Powermax85®

Duramax® hand/machine torch consumables





Minimum order quantity		1	1	5	5	1
Consumable type	**Torch type**	**Shield/deflector**	**Retaining cap**	**Nozzle**	**Electrode**	**Swirl ring**
Drag-cutting (30–85 A)	Hand	220818[2]	220854	220941[2] (45 A) 220819[2] (65 A) 220816[2] (85 A)	220842[2] or 220777[1,2]	220857
Quantity in kit		2	1	7	7	1
Essential cutting kit – 851468 (30–85 A)	Hand	220818	220854	220816	220842	220857



[1]For longer consumable life when cutting metal 1/2 inch (12 mm) and under, check out the CopperPlus electrode (part number 220777).
[2]Consumable available in bulk packaging. See order information below.



Minimum order quantity		1	1	5	5	1
Consumable type	**Torch type**	**Shield/deflector**	**Retaining cap**	**Nozzle**	**Electrode**	**Swirl ring**
Mechanized (30–85 A)	Machine	220817[2] or 220955[3]	220854 or 220953 ohmic	220941[2] (45 A) 220819[2] (65 A) 220816[2] (85 A)	220842[2] or 220777[1,2]	220857

Quantity in kit		2	1	1	7	4	3	1
Essential cutting kit – 851469 or 851470 (ohmic) (30–85 A)	Machine	220817 (Shield)	220955 (Deflector)	220854 or 220953 ohmic	220816[2]	220842 (Cutting)	220777 (CopperPlus)	220857



[1]For longer consumable life when cutting metal 1/2 inch (12 mm) and under, check out the CopperPlus electrode (part number 220777).
[2]Consumable available in bulk packaging. See order information below.
[3]Deflector for unshielded cutting.



Minimum order quantity		1	1	5	5	1
Consumable type	**Torch type**	**Shield/deflector**	**Retaining cap**	**Nozzle**	**Electrode**	**Swirl ring**
Max removal gouging[4] (45–85 A)	Hand/Machine	220798	220854	220797[2]	220842[2]	220857
Max control gouging[5] (45–85 A)	Hand/Machine	420480	220854	220797[2]	220842[2]	220857

[2]Consumable available in bulk packaging. See order information below.
[4]The Max removal gouging shield is designed for aggressive metal removal, deep gouge profiles and extreme metal washing.
[5]The Max control gouging shield is designed for more precise metal removal, shallower gouge profiles and light metal washing.

See pages 64–65 for current system part number information.



Minimum order quantity		1	1	5	5	1
Consumable type	**Torch type**	**Shield/deflector**	**Retaining cap**	**Nozzle**	**Electrode**	**Swirl ring**
FineCut® (30–45 A)	Hand	220931	220854 or 220953 (ohmic)	220930[2]	220842[2]	220947
	Machine	220955 or 220948 (ohmic)				

[2]Consumable available in bulk packaging. See order information below.



Minimum order quantity		1	1	1	1
Consumable type	**Torch type**	**Retaining cap**	**Nozzle**	**Electrode**	**Swirl ring**
HyAccess drag-cutting (30–65 A)	Hand	420413	420410	420408	220857
HyAccess gouging (30–65 A)			420412		

Quantity in kit		1	1	1	2	1
HyAccess kit – 428414 (30–65 A)	Hand	420413	420410 (cutting)	420412 (gouging)	420408	220857
		HyAccess cutting only starter pack – 428445[6] HyAccess gouging only starter pack – 428446[7]				



Warning: The Duramax HyAccess (65 amps and below) consumables should not be operated above 65 amps
[6]Starter pack contains 1 retaining cap (420413), 1 cutting nozzle (420410) and 1 electrode (420408)
[7]Starter pack contains 1 retaining cap (420413), 1 gouging nozzle (420412) and 1 electrode (420408)



Minimum order quantity		1	1	1	5	1
Consumable type	**Torch type**	**Retaining ring**	**Retaining cap**	**Nozzle/shield assembly**	**Electrode**	**Swirl ring**
FlushCut (30–45 A)[7]	Hand/Machine	420540	420536	420633	420635	420634
Quantity in kit		1	1	1	1	1
FlushCut kit – 428746 (30–45 A)	Hand/Machine	420540	420536	420633	420635	420634

[7]Using the 45 amp FlushCut consumables on the Powermax85 above 45 amps will cause premature consumable damage

Duramax® consumable bulk kits

Order quantity	25	25	25	25	25	25	25	10	10
Bulk kit part number	**228934**	**228767**	**228761**	**228762**	**228765**	**228759**	**228760**	**228763**	**228764**
Contents	220777 electrode	220842 electrode	220930 nozzle	220797 nozzle	220941 nozzle	220819 nozzle	220816 nozzle	220817 shield	220818 shield



See pages 64–65 for current system part number information.

Duramax® 75° hand torch parts

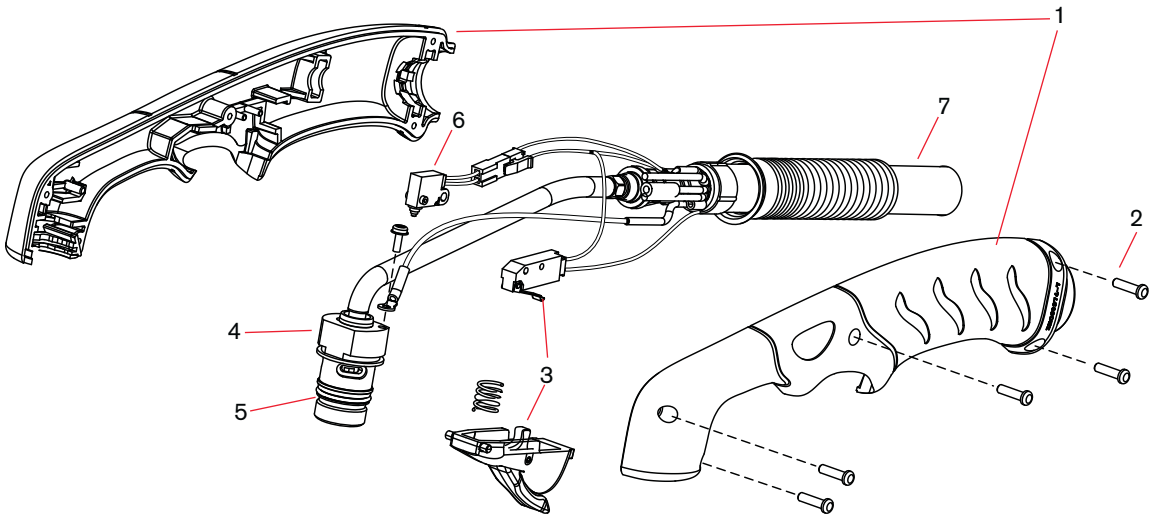
For use with the Powermax85®



Duramax 75° hand torch assembly

Item	Kit/Part number	Description
	059473	Duramax 75° hand torch assembly with 7.6 m (25') lead
	059474	Duramax 75° hand torch assembly with 15.2 m (50') lead
	059475	Duramax 75° hand torch assembly with 22.8 m (75') lead
1	228954	Kit: Duramax 75°/HRT Torch handle replacement
2	075714[1]	Handle screws, #4 x 1/2 slotted TORX pan head, S/B
3	228721	Kit: Duramax 75°/Duramax 15°/HRT/HRTs (spring and trigger assembly)
4	228714[1]	Kit: Duramax 75° Torch main body replacement (3/8" coupler)
4	228958[1]	Kit: Duramax 75° Torch main body replacment (1/2" coupler)
5	058519	O-ring
6	228719	Kit: Duramax 75° Cap-sensor switch replacement
7	228959[1]	Kit: Duramax 75° Torch lead replacement, 7.6 m (25')
7	228960[1]	Kit: Duramax 75° Torch lead replacement, 15.2 m (50')
7	228961	Kit: Duramax 75° Torch lead replacement, 22.8 m (75')
	223035[2]	Kit: 85 A Work lead with hand clamp, 7.6 m (25')

[1]Before ordering these parts verify the date the torch was built.
[2]Other work lead options available.



See pages 64–65 for current system part number information.

Duramax® 15° hand torch parts

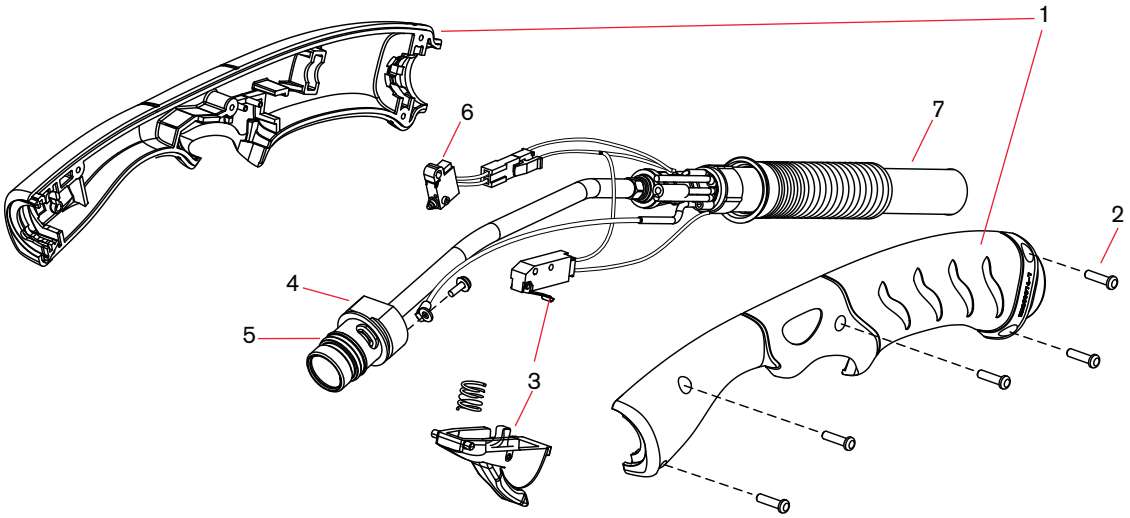
For use with the Powermax85®



Duramax 15° hand torch assembly

Item	Kit/Part number	Description
	059470	Duramax 15° hand torch assembly with 7.6 m (25') lead
	059471	Duramax 15° hand torch assembly with 15.2 m (50') lead
	059472	Duramax 15° hand torch assembly with 22.8 m (75') lead
1	228955	Kit: Duramax 15° Torch handle replacement
2	075714[1]	Handle screws, #4 x 1/2 slotted TORX pan head, S/B
3	228721	Kit: Duramax 15°/Duramax 75°/HRT/HRTs (spring and trigger assembly)
4	228715[1]	Kit: Duramax 15° Torch main body replacement (3/8" coupler)
4	228957[1]	Kit: Duramax 15° Torch main body replacment (1/2" coupler)
5	058519	O-ring
6	228109	Kit: Duramax 15° Cap-sensor switch replacement
7	228959[1]	Kit: Duramax 15° Torch lead replacement, 7.6 m (25')
7	228960[1]	Kit: Duramax 15° Torch lead replacement, 15.2 m (50')
7	228961	Kit: Duramax 15° Torch lead replacement, 22.8 m (75')
	223035[2]	Kit: 85 A Work lead with hand clamp, 7.6 m (25')

[1]Before ordering these parts verify the date the torch was built.
[2]Other work lead options available.



See pages 64–65 for current system part number information.

Duramax® 180° machine torch parts

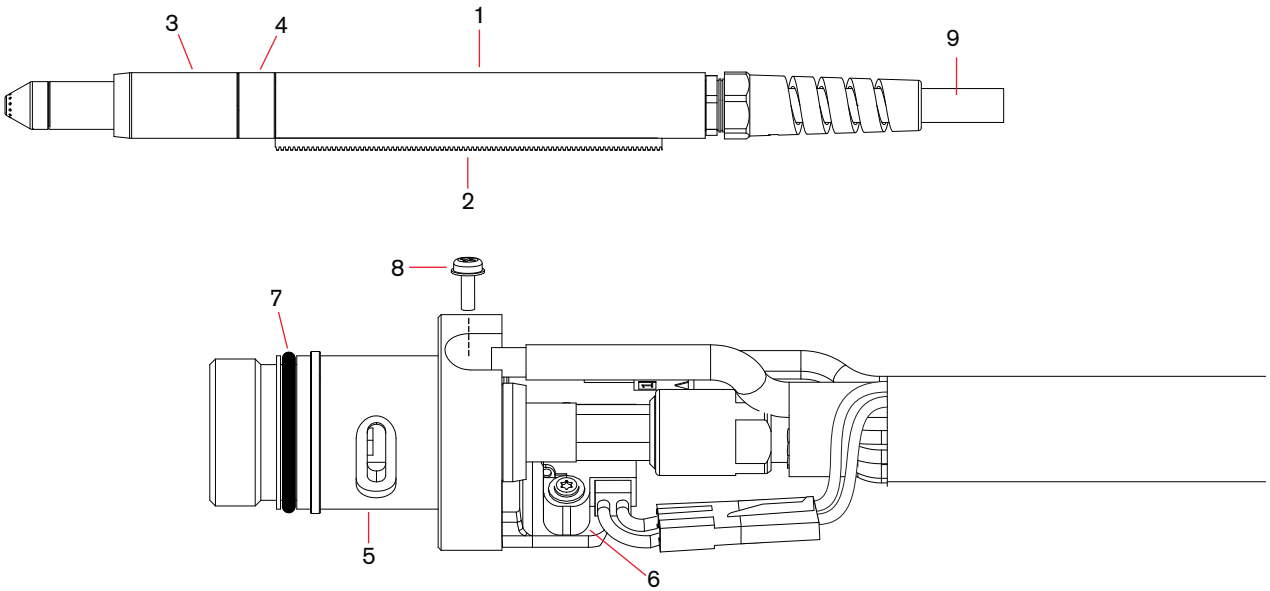
For use with the Powermax85®



Duramax 180° machine torch assembly

Item	Kit/Part number	Description
	059476	Duramax 180° machine torch assembly with 4.5 m (15') lead
	059477	Duramax 180° machine torch assembly with 7.6 m (25') lead
	059478	Duramax 180° machine torch assembly with 10.7 m (35') lead
	059479	Duramax 180° machine torch assembly with 15.2 m (50') lead
	059480	Duramax 180° machine torch assembly with 22.8 m (75') lead
1	228737	Kit: Duramax 180° positioning sleeve
2	228738	Kit: Duramax 180° removable gear rack
3	228735	Kit: Duramax 180°/Duramax 180° torch front mounting sleeve
4	228736	Kit: Duramax 180°/Duramax 180° torch adapter ring (coupler)
5	228716	Kit: Duramax 180°/Duramax 180° torch main body replacement
6	228720	Kit: Cap-sensor switch replacement
7	058519	O-ring
8	075504	Pilot terminal screw
9	228730	Kit: Duramax 180°/Duramax 180° torch lead replacement, 4.5 m (15')
9	228731	Kit: Duramax 180°/Duramax 180° torch lead replacement, 7.6 m (25')
9	228732	Kit: Duramax 180°/Duramax 180° torch lead replacement, 10.7 m (35')
9	228733	Kit: Duramax 180°/Duramax 180° torch lead replacement, 15.2 m (50')
9	228734	Kit: Duramax 180°/Duramax 180° torch lead replacement, 22.8 m (75')
	128650	Remote start pendant for machine torch, 7.6 m (25')
	128651	Remote start pendant for machine torch, 15.2 m (50')
	128652	Remote start pendant for machine torch, 22.8 m (75')
	223035[1]	Kit: 85 A Work lead with hand clamp, 7.6 m (25')

[1]Other work lead options available.



See pages 64–65 for current system part number information.

Duramax® 180° mini machine torch parts

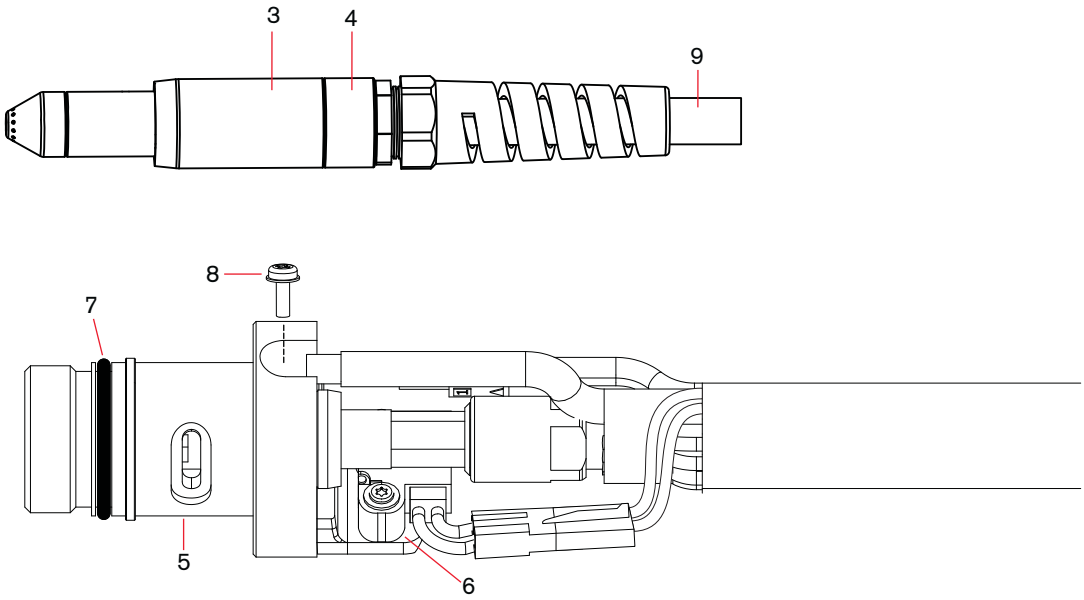
For use with the Powermax85®



Duramax 180° mini machine torch assembly

Item	Kit/Part number	Description
	059481	Duramax 180° mini machine torch assembly with 4.5 m (15') lead
	059482	Duramax 180° mini machine torch assembly with 7.6 m (25') lead
	059483	Duramax 180° mini machine torch assembly with 10.7 m (35') lead
	059484	Duramax 180° mini machine torch assembly with 15.2 m (50') lead
3	220956	Kit: Duramax 180°/Duramax 180° mini torch front mounting sleeve
4	228736	Kit: Duramax 180°/Duramax 180° mini torch adapter ring (coupler)
5	228716	Kit: Duramax 180°/Duramax 180° mini torch main body replacement
6	228720	Kit: Cap-sensor switch replacement
7	058519	O-ring
8	075504	Pilot terminal screw
9	228730	Kit: Duramax 180°/Duramax 180° mini torch lead replacement, 4.5 m (15')
9	228731	Kit: Duramax 180°/Duramax 180° mini torch lead replacement, 7.6 m (25')
9	228732	Kit: Duramax 180°/Duramax 180° mini torch lead replacement, 10.7 m (35')
9	228733	Kit: Duramax 180°/Duramax 180° mini torch lead replacement, 15.2 m (50')
9	228734	Kit: Duramax 180°/Duramax 180° mini torch lead replacement, 22.8 m (75')
	128650	Remote start pendant for machine torch, 7.6 m (25')
	128651	Remote start pendant for machine torch, 15.2 m (50')
	128652	Remote start pendant for machine torch, 22.8 m (75')
	223035[1]	Kit: 85 A Work lead with hand clamp, 7.6 m (25')

[1]Other work lead options available.



See pages 64–65 for current system part number information.

Duramax® 180° robotic torch parts

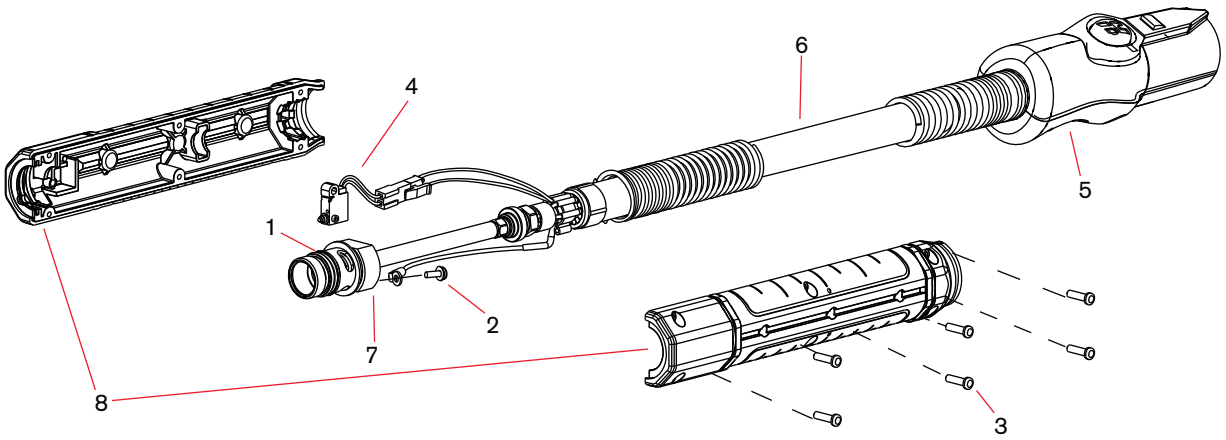
For use with the Powermax85®



Duramax 180° robotic torch assembly

The entire Duramax 180° robotic torch assembly with leads can be replaced, or individual component parts can be replaced.

Item	Kit/Part number	Description
	059466	Duramax 180° robotic torch assembly with 7.6 m (25') lead
	059587	Duramax 180° robotic torch assembly with 15.2 m (50') lead
1	058519	O-ring
2	075504	Pilot terminal screw
3	075714	#4 x 1/2 slotted TORX pan head screws
4	228109	Kit: Cap-sensor switch replacement
5	428260	Kit: FastConnect replacement
6	228852	Kit: Robotic torch lead replacement, 7.6 m (25')
7	228853	Kit: 180° Robotic torch main body replacement
8	228856	Kit: 180° Robotic torch positioning barrel replacement
	228806	Kit: Robotic torch clamp assembly



See pages 64–65 for current system part number information.

Duramax® 90° robotic torch parts

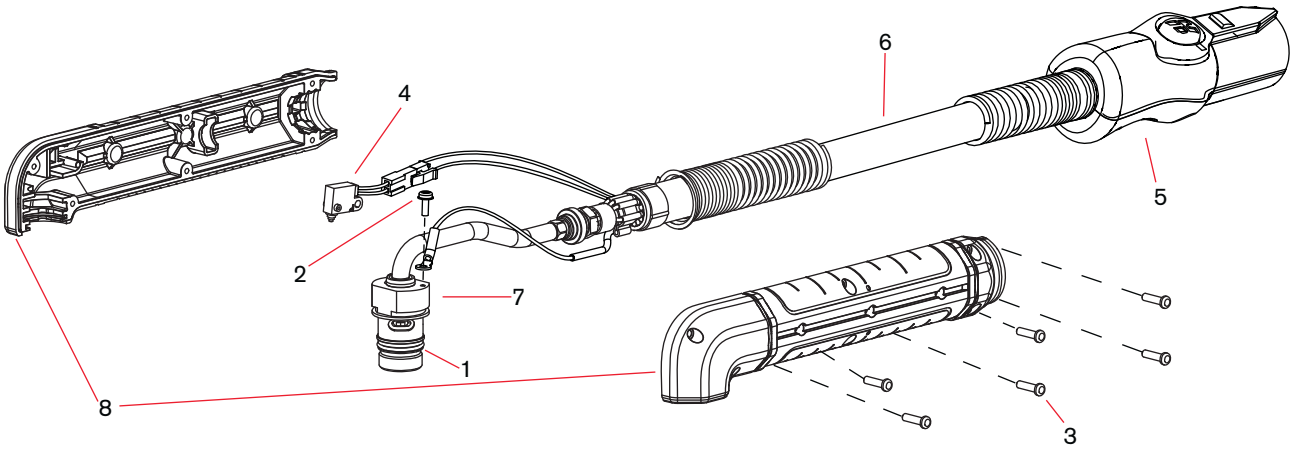
For use with the Powermax85®



Duramax 90° robotic torch assembly

The entire Duramax 90° robotic torch assembly with leads can be replaced, or individual component parts can be replaced.

Item	Kit/Part number	Description
	059465	Duramax 90° robotic torch assembly with 7.6 m (25') lead
	059586	Duramax 90° robotic torch assembly with 15.2 m (50') lead
1	058519	O-ring
2	075504	Pilot terminal screw
3	075714	#4 x 1/2 slotted TORX pan head screws
4	228109	Kit: Cap-sensor switch replacement
5	428260	Kit: FastConnect replacement
6	228852	Kit: Robotic torch lead replacement, 7.6 m (25')
7	228854	Kit: 90° Robotic torch main body replacement
8	228857	Kit: 90° Robotic torch positioning barrel replacement
	228806	Kit: Robotic torch clamp assembly



See pages 64–65 for current system part number information.

Duramax® 45° robotic torch parts

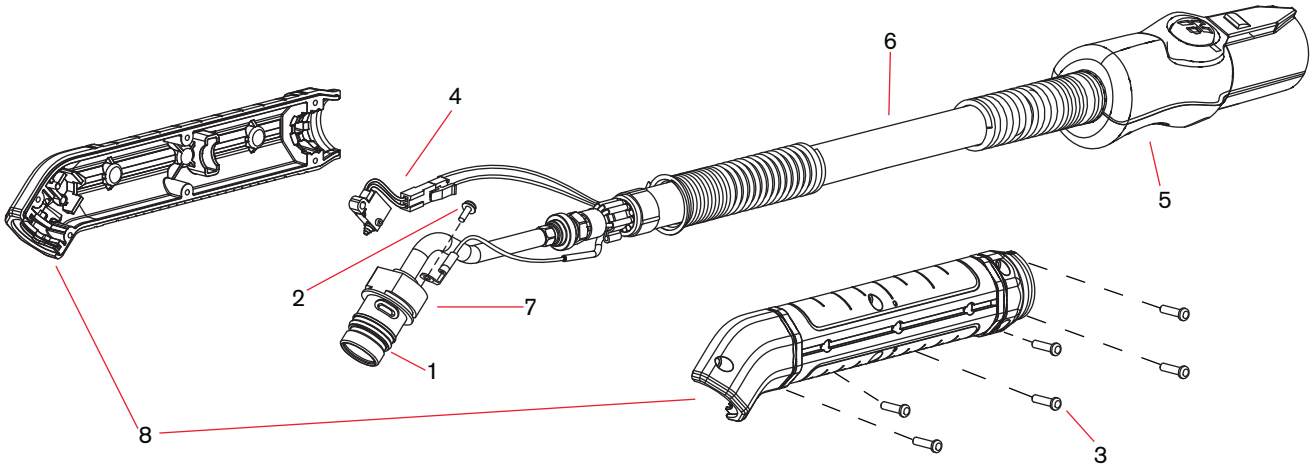
For use with the Powermax85®



Duramax 45° robotic torch assembly

The entire Duramax 45° robotic torch assembly with leads can be replaced, or individual component parts can be replaced.

Item	Kit/Part number	Description
	059464	Duramax 45° robotic torch assembly with 7.6 m (25') lead
	059585	Duramax 45° robotic torch assembly with 15.2 m (50') lead
1	058519	O-ring
2	075504	Pilot terminal screw
3	075714	#4 x 1/2 slotted TORX pan head screws
4	228109	Kit: Cap-sensor switch replacement
5	428260	Kit: FastConnect replacement
6	228852	Kit: Robotic torch lead replacement, 7.6 m (25')
7	228855	Kit: 45° Robotic torch main body replacement
8	228858	Kit: 45° Robotic torch positioning barrel replacement
	228806	Kit: Robotic torch clamp assembly



See pages 64–65 for current system part number information.