

# Cutmaster® 60i

## The new frontier in plasma

**THERMAL DYNAMICS**  
AN ESAB® BRAND



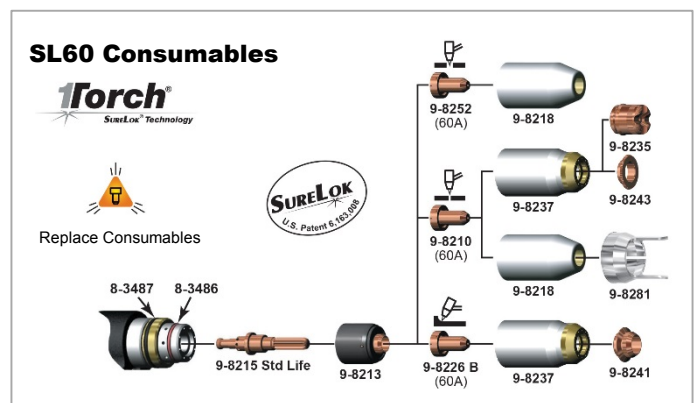
The Cutmaster® 60i with SL60QD™ 1Torch® is the perfect combination of end-user insight, advanced technology, and intelligent design. Packed with power and offering the highest power-to-weight ratio in its class, the Cutmaster 60i with SL60QD 1Torch also has best in class cutting arc length and the most empowering and engaging user experience no matter the application.

- 7.6 kW rated output, 50% Duty Cycle at 60A built for portability and durability with the integral multi-handle design
- SL60QD 1Torch quick disconnect with ATC® (Advanced Torch Connector) allowing selective replacement of either the torch handle assembly or the torch leads, using the patented SureLok® technology also available as an RPT Torch
- 16 mm recommended cut capacity with greater than 32 mm maximum cut and 16 mm pierce
- High-visibility, oversized display with gas optimizer technology and consumables end-of-life indicator
- Industry leading 3-year warranty on power supply and 1-year warranty on torch

Visit [esab.com](http://esab.com) for more information.

### Industry

- Agricultural Equipment
- Automotive Bodies
- Construction
- Fabrication
- General Manufacturing
- HVAC
- Repair and Maintenance
- Training Schools



# Cutmaster® 60i

Specifications	
Amperage Output	10 – 60 A, continuously adjustable
Rated Output Power	7.6 kW
Open Circuit Voltage (OCV)	300 V
Input Voltage	400 VAC
Number of Phases	3 ph
Supply Frequency	50/60 Hz
Rated Duty Cycle	50% @ 60 A 60% @ 50 A 100% @ 40 A
Amperage Draw	13.2 A @ 400 V
Input Power Cable and Plug	2.7 m
Work Lead with Ground Clamp	6 m #8 work cable with 50 mm connection
Gas Requirements	Compressed air
Operating Temperature Range	0° - 50° C
Operating Input Air Pressure Range	6.2 – 8.6 bar
Air Flow Requirements (cutting & gouging)	142 – 235 l/min
Power Supply Gas Filtering Ability	Particulates to 5 Microns
Recommended Cut	16 mm
Maximum Sever	38 mm
Pierce Rating	16 mm
SL60QD Torch Duty Cycle	100% at 60 A @ 190 l/min
Torch Air Pressure	5.2 bar
Torch Air Consumption	190 l/min
Torches – for use with the Cutmaster 60i	SL60QD 1Torch (supplied) SL60/SL100 1Torch SL100 1Torch Mechanized SL100SLV 1Torch Automated
Dimensions L x W x H	536 x 199 x 359 mm
Weight	16.2 kg

Cutting Specifications		
Plate Thickness	Recommended Cut Speed	Maximum Cut Speed
6 mm	2030 mm/min	2794 mm/min
13 mm	660 mm/min	914 mm/min
16 mm	480 mm/min	610 mm/min
19 mm	360 mm/min	Contact ESAB for specific application
25 mm	150 mm/min	Contact ESAB for specific application
32 mm	110 mm/min	Contact ESAB for specific application
38 mm	110 mm/min	Maximum Sever

# Cutmaster® 60i

## Ordering Information - Systems

TD Cutmaster 60i 3ph w. SL60QD 1Torch 6.1 m 75° Head	1-5630-4
TD Cutmaster 60i 3ph w. SL60QD 1Torch 15.2m 75° Head	1-5631-4
TD Cutmaster 60i 3ph Power Supply Only	3-5630-4
<b>Torches</b>	
SL60QD Torch and Lead 20' (6.1 m) 75° Head	7-5604
SL60QD Torch and Lead 50' (15.2 m) 75° Head	7-5605
SL60QD Torch Handle Assembly 75° Head (no leads)	7-5680
SL60QD Lead 20' (6.1 m)	4-5604
SL60QD Lead 50' (15.2 m)	4-5605
SL60 Torch and Lead 20' (6.1 m) 75° Head	7-5204
SL60 Torch and Lead 50' (15.2 m) 75° Head	7-5205
SL60 Torch and Lead 20' (6.1 m) 90° Head	7-5260
SL100 Mechanized Torch 5' (1.5 m) 180° Body	7-5213
SL100 Mechanized Torch 10' (3.0 m) 180° Body	7-5214
SL100 Mechanized Torch 25' (7.6 m) 180° Body	7-5215
SL100 Mechanized Torch 50' (15.2 m) 180° Body	7-5216

*Packages Include: Cutmaster 60i power supply, SL60QD 75° torch with lead, 6.1 m work lead with ground clamp, spare parts kit, operating manual, and filter wrench.*

## Wear and Spare Parts 1Torch

Electrode	9-8215
Start Cartridge	9-8213
Standoff Guide	9-8281
Shield Cup	9-8218
Shield Cup Max Life	9-8237
Shield Cap Gouging	9-8241
Shield Cap (Drag only)	9-8235
Shield Cap Deflector	9-8243
Tip – Drag (60 A)	9-8252
Tip – Standoff (60 A)	9-8210
Tip – “A” Gouging, (40 A Max), Profile: Shallow/Narrow	9-8225
Tip – “B” Gouging, (50 – 100 A), Profile: Deep/Narrow	9-8226
Tip – “C” Gouging, (60 – 120 A), Profile: Moderate/Moderate	9-8227
Tip – “D” Gouging, (60 – 120 A), Profile: Shallow/Wide	9-8228

# Cutmaster® 60i

Options & Accessories	
Cutting Guide Kit (Deluxe)	7-8910
Circle Cutting Guide Kit	7-3291
Filter Wrench	9-9675
Hand Pendant Extension 25 ft. (7.6 m)	7-7744
Lead Extension, 15 ft. (4.6 m)	7-7544
Lead Extension, 25 ft. (7.6 m)	7-7545
Lead Extension, 50 ft. (15.2 m)	7-7552
Leather Lead Covers 20 ft. (6.1 m)	9-1260
Multi-Purpose Cart	7-8888
Radius/Roller Cutting Guide Kit	7-7501
Remote Pendant Control 20 ft. (6.1 m)	7-3460
Single Stage Air Filter Kit	7-7507
Straight Line Cutting Guide	7-8911
Two Stage Air Filter Kit	9-9387
Work Cable #8 with Ground Clamp and 50 mm Plug	9-9692

## 1 Torch Consumables Parts Application Guide



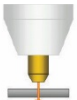
### Drag Tip Cutting

The preferred method of cutting light gauge metal up to 6 mm thickness. Produces the best cut quality narrowest kerf width, fastest cutting speeds, and with little to no distortion. Traditional drag cutting was limited to 40 A or less; now with Thermal Dynamics TRUE Cut Drag Tip Series™ technology, it is possible to cut up to 60 A. For best results, use the Shield Cup with the torch tip in direct contact with the work (up to 60 A).



### Drag Shield Cutting

This is an operator-friendly method of cutting between 70 to 120 A while maintaining a constant standoff distance. For metal thickness greater than 6 mm, simply drag the shield cap in contact with the work piece. Use the shield cup body with the appropriate drag shield cap matching the current level being used. This method is not recommended for cutting light-gauge sheet metal.



### Standoff Cutting

The preferred method of cutting metal thicker than 6 mm and at current levels above 60 A. Provides maximum visibility and accessibility. Shield cup for 'standoff' cutting (with the torch tip 3 mm to 6 mm from the work piece). Use the shield cup body together with the deflector for extended parts life and improved resistance to reflect heat. This combination provides cutting results similar to the single piece shield cup, as well as easy changeover to gouging or drag shield cutting.



### Gouging

A simple method of metal removal by angling the torch to a lead angle of 35°-45°, and using a gouging tip. While maintaining a constant standoff distance, this allows for only a partial penetration into the work, thus removing metal from the surface. The amount of current, travel speed, standoff distance, lead angle, and tip size will determine the amount of material removed and the profile of the gouge. You can use the shield cup body with either the gouging shield cap or the shield deflector. Also, you can use the single piece shield cup.



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