

## GPP

Metal Thickness	Tip Size	Cutting Oxygen (PSIG) <sup>***</sup>	Preheat Oxygen (PSIG) <sup>*</sup>	Preheat Fuel Gas (PSIG)	Speed I.P.M.	Kerf width
1/8"	000	20/25	For 3-Hose Machine Torches Only  See Table On Reverse Side	2/5	24/28	.04
1/4"	00	20/25		2/5	21/25	.05
3/8"	0	25/30		3/5	20/24	.06
1/2"	0	25/35		3/5	18/22	.06
3/4"	1	30/35		3/6	15/20	.08
1"	2	35/40		3/6	14/18	.09
1 1/2"	2	40/45		4/8	12/16	.09
2"	3	40/45		4/8	10/14	.10
2 1/2"	3	45/50		5/9	9/12	.10
3"	4	40/50		6/9	8/11	.12
4"	5	45/55		6/9	7/10	.14
5"	5	50/55		6/10	6/9	.14
6"	6 <sup>**</sup>	45/55		6/10	5/7	.17
8"	6 <sup>**</sup>	55/65		8/12	4/6	.18
10"	7 <sup>**</sup>	55/65		8/12	3/5	.34
12"	8 <sup>**</sup>	60/70		10/14	3/4	.41
15"	10 <sup>**</sup>	50/70		10/16	2/4	--
18"	12 <sup>**</sup>	45/65		--	2/3	--



\* Applicable for 3-hose machine cutting torches only. With a 2-hose cutting torch, preheat pressure is set by the cutting oxygen.  
 \*\* For best results use appropriate capacity torches and 3/8" hose when using tip size 6 or larger. Torches with flashback arrestors require up to 25% more pressure as tip size increases (15 PSI maximum acetylene pressure). \*\*\* All pressures are measured at the regulator using a 25' X 3/8" hose for tip size 6 and larger.

### MTHP High speed machine cutting

Metal Thickness	Tip Size	Cutting Oxygen (PSIG) <sup>***</sup>	Preheat Oxygen (PSIG) <sup>*</sup>	Preheat Fuel Gas (PSIG)	Speed I.P.M.	Kerf width
1/4"	00	85/95	See Below	See Below	23/30	.05
3/8"	00				22/29	.05
1/2"	0				20/28	.06
3/4"	0				18/26	.06
1"	1				17/24	.07
1 1/4"	1				16/20	.07
1 1/2"	1				12/16	.07
2"	2				11/15	.09
2 1/2"	2				10/13	.09
3"	2				9/11	.09
4"	3				7/10	.11
5"	3				6/8	.11
6"	3				5/7	.11
7"	4				5/6	.14
8"	4				4/6	.14
9"	5				4/5	.18
10"	5				3/5	.18



NOTE: The above data applies to all torches with the following exceptions:

Torch Series	Preheat Oxygen	Preheat Fuel
MT200N Series	N/A	8 oz. – up
MT300N Series	10-25 PSIG	8 oz. – up

NOTE: These speeds and pressure settings apply only to mild steel in good condition. Torches with flashback arrestors require up to 25% more pressure as tip size increases.

**CAUTION: High gas withdrawal rates may require cylinder manifolding. Consult your gas supplier.**

† 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.