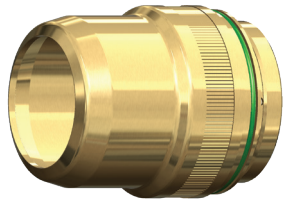
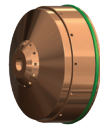


275A MILD STEEL

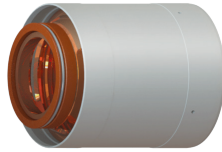
O₂ PLASMA AIR SHIELD



Shield Cap
90-4000



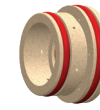
Shield
90-2602



Nozzle Retaining Cap
90-2601



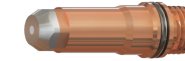
Nozzle
90-0439



Swirl Ring
90-0436



Electrode
90-0435



CleanCut™ Electrode
90-0668



Water Tube
90-0340

ENGLISH

Thickness	Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed	Cutting Height	Pierce Height	Pierce Time	Kerf Width
inches	psi	psi	psi	psi	volts	ipm	inches	inches	msec	inches
1/2	20	81	70	79	139	125	.140	.300	500	3.0
5/8						105	.135	.325	600	3.2
3/4					138	.120	.350	800	3.4	
1					144	.160	.400	1000	3.7	
1.25					150	.175	.500	1500	4.1	
1.50					163	.235	.750	2500	4.5	
1.75 **					170	.290	.350	1500	4.9	
2.00 **					180	.350			5.3	
1.25 **					185	.375			.375	5.6
2.50 **					190	.385			.385	6.0

† 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.

For Kaliburn Spirit system
90-275 L & R

METRIC

Thickness	Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed	Cutting Height	Pierce Height	Pierce Time	Kerf Width
mm	psi	psi	psi	psi	volts	mm/m	mm	mm	msec	mm
12	20	81	70	79	139	3290	3.6	7.4	500	3.0
16					138	2650	3.3	8.3	800	3.2
20						2190	3.1	9.0	1000	3.4
25					143	1690	4.0	10.1		3.7
32					150	1120	4.4	12.8	1500	4.1
38					162	645	5.9	19.1	2500	4.5
45 **					170	495	7.5	8.9	1500	4.9
50 **					178	395	8.7			5.3
55 **					183	345	9.2			5.6
60 **					187	285	9.6			6.0

MARKING

Type of Gas		Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed		Marking Height		Initial Height		Pierce Time
Plasma Shield		psi	psi	psi	psi	volts	ipm		inches		inches		msec
Nitrogen	Nitrogen	NA	25	25	NA	108	250	6350	.100	2.5	.100	2.5	0
Argon	Air	NA	50	25	NA	54	100	2540	.120	3.0	.100	2.5	0

WARNING: Do not connect H17 (combustible gas) to the gas inputs (Pre/Postflow, Plasma, or Shield) at the same time as Oxygen or Air.

Use an arc transfer height (ignition height) of .150" (3.8 mm) for cutting and .100" (2.5 mm) for marking.

† 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 are manufactured by the respective OEM.

**For Kaliburn Spirit system
90-275 L & R**