

# PAK MASTER 25

The power of plasma in a small affordable box. The 1/4" x 6 mm capacity on mild steel means most light duty maintenance, repair and fit up operations are well within the range of the system. Uses the PCH-25 torch, available with 12.5'/3.8 m and 25'/7.6 m leads. Ideally used as a hand held system.

- 115 or 220 Volt Input Power
- Smart Handle
- Variable Output
- Efficient Inverter Technology
- Rugged and Portable
- Simple to Operate

## PakMaster™ 25 Cutting System Specifications

### Power Supply

Output: 12-20 amps  
 Input: 115 or 220VAC, (±10%), Single Phase, 50/60 Hz  
 Duty Cycle: 40%  
 Panel Indicators: AC Power • Over Temperature • Gas • DC Power  
 Output Adjustment: Continuously Variable (12-20 amp)  
 Dimensions: Height 7.5"/191 mm  
 (no handle) Width 17.5"/445 mm  
 Depth 13.25"/337 mm  
 Shipping Weight: 46.7 lbs./21.2 kg  
 (Power Source) 42.5 lbs./19.3 kg

### PCH-25 Torch

Gas: Air or Nitrogen  
 Gas Pressure: 50 PSI/3.5 BAR  
 Gas Flow: 105 SCFH/50 lpm  
 Pilot: Electrode to Tip  
 Control: Hand-torch mounted switch  
 Torch Configuration: 70° or 90°  
 Lead Length: 12.5 ft./3.8 m  
 25 ft./7.6 m



The above system includes:

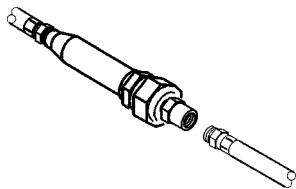
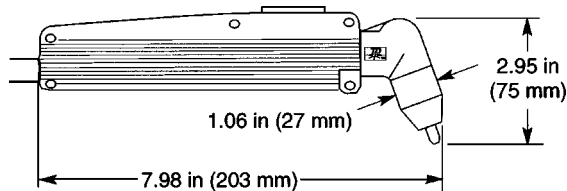
- Pak Master 25 Power Source
- PCH-25 Torch as indicated
- Spare Parts Kit and Box
- Input Cable and Ground Cable

An optional air filter is recommended to assure dry and clean air enters the machine.

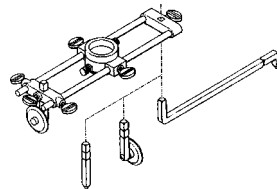
Part No. 115 Volt	Part No. 220 Volt	System Ordering Information
1-0250	1-0260	Pak Master 25 - 70° Torch/12.5' (3.8 m) leads
1-0252	1-0262	Pak Master 25 - 90° Torch/12.5' (3.8 m) leads
1-0251	1-0261	Pak Master 25 - 70° Torch/25' (7.6 m) leads
1-0253	1-0263	Pak Master 25 - 90° Torch/25' (7.6 m) leads
3-0250	3-0260	Pak Master 25 Power Supply Only

Part No. 12.5'/3.8m	Part No. 25'/7.6m	Torch & Leads Packages Only
2-0250	2-0251	PCH-25/70°
2-0252	2-0253	PCH-25/90°

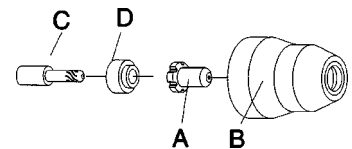
### PCH-25 Torch Dimensions



Part No.	Description
7-0250	Air Filter Single Stage
7-0252	Air Filter Replacement Cartridge



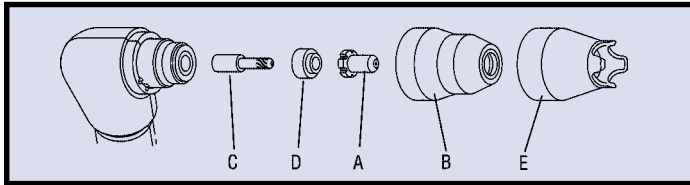
Part No.	Description
7-3291	Circle Cutting Attachment
7-0253	Leads Storage Kit



Part No.	Description
9-4476	A: Tip - 20 Amp/Air
9-6003	B: Shield Cup
9-6006	C: Electrode - Air
9-6007	D: Gas Distributor

**Consumables**

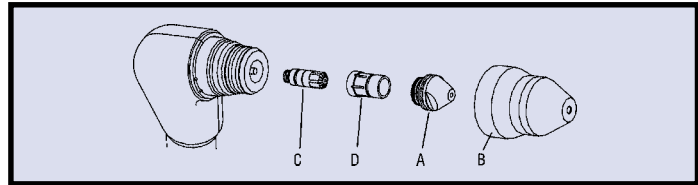
**KEY - 1**



Torch	Key - 1	Item	Part No.
PCH 20	A	Tip-20 Amp Air	8-3218
	B	Shield Cup	8-3214
	C	Electrode-Air	9-6006
	D	Gas Distributor	8-3233
PCH 25	A	Tip-20 Amp Air	9-4476
	B	Shield Cup	9-6003
	C	Electrode-Air	9-6006
	D	Gas Distributor	9-6007
PCH/M 35	A	Tip-35 Amp Air	9-6000
	A	Tip-Drag Cut Air	9-6001
	A	Tip-Heavy Duty	9-6120
	A	Tip-Gouging-Groove Air	9-6002
	A*	Tip-Stand Off (long life)	9-6500
	A*	Tip-Drag (long life)	9-6501
	B	Shield Cup	9-6003
	B*	Shield Cup (long life)	9-6503
	C	Electrode Air	9-6006
	C*	Electrode (long life)	9-6506
	D	Gas Distributor	9-6007
	D*	Gas Distributor (long life)	9-6507
	E	Shield Cup-Crown	9-6004
PCH/M 70	A	Tip-35 Amp Air/O <sub>2</sub> /N <sub>2</sub>	9-6008
	A	Tip-70 Amp Air/O <sub>2</sub> /N <sub>2</sub>	9-6009
	A	Tip-70 Amp ArH <sub>2</sub>	9-6013
	A	Tip-Gouging (.089)	9-6014
	A	Tip-Gouging (.110)	9-6015
	A	Tip-Gouging (.125)	9-6019
	B	Shield Cup (Tip Exposed)	9-6016
	B	Shield Cup-Crown	9-6017
	B	Shield Cup-Gouging	9-6018
	B	Shield Cup-Long	9-6024
	C	Electrode-Air/O <sub>2</sub> /N <sub>2</sub>	9-6019
	C	Electrode-ArH <sub>2</sub>	9-6021
	C	Electrode-Gouging Air/N <sub>2</sub>	9-6107
	C	Electrode-Gouging Ar/H <sub>2</sub>	9-6108
	D	Gas Distributor	9-6022
	N/S	Tip-Wrench	8-4053
	N/S	Electrode-Wrench	9-5620

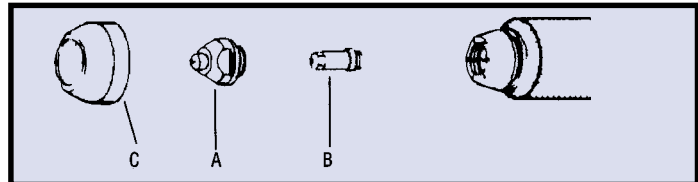
N/S= Not Shown

**KEY - 2**



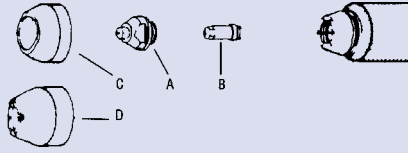
Torch	Key - 2	Item	Part No.
PCH/M 140	A	Tip-35 Amp Air/N <sub>2</sub>	9-6025
	A	Tip-70 Amp Air/N <sub>2</sub>	9-6026
	A	Tip-105 Amp Air/N <sub>2</sub>	9-6027
	A	Tip-140 Amp Air/N <sub>2</sub>	9-6028
	A	Tip-Gouging (1 Ring) (.110)	9-6037
	A	Tip-Gouging (2 Ring) (.125)	9-6038
	A	Tip-Gouging (3 Ring) (.156)	9-6039
	A	Tip-Gouging (4 Ring) (.171)	9-6040
	B	Shield Cup	9-6045
	B	Shield Cup-Crown	9-6046
	B	Shield Cup-Gouging	9-6047
	B	Shield Cup-Long Air/N <sub>2</sub>	9-6054
	C	Electrode-Air/N <sub>2</sub>	9-6048
	C	Electrode-Gouging Air/N <sub>2</sub>	9-6110
	D	Gas Distributor	9-6051
	D	Gas Distributor-Gouging	9-6112
	N/S	Cooling Tube	9-6052
	N/S	Cooling Tip-Gouging	9-6113

**KEY - 3**

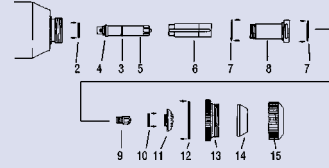


Torch	Key - 3	Item	Part No.
PCH/M 150	A	Tip-150 Amp Air	9-5746
	A	Tip-100 Amp Air	9-5747
	A	Tip-50 Amp Air	9-5748
	A	Tip-150 Amp Oxygen	9-5751
	A	Tip-100 Amp Oxygen	9-5752
	A	Tip-50 Amp Oxygen	9-5753
	A	Tip-150 Amp N <sub>2</sub>	9-5767
	A	Tip-100 Amp N <sub>2</sub>	9-5766
	A	Tip-50 Amp N <sub>2</sub>	9-5765
	A	Tip-150 Amp ArH <sub>2</sub>	9-5775
	A	Tip-Gouging (.120)	9-5755
	A	Tip-Gouging (.078)	9-5756
	B	Electrode-Air	9-5749
	B	Electrode-Oxygen	9-5760
	B	Electrode-N <sub>2</sub> or ArH <sub>2</sub>	9-5754
	C	Cup-Std. Ceramic front	9-5750
	C	Cup-Tip Exp. Ceramic	9-5758
	C	Cup-Standard Copper	9-5790
	C	Cup-Tip Exp. Copper	9-5801

**KEY - 4**



**KEY - 6**

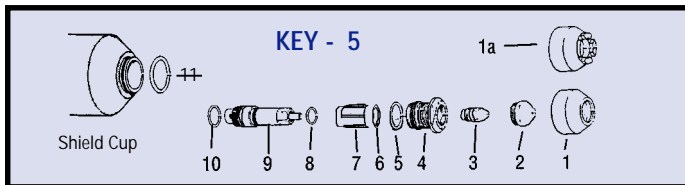
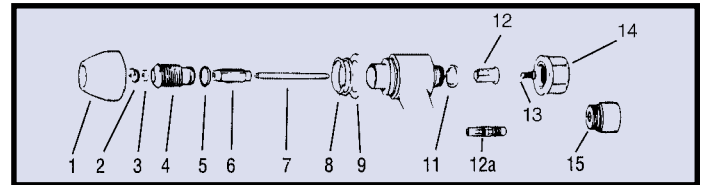


Torch	Key - 4	Item	Part No.
PCH/M 51	A	Tip-10-40 Amp Air	9-5718
	A	Tip-10-60 Amp Air	9-5631
	A	Tip-65 Amp Air	8-3321
	A	Tip-Gouging	9-5724
	B	Electrode-Air (Knurl)	9-5720
	B	Electrode-Air	9-5633
	C**	Cup-Ceramic	9-5630
	C*	Std-metal (8-2159)	9-5800
	C**	Cup-Hi Strength	8-2152
	C	Cup-Hi Strength long	8-2151
	C**	Cup-Black phenolic	8-2159
	D*	Crown-Metal (8-2159)	9-5779
	D	Cup-Ceramic crown	8-5526
PCH/M 52	A	Tip-35 Amp Air	9-5702
	A	Tip-45-55 Amp Air	9-5618
	A	Tip-60-70 Amp Air	9-5707
	A	Tip-80 Amp Air	9-5782
	A	Tip-105 Amp Air	9-5708
	A	Tip Gouging	8-5129
	B	Electrode-Air (plated)	9-5619
	B	Electrode-Air (unplated)	8-3331
	B	Electrode (Multi-Gas)	9-5711
	C	Cup-Ceramic	9-5617
	C	Cup-Ceramic Crown	9-5694
	C	Cup-Phenolic Std.	9-5781
	C	Cup-Ceramic Gouge	8-5128
	C	Cup-Hi Strength short	9-5712
	D*	Crown-Metal (9-5781)	9-5780
	D*	Standard-Metal (9-5781)	9-5799

Torch	Key - 6	Item	Part No.
PCH/M-6B	2	O-Ring	8-0531
	3	O-Ring	8-2960
	4	O-Ring	8-0527
	5	Electrode holder (includes items 3 & 4)	8-6615
	6	Gas Distributor	8-6569
	7	O-Ring	9-2956
	8	Liner (includes 2 & 7)	8-6571
	9	Electrode (General purpose)	8-6578
	9	Electrode (Low amp)	8-6586
	10	O-Ring	9-2863
	11*	Tip-100 Amp	8-6580
	11*	Tip-200 Amp	8-6575
	11*	Tip-300 Amp	8-6582
	11*	Tip-400 Amp	8-6572
	12	Gasket	8-6512
13	Outer Insulator	8-6581	
14	End Piece	8-6514	
15	End Cap	8-6515	
N/S	Electrode Holder Wrench	8-6574	
N/S	Electrode Wrench	8-6573	
N/S	Liner/Tip Wrench	8-6517	

N/S = Not Shown

**KEY - 7**



Torch	Key - 5	Item	Part No.
PCH 100	1	Shield Cup (hand torch)	8-1100
	1a	Crown Shield Cup	8-1113
	2	Tip-105 Amp	9-4341
	2	Tip-70 Amp	9-4342
	2	Tip-35 Amp	9-4343
	3	Electrode	9-4340
	4	Liner	8-1106
	5	O-Ring (included with Item 4)	8-1135
	6	O-Ring (included with Item 7)	8-1134
	7	Gas Distributor	9-4339
	8	O-Ring (included with Item 9)	8-1133
9	Electrode Holder	8-1108	
10	O-Ring (included with Item 9)	8-1152	
11	O-Ring (on shield cup)	8-0556	

Torch	Key - 7	Item	Part No.
PCH/M-4B, 4BT	1	Shield Cup (hand torch)	8-4088
	2	Tip-100 Amp	8-4153
	3	Gas Distributor	9-2421
	4	Liner	8-4154
	5	O-Ring (included with Item 4)	9-2960
	6	Sleeve	8-4182
	7	Electrode	8-4073
	8	O-Ring (included with Item 1)	8-0554
	9	Gasket	8-4069
	11	O-Ring-for PCH 4B	8-0530
	11	O-Ring-for PCM 4B	8-0532
	12	Collet (w/ 8-0525) -4B only	8-4156
	12a	Collet (w/ 8-0525) -4BT only	8-4197
	13	Spring	8-4050
	14	Back Cap: PCH-4B	8-4158
15	Back Cap: PCM-4B	8-4159	