

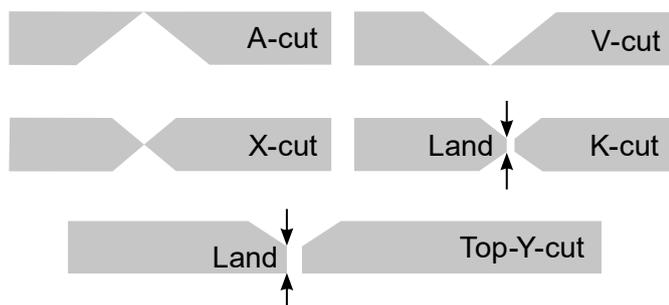
# True Bevel™ Technology for XPR™



Hypertherm's True Bevel™ technology was launched in 2012 with the HPRXD® family of products. It is now also offered on Hypertherm's 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.

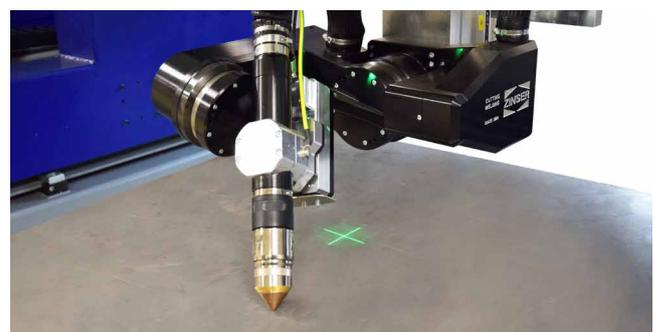
The True Bevel™ technology works with the ZINSER bevel head and covers V, A, Top-Y, X and K style cuts for mild steel:



## 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.

The True Bevel™ technology with ZINSER's plasma bevel unit is the best solution.



# Bevel angle and land density coverage

## Thickness coverage

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

## V, A and X angle coverage

		Angle*												
		-50°	-45°	-40°	-37.5°	-35°	-30°	-27.5°	-25°	-22.5°	-20°	-17.5°	-15°	
<b>V-cut</b>														
<b>A-cut</b>			45°	40°	37.5°	35°	30°	27.5°	25°	22.5°	20°	17.5°	15°	
<b>X-cut</b>	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.

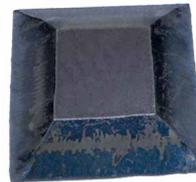
# Cutting examples

## Without True Bevel™



These three parts were job setup iterations during field testing using the existing method that took more than 1 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.

## Contact us for further information:

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SINCE 1898



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