

6290A STYLES General purpose medium preheat 1-piece

Metal Thickness Inch	Tip Size	Oxygen (PSIG)	Cutting Acetyline (PSIG)	Drill Size
light gauge to 3/16"	000	15-20	5-15	68
3/16-3/8"	00	20-25	5-15	64
3/8-5/8"	0	35-40	5-15	60
5/8-1"	1	35-40	5-15	56
1-2"	2	40-45	5-15	52*
2-3"	3	45-50	5-15	48
3-6"	4	50-75	10-15	42

*To provide required gas flow, use 3/8" ID hose for size 4 and larger.



6290NX STYLES Hand & machine cutting. General purpose straight. Line clean surface cutting 3/16-12"

Metal Thickness Inch	Tip Size	Oxygen (PSIG)	Fuel Gas (PSIG)	Drill Size
light gauge to 3/16"	000N & 000NX	15-30	5-15	68
3/16-3/8"	00NX	20-30	5-15	64
3/8-5/8"	0NX	30-40	5-15	60
5/8-1"	1NX	35-50	5-15	56
1-2"	2NX	40-55	5-15	52*
2-3"	3NX	45-60	5-15	48
3-6"	4NX	50-75	5-15	42
6-8"	5NX	65-80	5-15	35
8-12"	6NX	70-90	5-15	30



6290NH STYLES Machine cutting for heavy cutting of plate

Metal Thickness Inch	Tip Size	Oxygen (PSIG)	Fuel Gas (PSIG)	Drill Size
9-10	5NH*	60	.04-2	.25
10-11	6NH*	60	.04-2	.25
11-12	7NH*	60	.04-2	.25
12-15	8NH*	60	.04-2	.30



6290NFF STYLES Hand & machine cutting. General cutting general purpose scrap, heavily rusted, scaled or painted metal 5/8-12" ideal for bevel

Metal Thickness Inch	Tip Size	Oxygen (PSIG)	Fuel Gas (PSIG)	Drill Size
to 5/8"	1NFF	20-35	.04-2	.56
5/8-2"	2NFF	30-55	.04-2	.53
2-4"	3NFF	45-65	.04-2	.47
4-7"	4NFF	55-75	.04-2	.42
7-10"	5NFF	60-80	.04-2	.35
10-12"	6NFF	80-90	.04-2	.31



6290-VVC, VVCU & NH CUTTING TIP STYLES

VVCU & NH Cutting Tips are unplated

Metal Thickness Inch	Tip Size	Cutting Speed in/min	Oxygen (PSIG)	Preheat Oxygen Pressure high/low	Fuel Gas (PSIG)	Width Kerf inches	Drill Size
3/16	5/0 VVC & VVCU	20-24	40	15/8	4 OZ-2 PSI	.05	#75
1/4	4/0 VVC & VVCU	20-22	50	15/10		.06	#68
3/8	3/0 VVC & VVCU	18-22	75	35/10		.07	#64
1/2	2/0 VVC & VVCU	18-20	75	35/10		.07	#62
3/4	0 VVC & VVCU	15-18	90	35/10		.08	#60
1 1/4	01/2 VVC & VVCU	14-16	100	35/12		.08	#58
2	1 VVC & VVCU	13-15	100	35/12		.09	#56
3	1 1/2 VVC & VVCU	9-12	100	35/12		.11	#54
4	2 VVC & VVCU	7-9	100	35/12		.12	#53
5	2 1/2 VVC & VVCU	6-8	100	35/12		.13	#51
6	3 VVC & VVCU	5-7	100	40/12		.14	#49
8	4 VVC & VVCU	5-7	100	40/12		.16	#45
9	5 VVC & VVCU	4-6	90	40/-		.20	#41
10	5 1/2 VVC & VVCU	4-6	90	40/-		.25	#39
10	5NH	4-5	60	40/-		.25	#35
11	6NH	4-5	60	40/-		.25	#31
12	7NH	4-5	60	40/-		.25	#29
15	8NH	3-4	60	40/-		.30	#25



Note:

Correct cutting oxygen pressure must be available at torch entry.

Oxygen preheat pressures are for three hose torches.

For two hose torches set same gas pressures for both high and low preheat