VICTOR
THERMAL DYNAMICS®

1Torch®
with SureLok® Technology

One Torch for Virtually any Plasma Cutting System

The Victor® Thermal Dynamics® Universal 1Torch® Plasma Cutting Torch

The Victor Thermal Dynamics 1Torch utilizes revolutionary technology that allows these torches to work with almost any plasma cutting system. 1Torch allows end-users to standardize torches and consumables on a variety of manufacturers' systems, thus reducing inventory requirements and corresponding expenses associated with operating multiple systems. One torch for virtually any plasma cutting system!

VictorThermalDynamics.com

1TORCH®
with SureLok® Technology

Patented
SURELOK®
U.S. Patent 6,163,008

The Only Universal Plasma Torch! As a replacement (RPT®) torch, the 1Torch® has the ability to work on many of the plasma power supplies on the market today. Its unique design allows the 1Torch the ability to work with high frequency, touch, CD, and moving parts (blow back) start systems.

1 Year Warranty

Important Features Include...

Ergonomic Torch Handle
Hand Torches offer ergonomic handles with easy-to-use trigger release that provides comfort during prolonged use. 75° and 90° heads offer operators a choice of positions.

New Phenolic Position Tube
With an innovative, easy-to-remove 32 pitch gear rack, the phenolic positioning tube can easily be adapted to any $1^3/_8$" (35 mm) torch holder. If manual torch position is required, the use of the gear rack will complete the task. Simply remove the gear rack from the positioning tube if not needed.

Extended or Protected Consumable Parts
1Torch consumable parts are designed to adapt to your cutting style. By simply changing the shield cup, you can either have:

• An extended tip for greater visibility and control and precision drag cutting at low power.

• A protected tip for on the plate drag cutting at high power up to 120 Amps.

Lower Consumable Parts Inventories and Costs
Only 34 consumable parts cover the full range of cutting and gouging up to 120 Amps. Inventorying parts for a fleet of plasma units can be simplified using the 1Torch.

Improved Leads
1Torch leads are lightweight, extremely flexible, and rugged enough to withstand years of use.

ATC® (Advanced Torch Connector) Quick Disconnect Option
The ATC quick disconnect design brings extra flexibility to almost any plasma system. Switching to a machine torch, swapping out a damaged unit, or simply changing lead lengths is done quickly and requires no tools.

ATC Lead Extensions
ATC Lead extensions offer the flexibility of working up to 100' (30.4 m) away from the power supply. Extensions are offered in 15' (4.5 m), 25' (7.6 m), and 50' (15.2 m) lengths. The ATC makes it easy to add or subtract total torch lead length as requirements change.

Selecting the Right Torch Package for Your Needs...

1 **Torch and Leads Selection**
Step 1 gives you all the information to select the right torch.
    Step 1 - Manual Torch (pg. 3)
    Step 1 - Mechanized & Automation Torch (pg. 4)

Select the following:
• Torch – Standard or Shielded
• Connection – RPT (O2B) or ATC
• Lead Length
• ATC Lead Extensions (Optional, with ATC only)
• Remote Control Options (Mechanized or Automation only)

2 **Adapter Kit Selection**
Step 2 (pg. 6) Select the appropriate Adapter Kit. If you selected a torch with the ATC connection, you will also need an ATC Receptacle Adapter shown in **Step 1** (pg. 3 or 4).

3 **Spare Parts Selection**
Step 3 (pg. 7) select spare parts or parts kit that best suits your needs.

Hand Torch & Lead Selection

Listed below are the Torch and Lead selection charts for the SL60® and SL100® Hand 1Torch® RPT® torches

Hand Torches / Ordering Information

SL60 Light/Medium Duty Torch (20-80 Amps)

75°

90°

SL100 Medium/Heavy Duty Torch (20-120 Amps)

75°

90°

	CAT NO.		DESCRIPTION
A	**Standard RPT** (02B) **Torch Connection**		
	SL60 Hand Torch (20-80 Amps)		Torch & Leads
	75º	**90º**	
	7-5200	7-5261	SL60, 20' (6.1 m)
	7-5201	7-5262	SL60, 50' (15.2 m)
B	**ATC® Torch Connection**		
	SL60 Hand w/ATC (20-80 Amps)		Torch & Leads
	75º	**90º**	
	7-5204	7-5260	SL60, 20' (6.1 m)
	7-5205	7-5260[1]	SL60, 50' (15.2 m)[1]

ATC Adapter Kit

ATC Receptacle Adapter	
7-5207[3]	ATC Receptacle Connector
ATC Lead Extensions: Optional (For ATC Connections Only)	
7-7544	15' (4.5 m) Lead Extension
7-7545	25' (7.6 m) Lead Extension
7-7552	50' (15.2 m) Lead Extension

	CAT NO.		DESCRIPTION
A	**Standard RPT** (02B) **Torch Connection**		
	SL100 Hand Torch (20-120 Amps)		Torch & Leads
	75º	**90º**	
	7-5202	7-5264	SL100, 20' (6.1 m)
	7-5203	7-5265	SL100, 50' (15.2 m)
B	**ATC® Torch Connection**		
	SL100 Hand w/ATC (20-120 Amps)		Torch & Leads
	75º	**90º**	
	7-5206	7-5263	SL100, 20' (6.1 m)
	7-5208	7-5263[2]	SL100, 50' (15.2 m)[2]

ATC Adapter Kit

ATC Receptacle Adapter	
7-5207[3]	ATC Receptacle Connector
ATC Lead Extensions: Optional (For ATC Connections Only)	
7-7544	15' (4.5 m) Lead Extension
7-7545	25' (7.6 m) Lead Extension
7-7552	50' (15.2 m) Lead Extension

1 - Use 7-5260 with 7-7545 for a SL60 45' (13.7 m)
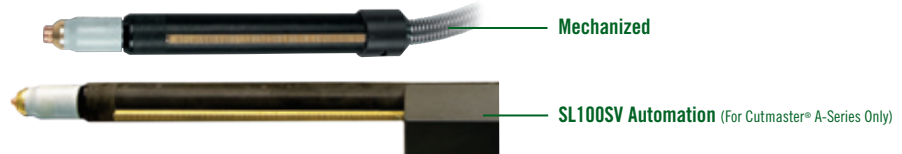2 - Use 7-5263 with 7-7545 for a SL100 45' (13.7 m)
3 - This receptacle adapter is required for each power supply using an ATC torch connection. This is connected to the torch adapter kit specific to each power supply. Total lead length including torch and extension(s), should not exceed the maximum length specified by the power supply manufacturer.

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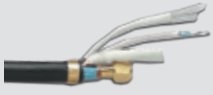
Mechanized & Automation Torch and Lead Selection

Listed below are the Torch and Lead selection charts for
the SL100® Machine 1Torch® RPT® torch.
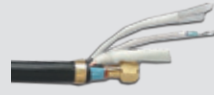
Machine Torch / Ordering Information

**SL100 Medium/
Heavy Duty Torch
(20-120 Amps)**

→ Mechanized

→ SL100SV Automation (For Cutmaster® A-Series Only)

STANDARD

CAT NO.	DESCRIPTION
A **Standard RPT** (O2B) **Torch Connection**	

SL100 Mechanized Torch & Leads -
(Fiberglass Tube w/Rack)

7-5209	SL100, 180°, 25' (7.6 m)
7-5210	SL100, 180°, 50' (15.2 m)

Remote Interface Adapter 7-3452 included with torch.

B **ATC® Torch Connection**

SL100 Mechanized Torch	SL100SV® Automated Torch[3]	Torch & Leads (For Cutmaster Series Only. Does Not Work With Lead Extensions)
7-5213		SL100, 180°, 5' (1.5 m)
7-5214		SL100, 180°, 10' (3.0 m)
7-5215	7-4001	SL100, 180°, 25' (7.6 m)
	7-4002	SL100, 180°, 35' (10.6 m)
7-5216	7-4003	SL100, 180°, 50' (15.2 m)
	7-4004	SL100, 180°, 75' (22.8 m)
	7-4005	SL100, 180°, 100' (30.4 m)

ATC Adapter Kit

ATC Receptacle Adapter

7-5207	ATC Receptacle Connector[2]

ATC Lead Extensions: Optional (For ATC Connections Only)

7-7544	15' (4.5 m) Lead Extension
7-7545	25' (7.6 m) Lead Extension
7-7552	50' (15.2 m) Lead Extension

Mechanized Remote Controls

7-3474	ATC Remote Interface Kit Provides an optional remote interface connection to allow the use of any remote control. Can be placed anywhere between the ATC Torch connection or Lead Extension and ATC Adapter
7-3452	Remote Pendant Interface Kit Interfaces into any torch adapter kit to allow the use of a Remote Pendant (7-3460) on any Mechanized torch system.
7-3460	Remote Pendant Control
9-8312	25' (7.6 m) CNC Remote Cable
9-8313	50' (15.2 m) CNC Remote Cable

SHIELDED[1]

CAT NO.	DESCRIPTION
A **Standard RPT** (O2B) **Torch Connection**	

**SL100 Mechanized Torch & Leads -
Shielded** (Fiberglass Tube w/Rack)

7-5211	SL100, 180°, 25' (7.6 m)
7-5212	SL100, 180°, 50' (15.2 m)

Remote Interface Adapter 7-3452 included with torch.

B **ATC Torch Connection**

**SL100 Mechanized Torch & Leads -
Shielded** (Fiberglass Tube w/Rack)

7-5219	SL100[1], 180°, 5' (1.5 m)
7-5220	SL100[1], 180°, 10' (3.0 m)
7-5221	SL100[1], 180°, 25' (7.6 m)
7-5222	SL100[1], 180°, 50' (15.2 m)

ATC Adapter Kit

ATC Receptacle Adapter

7-3472	ATC Receptacle Connector[2]

Mechanized Remote Controls

7-3452	Remote Pendant Interface Kit Interfaces into any torch adapter kit to allow the use of a Remote Pendant (7-3460) on any Mechanized torch system.
7-3460	Remote Pendant Control
9-8312	25' (7.6 m) CNC Remote Cable
9-8313	50' (15.2 m) CNC Remote Cable

1 - It is only recommended to install shielded torches onto a shielded ready system. Installation onto a non-shielded system may result in reduced performance. Installing a shielded torch on to a shielded system requires the shield connections to be terminated to a proper shield termination or earth ground point.

2 - This receptacle adapter is required for each power supply using an ATC torch connection. This is connected to the torch adapter kit specific to each power supply. Total lead length including torch and extension(s), should not exceed the maximum length specified by the power supply manufacturer.
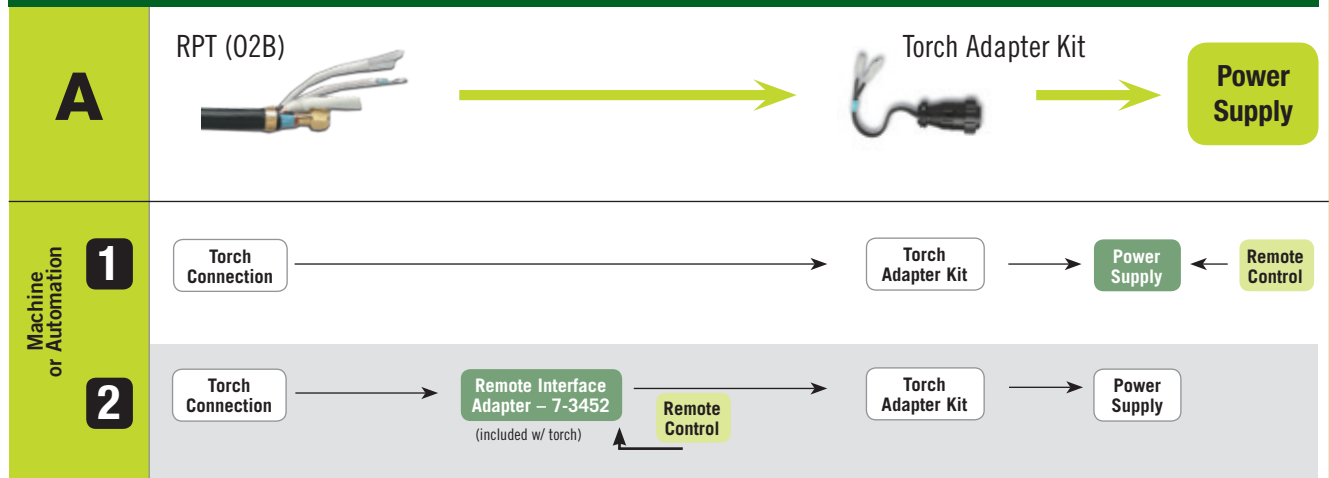
3 - ATC Lead Extensions are for use on hand and mechanized torches only. Will not work with automated torches.

Torch Connection Options - Remote Control

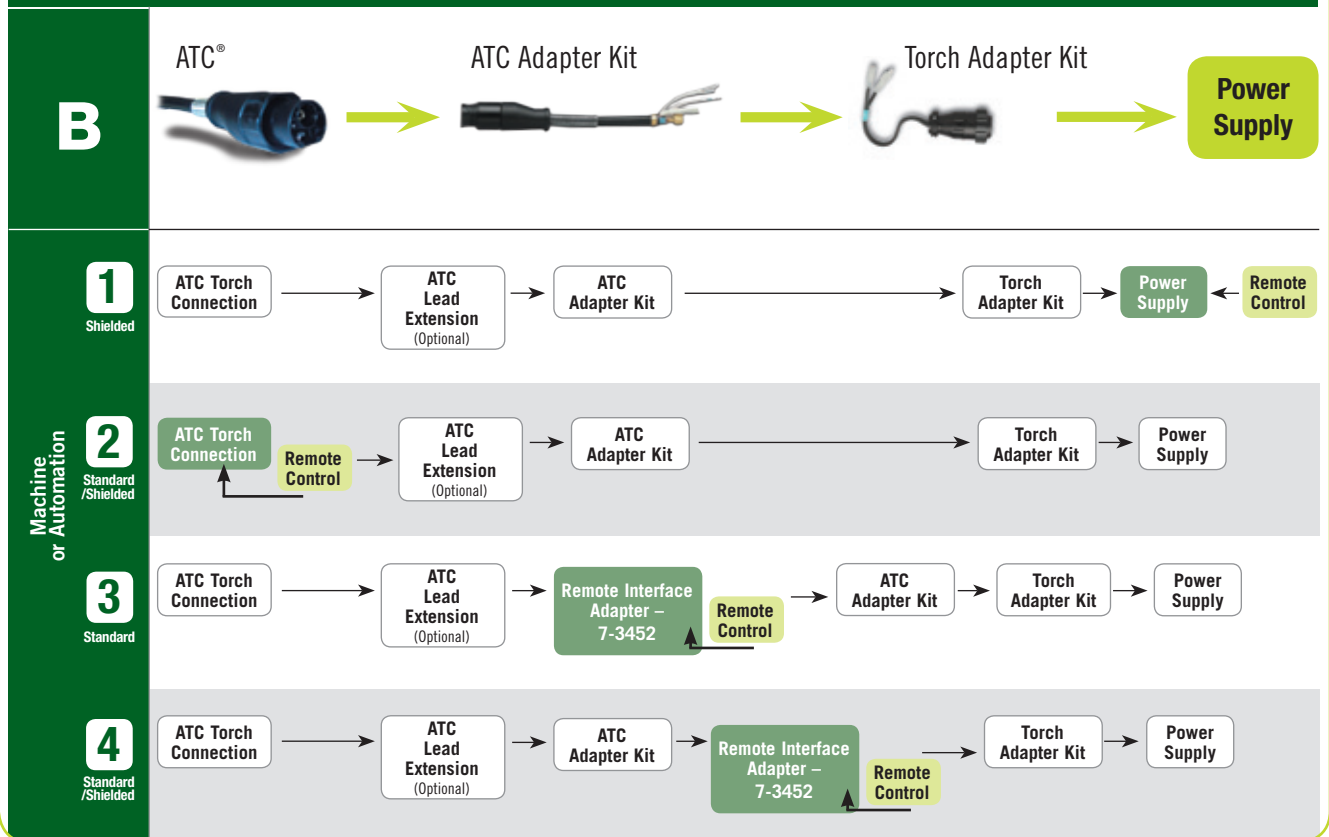The diagrams below show the different torch connections with remote connection options.

Standard RPT Connection

(Note: Remote control is either 7-3460 Remote Pendant Control or is user supplied.)

A

RPT (02B)   →   Torch Adapter Kit   →   **Power Supply**

Machine or Automation

1

Torch Connection → Torch Adapter Kit → Power Supply ← Remote Control

2

Torch Connection → Remote Interface Adapter – 7-3452 (included w/ torch)   Remote Control → Torch Adapter Kit → Power Supply

ATC Torch Connection

(Note: Remote control is either 7-3460 Remote Pendant Control or is user supplied.)

B

ATC®   →   ATC Adapter Kit   →   Torch Adapter Kit   →   **Power Supply**

Machine or Automation

1 — Shielded

ATC Torch Connection → ATC Lead Extension (Optional) → ATC Adapter Kit → Torch Adapter Kit → Power Supply ← Remote Control

2 — Standard /Shielded

ATC Torch Connection   Remote Control → ATC Lead Extension (Optional) → ATC Adapter Kit → Torch Adapter Kit → Power Supply

3 — Standard

ATC Torch Connection → ATC Lead Extension (Optional) → Remote Interface Adapter – 7-3452   Remote Control → ATC Adapter Kit → Torch Adapter Kit → Power Supply

4 — Standard /Shielded

ATC Torch Connection → ATC Lead Extension (Optional) → ATC Adapter Kit → Remote Interface Adapter – 7-3452   Remote Control → Torch Adapter Kit → Power Supply

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Adapter Kit Selection

Listed below is the Adapter Kit selection charts for the Hand 1Torch® RPT® torch.

Torch Adapter Kits

Manufacturer	Power Supply Model	Catalog Number	Manufacturer	Power Supply Model	Catalog Number
ESAB®				PCM-750i, 1000i	7-3435
	PCM-SMi, 500i, 625i, PCS-43	7-3425		PCM-101	7-3436
	PCS-53, 80, 90	7-3435	**LINCOLN®**		
	ESP-100i	7-3426		Procut 60	7-3431
	PCM-750i, 875, 1000i, 1125	7-3429	**MILLER®**		
	Sidewinder 30,55,105	7-3434		Plazcut 60†/Zipcut	7-3432
	Powercut® 650	7-3464		Spectrum® 250D, 500, 750	7-3433
	Powercut 875, 1125	7-3465		Spectrum 700, 1000,1250,PLUS	7-3430
	Powercut 1250, 1500	7-3462		Spectrum 3080*	7-3456
HARRIS®				Spectrum 650*, 701*, 2050*	7-3457
	System 50, 65 and 100	7-3439		Spectrum 300*	7-3476
HOBART®				Spectrum 375*	7-3477
	Smoothcut II 35A, 60A, and 100A	7-3427		Spectrum 625*	7-3478
HYPERTHERM®			**OTHERS**		
	Max®40, HT®40 (H/F Start) Max 70, 80, 100 (w/ & w/o Q.D.)	7-3430		OTC®: D-5000 and D-7000 PTRON®: P-TRON 75 and 100 Daihen®: MRAT-70 Multiquip®: PCX50SS	7-3437
	Max 42*, 43*, 40cs*, Powermax®600*, 800*, 900* (w/ Q.D.)	7-3454	**SMITH**		
	Powermax 1100*	7-3455		Powerpro 55 and 75	7-3487
	Powermax 1000*, 1250*	7-3461	**VICTOR® THERMAL DYNAMICS®**		
	Max 40cs* (w/o Q.D.)	7-3476		PAK® 3XR, 5XT, 6XR, 7XR, 625XR, 750XR	7-3446
	Powermax 380*	7-3477		PAK 8XR, 10XR, 1000XR, 1250XR, PakMaster® 75, 100	7-3434
	Powermax 600* (w/o Q.D.)	7-3480		PakMaster 50XL/XLP,75XL/XLP, 100XL/XLP Cutmaster® 50, 75, 80XL, 100	7-3447
	Powermax 800*, 900* (w/o Q.D.)	7-3481		PakMaster 25, 38XL, EconoPAK® 25, Drag-Gun® 38, PAK 4Xi, 6Xi, PAK 2XT, Dynapak® 110	7-3443
	Powermax 1650*	7-3483		PakMaster 50 w/Smart Torch (Q.D)	7-3445
	Powermax 350*	7-3484		EconoPAK 50	7-3449
L TEC®				EconoPAK 100	7-3450
	PCM-31, SMi, 32i/34i, VPi PCM-500i, 625i, PCS-80i	7-3425		PAK 5	7-3444
	PCM-50A, 70, 80, 52i/54i, 82i/84i ESP-100i, PCM-50, PCM-100 (Single Gas) PCM-50, P-MC-100 (Dual Gas)	7-3426		PAK 10	7-3436
	PCS-40	7-3430			

*Non-HF Systems.

†The Miller PlazCut machines with Serial Numbers beginning JE are not compatible with 1Torch® RPT Torches.

NOTES: Each Adapter Kit includes connection fitting, electrical connectors and installation instruction sheets for the selected power supply.

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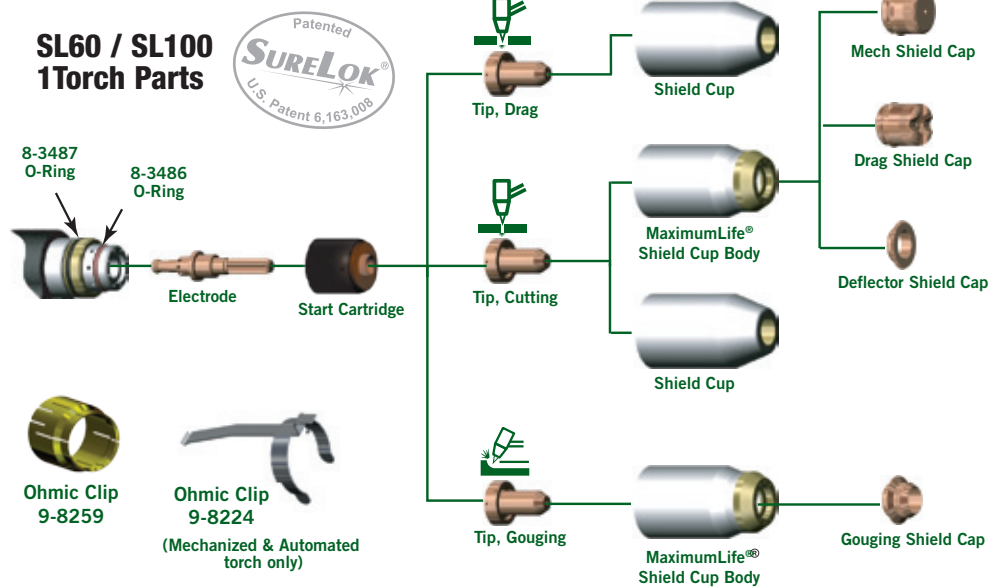
Spare Parts Selection

Listed below is the Spare Part selection charts for the SL60® and SL100® 1Torch® Parts.

1Torch Consumables / Parts

Description	Cat. No.
O-Ring	8-3487
O-Ring	8-3486
Electrode, MaximumLife®	9-8215 ■
Start Cartridge	9-8213 ■
Start Cartridge SL55™ Lincoln	9-8255 ★
Start Cartridge SL80™ Lincoln	9-8257 ‹
Tip, 20A, Drag	9-8205
Tip, 30A, Drag	9-8206
Tip, 40A, Drag	9-8207
Tip, 40A, Cutting	9-8208
Tip, 50/55A, Cutting	9-8209
Tip, 60A, Cutting	9-8210 ▲
Tip, 60A, Drag	9-8252
Tip, 70A, Cutting	9-8231
Tip, 80A, Cutting	9-8211
Tip, 90/100A, Cutting	9-8212 ●
Tip, 120A, Cutting	9-8253
Tip, A, Gouging	9-8225
Tip, B, Gouging	9-8226
Tip, C, Gouging	9-8227
Tip, D, Gouging	9-8228
Tip, E, Gouging	9-8254
Shield Cup	9-8218
Shield Cup Body, MaximumLife®	9-8237 ■
Shield Cap, Drag, 40A	9-8244
Shield Cap, Drag, 50-60A	9-8235 ▲
Shield Cap, Drag, 70-100A	9-8236 ●
Shield Cap, Drag, 120A	9-8258
Shield Cap, Mech, 40A	9-8245
Shield Cap, Mech, 50-60A	9-8238
Shield Cap, Mech, 70-100A	9-8239
Shield Cap, Mech, 120A	9-8256

SL60 / SL100 1Torch Parts

Patented
SURELOK®
U.S. Patent 6,163,008

8-3487 O-Ring
8-3486 O-Ring
Electrode
Start Cartridge

Ohmic Clip 9-8259
Ohmic Clip 9-8224
(Mechanized & Automated torch only)

Tip, Drag
Shield Cup
Mech Shield Cap
Drag Shield Cap

Tip, Cutting
MaximumLife® Shield Cup Body
Deflector Shield Cap
Shield Cup

Tip, Gouging
MaximumLife® Shield Cup Body
Gouging Shield Cap

Description	Cat. No.
Shield Cap, Deflector	9-8243 ■
Shield Cap, Gouging	9-8241
Spare Parts Kit, 30 Amp	5-2550
Spare Parts Kit, 40 Amp	5-2551
Spare Parts Kit, 50/55 Amp	5-2552
Spare Parts Kit, 60 Amp	5-2553
Spare Parts Kit, 70 Amp	5-2554
Spare Parts Kit, 80 Amp	5-2555
Spare Parts Kit, 90/100 Amp	5-2556

Note: All Spare Parts Kits include ten (10) Tips, five (5) Electrodes and one (1) Start Cartridge.

■ Standard for all RPT® Torches
‹ Standard on SL80 Torches
★ Standard on SL55 Torches
▲ Standard on SL60 RPT Torches
● Standard on SL100 RPT Torches

Accessories

Product Description	Catalog No.
Single Stage Air Filter	7-7507
Two-Stage Air Filter	9-9387
Remote Pendant Control 20 (6.1 m)	7-3460
Remote Pendant Extension 7-7744 25' (7.6 m) For Use with Mechanized Torch	

Product Description	Catalog No.
Leather Leads Cover	
20' (6.1 m)	9-1260
25' (7.6 m)	9-1270
50' (15.2 m)	9-1280
Straight Line Cutting Guide	7-8911

Product Description	Catalog No.
Cutting Guide Kits	
Circle Guide Kit	7-3291
Roller / Radius Kit	7-7501
Deluxe Kit	7-8910

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