

 **contour cut**

## Precision in Detail

Small holes, fine inner and outer contours: the precision of Contour Cut revolutionises the plasma cutting of mild steel.



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## Contour Cut for Highest Quality Standards

Until now the quality of cutting edges has been insufficient when cutting small holes with a diameter equal to the material thickness. Being the technology leader in plasma cutting, Kjellberg Finsterwalde offers an optimum solution for this problem. The HiFocus systems with Contour Cut redefine the state of the art. The result - excellent quality without time-consuming after-treatment at low costs.

### Precision in Detail

Contour Cut is the further development of our successful HiFocus technology for cutting contours in mild steel, in particular small holes as well as fine inner and outer contours.

This newest development ensures the further improvement of the quality with respect to contour accuracy, perpendicularity and surface quality.

Contour Cut is integrated as standard into all plasma cutting systems of the HiFocus series with the plasma torches PerCut 200/210 and PerCut 440/450.

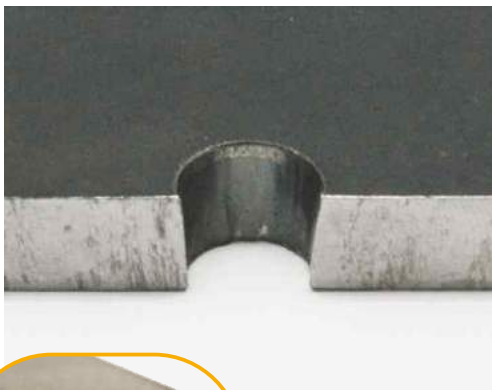


### Results

When cutting small contours, i.e. holes, slotted holes, squares and hexagons, convincing cut qualities can be achieved:

- Holes with angular deviations ranging between 2 and 4 according to DIN EN ISO 9013
- Further reduction of perpendicularity tolerances at inner and outer contours
- Reduced difference of angular deviations on all sides of outer contour

**Competitor**



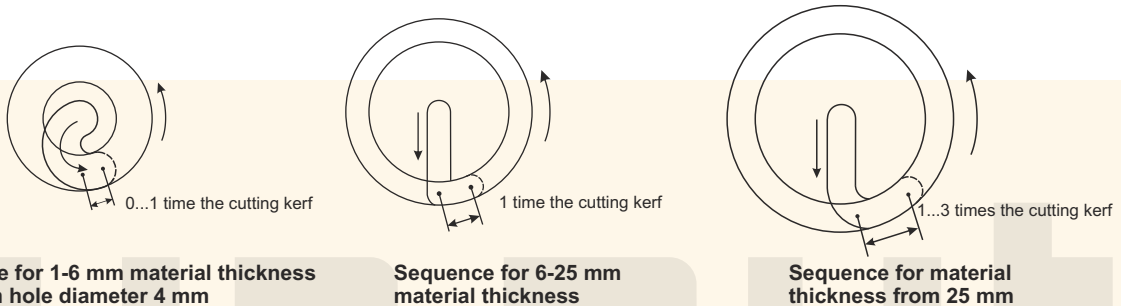
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## Plasma Cutting with Contour Cut

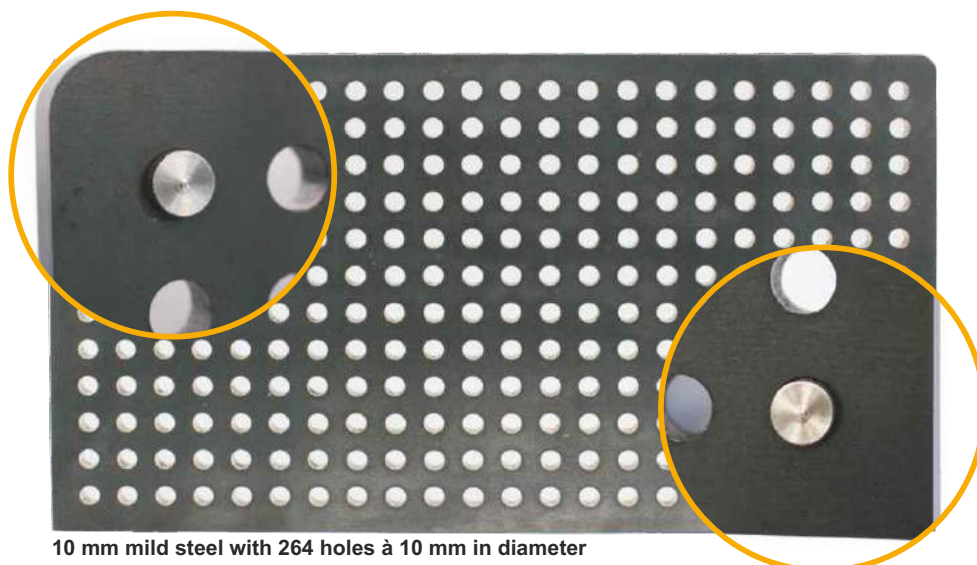
Contour Cut is the latest patented plasma cutting technology for mild steel. The following points should be considered to achieve good results when cutting holes with a diameter to thickness ratio of 1:1:

- Align the work-piece horizontally to the plasma torch that is in absolutely vertical position
- Adjust correct torch height
- Freeze the height control for hole diameters of up to 25 mm
- Select speed in correspondence with the cutting parameters for Contour Cut
- Program contours according to the following drawings



### Advantages at a Glance

- High cut quality and contour accuracy on inner and outer contours
- Reduced angular deviations and improved quality of cut surfaces
- Very high repeatability and dimension accuracy
- High productivity at low costs
- No further equipment or software required
- No new consumables required
- Standard for all HiFocus systems with the new plasma torches



10 mm mild steel with 264 holes à 10 mm in diameter