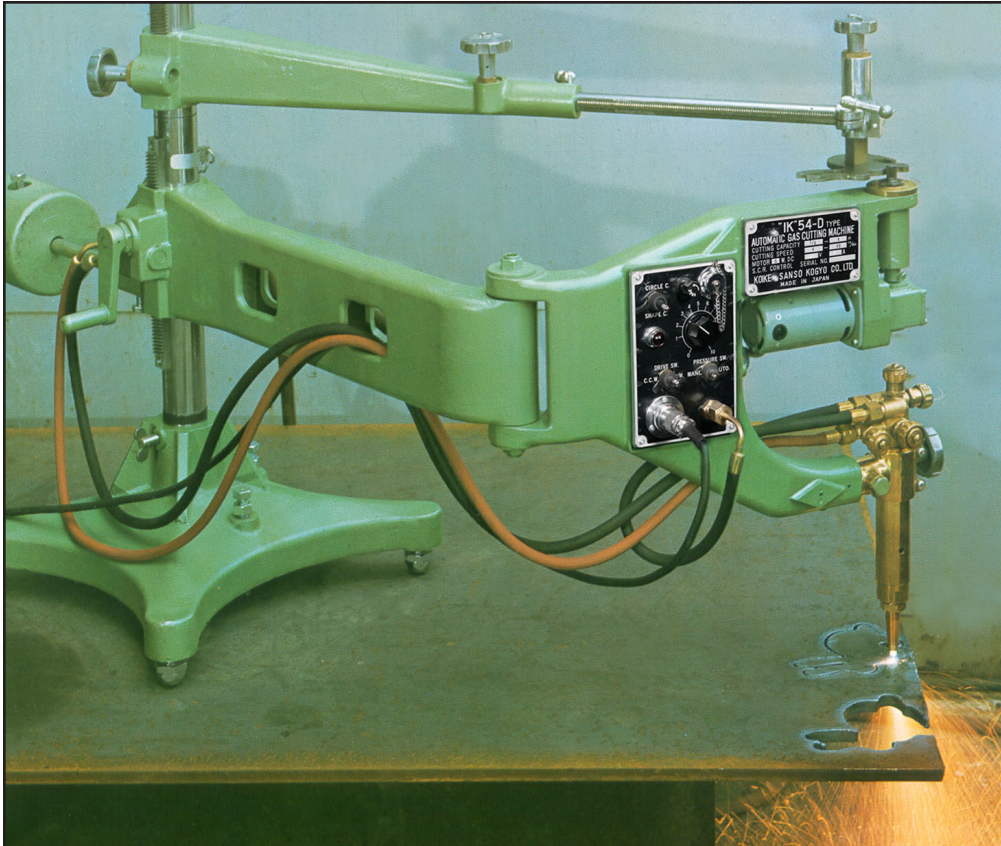


IK-54D

Portable Shape Cutting Machine



Features & Benefits

- **Oxy Fuel Pattern Cutter** Shape cut steel parts
- **Ball Transfer Base** Allows easy positioning of the unit on the plate
- **Auto Start Cutting Oxy Valve** Start or stop machine motion with cutting oxygen valve
- **3-Part Body Construction** Body consists of the pantograph, jaw and magnetic tracing system mounted on upper jaw with torch mounted on lower jaw; template fitting arm assembly and stand complete the construction
- **Magnetic Roller** 10mm ($\frac{25}{64}$ in) diameter standard roller follows shape of steel template fixed to template holder and accurately guides torch; 6, 8, 15 and 20mm available and allows various cut sizes with same template
- **Stable Cutting Speed** PWM control system ensures stable cutting speeds
- **Circle Cutting Option** Cut circles without a template 60-400mm (2.4-16 in) diameter
- **Cut Around Base of Machine** For larger part cutting
- **Light Weight** 33kgs (72.5lbs), easy enough to carry just about anywhere
- **High Quality Tips** Koike's superior design Series 100 torch tips are included to ensure fast, smooth cuts
- **Optional Snap Valve** One-touch on/off gas valve

Low Cost - Built for Efficient, High Production Operation

The IK-54D is a precision, quality constructed, hard-working gas shape cutter built for high production. Compact and simple to operate, this machine excels at repetitive work, continuously producing accurate flame cuts by following a steel template.

A powerful magnetic roller smoothly guides the cutting torch around any shape, cutting steel plate up to 4 inches thick. The Koike IK-54D offers all the convenient features of more expensive models with all the dependability and efficiency needed for your applications.



KOIKE ARONSON, INC.

Specifications

IK-54D-1000-0608

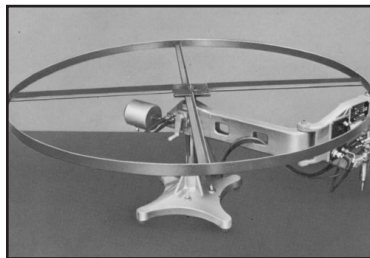


IK-54D Portable Shape Cutting Machine

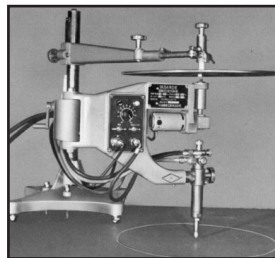
SPECIFICATIONS	
Cutting Range	
Standard Circle Diam.	30-70mm ϕ (1 $\frac{1}{4}$ - 27 $\frac{1}{2}$ in ϕ)
Using Attachment	600 -1700mm ϕ (24-67 in ϕ)
Square Side	30-70mm (1 $\frac{1}{4}$ - 27 $\frac{1}{2}$ in)
Using Attachment	500 - 1200mm (20 - 48 in)
Cutting Thickness	3-100mm ($\frac{1}{8}$ - 4 in)
Cutting Speed	100-1000 mm/min (4 - 39 $\frac{1}{2}$ in/min)
Cutting Accuracy	± 0.5 mm (0.02 in) over 500mm ϕ (19 $\frac{3}{4}$ in ϕ) cutting
Speed Control	PWM control system
Motor	DC Shunt motor 5W
Power Source	100V, 200V, (50, 60 cycles)
Weight	33 kg (72.5 lbs)
Magnetic Roller Diam.	10mm ϕ ($\frac{1}{2}$ in ϕ)

MODELS	
Description	Part #
Acetylene Kit* (consists of below items)	IK54D102
LPG Kit* (consists of below items)	IK54D106
*(1) IK-54D with Torch 120V** (see option)	ZA410-1005
*(3) Cutting Tips - 102 for Acetylene, 106 for LPG	Koike 100 series
*(1) Stand (Carriage)	ZA410-1006
*(1) Counterweight	ZM410-1007

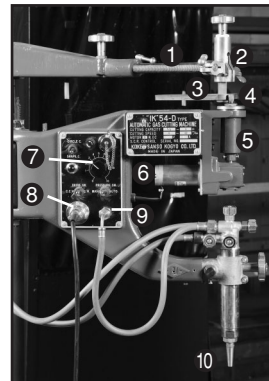
OPTIONAL EQUIPMENT	
** IK-54D 220Volt	ZA410-1004
Circle Cutting Attachment w/ Motor 60-400mm ϕ (2 $\frac{3}{8}$ -16 in ϕ)	ZS30825
Large Template Cutting Adapter	ZS30799
Snap Valve	SNAPVALVEII



Example using Large Template Adapter



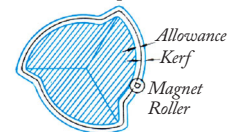
Template Cutting



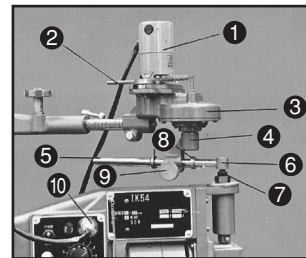
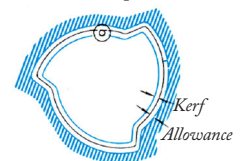
IK-54D Features

1. Arm
2. Template Holder
3. Template
4. Magnet Roller
5. Magnet Head
6. Motor
7. Speed Control Dial
8. Power Switch (Counter-clockwise - Stop - Clockwise)
9. Auto Switch (Off-On)
10. Torch

External Template

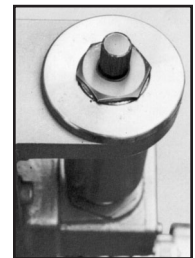


Internal Template

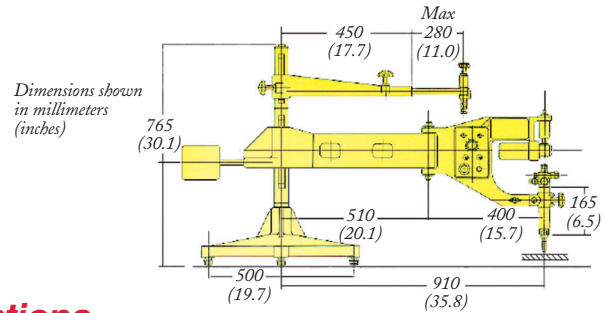


IK-54D w/ Circle Cutting Attachment

1. Motor
2. Clutch Lever
3. Speed Reduction Unit
4. Rotator
5. Slide Bar (w/ graduated pipe)
6. Rotator Holder
7. Rotation Spindle
8. Stop
9. Circle Diameter Adjustment Handle
10. Circle Cutting Socket



Magnet Roller



Operations

Template manufacturing is a simple process and as shown in the diagrams below, allowance is easily made for the diameter of the tracing roller as well as for kerf, with both external and internal templates. Once constructed, the template is quickly attached to the holder with a suitable size tip. The direction changeover switch is then flipped to either right or left handed rotation. Power travels to the magnetic roller motor where speed can be adjusted from 100 to 1,000mm (4 to 39 $\frac{1}{2}$) per minute.



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