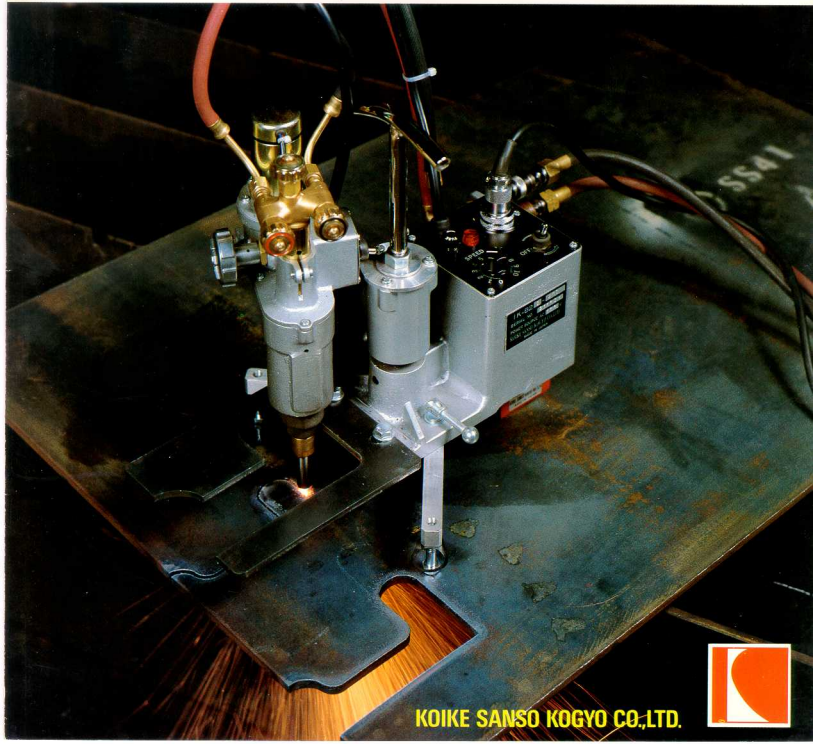
Code No. 83005

PORTABLE AUTOMATIC SHAPE GAS CUTTING MACHINE

IK-82 SERIES

The IK-82 series are the most advanced magnetic tracing type gas cutters on the market. Effective designing and modular structure greatly reduce equipment weight, and provide a system configuration to ensure operation ease according to the particular operation requirements. These cutters are available in three types according to the effective cutting length; S, M and L. Types S and M employ interchangeable arms, while type L permits adjustment of the rail pipe on the rail carriage, which enables size adjustment according to workpiece dimensions. Try the IK-82 series for more effective cutting operations.



KOIKE SANSO KOGYO CO.,LTD.

PORTABLE AUTOMATIC SHAPE GAS CUTTING MACHINE

IK-82 SERIES

BASIC STRUCTURE OF IK-82 FEATURING BETTER FUNCTIONS

● TRACER HEAD FOR HANDLING EASE AND HIGH-PRECISION CUTTING

For easy positioning, the tracer head has a cutting tip at the center of the magnet roller. High-precision and eye-pleasing cut faces are ensured due to cutting in close contact with the tracing template.

● LIGHT-WEIGHT AND RUGGED ARM BY STAINLESS STEEL PIPE STRUCTURE (Types S and M)

The arms of types S and M employ simple and rugged stainless steel pipes for substantial decrease in weight. This structure also has improved portability. (This weight of Type M has been reduced by 36 percent, compared to that of the conventional type.)
Maximum standardization of parts and components facilitates expansion of the cutting capacity, one set of equipment provides the capacity of two set.

● MAGNETIC ROLLER SELECTABLE FOR YOUR REQUIREMENTS (Types S and M)

diamter. Use the 16mm-diameter type for template not mounted on the machine, and 25mm-diameter type for template mounted on the machine. The latter type can be ued also for the template not mounted on the machine when the height is adjusted. (For details, refer to "Major points for template production".)

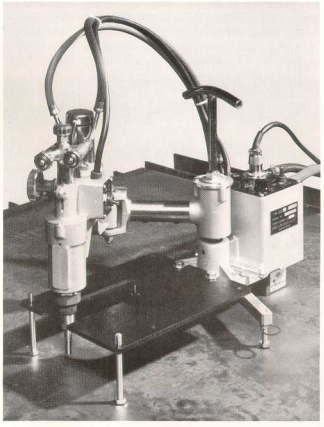
● RAIL CARRIAGE FEATURING ADJUSTABLE RAIL LENGTH ACCORDING TO WORKPIECE (Types L)

The rail length of type L features free adjustment of rail length according to the workpiece dimensions. This design eliminates the possibility of the carriage wheel detaching from the workpiece, and greatly expands working capabilites.

● EASY TIP REPLACEMENT

The tip can be replaced and cleaned and the flame adjusted easily by merely raising the tracer head.

IK-82 S200

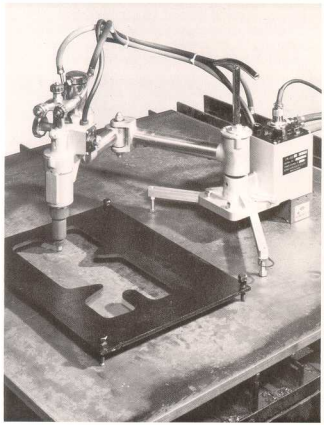


This is the basic model of the IK-82 series, and is equipped with a standard small arm and 25mm (63/64") -diameter magnetic roller. It is best suited to cut RONJI materials.

SPECIFICATIONS

Weight	7.5kg (16.5 lbs)
Motor	100VDC, 6W, 10,000 rpm
Effective cutting capacity	circle 200mm (8") diam. ellipse 420 x 160mm (16-1/2 x 6-1/4")
Speed control	by transistor
Speed adjustment	by dial
Cutting speed	100~900mm/min.(4~35")
Power	110, 120, 220V AC 50/60Hz
Magnetic roller diameter	25mm (1")
Cutting thickness	5~50mm (1/4~2")
Tip	Acetylene 402ST type L.P.G. 406NT type
Setting	50kg (110 lbs) magnet with lever

IK-82 M300

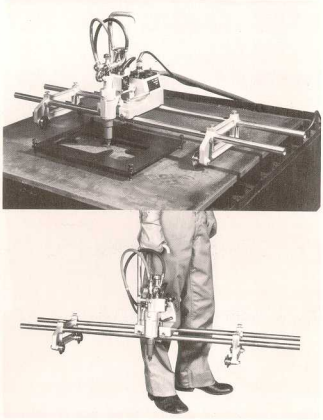


This model features a cutting capacity up to a circle of 300mm in diameter and ellipse of 600 x 200mm. (23-5/8 x 7-7/8") Use this model to cut L- and H-beams as well as general template.

SPECIFICATIONS

Weight	9.5kg (20.9 lbs)
Motor	100VDC, 6W, 10,000 rpm
Effective cutting capacity	circle 300mm (12") diam. ellipse 600 x 200mm (8 x 24")
Speed control	by transistor
Speed adjustment	by dial
Cutting speed	100~600mm/min.(4~24")
Power	110, 120, 220V AC 50/60Hz
Magnetic roller diameter	16mm (5/8")
Cutting thickness	5~50mm (1/4~2")
Tip	Acetylene 402ST type L.P.G. 406NT type
Setting	50kg (110 lbs) magnet with lever

IK-82 L900



This is a large-sized template cutter using a rail carriage. The length can be adjusted as required. It can be used to cut workpieces of any desired dimensions.

SPECIFICATIONS

Machine weight	5.5kg (12.1 lbs)
Rail carriage weight	4.0kg (8.8 lbs)
Motor	100V DC, 6W, 10,000 rpm
Rail length	1,120mm (44-3/32") (standard)
Effective cutting capacity	900mm (36") (wide) x desired length
Speed control	by transistor
Speed adjustment	by dial
Cutting speed	100~600mm/min. (4~24")
Power supply	110, 120, 220V AC 50/60Hz
Magnetic roller diameter	16mm (5/8") (standard)
Cut plate thickness	5~50mm (1/4~2")
Tip	Acetylene 402ST type L.P.G. 406NT type

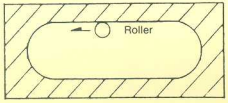
*This model is also available in optional types featuring a variety of effective cutting capacities.

- IK-82L/300 300mm (12") (wide) x desired length
- IK-82L/600 600mm (24") (wide) x desired length

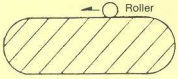
TEMPLATE PRODUCTION

In the IK-82 series, the locus of magnetic roller movement is the same as that of the torch movement. When making template take the following into consideration.

Internal rotation



External rotation



- Normally, the template of internal rotation type is used. If the external rotation type is used, the template may drop with the workpiece immediately when cutting operation has completed.
- Make sure the template has plate thickness of 6mm or more.
- Template dimensions and layout

(1) When the outer section of the cut-out workpiece is the product:
Product + roller diameter − cut width = template

(2) When the inner section of the cut-out workpiece is the product:
Product + roller diameter + cut width = template

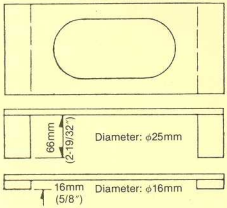
*Note that the cut-width varies according to the type number of the tip. (For details, refer to the separate instruction.)

MAJOR POINTS FOR TEMPLATE PRODUCTION

● WHEN THE TEMPLATE IS NOT MOUNTED ON MACHINE

Clamp the template or apply load to prevent it from being drawn up by the magnetic roller or being moved out of position. Make the template so that die bottom will match the roller bottom.

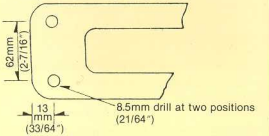
Template not mounted on machine



● TEMPLATE MOUNTED ON MACHINE

To mount the template on the machine, drill the fitting holes on the template as illustrated below:
Use the template mounting bolt hole (M8) on the machine when mounting the template
If the template is large, install an auxiliary template leg at the position where it does not interrupt magnetic roller travel. This will stabilize the machine.

Template Mounted on Machine



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