

True Hole technology for XPR



True Hole, part of our SureCut™ technology was launched in 2008 with the HPRXD® autogas family of products. It is now also offered on Hypertherm XPR™ systems. True Hole for mild steel produces significantly better hole quality than what has been previously possible using plasma. Equally important, True Hole technology is delivered automatically without operator intervention, to produce unmatched hole quality.



With True Hole technology

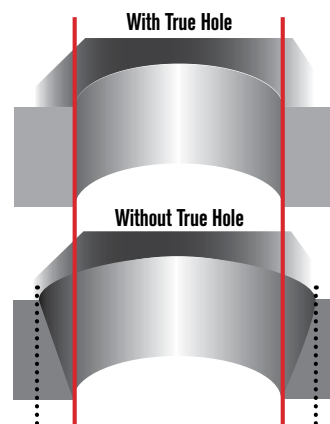


Without True Hole technology



Benefits of True Hole for XPR

- Bolt hole quality is delivered automatically without operator intervention
- Narrows the gap with laser hole quality making the plasma process suitable for many jobs previously cut with laser
- Virtually eliminates hole taper
- Improves top and bottom level roundness
- Delivers true “bolt-hole” quality



True Hole technology requires a Hyperformance® Plasma HPRXD® or XPR™ system along with a True Hole enabled cutting machine. Consult with your machine manufacturer for more details on specific components you may require.

Note: HPRXD must be autogas configuration only

Available from Hypertherm Associates and our partners.

True Hole performance is optimized through seamless integration of all of the components.

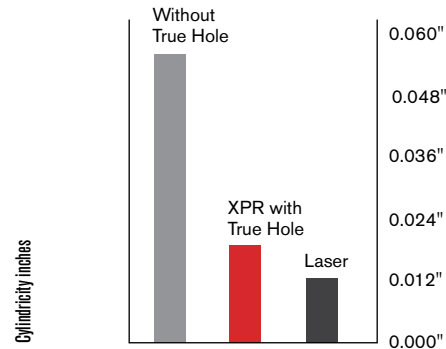
Revolutionary plasma performance: True Hole cut quality

As part of our SureCut technology, True Hole® for mild steel is exclusively available for use in conjunction with Hypertherm HPRXD® and XPR™ plasma systems. True Hole is automatically applied by nesting software or CNC software to thicknesses up to 1 inch. Hole coverage ranges from hole diameter to thickness ratios from 2:1 to as low as 1:1.

True Hole technology is a specific combination of the following parameters that is linked to a given amperage, material type, material thickness and hole size:

- Process gas type
- Gas flow
- Amperage
- Piercing methodology
- Lead in/lead out technique
- Varying speeds across multiple hole segments
- Arc termination synchronized with torch motion

0.394" holes, 3/8" mild steel plate, 130 A process



True Hole processes for XPR by thickness

	3 mm	4 mm	5 mm	6 mm	8 mm	10 mm	12 mm	15 mm	20 mm	22 mm	25 mm
30 A	■	■	■								
50 A	■	■	■	■							
80 A				■	■	■					
130 A				■	■	■	■				
170 A						■	■	■	■		
300 A								■	■	■	■

	10 ga	3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"	7/8"	1"
30 A	■	■								
50 A	■	■	■							
80 A			■	■	■					
130 A			■	■	■	■				
170 A					■	■	■	■		
300 A							■	■	■	■

Note: Interpolated hole settings between thicknesses may be possible. Contact your machine manufacturer for details.

See True Hole in action at: www.hypertherm.com/truehole

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