

PROCESS



Air Plasma Cutting

5/3/1 INDUSTRIAL WARRANTY



Comes Complete With:

- ICE-27C hand-held torch with 20 ft (6 m)
- Heavy-duty work clamp with 20 ft (6.1 m) cable
- Extra consumables (3 electrodes, 3 tips and 1 air fitting)
- 10 ft (3 m) power cord with 115 VAC, 20 A plug
- Easy-to-connect, built-in gas/air filter and regulator with extra protection

Industrial Applications

- Maintenance
- Light Construction
- Prototyping
- Body Shops
- Fabrication
- HVAC Ductwork

FEATURES

BENEFITS

Pilot Arc Controller	Helps the operator minimize tip burnout by eliminating the need to restart the arc at the beginning of each new cut which increases cutting capabilities and speeds, and improves tip life.
ICE-27C torch	The rugged ICE-27C torch, with patented trigger safety guard, is ergonomically built and includes drag tips for convenient cutting on all metals.
LVC™ line voltage compensation	Keeps the output of a power source constant, regardless of minor fluctuations in input power.
Power factor correction	Expands operator's work area via extension cords while minimizing nuisance trips caused by voltage drops.
LED indicators	Diagnostic lights for quick troubleshooting of pressure, power and cup situations.
Starts without high frequency	Protects unit by not interfering with or damaging controls or computers.
Consumables storage compartment	Convenient storage compartment that stores additional parts and accessories.
Full cutting capacity	The AirForce 400 provides excellent cutting capability when powered by most engine-driven welders with 240 VAC receptacles.
Internal gas/air filter/regulator	Controls amount of usage and flow of air and gas.
Postflow cooling circuit	Extends life of consumables and torch by cooling them with postflow air after trigger is released.
Hobart's 5/3/1 Warranty	No other manufacturer offers a better warranty than Hobart does. Power source is warranted for three years, parts and labor. Original rectifier parts have a five-year warranty and the ICE torches have a one-year parts and labor warranty.

SPECIFICATIONS (SUBJECT TO CHANGE WITHOUT NOTICE.)

INDUSTRIAL

DC 1 Phase

Rated Output	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz, 1-Phase				Plasma Gas Flow/Pressure	Dimensions	Net Weight with torch	Ship Weight
		115 V	230 V	kVA	KW				
27 A with 90 VDC, 35% Duty Cycle	288 VDC	28*	14	3.3	3.2	4.5 CFM (129 L/min) at 60 PSI (414 kPa)	H: 13-1/2 in (343 mm) W: 8-1/2 in (216 mm) D: 16 in (406 mm)	55 lb (25 kg)	61.5 lb (27.9 kg)

*Recommended 30 A branch circuit for maximum performance. Performance on 20 A branch service may be limited due to breaker/line fuse. Reducing unit output amperage will minimize nuisance breaker/line fuse tripping.



Hobart Welders An Illinois Tool Works Company

U.S. Distributor Sales Phone 920-735-4576 FAX 800-637-2315
 Hobart Retail Sales Phone 800-332-3281 FAX 937-332-4161
 Canadian Sales Phone 888-489-9353 FAX 519-421-0480
 International Sales Phone 920-735-4509 FAX 920-735-4125

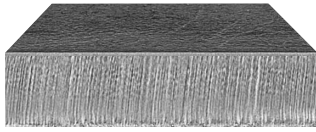
Web Site www.HobartWelders.com



MILD STEEL CUTTING CAPABILITY (Thickness to scale.)

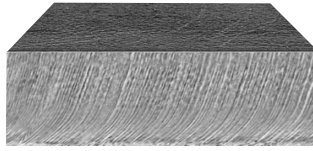
1/16 in Standoff Cutting

Rated



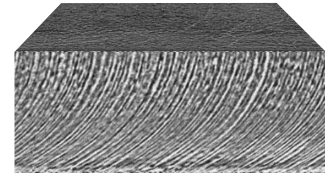
3/8 in (10 mm)

Quality



1/2 in (13 mm)

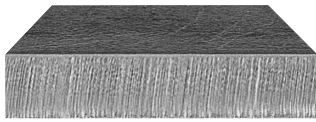
Sever



5/8 in (16 mm)

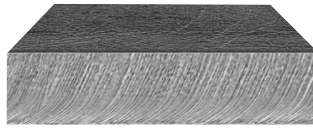
Drag Cutting

Rated



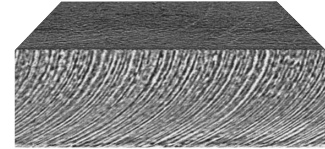
5/16 in (8 mm)

Quality



3/8 in (10 mm)

Sever



1/2 in (13 mm)

Rated Cutting Capacity

10 inches per minute (minimum speed at which an operator achieves a smooth, steady cut using a hand-held torch).

Maximum Quality Cutting Capacity

Good-quality cut achieved at lower speeds.

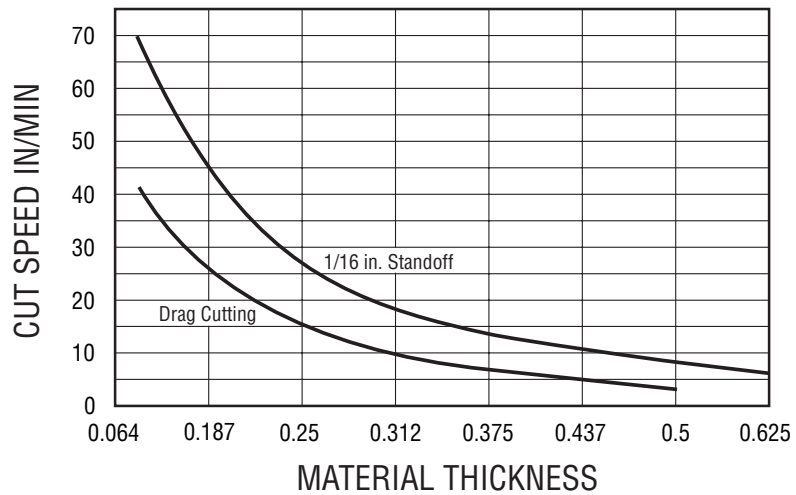
Sever Cut Capacity

Maximum cut achieved in ideal conditions.

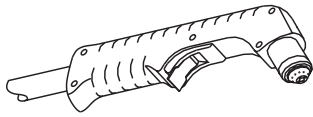
CUTTING PERFORMANCE

To determine the maximum rated cutting thickness of mild steel, follow the line from the 10 IPM (inches per minute) point on the cutting chart. The point at which this line intersects the cutting curve determines the maximum recommended production cutting thickness of the unit.

Note: The rating is based on 10 IPM because this is the minimum speed at which the operator achieves a smooth, steady cut when using a hand-held torch.



ACCESSORIES



ICE-27C Replacement Torch
#195 014 20 ft (6 m)

Full KVA Plug Kit #119 172 Field
240 VAC, 50 amp plug (NEMA 14-50P) to fit full KVA receptacle on Champ 16 or 8500.

115 VAC, 20 A Receptacle #141 432 Field
Receptacle matches 20 amp plug supplied with Airforce 400.

115 VAC, 15 A Plug Kit #073 690 Field
Allows connection to 15 amp household receptacle.



Plastic Consumables Box with Compartments
#127 493
For storing additional parts and accessories.

Cable Cover #118 678 30 ft (9 m)



Plasma Standoff Roller Guide #194 883
Helps maintain recommended standoff distance to maximize cutting performance and improve tip life.



Plasma Circle-Cutting Guide
#195 981
ICE-12C, 25C, 27C, 50C, 55C, 80C
Cut straight lines or circles up to 12 in diameter with ease.

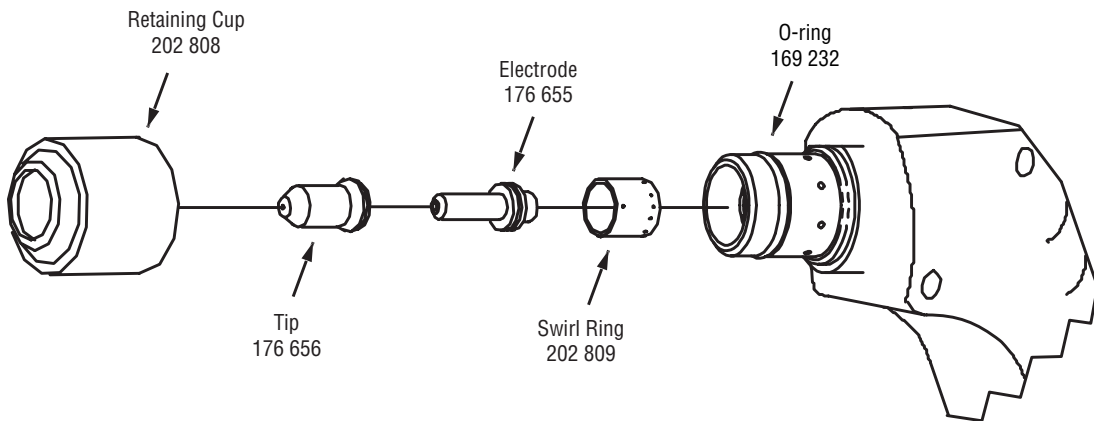


Suction/Magnetic Pivot Base #195 979
Add this to your cutting guide for convenient attachment to all flat surfaces. The extended arm accommodates holes up to 30 in diameter.



#30A Economy Running Gear and Cord Wrap #195 093
Economical running gear with angle for easy front panel access provides storage for gloves and tools. (Fits AirForce™ 250, 250A, and 400).

TORCH CONSUMABLES (Order from Hobart Service Parts.)



ORDERING INFORMATION AND SYSTEM CHECKLIST

Power Source	Stock No.	Description	Qty.	Price
AirForce™ 400	#500 474	With 20 ft (6 m) hand-held torch single-phase, 115/230 VAC, 60 Hz		
UPC: #715959260268; Shipping Weight: 61.5 lb; Carton Dimensions: 21-1/2 x 13 x 16 in; Pallet Qty: 6 <i>Note: Shipping via UPS not recommended.</i>				
Accessories				
Replacement Torch	#195 014	20 ft (6 m) ICE-27C hand-held torch		
Full KVA Plug Kit	#119 172	Field		
115 V, 20 A Receptacle	#141 432	Field		
115 V, 15 A Plug Kit	#073 690	Field		
Plastic Consumables Box	#127 493	With compartments		
Cable Cover	#118 678			
Plasma Standoff Roller Guide	#194 883			
Plasma Circle-Cutting Guide	#195 981	For ICE-12C, 25C, 27C, 50C, 55C, 80C		
Suction/Magnetic Pivot Base	#195 979			
#30A Economy Running Gear	#195 093	With cord wrap		
Compressed Air/Nitrogen				
Gas Hose with Fittings				
Primary Cable and Plug				
Safety Face Shield				
Hearing Protective Device				
Gloves and Protective Clothing				
Date:			Total Quoted Price:	

HOBART

W E L D E R S

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