

# Upgrade Option #3 – HPR130 / HPR260

## Benefits include:

- PowerPierce technology for thicker piercing capability
- True Hole\* technology enabled
- Internal Ohmic contact system
- New 80 amp mild steel bevel process
- Improved reliability/robustness
- **Improved argon marking process**

## What to order:

1. Upgrade kit which includes: 228524
2. New control board with firmware for the power supply
  - Gas console firmware for both Auto Gas selection console and metering console, and tool to remove firmware chips
  - Adapter fittings for metering console, to connect new torch leads to old style connectors on metering console)
  - Field service bulletin
  - XD and PowerPierce labels
2. New XD machine torch assembly which includes a quick disconnect torch and receptacle, torch sleeve (length 178mm/7"), and 1 set of consumables (choose one):
  - HPR130XD torch 228520
  - HPR260XD torch 228521
3. New torch leads (choose one set, 72" gas hose from torch to metering console or off-valve):  
Bevel torch leads are also available
  - Standard Torch Leads, 2m/6' 228291
  - Standard Torch Leads, 3m/10' 228292
  - Standard Torch Leads, 4.5m/15' 228293
  - Standard Torch Leads, 6m/20' 228294
  - Standard Torch Leads, 7.5m/25' 228295
  - Standard Torch Leads, 10m/35' 228296
  - Standard Torch Leads, 15m/50' 228297
  - Standard Torch Leads, 20m/65' 228547
4. IHS ohmic contact wire, necessary for ohmic sensing:
  - IHS Ohmic Contact Wire, 3m/10' 123983
  - IHS Ohmic Contact Wire, 6m/20' 123984
  - IHS Ohmic Contact Wire, 7.5m/25' 123985
  - IHS Ohmic Contact Wire, 9m/30' 123986
  - IHS Ohmic Contact Wire, 12m/40' 123987
  - IHS Ohmic Contact Wire, 15m/50' 123988
  - IHS Ohmic Contact Wire, 23m/75' 123989
  - IHS Ohmic Contact Wire, 30m/100' 123990
  - IHS Ohmic Contact Wire, 45m/150' 123991
5. **HPRXD Auto Gas Selection Console 078533**
6. **Auto Gas Metering Console 078535**
7. **Gas Leads Assembly (from Selection Console to Metering Console)**
  - Gas Leads Assembly, automatic, 10 ft (3 m) 128992
  - Gas Leads Assembly, automatic, 15 ft (4.5 m) 128993
  - Gas Leads Assembly, automatic, 20 ft (6 m) 228338
  - Gas Leads Assembly, automatic, 25 ft (7.5 m) 128952
  - Gas Leads Assembly, automatic, 35 ft (10 m) 128994
  - Gas Leads Assembly, automatic, 50 ft (15 m) 128930
  - Gas Leads Assembly, automatic, 65 ft (20 m) 128995

*\*True Hole Technology requires a HyPerformance Plasma HPRXD auto gas system along with a True Hole enabled cutting table, nesting software, CNC, and torch height control.*

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