Hypertherm 120926

Hypertherm Plasma Electrode User Manual

Model: **120926** | Brand: **Hypertherm**

1. Product Overview

This manual provides essential information for the proper handling, installation, and use of Hypertherm 120926 Plasma Electrodes. These electrodes are genuine Hypertherm consumables designed for optimal performance in compatible plasma cutting systems.

The Hypertherm 120926 electrodes are specifically designed for 40-80A plasma cutting applications, compatible with Hypertherm Powermax 1000/1250/1650/RT80 systems. Each package contains 5 electrodes, ensuring you have a supply of critical components for continuous operation.

Figure 1: Front view of the Hypertherm 120926 Plasma Electrodes packaging, showing the product name, quantity (5), and model number.

Figure 2: Rear view of the Hypertherm 120926 Plasma Electrodes packaging, displaying the five individual electrodes and important safety warnings.

2. Installation Instructions (Setup)

2.1 Safety Precautions

- Always disconnect power to the plasma cutting system before performing any maintenance or component replacement.
- Wear appropriate personal protective equipment (PPE), including welding gloves and eye protection, when handling plasma torch components.
- Ensure the work area is well-ventilated.

2.2 Electrode Replacement Procedure

1. **Power Off:** Turn off and unplug the plasma cutting power source.
2. **Cool Down:** Allow the torch to cool down if it has been recently used.
3. **Disassemble Torch:** Carefully unscrew the retaining cap and remove the nozzle. The electrode will typically be located behind the nozzle.
4. **Remove Old Electrode:** Gently pull out the worn electrode. Inspect the torch body for any damage or debris.
5. **Install New Electrode:** Insert a new Hypertherm 120926 electrode into the torch body, ensuring it seats properly. Do not force it.
6. **Reassemble Torch:** Replace the nozzle and screw the retaining cap back on securely. Ensure all components are tightened to the manufacturer's specifications to prevent gas leaks or poor performance.
7. **Power On:** Reconnect power to the plasma cutting system.

Refer to your specific plasma cutting system's user manual for detailed torch disassembly and reassembly instructions.

3. Usage Guidelines (Operating)

Hypertherm 120926 electrodes are critical components for plasma cutting. Proper usage ensures optimal cut quality and consumable life.

- **Current Settings:** Use the recommended amperage settings for your material thickness and the specific Hypertherm plasma system. Operating outside recommended parameters can prematurely wear electrodes.
- **Air Quality:** Ensure your compressed air supply is clean, dry, and oil-free. Contaminants in the air can significantly reduce electrode life and cut quality.
- **Torch Standoff:** Maintain the correct torch-to-work distance (standoff) as specified by your plasma system's manual. Incorrect standoff can cause excessive wear on the electrode and nozzle.
- **Piercing Technique:** When piercing, use the recommended piercing height and technique to minimize electrode wear. Avoid "diving" the torch into the material.
- **Consumable Inspection:** Regularly inspect the electrode and nozzle for signs of wear, such as pitting, excessive erosion, or a deformed orifice. Replace consumables as a set when wear is evident to maintain cut quality.

4. Care and Storage (Maintenance)

Proper care and storage of electrodes can help maintain their integrity and readiness for use.

- **Storage:** Store unused electrodes in their original sealed packaging in a cool, dry place to protect them from moisture and contaminants.
- **Handling:** Handle electrodes with clean hands or gloves to avoid transferring oils or dirt to the contact surfaces.
- **Inspection:** Before installation, visually inspect each new electrode for any manufacturing defects or damage.

5. Troubleshooting

Electrodes are wear parts, and their performance directly impacts cut quality. Most "troubleshooting" related to electrodes involves recognizing when they need replacement.

Symptom	Possible Cause (Electrode Related)	Solution
Poor cut quality (rough, drossy cuts)	Worn or pitted electrode	Replace electrode (and nozzle)
Short consumable life	Incorrect operating parameters (amperage, standoff), contaminated air, improper piercing technique	Verify settings, check air quality, adjust technique
Torch misfiring or unstable arc	Poor electrical contact due to dirty or damaged electrode, incorrect installation	Clean contact surfaces, ensure proper seating, replace if damaged

If issues persist after replacing consumables, consult your plasma cutting system's comprehensive troubleshooting guide or contact Hypertherm technical support.

6. Technical Specifications

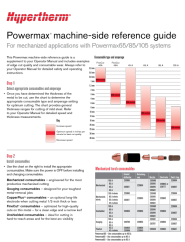
Attribute	Detail
Manufacturer	Hypertherm
Part Number	120926
Item Weight	1.6 ounces
Product Dimensions	1 x 1 x 6 inches

Attribute	Detail
Item Model Number	120926
Material	Copper
Item Package Quantity	5
National Stock Number	3439-01-616-9044
ASIN	B005V2FYGM
First Available Date	October 12, 2011

7. Warranty and Support

As a consumable item, the Hypertherm 120926 Plasma Electrodes are designed for a finite lifespan and are subject to wear during normal operation. Specific warranty information for consumables is typically limited to manufacturing defects upon receipt.
For detailed warranty terms, technical assistance, or to report a manufacturing defect, please contact Hypertherm directly through their official website or customer service channels. Ensure you have your product details and purchase information available when contacting support.
Manufacturer: Hypertherm
Official Website: www.hypertherm.com

Related Documents - 120926

	Hypertherm Powermax Machine-Side Reference Guide for Mechanized Cutting Comprehensive guide for Hypertherm Powermax 65, 85, and 105 systems, detailing mechanized applications, consumable selection, setup, operation, and maintenance for optimal plasma cutting performance.

	[Hypertherm Powermax SYNC Machine-Side Reference Guide for Mechanized Cutting] A comprehensive machine-side reference guide for Hypertherm Powermax SYNC systems (65/85/105) used in mechanized cutting applications. Covers setup, consumables, cut quality, troubleshooting, and maintenance.
	[Hypertherm MAXPRO200 Instruction Manual: Comprehensive Guide] This comprehensive instruction manual provides detailed information on the Hypertherm MAXPRO200 plasma cutting system, covering installation, operation, safety procedures, specifications, maintenance, and troubleshooting for industrial applications.
	[Hypertherm HPR400XD Auto Gas Instruction Manual] Instruction manual for the Hypertherm HPR400XD Auto Gas system, covering installation, operation, safety, and warranty information.
	[Hypertherm Operator's Manual for Shape Cutting Control Systems] This comprehensive operator's manual provides detailed guidance on the setup and operation of Hypertherm's advanced shape-cutting control systems. It covers essential functionalities such as ShapeWizard, Nester, HyperCAD, and various cutting technologies including Plasma, Laser, Oxy-Fuel, and Waterjet, emphasizing user-friendliness and enhanced productivity.
	[Hypertherm ProNest 2019 CAD/CAM Nesting Software Overview] An overview of Hypertherm's ProNest 2019, an industry-leading CAD/CAM nesting software for advanced mechanized cutting. Details features, benefits, and modules for plasma, laser, waterjet, and oxyfuel cutting.