



Westwood Tech Tips



A Monthly Newsletter from WMT

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Welcome to the first issue of Westwood Metal Technologies Tech Tips .

Getting The Best From Your Plasma Process

Part 1 Consumables:

A good starting point with most issues experienced with plasma cutting processes is consumables. More than 50% of cutting issues can be traced back to a problem with consumables. Although there are after market consumables that may provide some difference in cost usually the reduction in life of the consumable will more than compensate for the additional cost.

Without exception I always recommend OEM consumables that will give you better performance. At least one after market consumable manufacturer claims that using their consumables will turn standard plasma into high performance plasma.

Before the start of production each day examine the following:

1. Pull out your chart and ensure you have all the correct consumables for the material and amperage you are cutting.
2. Check your nozzle for out of shape wear on the opening.
3. Check your electrode for depth wear.
4. Check all O-rings for tearing and wear.
5. Check your swirl ring for cracks and wear.

Remember good consumables will equal good parts.

When changing consumables ensure that you use an O-ring lubricant specially designed for your consumables. The lubricant must be applied sparingly, only a very slight sheen should be present after application. In addition, use the recommended tools for removing and installing your consumables to prevent damage to the consumables and the torch. In the past I have replaced expensive torches due to operators prying shield caps off with a screwdriver instead of the correct tool.

Sometimes the simplest things are over looked when experiencing cutting problems. I will cover the second most common problem of the plasma cutting process in Part 2 of this article.

Comments ,suggestions I would love to hear from you Terry Baxter tsbaxter@ec.rr.com



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