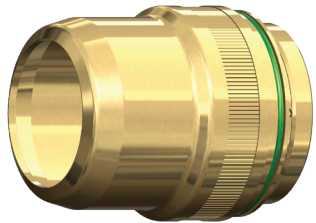


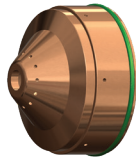
400A MILD STEEL BEVEL

O₂ PLASMA AIR SHIELD

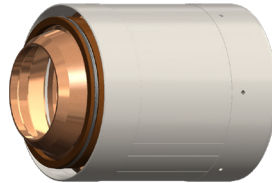
Plasma gas inlet:
120psi/8.4bar
Shield gas inlet:
120psi/8.4bar



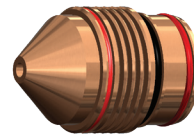
Shield Cap
90-4000



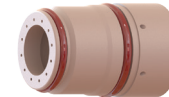
Shield
90-4002



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 | Prewlow | | Cutflow | | Minimum Clearance | Torch-to-Work | Cutting Speed | Initial Pierce Height | | Pierce Delay |
|-----------|---------|-----------------------|------------|-----------------------|-------------------|---------------|---------------|-----------------------|--------|--------------|
| | Inches | O ₂ Plasma | Air Shield | O ₂ Plasma | | | | Air Shield | Inches | |
| 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 | | | | | | 0.16 - 0.37 | 85 | 0.32 | | 0.9 |
| 1-1/4 | | | | | | 0.18 - 0.37 | 65 | 0.36 | | 1.2 |
| 1-1/2 | | | | | | 0.18 - 0.37 | 48 | 0.45 | 250 | 1.6 |
| 1-3/4 | | | | | | | 40 | | | 2.5 |
| 2 | | | | | | 0.21 - 0.37 | 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 | Prewlow | | Cutflow | | Minimum Clearance | Torch-to-Work | Cutting Speed | Initial Pierce Height | | Pierce Delay |
|-----------|-----------------------|------------|-----------------------|------------|-------------------|---------------|---------------|-----------------------|-----|--------------|
| | O ₂ Plasma | Air Shield | O ₂ Plasma | Air Shield | | | | mm | mm | |
| 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 | | | | | | | 2210 | 8.0 | 0.9 | |
| 30 | | | | | | | 1790 | 9.2 | 1.1 | |
| 40 | | | | | | 4.6 - 9.4 | 1160 | 11.5 | 250 | 1.9 |
| 50 | | | | | | | 795 | 19.1 | 360 | 5.2 |
| 60 | | | | | | 6.4 - 9.4 | 580 | Edge start | | |
| 70 | | | | | | | 380 | | | |
| 80 | | | | | | | 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 |

† 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.