Versatile, powerful cutting in a lightweight power source.

Inverter-based design and reliable technology pack a lot of performance into a very portable package. The Airforce 27i features a multi-voltage plug (MVP™) that allows you to connect to common 120- or 240-volt power receptacles without using any tools. You can easily transport this plasma cutter to the job, connect to power and begin cutting up to 5/8-inch material on 240-volt power quickly.

Applications
- Maintenance
- Body Shops
- Light Construction
- HVAC

Includes
- 12 ft. (3.7 m) XT30R hand-held torch
- 12 ft. (3.7 m) work cable with clamp
- 10 ft. (3 m) power cord with 5-15P (120 V, 15 A) and 6-50P (240 V, 50 A) MVP™ plugs
- Easy-to-connect, built-in gas/air filter and regulator for extra protection
- Extra consumables (2 tips, shield deflector, and electrode)
- Cable management included

Quick Specs

<table>
<thead>
<tr>
<th>Rated Output</th>
<th>120 V (15 A): 20 A at 88 VDC, 60% duty cycle</th>
</tr>
</thead>
<tbody>
<tr>
<td></td>
<td>120 V (20 A): 27 A at 92 VDC, 35% duty cycle</td>
</tr>
<tr>
<td></td>
<td>240 V: 30 A at 92 VDC, 40% duty cycle</td>
</tr>
</tbody>
</table>

| Mild Steel Cutting Capacity | Rated: At 20 amps: 1/4 in. (6.4 mm) |
|                            | Max. Cut: At 20 amps: 3/8 in. (9.5 mm) |
|                            | Rated: At 30 amps: 3/8 in. (9.5 mm)   |
|                            | Max. Cut: At 30 amps: 5/8 in. (15.9 mm) |

Features

- MVP (multi-voltage plug)
- Small lightweight design
- XT30R torch
- Wind Tunnel Technology™
- Fan-On-Demand™
- Power factor correction (PFC) circuitry
- LVC™ line voltage compensation
- Internal gas/air filter and regulator
- Starts without high frequency
- Postflow cooling circuit
- Compatible with engine-driven welders
- Hobart 5/3/1 industrial warranty

Benefits

- Connect to 120 or 240 V power receptacles without the use of any tools — simply choose the plug that fits the receptacle.
- At just 19 pounds (8.6 kg), the shoulder strap allows the end user to easily move from location to location.
- Increased comfort with an ergonomic trigger safety, more efficient cooling and economical replacement cutting tips.
- Prevents abrasive dust and particles from damaging internal components.
- Cooling system operates only when needed reducing power consumption and contaminants drawn into the machine.
- Draws up to 30% less amperage for the same cutting range as compared to the competition. PFC expands operators work area via extension cord, while minimizing nuisance circuit breaker trips caused by voltage drops.
- Provides peak performance power under variable input voltage conditions (±15%) for steady and cleaner-ending cuts.
- Controls amount of usage and flow of air or gas.
- Protects unit by not interfering with or damaging controls or computers.
- Extends life of consumables and torch by cooling them with postflow air after trigger is released.
- Complete cutting capability when powered by an engine-driven welder/generator with a 240 V receptacle of 4 kW or more.
- Five-year warranty on transformers, stabilizers and main rectifiers; three years on generators, PC boards and drive systems; and one year on guns (MIG, plasma and TIG torches).
Certified by Canadian Standards Association to both the Canadian and U.S. Standards.

### Specifications (Subject to change without notice.)

<table>
<thead>
<tr>
<th>Input Power</th>
<th>Rated Output</th>
<th>Amps Input at Rated Output, 50/60 Hz</th>
<th>Max. Open Circuit Voltage</th>
<th>Plasma Gas Flow/Pressure</th>
<th>Dimensions (H x W x D)</th>
<th>Net Weight with Torch</th>
</tr>
</thead>
<tbody>
<tr>
<td>120 V (15 A)</td>
<td>20 A at 88 VDC, 60% duty cycle</td>
<td>18.3</td>
<td>400 VDC</td>
<td>5.0 cfm (142 L/Min) at 90–120 psi (621–827 kPA) recommended</td>
<td>9 x 5.5 x 13.25 in. (229 x 140 x 337 mm)</td>
<td>19 lb. (8.6 kg)</td>
</tr>
<tr>
<td>120 V (20 A)</td>
<td>27 A at 92 VDC, 35% duty cycle</td>
<td>26.1</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
<tr>
<td>240 V</td>
<td>30 A at 92 VDC, 40% duty cycle</td>
<td>14.7</td>
<td></td>
<td></td>
<td></td>
<td></td>
</tr>
</tbody>
</table>

### Mild Steel Cutting Capacity (Thickness to scale.)

**Cutting at 20 Amps** (120 V, 15 A service with 5-15P MVP)

<table>
<thead>
<tr>
<th>Thickness</th>
<th>Approximate Travel Speeds*</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/8 in. (3.2 mm) at 50 IPM</td>
<td>158 IPM (4,014 mm/min.)</td>
</tr>
<tr>
<td>1/4 in. (6.4 mm) at 17 IPM</td>
<td>50 IPM (1,260 mm/min.)</td>
</tr>
</tbody>
</table>

Note: Recommended maximum piercing capacity for hand-held applications is 1/8 in. (3.2 mm). Maximum sever cut of 3/8 in. (9.5 mm).

For aluminum and other metals with high thermal conductivity, cutting capabilities will be derated as much as 30%.

**Cutting at 30 Amps** (240 V service with 6-50P MVP)

<table>
<thead>
<tr>
<th>Thickness</th>
<th>Approximate Travel Speeds*</th>
</tr>
</thead>
<tbody>
<tr>
<td>1/4 in. (6.4 mm) at 36 ipm</td>
<td>240+ IPM (6,096+ mm/min.)</td>
</tr>
<tr>
<td>3/8 in. (9.5 mm) at 18 ipm</td>
<td>100 IPM (2,540 mm/min.)</td>
</tr>
</tbody>
</table>

Note: Recommended maximum piercing capacity for hand-held applications is 3/16 in. (4.8 mm). Maximum sever cut of 5/8 in. (15.9 mm).

For aluminum and other metals with high thermal conductivity, cutting capabilities will be derated as much as 30%.

**Rated cut capacity is based on traveling approximately 15 inches per minute to achieve a steady, precise cut. This is the key rating that should meet or exceed your typical cutting thickness requirements.**

### Torch Consumables (Order from Hobart Service Parts.)

- Drag Shield: 770799
- Tip (2): 770796
- Electrode (2): 770791
- Retaining Cup
- Swirl Ring
- O-Ring
- Deflector

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*Travel speeds are approximately 80% of maximum.*
The following accessories are available through Miller/Hobart Service Distributors.

**XT30R Replacement Torch** 284514
12 ft. (3.7 m)

**Protective Cover** 770966
Weather-resistant nylon resists stains and mildew while protecting the finish of your plasma cutter.

**Shade 5.0 Safety Glasses**
- 770726 Mirrored lens with black frame
- 770727 Black lens with orange frame
Stylish protection that meets ANSI Z87.1 standards.

**Plasma Standoff Roller Guide** 253054
Helps maintain recommended standoff distance to maximize cutting performance and improve tip life.

**Plasma Circle-Cutting Guide** 253055
Cut straight lines or circles up to 12-inch diameter with ease.

**Suction/Magnetic Pivot Base** 195979
Add this to your cutting guide for convenient attachment to all flat surfaces. The extended arm accommodates holes up to 30-inch diameter.

**240-Volt Extension Cord** 770644
20-foot (6.1 m) NEMA 6-50P to NEMA 6-50R heavy-duty extension cord. 8-gauge cord has lighted ends that show power is on and a molded integrated strain relief.

**XT30 Consumable Kit**
- 253520 Consumable kit includes 5 electrodes, 5 tips, 1 swirl ring, 1 retaining cup, 1 o-ring and silicone grease.

In-Line Air Filter Kit 228926
Mounts to the back of the AirForce® 27i and 40i. Includes male and female 1/4-inch NPT quick disconnect fittings and hose for easy on/off connection. The replaceable filter element filters to .85 microns.

In-Line Air Filter Replacement Element 228928
Includes one replacement filter for in-line filter kit 228926.

**MVP™ Adapter Plugs**
- 219259 For power cable 5-20P (115 V/20 A). Optional.
- 219258 For power cable 6-50P (230 V/50 A). Included with machine.

**X-CASE™** 300184
Sturdy case provides ultimate protection for transport and storage. Also features convenient top carrying handle and side recessed hand grips. Store the plasma cutter, accessories and gear in this generous case to be ready to go at any time. Dimensions (H x W x D): 13 x 10.5 x 30.625 in. (330 x 267 x 778 mm).