

www.thermal-dynamics.com

THERMAL DYNAMICS[®]



GUIDES & ACCESSORIES - GUIDES ET ACCESSOIRES - GUIAS Y ACCESORIOS

Quality Guides & Accessories for PLASMA CUTTING

Guides et accessoires de qualité pour le DÉCOUPAGE de PLASMA
 Guías y accesorios de calidad para CORTE CON ARCO DE PLASMA

SHAPES * CIRCLES * STRAIGHT LINES * BEVEL EDGES
 FORMES * CERCLES * LIGNES DROITES * BORDS BISEAUTÉS
 FIGURAS * CIRCULOS * LINEAS RECTAS * BISELES

GET THE MOST FROM YOUR CUTTING EQUIPMENT. EASY TO USE, PROFESSIONAL RESULTS EVERY TIME. PURPOSE DESIGNED, QUALITY ENGINEERED
 OBTENEZ LES LA PLUPART DE VOTRE ÉQUIPEMENT DE DÉCOUPAGE. FACILE À EMPLOYER, RÉSULTATS PROFESSIONNELS CHAQUE FOIS. BUT CONÇU, QUALITÉ MACHINÉE
 APROVECHE AL MAXIMO SU EQUIPO DE CORTE. FACIL DE USAR, CON RESULTADOS PROFESIONALES. DESARROLLADO CON PROPOSITO, CALIDAD EN INGENIERIA

PLASMA GUIDES ENABLE CONSTANT
 TIP HEIGHT
 IMPROVE CUT QUALITY
 INCREASED CUTTING SPEED
 ENHANCED TIP LIFE

*LES GUIDES PLASMA PERMETTENT
 L'HAUTEUR CONSTANTE DE BOUT
 AMÉLIOREZ LA QUALITÉ DE COUPE
 VITESSE DE COUPURE ACCRUE
 LA VIE AUGMENTÉE DE BOUT*

LAS GUIAS PLASMA PERMITEN UNA ALTURA
 CONSTANTE EN LA BOQUILLA
 MEJORA LA CALIDAD DE CORTE
 INCREMENTO EN LA VELOCIDAD DE CORTE
 MEJORA LA VIDA DE LA BOQUILLA

HOW TO USE PRODUCTS
 COMMENT EMPLOYER DES PRODUITS
 COMO USAR EL PRODUCTO



CONTENTS

TABLE DES MATIÈRES CONTENIDO

PRODUCT TYPE	DESCRIPTION	PAGE
ROLLER GUIDE	USING THE ROLLER GUIDE	1
CIRCLE GUIDE	USING THE CIRCLE GUIDE	2
CIRCLE GUIDE	USING THE CIRCLE GUIDE FOR STRAIGHT LINES	3
CIRCLE GUIDE	USING THE CIRCLE GUIDE WITH ACCESSORIES	4
CIRCLE GUIDE	ASSEMBLY OF PLASMA CIRCLE CUTTING GUIDE	5
ACCESSORIES	MAGNETIC PIVOT & SUCTION PIVOT	6
ADDITIONAL	PRODUCT DESCRIPTIONS SPARE PARTS IDENTIFICATION	7

ESPÈCE DE PRODUIT PRODUCTO	DESCRIPTION DESCRIPCION	PAGE PAGINA
GUIDE DE ROULEAU GUIA CON RODAMIENTOS	EMPLOYER LE GUIDE DE ROULEAU USO DE LA GUIA CON RODAMIENTOS	8
GUIDE DE CERCLE GUIA CIRCULAR	EMPLOYER LE GUIDE DE CERCLE USO DE LA GUIA CIRCULAR	9
GUIDE DE CERCLE GUIA CIRCULAR	EMPLOYER LE GUIDE DE CERCLE POUR DES LIGNES DROITES USO DE LA GUIA CIRCULAR PARA REALIZAR CORTES RECTOS	10
GUIDE DE CERCLE GUIA CIRCULAR	EMPLOYER LE GUIDE DE CERCLE AVEC DES ACCESSOIRES USO DE LA GUIA CIRCULAR CON ACCESORIOS	11
GUIDE DE CERCLE GUIA CIRCULAR	ASSEMBLÉE DE GUIDE DE DÉCOUPAGE DE CERCLE DE PLASMA COMO ENSAMBLAR LA GUIA DE CORTE CIRCULAR PLASMA	12
ACCESSOIRES ACCESORIOS	PIVOT MAGNÉTIQUE ET PIVOT D'ASPIRATION PIVOTE MAGNETICO Y PIVOTE DE SUCCION	13
SUPPLÉMENTAIRE ADICIONALES	DESCRIPTIONS DE PRODUIT DESCRIPCION DE PRODUCTO	14

THERMAL DYNAMICS
82 BENNING STREET
West Lebanon NH 03784
USA

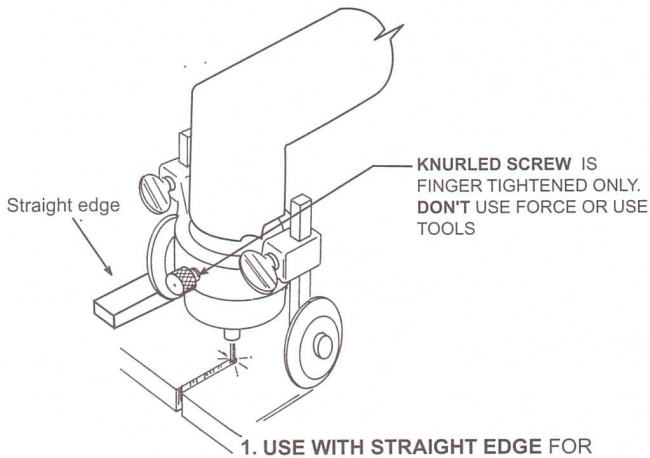
TEL: 1-800-PLASMA2
FAX: 1-800-221-4401
EMAIL:
tdctech@thermadyne.com

WARNING:

This product contains chemicals, including lead, or otherwise produces chemicals known to the State of California to cause cancer, birth defects and other reproductive harm.

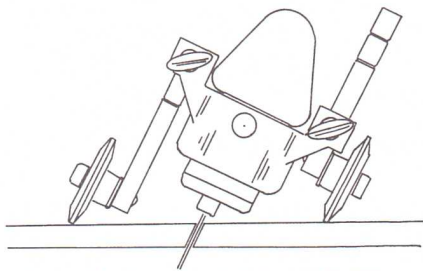
Wash Hands After Handling.

(California Health & Safety Code § 25249.5 et seq.)

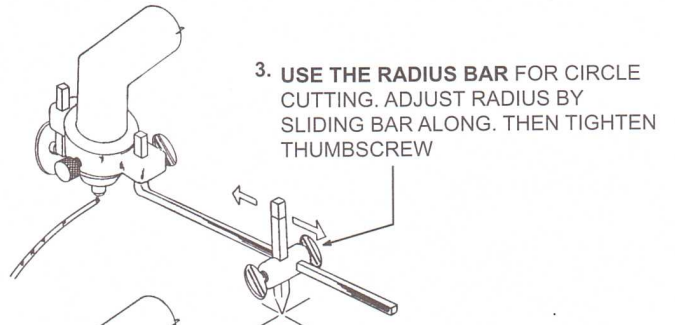


1. USE WITH STRAIGHT EDGE FOR BEST LINE CUTTING, OR FOLLOW MARKED LINES FOR SHAPES. SET AT STAND-OFF RECOMMENDED FOR TORCH, OR MINIMUM CLEARANCE TO RUN FREELY

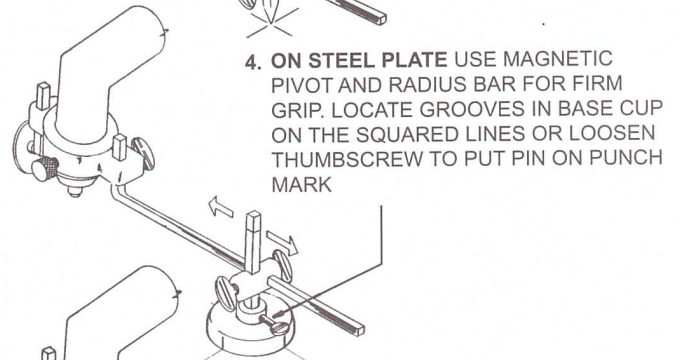
2. ADJUST HEIGHTS TO SET ANGLE FOR BEVELING OR KERF COMPENSATION



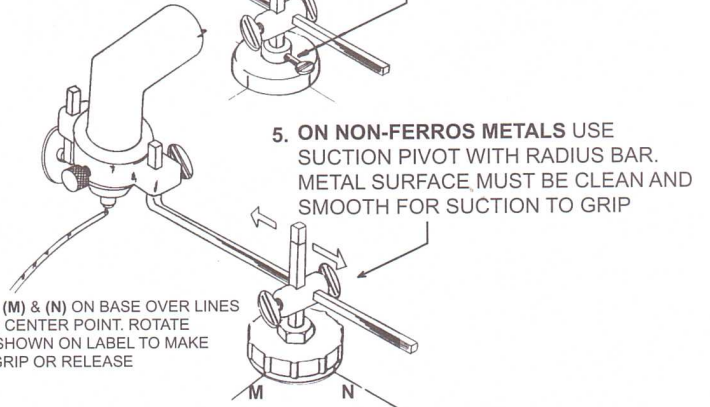
REPLACEMENT WHEELS ARE AVAILABLE #9-6518



3. USE THE RADIUS BAR FOR CIRCLE CUTTING. ADJUST RADIUS BY SLIDING BAR ALONG. THEN TIGHTEN THUMBSCREW



4. ON STEEL PLATE USE MAGNETIC PIVOT AND RADIUS BAR FOR FIRM GRIP. LOCATE GROOVES IN BASE CUP ON THE SQUARED LINES OR LOOSEN THUMBSCREW TO PUT PIN ON PUNCH MARK

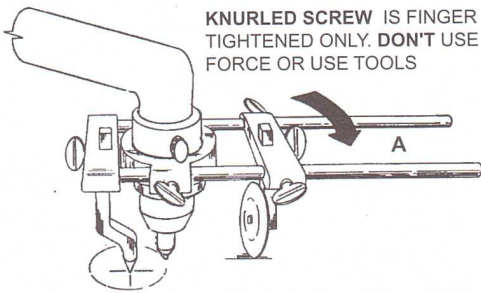


5. ON NON-FERROS METALS USE SUCTION PIVOT WITH RADIUS BAR. METAL SURFACE MUST BE CLEAN AND SMOOTH FOR SUCTION TO GRIP

LOCATE GROOVES (M) & (N) ON BASE OVER LINES SQUARED ACROSS CENTER POINT. ROTATE KNURLED CUP AS SHOWN ON LABEL TO MAKE SUCTION ACTION GRIP OR RELEASE

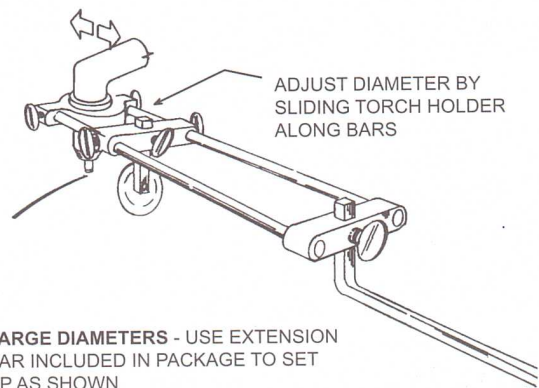
HOW TO USE PRODUCTS

2



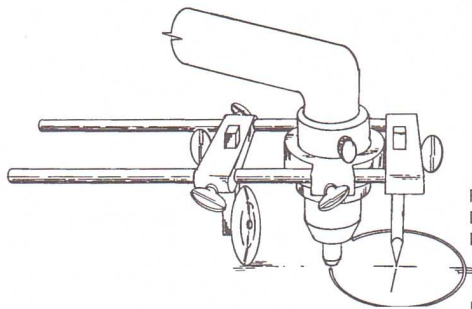
KNURLED SCREW IS FINGER TIGHTENED ONLY. DON'T USE FORCE OR USE TOOLS

1. **SMALL DIAMETERS** - LOCATE PIN ON PUNCH MARK, WITH TWIN BARS POINTING BACK UNDER TORCH BARREL. START TORCH AND PIERCE PLATE. THEN ROTATE GUIDE BY PUSHING (A) ONE WAY WITH A SMOOTH ACTION. THE TORCH BARREL AND OPERATOR STAY IN ONE PLACE AS CIRCLE IS COMPLETED IN ONE MOTION SHOWN BELOW



ADJUST DIAMETER BY SLIDING TORCH HOLDER ALONG BARS

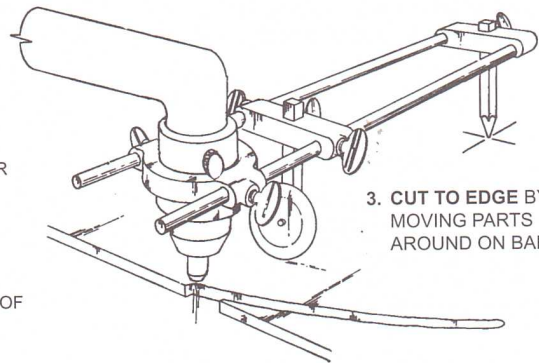
2. **LARGE DIAMETERS** - USE EXTENSION BAR INCLUDED IN PACKAGE TO SET UP AS SHOWN



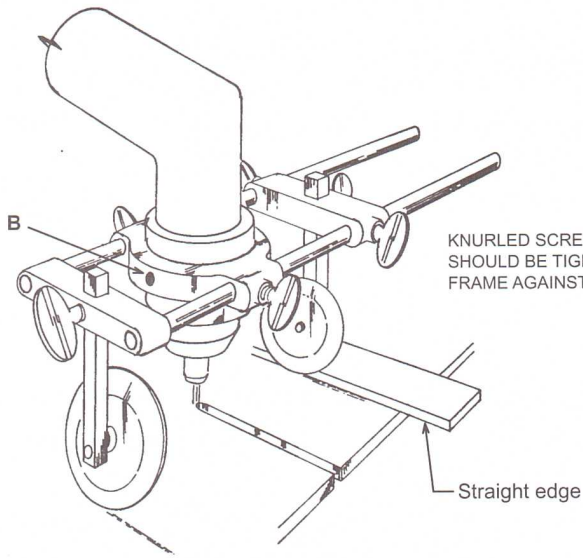
FOR BEST RESULTS, PIERCING OR DRILLING INSIDE RADIUS MAY BE NECESSARY ON HEAVIER PLATE

MAXIMUM CUTTING CAPACITY IS SPECIFIED BY MANUFACTURERS OF PLASMA MACHINE & TORCH

NOTE: POINT MAY NEED TO BE LIGHTLY HELD DOWN TO BALANCE WEIGHT OF TORCH



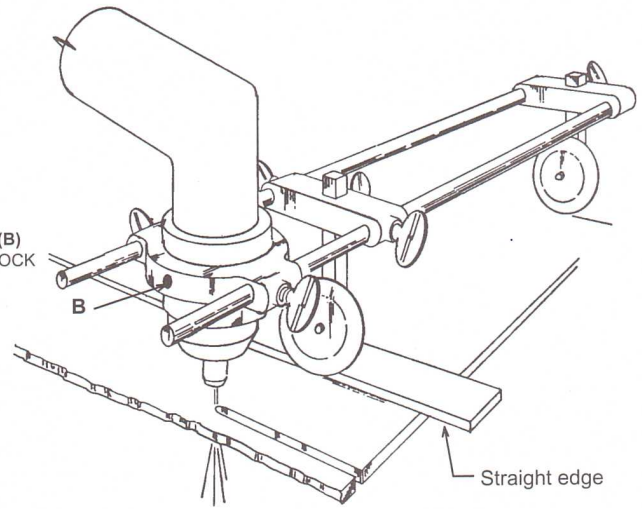
3. **CUT TO EDGE** BY MOVING PARTS AROUND ON BARS



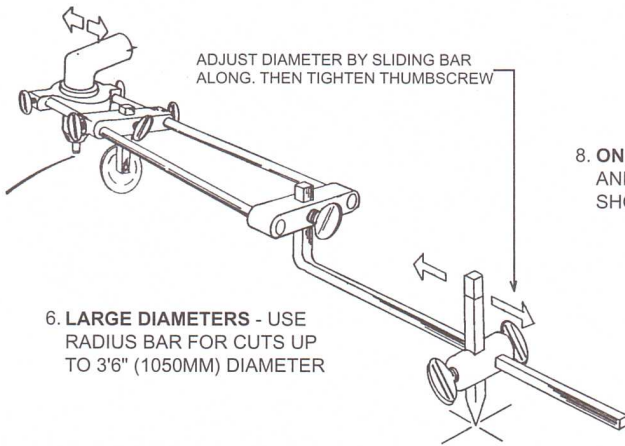
KNURLED SCREW FITTED AT (B) SHOULD BE TIGHTENED TO LOCK FRAME AGAINST ROTATION

STRAIGHT LINE CARRIAGE CAN BE SET UP BY FITTING SECOND WHEEL, INCLUDED IN PACK. TIGHTEN SCREW (B) TO STOP FRAME ROTATION

SET TORCH TO CORRECT STAND-OFF AS SPECIFIED BY MANUFACTURER, OR MINIMUM CLEARANCE OFF PLATE TO ALLOW PROPER CUTTING OPERATION

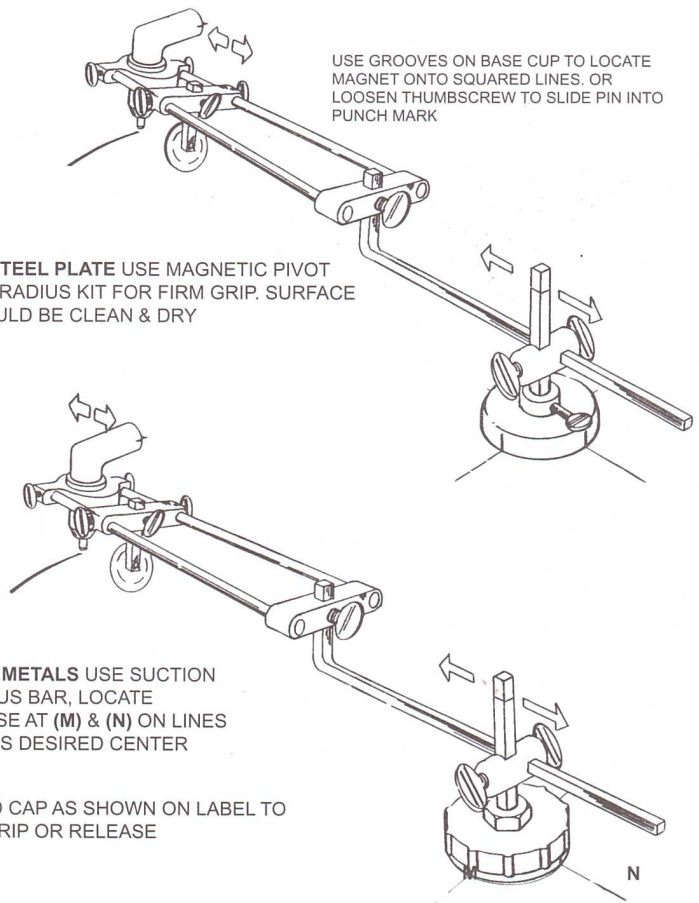


5. OFFSET CUTTING IS POSSIBLE BY MOVING PARTS AROUND AS SHOWN. THIS FEATURE IS USEFUL FOR CUTTING EDGES, OR NEAR TO A VERTICAL SURFACE



ADJUST DIAMETER BY SLIDING BAR ALONG. THEN TIGHTEN THUMBSCREW

6. **LARGE DIAMETERS** - USE RADIUS BAR FOR CUTS UP TO 3'6" (1050MM) DIAMETER



USE GROOVES ON BASE CUP TO LOCATE MAGNET ONTO SQUARED LINES. OR LOOSEN THUMBSCREW TO SLIDE PIN INTO PUNCH MARK

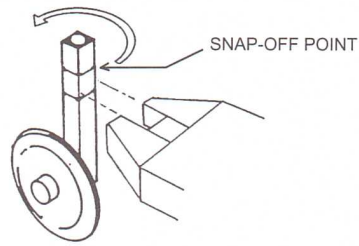
8. **ON STEEL PLATE** USE MAGNETIC PIVOT AND RADIUS KIT FOR FIRM GRIP. SURFACE SHOULD BE CLEAN & DRY

9. **ON NON-FERROS METALS** USE SUCTION PIVOT WITH RADIUS BAR, LOCATE GROOVES ON BASE AT (M) & (N) ON LINES SQUARED ACROSS DESIRED CENTER POINT.

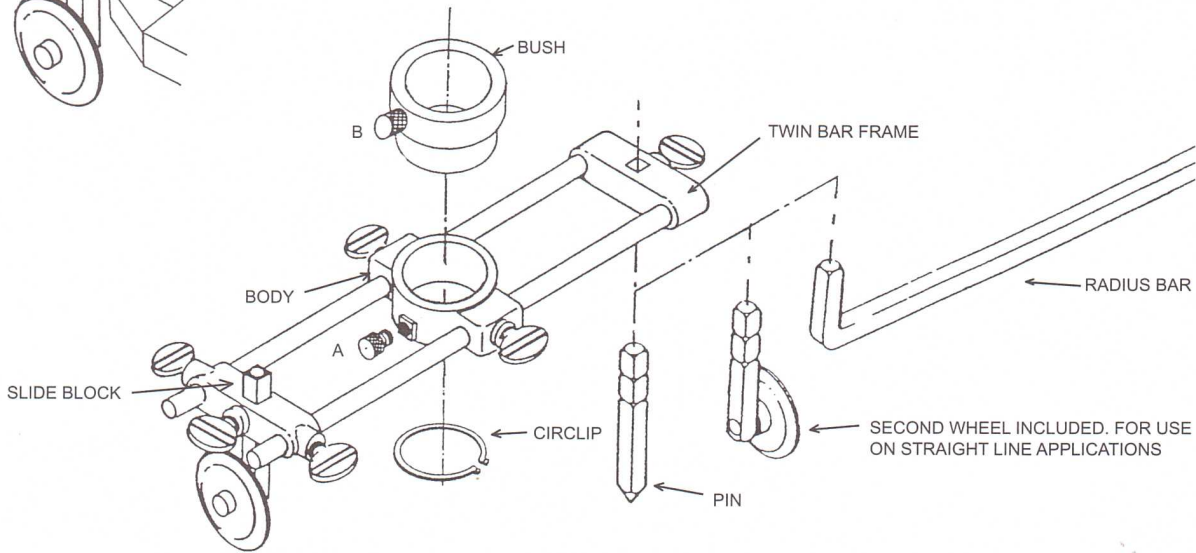
ROTATE KNURLED CAP AS SHOWN ON LABEL TO MAKE SUCTION GRIP OR RELEASE

N

FIG.1A SHORTENING SHAFTS



SUPPORT THE SHAFT BELOW THE GROOVE, THEN USING A SECOND SPANNER TWIST THE SHAFT ABOVE THE GROOVE BY ROTATION. THIS WILL SHEAR OFF THE PORTION CLEANLY AS THESE BARS HAVE BEEN HARDENED. PIVOT PINS CAN ALSO BE SHORTENED BY USING THIS METHOD AT ANY GROOVED MARK

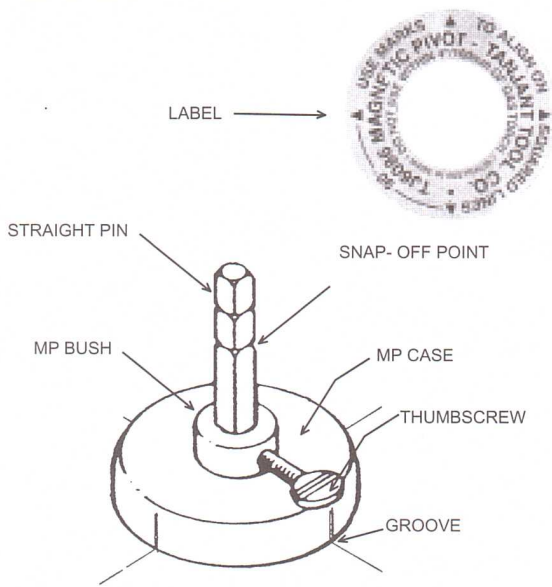


KNURLED SCREWS
FINGER TIGHTEN ONLY

SCREW (A) - LOCK ROTATION
SCREW (B) - HOLD TORCH

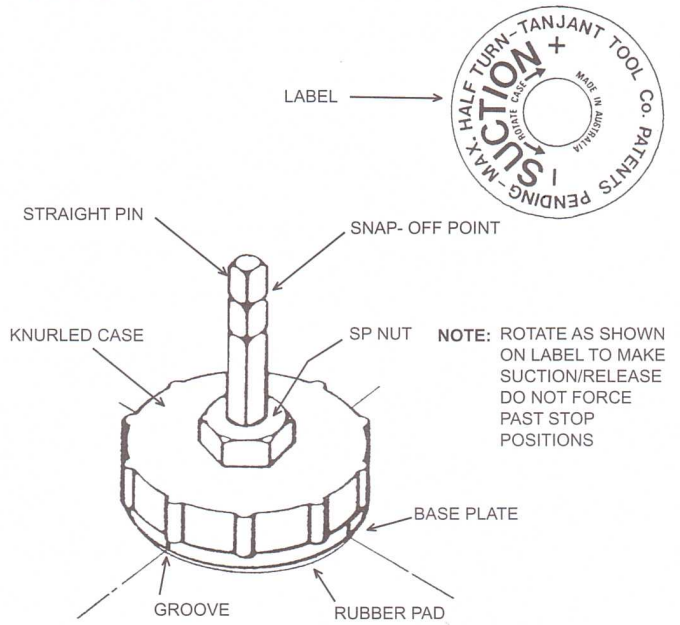
IMPORTANT: THE ITEM SHOWN IS A TYPICAL ASSEMBLY ONLY. THE ACTUAL GUIDE TO SUIT A PARTICULAR TORCH MAY VARY.
REPLACEMENT PARTS ARE AVAILABLE

FIG.1 MAGNETIC PIVOT



MAGNET IS PERMANENTLY BONDED TO CASE WITH A FIRE RETARDANT RESIN. PIN MAY BE SHORTENED IF REQUIRED BY THE METHOD SHOWN IN FIG 1A ONLY. WHEN LOCATING ONTO A CENTER PUNCH MARK, FIT PIN THROUGH BUSH AND LET MAGNET SLIDE DOWN FIRM ONTO WORK BEFORE TIGHTENING THUMBSCREW TO HOLD POSITION. USE MARKS ON SIDE OF CASE TO ALIGN TO SQUARED LINES ON WORK.

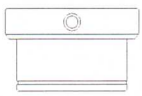
FIG.2 SUCTION PIVOT



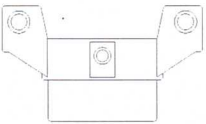
NOTE: ROTATE AS SHOWN ON LABEL TO MAKE SUCTION/RELEASE DO NOT FORCE PAST STOP POSITIONS

SCREW NUT & SHAFT ASSEMBLY INTO TOP OF KNURLED CASE. SHAFT MAY BE SHORTENED IF REQUIRED BY THE METHOD SHOWN IN FIG. 1A ONLY. NOTE GROOVES IN BASE AT 90° INTERVALS TO ALLOW LOCATION ON SQUARE LINES.

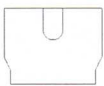
SPARE PARTS IDENTIFICATION



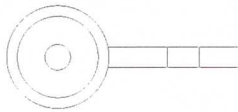
(9-6516) BUSH -STAMPED"75"
PCH-60,62,75,76,80,100XL,102,
RPT-28
(9-6529) BUSH -STAMPED "1"
"1" Torch



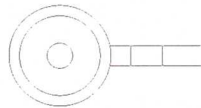
(9-6517) ROLLER GUIDE



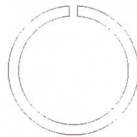
(9-6515) ADAPTER SLEEVE
FITS # 9-6529 BUSH &
9-6517 ROLLER GUIDE,
USED FOR PCH-10,25,26,28,
35,38,40,42



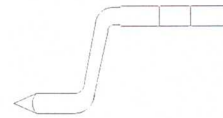
(9-6518)
WHEELS, LONG



(9-6519)
WHEELS, SHORT



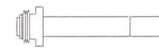
(9-6514) 35mm
SNAP RING



(9-6531) OFFSET PIN



(9-6520) STRAIGHT PIN



(9-6530) SP PIN & NUT



(9-6527) LINK NUT



(9-6513) 1/4" Thumbscrew
(Used on circle guide
frame, roller guide, radius
bar, wheels)



(9-6512) 3/16" Thumbscrew
(Used on magnetic pivot)



(9-6511) 3/16" Capscrew (1/4" Long)



(9-65XX) 3/16" Capscrew
(3/8" Long) (Used on bush
& roller guide when # 9-6515
adapter sleeve is in place)

OTHER QUALITY PRODUCTS FROM THERMAL DYNAMICS

TRAKKA LINE CUTTER

- #7-8911 TRAKKA - 1.2 METER (4') TRACK WITH TROLLEY & 2 MAGNETIC BASES
- #9-7971 RAIL - 1.2 METER (4') TRACK ONLY
- #9-7970 MAGNETIC BASE - WITH LOCK WHEEL TO ATTACH TO TRACK
- #9-7972 JOINER - MACHINED JOINING SECTION TO EXTEND TRACK LENGTHS
- #7-3152 SUCTION BASE - FOR CLAMPING TRACK TO ALLOY AND NON-FERROS METALS

TRAKKA OFFERS A COMPACT AND PORTABLE HAND OPERATED GUIDING SYSTEM THAT IS QUICK TO SET UP, ELIMINATING THE NEED FOR STRAIGHT EDGE CLAMPING, CAN BE USED FOR POSITIONAL WORK AND REPETITIVE CUTTING