

Steel Industry Products **Ultra-Line**

Portable Straight Line Cutter

SIP Ultra-Line Portable Cutter

The Steel Industry Products Ultra-Line is a lightweight carriage designed for cutting applications in steel mills or other heavy industries. It is designed for cutting product from 4" to 20" thick and material temperatures of up to 300° F (400 - 450° F with "K"WOOL insulation and remote control kit).

Standard Features

- *Solid state control*
- *Convenient, easily accessible controls*
- *Speed range of 2-45 ipm (51-1143 mm/m)*
- *Sturdy one-piece cast aluminum housing*
- *Knurled drive wheels for positive traction*
- *Track lengths of 6, 7 1/2 and 9 ft., with interlocking ability for longer travel.*
- *Extensive variety of accessory equipment for expanded capability*
- *Standard 115 VAC 50/60 Hz power source*
- *Control Panel Mounted vertically and shielded to protect components from spatter, slag, and abuse*
- *Speed potentiometer includes drag for ease of adjustment*
- *Pilot light to indicate power "on"*
- *Metal toggle switches*
- *Power cable located to avoid interference*
- *Thumbwheels on casters*
- *One piece "fitted" bottom cover with insulation board keeps out dirt, dust and heat*
- *Venting of motor/drive compartment for cooling*
- *Bronze lever washer for long life*
- *Low speed range for cutting at slower speeds*
- *Control board located for heat protection*

Operator Controls are mounted on the carriage within arms reach. Controls include:

Jog/Off/On - controls power distribution to the machine. Jog is momentary for positioning to start out.

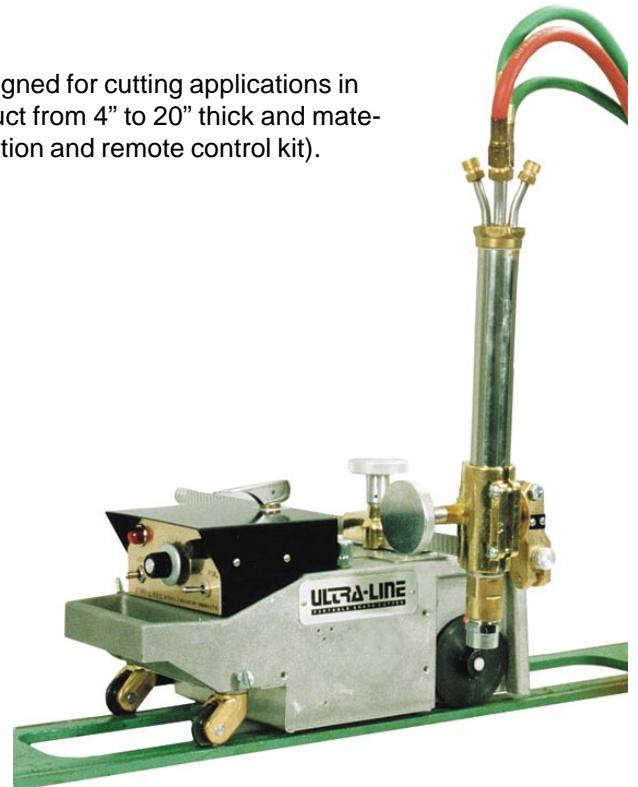
Forward/Reverse - selects direction of machine travel.

Speed Control - adjusts speed of machine travel.

Clutch Lever - engages or disengages the drive mechanism.

Fuse - provides electrical component protection via a 1 amp slow blow fuse.

Pilot Light - indicates power is "on"



Using an OXWELD® oxy/fuel-gas machine cutting torch, the Steel Industry Product's Ultra-Line can cut material up to 20 in. (508 mm) thick.

With Solid State Control, no "warm-up time" is required to start carriage travel. The carriage is driven by a reversible DC motor with built-in solid state speed regulation.

Ordering Information

SIP ULTRA-LINE, 115 VAC 50/60 Hz. 2225235

Specifications

The one-piece aluminum housing measures 16 in. (406 mm) long 7 1/4 in. (184 mm) wide and 5 3/4 in. (146 mm) high without torch rigging. Weight is approximately 22 lbs. (9.98 kgm) without accessories.

Accessories

The wide selection of accessories available makes the Steel Industry Products Ultra-Line a very successful tool.

Torch Rigging Assembly - includes mounting unit, a 24 in. (609.6 mm) rack for horizontal positioning of cutting torch, and a torch holder equipped to ease vertical positioning of torch with rack attached 16V90

Circle Cutting Attachment - consists of an 18 in (457 mm) radius bar and pivot system permitting 2 - 54 in. (50.8 - 137.6 mm) diameter circles to be cut 16V84

Two Torch Operation - the carriage can be set up for simultaneous cutting with two torches using one of two adaptors 16V89 or 16V92

Vertical Post - used for applications where cutting in the vertical plane is desired 491620

Cutting Torch Accessories

The following items are available for use with OXWELD oxygen/fuel-gas machine cutting torches:

1. Quick Active Valve Assembly - substitutes for the standard cutting oxygen throttle valve 32Y08

2. Adjustable Bevel Cutting Adaptor - connects to the torch like a nozzle and can be adjusted 0 - 90 degrees from the torch center line 18845

Auxiliary Preheat Kits - available for preheating the plate ahead of the cut. Mounted to the bevel cutting adaptor.

Acetylene 61Y99

Other Fuel Gas 63Y13

3. Scissor Type Slitting Adaptor - divides cutting operation into two nozzles to make parallel cuts ranging from 1 1/2 to 12 inches (38 - 305 mm) wide. The adaptor is mounted to the torch in place of the standard single nozzle 22X42

4. Two-way Oxygen Inlet Adaptor - allows one oxygen inlet hose to supply preheat and cutting oxygen to a three inlet torch 18X20

Track - vee-grooved guide rail that is easily set up for straight line cutting by placing the edge parallel to the line of cut. The track can be placed on the plate or a mounting structure beside the cutting area. Sections can be linked to extend length.

6 ft. (1828.8 mm) 16V82

7 1/2 ft. (2286mm) 20086

9ft. (2734.2 mm) 2223156

Standard Heat Shield Kit - includes a fixed and a plate riding shield to protect machine components when engaged in prolonged cutting or cutting close to the carriage. Recommended when the carriage gets hot-to-the-touch. For use on non-PM torch applications 995586

Standard Counterweight - used when an off-balance condition exists due to weight of equipment mounted to one side of the carriage 995587

Hi-FLOW Manifold Block: Aluminum (2223796), Brass (2225427), Mounting Bracket (2223797) - The customer can use either the aluminum or brass block with the mounting bracket and his own valves/fittings/hardware for oxygen/fuel gas hose connection.

Hi-FLOW Manifold Kit: Aluminum (2226713) Brass (2226712) - Same as above, but includes all valves/fittings and hardware for oxygen/fuel gas hose connection.

Hook-Up Hose Assemblies

These hose assemblies with captive fittings are used to connect the oxygen & fuel gas regulation supply to the machine carriage. The customer should select the shortest length and largest diameter assembly to suit his needs.

Part No.	Size	Service	Length
2060396	"B" - 3/8	Oxygen	50 ft.
2228057	"B" - 3/8	Oxygen	75 ft.
2228058	"B" - 3/8	Oxygen	100 ft.
2060397	"B" - 3/8	Fuel Gas	50 ft.
2228060	"B" - 3/8	Fuel Gas	75 ft.
2228061	"B" - 3/8	Fuel Gas	100 ft.
2120399	"C" - 1/2	Oxygen	50 ft.
2228062	"C" - 1/2	Oxygen	75 ft.
2228063	"C" - 1/2	Oxygen	100 ft.
2228124	"D" - 3/4	Oxygen	100 ft.

Jumper Hose Assemblies (2228140, 2228141, 2228142) -

These SS/Teflon hose assemblies with captive fittings are used to connect the Hi-Flow valve block to the torch:

2228140 - "B" Size Oxygen, 40" Long

2228141 - "B" Size Fuel Gas, 40" Long

2228142 - "C" Size Oxygen, 40" Long

Motor Insulation Kit (2228049) - Includes insulation and insulating tape for customer re-insulation of motor.

Post Mixed (PM) Torch Accessories

The following accessories are used with the PM (Post Mixed) torches, which produce more heat requiring extra protection of the SIP Ultra-Line.

High-Temp Heat Shield Kit 2228130

Extended Rack For Torch Rigging, 44" Long 2228133

Rack Counterweight 2228129

Bottom Cover Insulation Set 2228128

Remote Control Kit 2228560



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