

## 100 HE Plasma Parameters

Abradables		Hardware				Gas SCFH			Power	Powder Feed		Torch
Powder	Composition	Particle Size	Nozzle	Pwdr Ports	Ext Attach	Ar	N2	H2	GV/KW	Gr/min	Cr Gas	Stnd Off
Amdry 2010	AlSi/Polyester	11-125 micron	866695	841149	2-Port	350	70	60	210/65	85	40	4.5 in
Amdry 2010	AlSi/Polyester	11-125 micron	866695	841149	3-Port	300	100	30	229/50	155	75	6.5 in
SM 601 NS	AlSi/Polyester	11-125 micron	866695	841150	2-Port	300	120	120	269/90	45	40	6.0 in
SM 601 NS	AlSi/Polyester	11-125 micron	866695	841149	2-Port	220	120	NA	157/90	70	20	6.0 in
SM 601 NS	AlSi/Polyester	11-125 micron	866695	841149	3-Port	280	120	50	239/70	140	50	6.0 in
SM 601 NS	AlSi/Polyester	11-125 micron	866695	841149	3-Port	300	120	50	240/70	200	75	6.5 in
MC 517	AlSi/Polyester	11-125 micron	866695	841149	2-Port	320	90	120	243/85	180	40	6.0 in
MC 517	AlSi/Polyester	11-125 micron	866695	841149	2-Port	220	120	NA	177/90	100	40	5.0 in
PAC 905-3	AlSi/Polyester	11-125 micron	866695	841149	2-Port	300	100	120	254/90	100	40	6.0 in
PAC 905-3	AlSi/Polyester	11-125 micron	866695	841149	3-Port	320	90	120	241/85	180	60	6.0 in
PAC 905-3	AlSi/Polyester	11-125 micron	866695	841149	3-Port	220	120	NA	175/95	300	45	6.0 in
PAC 905-3	AlSi/Polyester	11-125 micron	866695	841149	3-Port	300	10	50*	90/50	100	60	6.0 in
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	2-Port	300	100	30	214/80	50	35	5.0 in
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	2-Port	300	100	30	214/70	70	40	5.0 in
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	2-Port	320	100	40	220/80	100	40	6.0 in
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	3-Port	220	120	NA	152/68	150	60	6.0 in
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	3-Port	220	120	NA	155/68	170	75	6.0 in
SM 320 NS	AlSi/BN	22-212 micron	866695	841149	2-Port	250	100	50	226/65	100	35	5.5 in
SM 320 NS	AlSi/BN	22-212 micron	866695	841151	2-Port	280	100	220*	175/65	100	30	4.5 in
SM 320 NS	AlSi/BN	22-212 micron	866695	841149	3-Port	200	120	NA	160/90	150	28	6.0 in
SM 2043 NS	CoNiCrAlY/Poly	7.8-176 micron	866695	841149	2-Port	220	100	70	230/85	100	25	6.0 in
SM XPT 268	AlSi/BN/Poly	45-212 micron	866695	841149	3-Port	220	100	60	227/50	100	29	4.5 in
*Helium Gas	* Helium Gas											

## 100 HE Disclaimer and Coating Parameter Legend

Coating parameters contained in this manual should be considered starting points. The parameters published in this manual were developed under laboratory conditions. Field results may vary.

Progressive Technologies, Inc. is constantly striving to improve coating characteristics and properties through parameter and 100 HE hardware development. **Contact your Sales Engineer or the Application Manager at PTI for the latest developments and parameter that best fits your requirements.** A complete coating report will be supplied upon request.

The Two Port and Three Port External attachments are interchangeable for all coatings listed as 2-Port or 3-Port injection in the Parameter Guide. In most cases the Three Port Injection shows slight improvement in density and deposition efficiency over the Two Port injection method.

### Material Selection Guide

- \*Sulzer Metco, Inc. (SM)
- \*Sulzer Metco, Inc. (Amdry)
- \*HC Starck, Inc. (HC)
- \*Saint-Gobain, LLC. (SG)
- \*Praxair Surface Technologies, Inc. (PX)
- \*Powder Alloy Corporation (PAC)
- \*Deloro Stellite, Inc. (Stellite)
- \*Carpenter Alloys, Inc. (Carp)
- \*Hoganas International, Inc. (Hog)
- \*Wall Colmonoy, Inc. (WC)
- \*Liquid Metals, Inc. (Armacor)
- \*Nano Steel Corporation (Nano)
- \*Montreal Carbide, Ltd. (MC)
- \*Lineage Alloys, Inc. (LA)
- \*Atlantic Minerals Corporation. (Hochrhein).

**\*Materials outlined in the Parameter Guidelines are registered trade marks of the aforementioned companies.**