y-top, X, K	V, A, Y-top, X, K	V, A, Y-top, X, K			
300 A									V, A, Y-top, X, K	V, A, Y-top, X, K	V, A, Y-top, X, K

Thickness coverage – English units (inches)

	0.25"	0.312"	0.375"	0.5"	0.625"	0.75"	0.875"	1"	1.25"	1.5"
80 A	V, A, Y-top	V, A, Y-top	V, A, Y-top							
130 A		V, A, Y-top	V, A, Y-top	V, A, Y-top	V, A, Y-top					
170 A				V, A, Y-top, X	V, A, Y-top, X, K	V, A, Y-top, X, K	V, A, Y-top, X, K			
300 A								V, A, Y-top, X, K	V, A, Y-top, X, K	V, A, Y-top, X, K

V, A, and X angle coverage

		Angle*											
V-cut		-50°	-45°	-40°	-37.5°	-35°	-30°	-27.5°	-25°	-22.5°	-20°	-17.5°	-15°
A-cut			45°	40°	37.5°	35°	30°	27.5°	25°	22.5°	20°	17.5°	15°
X-cut	Top pass		-45°	-40°	-37.5°	-35°	-30°						
	Bottom pass		45°	40°	37.5°	35°	30°						

*Angle signs based on negative bias head.

Y-top cut angle and land coverage

Angle*	-50			-45			-37.5			-30			-27.5			-22.5		
Land dimension**	20	35	50	20	35	50	20	35	50	20	35	50	20	35	50	20	35	50

*Angle signs based on negative bias head.

**Land dimension denotes % of thickness.

K-cut angle and land coverage

Angle*	45			40			37.5			35			30		
Land dimension**	10	20	35	10	20	35	10	20	35	10	20	35	10	20	35

*Equal top and bottom pass angles. Top angle is negative and bottom angle is positive for negative bias head.

**Land dimension denotes % of thickness.

Without True Bevel™



These three parts were job setup iterations during field testing using the existing method that took more than one hour to complete. At least one further iteration would be required to obtain an acceptable part.

With True Bevel



This single part was achieved on the first try using True Bevel and is an acceptable part ready to start production.

See the True Bevel white paper to find out more

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Please visit www.hypertherm.com/patents for more details about Hypertherm Associates patent numbers and types.

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