

# Spectrum® 1000

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**Air Plasma  
Cutting and Gouging** 

## Quick Specs

### Industrial Applications

Heavy Fabrication  
Manufacturing

### Processes

Air Plasma Cutting  
and Gouging

### Rated Output

100% Duty Cycle (see page 2)  
3-Phase: 80 A at 150 VDC,  
60% Duty Cycle (230–575 V)  
50% Duty Cycle (208 V)  
1-Phase: 80 A at 150 VDC,  
40% Duty Cycle (230 V)  
30% Duty Cycle (208 V)

### Cutting Capability

Rated: 1 in (25.4 mm)  
Sever: 1-1/2 in (38.1 mm)

### Weight

With torch: 92 lb (41.7 kg)

### Required Input Pressure/Flow

7.8 SCFM (222 L/min) at  
90 PSI MIN (621 kPa)  
120 PSI MAX (828 kPa)

## The Power of Blue.®

**Auto-Line™** automatically connects unit to any primary input voltage from 208 to 575 volts single- or three-phase, 50 or 60 Hz.

**LVC™ line voltage compensation** provides peak performance power under variable input voltage conditions (176–630 V) for steady cuts and cleaner ending cuts.

**Auto-Retire™ Technology** provides ultimate customer convenience by automatically controlling the pilot arc when cutting expanded metal or multiple pieces of metal. The pilot arc will switch in and out as fast as needed when cutting expanded metal and provides maximum power for cutting thicker metal—all automatically! No need for manual re-triggering which reduces user hand fatigue.

**Consumables storage compartment** provides convenient access to consumables and parts.

**Wind Tunnel Technology™** prevents abrasive dust and particles from damaging internal components. Also, the **Fan-On-Demand™** cooling system only operates when needed, reducing the amount of airborne dust/dirt pulled through the unit.

**Superior gouging capability** provides an extremely long gouging arc for those hard-to-reach, heavy applications. Plasma arc gouging produces less dust, smoke and other harmful environmental hazards compared to carbon arc gouging.

**CNC/Robotic machine interface** is standard on all units, allowing automated control and rapid changeover to mechanized operation.

**Portable** powerful package that cuts up to 1-1/2 in (38 mm) but weighs only 92 lb (41.7 kg).



**Starts without high-frequency** so it will not interfere with or damage controls or computers.

**TRUE BLUE®**  
3YR WARRANTY

Power source is warranted for 3 years, parts and labor.  
ICE torch is warranted for 1 year, parts and labor.



Spectrum Plasma Cutters offer reliability and performance that others can't match! See more at [MillerWelds.com/reliable](http://MillerWelds.com/reliable)

### Comes Complete With:

- ICE-80T hand-held torch with 25 ft (7.6 m) or 50 ft (15.2 m) cable, or ICE-80TM machine-held torch with 25 ft (7.6 m) or 50 ft (15.2 m) cable. Extra consumables supplied
- Heavy-duty work clamp with 25 ft (7.6 m) or 50 ft (15.2 m) cable
- 10 ft (3 m) power cord
- CNC/Robotic remote cable kit (included w/machine-held torch pkg)

**Postflow cooling circuit** cools the consumables and torch with postflow air after you release the trigger. This feature extends life of torch and consumables.



**Patented Ultra-Quick Connect™ torch** offers the fastest plasma torch connection and removal in the industry.

Miller's rugged **ICE-80T torch** provides an increased rated cut of 1 in, longer consumable life, and a torch cable that is more resistant to burns and cuts.

The ICE-80T torch includes a **drag shield** that attaches to the cup and holds the tip 1/8 in (3.2 mm) off the workpiece. This permits the operator to drag the torch on the workpiece while cutting at full output, which increases operator comfort and makes template cutting easier.

The ICE-80T/TM utilizes the same consumables as the ICE-80CX.

MADE IN USA  
APPLETON, WI



### Miller Electric Mfg. Co.

An Illinois Tool Works Company  
1635 West Spencer Street  
Appleton, WI 54914 USA

### International Headquarters

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### Web Site

[www.MillerWelds.com](http://www.MillerWelds.com)



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# Specifications (Subject to change without notice.)

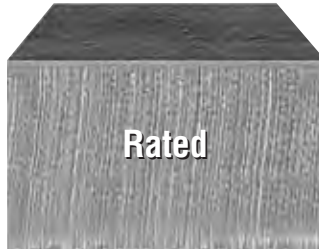


Input Power	Rated Output	Duty Cycle at Input Voltage	Amps Input at Rated Output, 50/60 Hz								Plasma Gas	Dimensions	Net Weight with Torch
			208 V	230 V	400 V	460 V	575 V	KVA	KW				
3-phase	80 A at 150 VDC	60% (230–575 V) 50% (208 V)	41	36	21	18	14	14.6	13.7	Air or Nitrogen only	H: 17 in (432 mm) W: 12-1/2 in (318 mm) D: 20-1/2 in (521 mm)	Net: 92 lb (41.7 kg)	
1-phase	80 A at 150 VDC	40% (230 V) 30% (208 V)	69	62	—	—	—	14.3	14.4				

# Mild Steel Cutting Capability (Thickness to scale.)



1/2 in (12.7 mm) at 40 IPM



1 in (25.4 mm) at 10 IPM

Thickness	Approximate Travel Speeds*
3/16 in (4.8 mm)	140 IPM (3556 mm/min)
1/4 in (6.4 mm)	105 IPM (2667 mm/min)
3/8 in (9.5 mm)	61 IPM (1549 mm/min)
1/2 in (12.7 mm)	40 IPM (1016 mm/min)
5/8 in (15.9 mm)	26 IPM (660 mm/min)
3/4 in (19.0 mm)	20 IPM (508 mm/min)
1 in (25.4 mm)	10 IPM (254 mm/min)

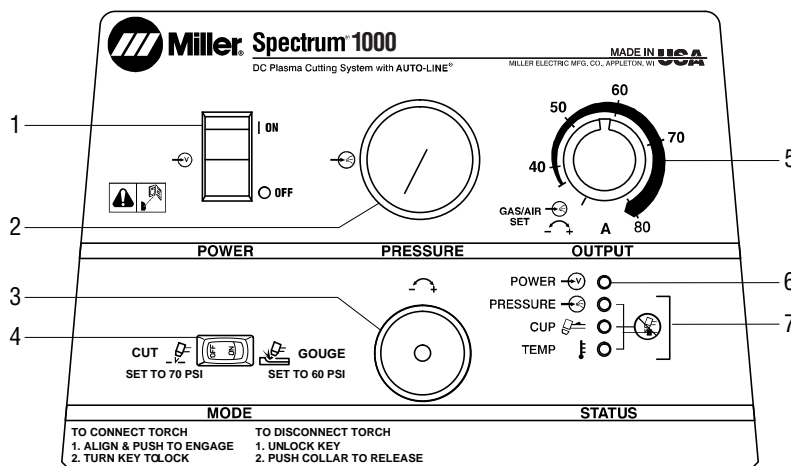
Note: Recommended maximum piercing capacity for hand-held applications is 1/2 in (12.7 mm).  
Maximum Sever cut of 1-1/2 in (38.1 mm) at 4 IPM.

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

\* Travel speeds are approximately 80% of maximum.

Rated cut capacity is based on traveling approximately 10 inches per minute to achieve a steady, precise cut. This is the key rating that should meet or exceed your typical cutting thickness requirements.

# Control Panel



# Operating Data

Output for 100% Duty Cycle at 40° C (104° F)

Input	Output
208 V, 1-Phase	44 A
230 V, 1-Phase	50 A
400–575 V, 1-Phase	60 A
208 V, 3-Phase	55 A
230–575 V, 3-Phase	60 A

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# Genuine Miller Accessories



## No. 30A Economy Cart with Cord Wrap #195 093

This economical running gear provides mobility with an angle for easy front panel access and extra storage space.



## No. 50HD Cart #300 026

This heavy-duty cart accommodates the Spectrum 125C, 375, 625, 2050, and 1000.



## Protective Cover #195 424

Water-resistant, odor-free cover protects your machine's finish.



## RTI Filter and Bracket #195 425

Dryer will remove water, dirt and oil as small as one micron with 99.9% efficiency. Can be mounted on plasma cutter or on wall. Install as close as possible to point of air consumption.

## Motor Guard Air Filter #042 306

The filter is equipped with a 1/4 in NPT port to match the fittings on most plasma systems; it has a rated airflow of over 45 SCFM.

## Miller Service Parts Accessories

*The following accessories must be ordered from Miller Service Parts.*

**RTI Replacement Filter Element #212 771**  
Replacement filter for #195 425.

**Motor Guard Replacement Filter Element #042 312**  
Carton of four filters for use with motor guard air filter #042 306.

**CNC/Robotic Remote Cable Kit #195 432** with 25 ft (7.6 m) torch  
**#300 027** with 50 ft (15.2 m) torch  
Consists of an ICE-80TM mechanized torch and cable assemblies for CNC/Robotic interface for remote start and okay-to-move functions as well as voltage-sensing. Includes remote pendant control with cable.

**Remote Pendant Control #195 513**  
Provides remote start and stop of the arc for the ICE-80TM machine-held torch.



**ICE-80T Consumable Kit #222 942**  
Consumable kit includes 6 standard electrodes, 3 tips (80 A), 2 ext tips (80 A), 1 gouge tip, 1 gouge shield, 1 retaining cup, 1 drag shield and 3 o-rings.



**Plasma Circle-Cutting Guide #195 981**  
Cut straight lines or circles up to 12 inch diameter with ease.



**Suction/Magnetic Pivot Base #195 979**  
Add this to your cutting guide for convenient attachment to all flat surfaces. The extended arm accommodates holes up to 30" diameter.



**Torch Cable Covers**  
**#231 867** 25 ft (7.6 m)  
**#231 868** 50 ft (15.2 m)



**MIG Gloves**  
**#227 821** Small  
**#227 822** Medium  
**#227 823** Large  
**#227 824** X-Large  
*For medium-duty MIG welding and metalworking tasks.*

Combination of durable top grain cowhide palm and abrasion-resistant pig split back sewn with Kevlar® thread.



**Metalworker Gloves**  
**#227 817** Small  
**#227 818** Medium  
**#227 819** Large  
**#227 820** X-Large  
*Designed for the daily demands of the*

*metalworker and material handler. Padded, goatskin palm with textured G-Grip™ patch for excellent grip. Neoprene wrist with Velcro® closure for improved fit. NOT intended for use while welding.*

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# Replacement Torch and Consumables



**ICE-80T Hand-Held Torch**  
**#195 223** 25 ft (7.6 m)  
**#195 225** 50 ft (15.2 m)



The **ICE-80TM Machine-Held Torch** is also available for the Spectrum 1000.  
**#195 221** 25 ft (7.6 m)  
**#223 535** 50 ft (15.2 m)

*Note: Call Miller Service Parts for info.*

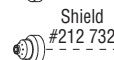
**#907 162-01-3** with 25 ft (7.6 m) torch  
**#907 162-01-5** with 50 ft (15.2 m) torch  
 Packages include Spectrum 1000 power source, ICE-80TM machine-held torch, CNC/Robotic remote cable kit, and remote pendant control.

**Standard Cutting  
80 Amp**



Apply silicone grease (#169 231) before installing.

**Machine Cutting**



**60 Amp Cutting**



**40 Amp Cutting**



**Extended Cutting  
80 Amp**



**Extended Cutting  
60 Amp**



**Extended Cutting  
40 Amp**



**Gouging  
80 Amp**



**Gouging  
60 Amp**



## Ordering Information

Power Source and Options	Stock No.	Description	Qty.	Price
<b>Spectrum® 1000</b> Single-/three-phase, 208–575 VAC, 50/60 Hz, Auto-Line™ <i>Note: Each Spectrum unit includes extra consumables (1 standard electrode, 1 standard tip, 1 gouge tip, 1 gouge shield, 1 extended tip, and 1 deflector).</i>	<b>#907 162-01-1*</b> <b>#907 162-01-2*</b> <b>#907 162-01-3*</b> <b>#907 162-01-5*</b>	With 25 ft (7.6 m) ICE-80T hand-held torch With 50 ft (15.2 m) ICE-80T hand-held torch With 25 ft (7.6 m) ICE-80TM machine-held torch With 50 ft (15.2 m) ICE-80TM machine-held torch <i>(Machine torch package includes CNC/Robotic remote cable kit and remote pendant)</i>		
<b>Replacement Torches and Consumables</b>				
ICE-80T Hand-Held Torch	<b>#195 223</b> <b>#195 225</b>	25 ft (7.6 m). <i>Order from Miller Service Parts</i> 50 ft (15.2 m). <i>Order from Miller Service Parts</i>		
ICE-80TM Machine-Held Torch	<b>#195 221</b> <b>#223 535</b>	25 ft (7.6 m). <i>Order from Miller Service Parts</i> 50 ft (15.2 m). <i>Order from Miller Service Parts</i>		
Consumables		See above. <i>Order from Miller Service Parts</i>		
<b>Accessories</b>				
No. 30A Economy Cart	<b>#195 093</b>			
No. 50HD Cart	<b>#300 026</b>			
Protective Cover	<b>#195 424</b>			
RTI Filter and Bracket	<b>#195 425</b>			
RTI Filter Replacement Element	<b>#212 771</b>	For RTI filter #195 425. <i>Order from Miller Service Parts</i>		
ICE-80TM torch with CNC/Robotic Remote Cable Kit <i>(Includes ICE-80TM torch, cables and remote pendant control)</i>	<b>#195 432</b> <b>#300 027</b>	25 ft (7.6 m). <i>Order from Miller Service Parts</i> 50 ft (15.2 m). <i>Order from Miller Service Parts</i>		
Remote Pendant Control	<b>#195 513</b>	<i>Order from Miller Service Parts</i>		
ICE-80T Consumable Kit	<b>#222 942</b>	See page 3 for contents. <i>Order from Miller Service Parts</i>		
Plasma Circle-Cutting Guide	<b>#195 981</b>	<i>Order from Miller Service Parts</i>		
Suction/Magnetic Pivot Base	<b>#195 979</b>	<i>Order from Miller Service Parts</i>		
Torch Cable Covers		See page 3. <i>Order from Miller Service Parts</i>		

Date:

Total Quoted Price:

\* Certified to both the Canadian and U.S. Standards for welding and plasma cutting equipment.

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