

### CUTTING TIP DATA CHART

**IMPORTANT:** Use cutting tips with proper type seats for each type torch and fuel gas. (See CHART below.) Use proper tips for fuel gases or acetylene. See manufacturer's chart for proper tip selection. Use proper tip size, pressures and flame size to avoid backfire and flashback.

Metal Thickness	TORCH & TIP TYPES			Oxygen PSIG	Acet./Fuel gas PSIG	Speed IPM
	V-Style Type Seat-2 Taper Tube Mix	A-Style Type Seat-3 Taper Tip Mix	H-Style Type Seat-2 Flat Head Mix			
	1-101, 3-101 5-101, GPM-N-P, 1-303 MP	144 164	Use upper PSIG 6290			
1/8"	000	00	000	20-25	5	28-32
1/4"	00	0	00	20-25	5	25-30
3/8"	0	1	00	25-30	5	24-28
1/2"	0	1	0	30-35	5	20-24
3/4"	1	2	1	30-40	8	17-20
1"	2	2	1	35-50	8	15-20
1 - 1/2"	2	3	2	40-50	8	12-17
2"	3	3	3	40-55	10	12-15
2 - 1/2"	3	4	3	45-55	10	10-13
3"	4	5	4	45-60	10	9-12
4"	5	5	4	45-60	12	8-11
5"	5	6	4	50-70	12	7-9
6"	6	6	5	50-75	12	6-8
8"	6	7	5	55-80	15	5-6
10"	7	7	6	55-85	15	4-5
12"	8	8	6	55-95	15	3-5

#### INFORMATION:

##### CUTTING OXYGEN TIP AND TORCH GUIDE

**Type 101 etc.**, V-style type tip, tube mix, use lower PSIG range (oxygen)\*.  
**Type 144 etc.**, A-style type tip, tip mix, use mid PSIG range (oxygen).  
**Type 6290 etc.**, H-style type tip, head mix, use upper PSIG range (oxygen).

**NOTE:** Data is based on 25ft. of 1/4" hose up to size 4 tip (3/8" hose may be required for size 5 and larger); increase pressures approximate 3 PSIG per 25 ft. of hose added and increase working pressure 2-4 PSIG for check valves and flashback arrestors. Acetylene delivery pressure should not exceed 15 PSIG under flow conditions.

\* **NOTE:** Series 62 & 67 machine torches use upper psig range for type 101 tips etc., same as 6290 tips

#### GUIDE FOR SAFE EFFECTIVE USE OF EQUIPMENT

⚠ **WARNING: DO NOT OPERATE EQUIPMENT UNLESS THE USER IS FULLY TRAINED IN THE SAFE USE AND OPERATION OF OXYFUEL CUTTING AND WELDING EQUIPMENT.** Equipment should not be operated if the user is under the influence of any controlled substances, including but not limited to alcohol or drugs. The safe and effective use of equipment depends on the technician fully understanding and carefully following practical time-tested safety and operating instructions. These instructions will help to prevent and avoid unnecessary painful injuries, as well as possible costly property damages or losses due to improper equipment use. **Read instruction sheets** supplied with equipment for complete information **before using equipment.** **SAFETY PRECAUTIONS** to take BEFORE STARTING WORK: Proper personal protection - Adequate, proper ventilation - Fire prevention protection, and Prevention measures (Equipment must be kept CLEAN and OIL FREE)

⚠ **WARNING: DO NOT LIGHT OR USE A TORCH IN A GAS OR VAPOR LEAK AREA. NEVER USE A TORCH ON ANY KIND OF CONTAINER OR PIPE UNTIL IT IS PROPERLY CLEANED, PURGED, AND VENTED COMPLETELY OF ALL FLAMMABLE GASES AND VAPORS WHICH CAN EXPLODE WHEN IGNITED.**