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RIVERWELD C1372

RIVERWELD C1372 Plasma Tip Nozzle 1.3 User Manual

For Cebora CP160, HP100, MP100, CB100, CB150 Plasma Torches

INTRODUCTION

This manual provides essential information for the proper use, installation, and maintenance of RIVERWELD C1372 Plasma Tip Nozzles. These tips are designed as replacement consumables for specific plasma cutting torches. Adhering to these instructions will help ensure optimal performance and longevity of the tips.

PRODUCT OVERVIEW

The RIVERWELD C1372 Plasma Tip Nozzle is a consumable component used in plasma cutting systems. Each package contains 10 pieces of 1.30 mm nozzles, referenced as C1372. These tips are manufactured from copper and are designed for precision cutting applications.



Image 1: A pack of ten RIVERWELD C1372 Plasma Tip Nozzles. These copper-colored tips are essential consumables for plasma cutting, featuring a precise 1.3mm orifice.

COMPATIBILITY

These C1372 Plasma Tip Nozzles are compatible with the following plasma cutting torches:

- Cebora CP160
- Cebora HP100
- Cebora MP100
- Cebora CB100
- Cebora CB150
- Cebora CB150P

They are equivalent to PD0026-13 Tip 1.3mm for CB100 and CB150 torches.

SETUP AND INSTALLATION

Proper installation of the plasma tip is crucial for safe and effective operation. Always refer to your plasma torch's specific user manual for detailed instructions on consumable replacement.

1. **Safety First:** Ensure the plasma cutter is powered off and disconnected from the power source before attempting any maintenance or part replacement.
2. **Cool Down:** Allow the torch to cool completely if it has been recently used.
3. **Disassemble Torch Head:** Carefully unscrew or unclip the retaining cap and remove the old consumables (shield cap, nozzle, electrode, swirl ring). Note the order of removal.
4. **Inspect Components:** Inspect the torch body for any damage or debris. Clean if necessary.
5. **Install New Tip:** Insert the new C1372 plasma tip nozzle into its designated position. Ensure it seats correctly and is aligned with the electrode.
6. **Reassemble:** Reinstall the other consumables (swirl ring, electrode, shield cap) in the correct order, ensuring all components are securely tightened but not overtightened.
7. **Check Connections:** Verify all torch connections are secure before restoring power.



Image 2: A detailed view of the RIVERWELD C1372 Plasma Tip Nozzles, highlighting their internal design and the critical 1.3mm opening for plasma arc constriction.

OPERATING CONSIDERATIONS

While these tips are consumables, proper operating practices can extend their effective life and improve cut quality.

- **Correct Amperage:** Use the recommended amperage settings for your material thickness and the 1.3mm nozzle size. Over-amperage can rapidly degrade the tip.
- **Proper Standoff Distance:** Maintain the correct standoff distance between the torch and the workpiece. Too close or too far can cause premature tip wear and poor cut quality.
- **Clean Air Supply:** Ensure your plasma cutter has a clean, dry, and oil-free air supply. Contaminants can clog the nozzle and reduce performance.
- **Pierce Height:** Use the recommended pierce height to prevent molten metal from splashing back onto the tip, which can cause damage.
- **Inspect Regularly:** Periodically inspect the tip for signs of wear, such as an enlarged or oval-shaped orifice, excessive dross buildup, or signs of double arcing.

MAINTENANCE

Regular inspection and timely replacement of consumables are key to consistent plasma cutting performance.

- **Tip Replacement:** Replace the C1372 plasma tip when the orifice shows signs of wear, such as becoming oval, enlarged, or when cut quality degrades significantly.
- **Cleanliness:** Keep the torch head and all consumable parts clean. Remove any spatter or dross buildup using a non-abrasive tool.

- **Storage:** Store unused tips in a dry, clean environment to prevent contamination or damage.

TROUBLESHOOTING

If you experience issues with your plasma cutting, consider the following common troubleshooting steps related to the plasma tip:

Problem	Possible Cause	Solution
Poor Cut Quality / Excessive Dross	Worn or damaged plasma tip nozzle. Incorrect standoff distance.	Replace the C1372 tip. Adjust standoff distance according to torch manual.
Short Tip Life	Over-amperage. Incorrect pierce height. Contaminated air supply.	Reduce amperage. Adjust pierce height. Check air filter/dryer.
No Arc / Intermittent Arc	Tip not seated correctly. Damaged tip or electrode.	Reinstall tip and other consumables. Replace tip and electrode if damaged.

SPECIFICATIONS

Feature	Detail
Model Number	C1372
Nozzle Orifice Size	1.30 mm
Reference Number	C1372 (equivalent to PD0026-13)
Material	Copper
Package Quantity	10 pieces
Product Dimensions	Approximately 5.91 x 3.94 x 0.55 inches (package)
Item Weight	Approximately 2.24 ounces (package)
Compatibility	Cebora CP160, HP100, MP100, CB100, CB150, CB150P torches

WARRANTY AND SUPPORT

As these are consumable parts, specific warranties may vary. For any questions regarding product compatibility, performance, or support, please contact your retailer or the manufacturer, RIVERWELD, directly. Always ensure you are purchasing genuine RIVERWELD products or compatible OEM replacements from authorized sellers.

For more information, visit the RIVERWELD Store on Amazon.