

PORTABLE, SHAPE CUTTING MACHINE

# IK-54D

Economically cuts all desired shapes

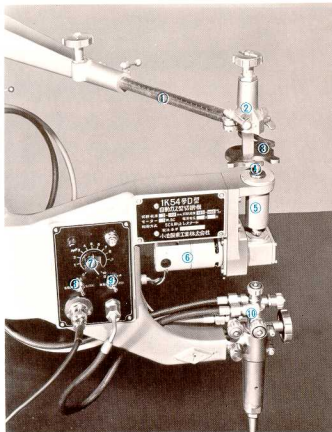


KOIKE SANSO KOGYO CO., LTD.

THE LOW COST

# IK-54D

BUILT FOR EFFICIENT,  
HIGH PRODUCTION OPERATION



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

The IK-54D is a quality constructed, hard-working gas shape cutter for high production accuracy. Compact and simple to operate, this fine Koike machine is most at home doing highly repetitive work where it can continuously produce the same precision flame cuts by following a steel template. A powerful magnet roller smoothly guides the cutting torch around any shape, cutting steel plate up to four inches in thickness. Weighing in at only 33 kg (72.5 lbs.), it can be carried anywhere, and its versatility of performance meets your exact cutting needs. The IK-54D offers all the convenient features of more expensive machines with no sacrifice in operational ease and dependability and promises to be an efficient time and labor saving addition to your working inventory.

## QUALITY CONSTRUCTION

The IK-54D is ruggedly constructed in three main sections: the body, the template-fitting arm assembly, and the stand. The body consists of the pantograph, jaw, magnetic tracing system mounted securely on the upper jaw and Koike's exclusive cutting torch mounted to the lower jaw. Control functions are conveniently concentrated on the jaw side. The torch can be swiveled up for easy replacement of the tip and maintenance.

The 25/64 inch diameter (10mm) standard magnetic roller follows the shape of the steel template fixed to the template holder and accurately guides the cutting torch.

Besides the standard roller, optional rollers of various diameter (0, 8, 15, and 20mm) are available for use with this machine. A change of rollers permits cuts of different size with the same template.

Using a Koike 102 Oxy-acetylene or 106P Oxy-propane cutting tip ensures the most accurate and efficient shape cutting available anywhere.

## FEATURES

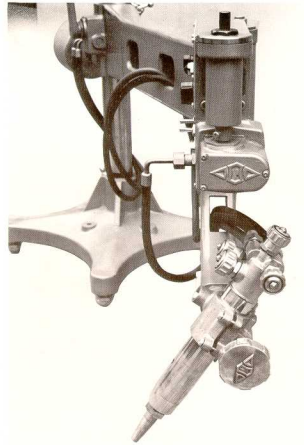
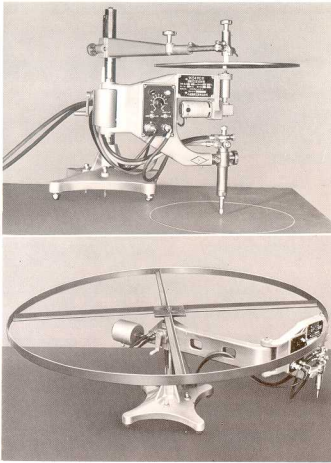
**CONVENIENCE** — An automatic switch permits simultaneous actuation of the cutting oxygen and the motor. The adjustment and control functions are conveniently, located on the jaw, and all operations have been simplified for labor saving and dependability.

Easy vertical and horizontal adjustment of the template holder facilitates centering and flange cutting.

**ACCURACY** — An extremely powerful permanent magnetic roller ensures precision conformity to complicated template shape by preventing slippage during the operation. An S.C.R. control system is employed in this machine so that cutting speed is highly stable.

**CAPABILITY** — Effective cutting range is greatly extended. In circle cutting, the max. diameter is 700mm (27.39/64"). By using the appropriate attachment, cutting circle diameter is extended up to 1,700mm (67").

The cutting speed also ranges widely from 100 to 1,000 mm/min. (3-15/16 to 39-13/32 in./min.) and the optimum speed for the thickness of the plate being cut is easily obtainable.



## OPERATIONS

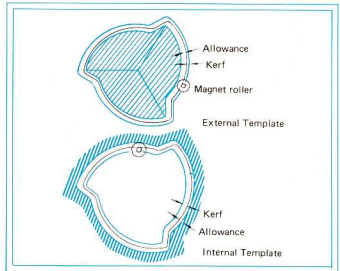
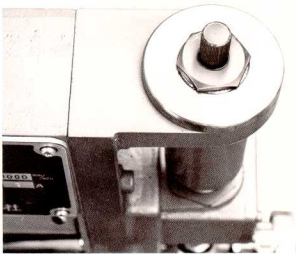
Template manufacture is a simple process, and, as shown in the diagrams to the right, allowance is easily made for the diameter of the tracing roller, as well as for kerf, with both external and internal templates.

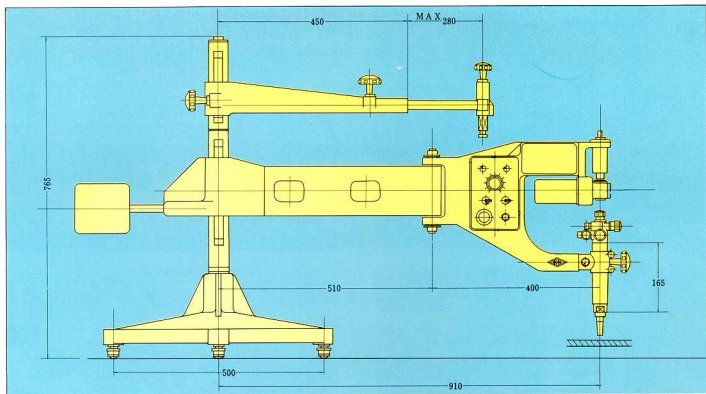
Once constructed, the template is quickly attached to the

*Magnet roller*

holder, a suitable size tip is attached, and the direction changeover switch is flipped to either right handed or left handed rotation.

Power is then switched to the magnetic roller motor and speed may be adjusted from 100mm (3-15/16") to 1,000mm (39-13/32") per minute. Power is then switched off, the plate is pre-heated for a few seconds, and the automatic switch and cutting oxygen valves may be opened. At this point the machine begins its automatic accurate shape cutting.





## SPECIFICATIONS

Weight	33kg (72.5 lbs.)
Power	100V, 200V, (50, 60 cycles)
Motor	D.C. Shunt Motor 5W
Cutting range	
Standard circle dia.	30 ~ 700mm $\phi$ (1-9/32 ~ 27-39/64" $\phi$ )
Using attachment	600 ~ 1,700mm $\phi$ (23-39/64 ~ 67" $\phi$ )
Square side	30 ~ 600mm $\square$ (1-9/32 ~ 23-39/64" $\square$ )
using attachment	500 ~ 1,200mm $\square$ (19-45/64 ~ 47-13/64" $\square$ )
Cutting thickness	3 ~ 100mm (11-13/16 ~ 394")
Cutting speed	100 ~ 1,000mm/min. (3-15/16 ~ 39-13/32in/min.)
Cutting accuracy	$\pm 0.5$ mm (0.02") over 500mm $\phi$ (19-11/16" $\phi$ ) cutting

Control system	S.C.R. control
Magnet roller dia.	10mm $\phi$ (25/64" $\phi$ )

## ACCESSORIES

Cutting tip	102 (acetylene) or 106V (propane)	1 set
Cabletyre cord 5m(19-45/64")		1 pc.
Tip cleaner		1 set
Wire brush		1 pc.
Spanner		1 pc.
Alignment device		1 set



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