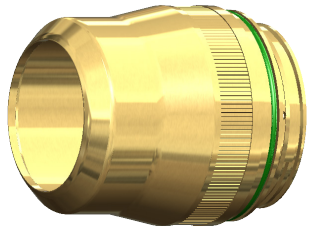


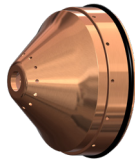
400A MILD STEEL BEVEL

O₂ PLASMA AIR SHIELD

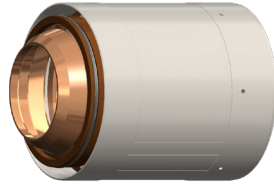
Plasma gas inlet:
120psi/8.4bar
Shield gas inlet:
120psi/8.4bar



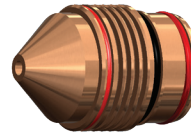
Shield Cap
90-4000AT



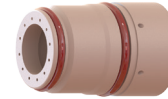
Shield
90-4002AT



Nozzle Retaining Cap
90-4001



Nozzle
90-0632



Swirl Ring
220631*



Electrode
90-0629



Water Tube
90-0571

Note: Bevel angle range is 0° to 45°

ENGLISH

Thickness Inches	Prewlow		Cutflow		Minimum Clearance Inches	Torch-to-Work Inches	Cutting Speed Inches/Minute	Initial Pierce Height		Pierce Delay Sec
	O ₂ Plasma	Air Shield	O ₂ Plasma	Air Shield				In	Factor	
1/2	24	50	60	50	0.08	0.14 - 0.37	170	0.28	200	0.4
5/8							150			0.5
3/4							115			0.6
7/8						0.15 - 0.37	100	0.30	0.8	
1							85	0.32	0.9	
1-1/4						0.18 - 0.37	65	0.36	1.2	
1-1/2							48	0.45	250	1.6
1-3/4						0.21 - 0.37	40	0.75	360	2.5
2							30	0.75	360	5.5
2-1/4						0.25 - 0.37	25	Edge start		
2-1/2	20									
3	10									

† American Torch Tip Company is in no way affiliated with the above-named manufacturer(s). References to the above-named machines, torches and numbers are for your convenience only. American Torch Tip is not necessarily authorized by the above-named manufacturer(s) to provide replacement parts. Most parts advertised for sale are made by, or for, American Torch Tip Company and other parts, as indicated, are original parts manufactured by the above-named OEM and are simply being resold by American Torch Tip Company. Part numbers followed by an * are manufactured by the respective OEM.

METRIC

Thickness mm	Prewlow		Cutflow		Minimum Clearance mm	Torch-to-Work mm	Cutting Speed mm/Minute	Initial Pierce Height		Pierce Delay Sec			
	O ₂ Plasma	Air Shield	O ₂ Plasma	Air Shield				mm	Factor				
12	24	50	60	50	2.0	3.6 - 9.4	4430	7.2	200	0.4			
15							3950			0.5			
20							2805			0.7			
22						3.8 - 9.4	2540	7.6		0.8			
25						4.0 - 9.4	2210	8.0		0.9			
30						4.6 - 9.4	1790	9.2		1.1			
40						5.3 - 9.4	795	19.1	360	1160	11.5	250	1.9
50										580	Edge start	5.2	
60										380			
70										180			
80	7.9 - 9.4	180											

MARKING

Select Gases		Set Prewlow		Set Cutflow		Amperage	Torch-to-Work		Marking Speed		Arc Voltage
						Amps	mm	Inches	mm/Minute	Inches/Minutes	Volts
N ₂	N ₂	10	10	10	10	22	2.5	0.10	1270	50	123
Air	Air	20	10	30	10	25	3.0	0.12	1270	50	55

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