Kjellberg CUTTING

PLASMA CUTTING

CONTOUR CUT

Contour Cut
Precision in Detail

Plasma Cutting Technology
Precise cutting of holes and contours

kjellbergcutting.com

Contour Cut & Contour Cut Speed for Mild Steel

contour cut

contour cut SPEED

Patented technology: Contour Cut

The patented Contour Cut (CC) technology stands for the precise cutting of mild steel and gives the following benefits:

- ✓ Cutting of bolt ready holes with 1:1 ratio
- ✓ Significant reduction of taper
- ✓ Cutting of small contours and narrow bars
- ✓ Sharp top and bottom edge cuts
- ✓ Quality based on integrated cut charts and programming of the correct contour, not on expensive nesting software
- ✓ Reduction of time-consuming secondary processes

CC is standard in all actual HiFocus*, Smart Focus and Q systems

* excepted HiFocus 80i

The next step: Contour Cut Speed

The technology enhancement Contour Cut Speed offers best cutting performance at highest cutting speed and with highest quality. It makes cutting faster by up to 50 % at similar quality. Due to the shorter processing time the costs per cutting metre are reduced.

Advantages

High cut quality regarding contour accuracy & angularity

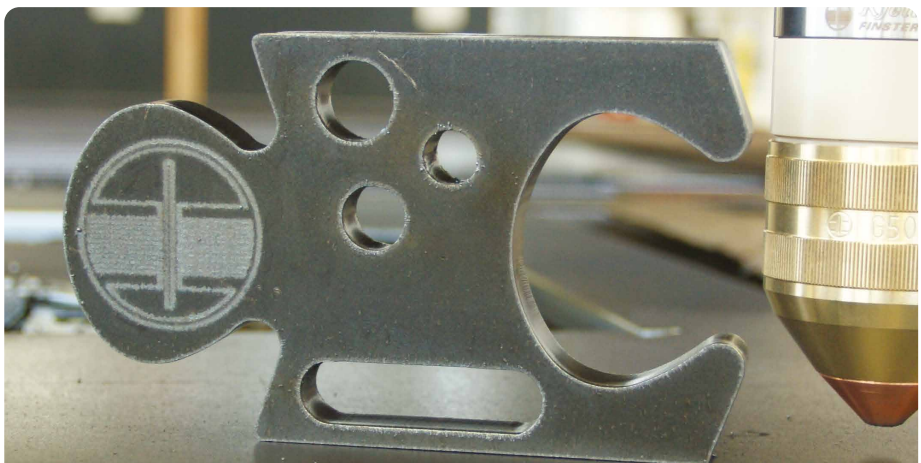
Excellent repeatability & dimension accuracy

High productivity at low costs

Sharp cut edges at the top & bottom

Angular deviations ranging between 2 & 4 according to the standard DIN EN ISO 9013

Standard - no further equipment or consumables



Precise Cutting of Contours

Optimal results

The following points should be considered to achieve good cutting results*:

- ✓ Align the work-piece horizontally to the plasma torch that is in vertical position
- ✓ Adjust correct torch height and piercing regime
- ✓ Freeze the height control for hole diamters of up to 1 1/4 inch
- ✓ Adjust correct parameters
- ✓ Programming of the cutting process: clockwise (cw) direction for outer contours and counter clockwise (ccw) direction for inner contours

* minimum hole diameter 0.135 inch

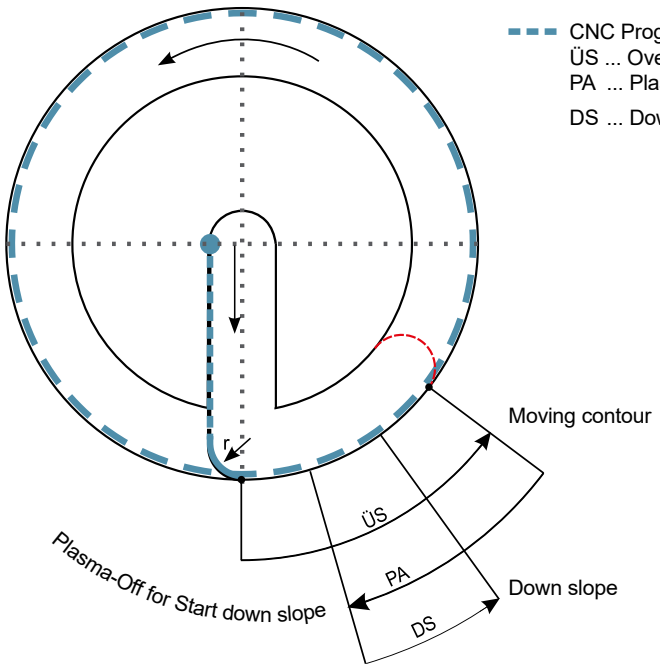
Outer contours = Clockwise

Cutting process for outer contours

Inner contours = counter clockwise

Cutting process for inner contours

Leading & contour with kerf compensation



Kjellberg CUTTING

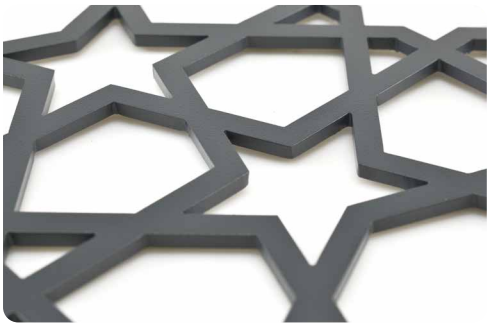
PLASMA CUTTING

CONTOUR CUT

Plasma cutting without Contour Cut

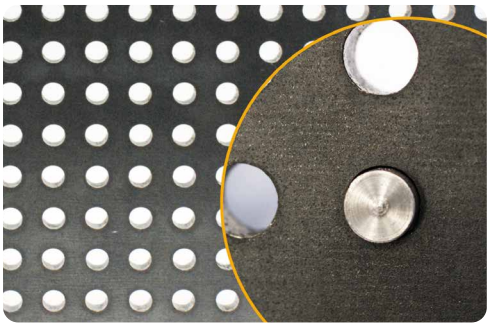
Plasma cutting with Contour Cut

Precise cutting of any contours



High cut quality with regard to contour accuracy and rectangularity on inner and outer contours

Low angular deviations and smooth cut surfaces



Excellent repeatability and dimensional accuracy

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Contact

Kjellberg Cutting, Inc.
1504 Eagle Court Unit 4 | Lewisville | Texas 75057 | USA
Office: 469.770.9799 | sales@kjellbergcutting.com

kjellbergcutting.com