



### PROCESS



Air Plasma Cutting

**5/3/1**  
INDUSTRIAL  
WARRANTY



**New!**

**N**eed to cut steel? Thinking about an oxy acetylene cutting torch to do the job? Consider a plasma cutter. This simple technology uses an electrical arc and compressed air to cut steel, aluminum, and other conductive metals.

Designed to cut up to 1/4 inch mild steel, the AirForce™ 250ci is powered by standard household voltage (115 VAC). A built-in air compressor and lightweight inverter power supply make this plasma cutter the most convenient, totally portable cutting system available. The AirForce™ 250ci excels at cutting sheet metal and 1/8 inch mild steel, and can even sever 1/4 inch steel.

Compared to the complexities of an oxy fuel cutting torch system, plasma cutting is easy:

- Cuts faster than oxy fuel
- More precise cut, thinner kerf, less slag to clean up
- Smaller heat-affected zone for less warping
- No gas pressure settings or flame tuning needed
- No preheating of metal prior to cutting
- No pressurized gas cylinders to transport
- No worries about running out of gas on the job
- No expense for gas refills... ever

The AirForce™ 250ci comes ready to cut out of the box, with extra replacement tips and a convenient cable management strap for easy transportation. Just pull the trigger and cut.

#### Comes Complete With:

- HP-25 16.4 ft (5 m) hand-held torch
- Heavy-duty work clamp with 16.4 ft (5 m) cable
- 7 ft (2.1 m) power cord with 115 VAC plug
- Extra consumables (2 tips, 2 electrodes)

#### Applications

- Sheet metal
- HVAC duct work
- Auto body repair
- Home hobby
- Plumbing

### FEATURES

### BENEFITS

<b>New inverter design</b>	Powerful cutting ability at half the weight of prior model (AirForce 250A.) Weighs only 27 lbs.
<b>Built-in air compressor</b>	Internal piston-driven air compressor makes the system highly portable. No additional compressor to purchase or transport. Pressure is preset... ready to cut, right out of the box.
<b>New ergonomic torch</b>	The new HP-25 torch is designed for increased comfort, more efficient cooling and economical replacement cutting tips.
<b>Powered by 120 V, 20 amp circuit</b>	Runs on standard household power. No need for 230 volt hookup by utility company.
<b>Post-flow air cooling</b>	Cools the torch and tip after cutting, extending life of replaceable tip and electrode.
<b>Fan-On-Demand</b>	Runs only when needed reducing dust/debris pulled into unit.
<b>Pilot Arc Control</b>	Ensures consistent arc starts prior to each cut, minimizes tip burnout.
<b>Diagnostic lights</b>	LED lights indicate system status for power, temperature, and torch readiness eliminating unnecessary downtime.
<b>Thermal overload protection</b>	Built to withstand tough working environments. Rated for 35% duty cycle at 104° Fahrenheit. Duty cycle will increase as environmental temperature decreases.
<b>Cable management strap</b>	Secures torch, work cable and power cord to make transporting easy and convenient.
<b>Hobart 5/3/1 Warranty</b>	No other manufacturer offers a better warranty than Hobart. Power source is warranted for <b>three years</b> , parts and labor. Original rectifier parts have a <b>five-year</b> warranty and the HP-25 torches have a <b>one-year</b> parts and labor warranty.

### SPECIFICATIONS (SUBJECT TO CHANGE WITHOUT NOTICE.)

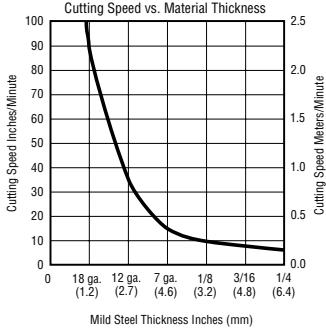
**DC** **1**  
Phase

Rated Output	Max. Open-Circuit Voltage	Amps Input at Rated Output, 60 Hz, Single-Phase			Dimensions	Net Weight with torch	Ship Weight
		120 V	KVA	KW			
12 Amps at 110 VDC, 35% Duty Cycle	375 VDC	20	2.27	2.0	H: 10 in (254 mm) W: 7-1/2 in (191 mm) D: 13 in (330 mm)	27 lb (12.3 kg)	30 lb (13.6 kg)



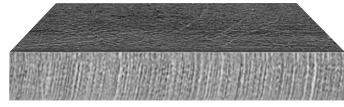
## CUTTING PERFORMANCE

To determine the maximum rated cutting thickness of mild steel, follow the line from the 10 IPM (inches per minute) point on the cutting chart. The point at which this line intersects the cutting curve determines the maximum recommended production cutting thickness of the unit.



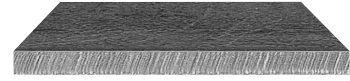
Note: The rating is based on 10 IPM because this is the minimum speed at which the operator achieves a smooth, steady cut when using a hand-held torch.

## MILD STEEL CUTTING CAPACITY (Thickness to scale.)



**Max Cut** 1/4 inch (6.4 mm)

**Maximum Cutting Capacity\***  
3 inches per minute at ideal conditions

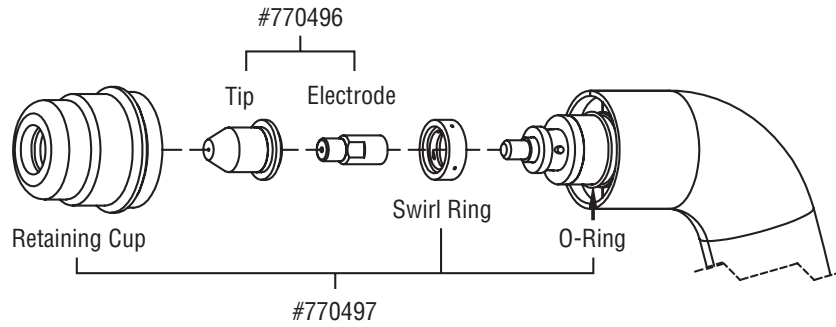


**Rated Cut** 1/8 inch (3.2 mm)

**Rated Cutting Capacity\***  
10 inches per minute (minimum speed at which an operator achieves a smooth, steady cut using a hand-held torch).

\*Ratings for stainless and aluminum reduced by 30%.

## TORCH CONSUMABLE KITS



## ORDERING INFORMATION AND SYSTEM CHECKLIST

Power Source	Stock No.	Description	Qty.	Price
AirForce 250ci	#500534	Single-phase, 120 VAC, 60 Hz		
UPC: #715959372183; Shipping Weight: 30 lb (13.6 kg); Carton Dimensions: 18-1/4 x 11-5/8 x 17 in (464 x 295 x 432 mm); Pallet Qty: 12				
<b>Torch Consumable Kits</b>				
Contact Tip and Electrode Kit	#770496			
Cup, Swirl Ring, O-ring Kit	#770497			

Date:

Total Quoted Price:

# HOBART

W E L D E R S

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