

### 100 HE Plasma Parameters

Abradables		Hardware				Gas SLM			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	165	33	28	210/65	85	19	11.4 cm
Amdry 2010	AlSi/Polyester	11-125 micron	866695	841149	3-Port	142	47	14	229/50	155	35	16.5 cm
SM 601 NS	AlSi/Polyester	11-125 micron	866695	841150	2-Port	142	57	57	269/90	45	19	15.0 cm
SM 601 NS	AlSi/Polyester	11-125 micron	866695	841149	2-Port	104	57	NA	157/90	70	10	15.0 cm
SM 601 NS	AlSi/Polyester	11-125 micron	866695	841149	3-Port	132	57	24	239/70	140	24	15.0 cm
SM 601 NS	AlSi/Polyester	11-125 micron	866695	841149	3-Port	142	57	24	240/70	200	35	16.5 cm
MC 517	AlSi/Polyester	11-125 micron	866695	841149	2-Port	151	42	57	243/85	180	19	15.0 cm
MC 517	AlSi/Polyester	11-125 micron	866695	841149	2-Port	104	57	NA	177/90	100	19	13.0 cm
PAC 905-3	AlSi/Polyester	11-125 micron	866695	841149	2-Port	142	47	57	254/90	100	19	15.0 cm
PAC 905-3	AlSi/Polyester	11-125 micron	866695	841149	3-Port	151	42	57	241/85	180	28	15.0 cm
PAC 905-3	AlSi/Polyester	11-125 micron	866695	841149	3-Port	104	57	NA	175/95	300	21	15.0 cm
PAC 905-3	AlSi/Polyester	11-125 micron	866695	841149	3-Port	142	5	24*	90/50	100	28	15.0 cm
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	2-Port	142	47	14	214/80	50	17	13.0 cm
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	2-Port	142	47	14	214/70	70	19	13.0 cm
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	2-Port	151	47	19	220/80	100	19	15.0 cm
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	3-Port	104	57	NA	152/68	150	28	15.0 cm
SM 313 NS	AlSi/Graphite	7.8-150 micron	866695	841149	3-Port	104	57	NA	155/68	170	35	15.0 cm
SM 320 NS	AlSi/BN	22-212 micron	866695	841149	2-Port	118	47	24	226/65	100	17	14.0 cm
SM 320 NS	AlSi/BN	22-212 micron	866695	841151	2-Port	132	47	104*	175/65	100	15	11.4 cm
SM 320 NS	AlSi/BN	22-212 micron	866695	841149	3-Port	94	61	NA	160/90	150	13	15.0 cm
SM 2043 NS	CoNiCrAlY/Poly	7.8-176 micron	866695	841149	3-Port	104	47	33	230/85	100	12	15.0 cm
SM XPT 268	AlSi/BN/Poly	45-212 micron	866695	841149	3-Port	104	47	28	227/50	100	14	11.4 cm
*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.**