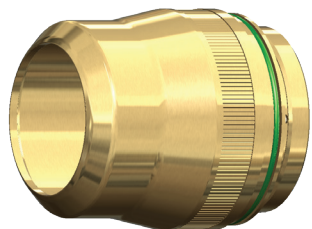


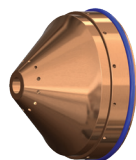
BEVEL

260A MILD STEEL

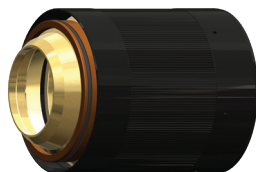
O₂ PLASMA Plasma gas inlet: 120psi/8.4bar
AIR SHIELD Shield gas inlet: 120psi/8.4bar



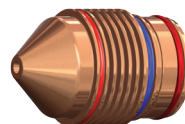
Shield Cap
97-0200



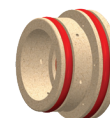
Shield
97-0491



Nozzle Retaining Cap
97-0365



Nozzle
97-0279



Swirl Ring
90-0436



Electrode
97-0276



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		
1/4	22	49	76	46	0.08	0.11 - 0.30	245	0.33	300	0.3	
5/16							215				
3/8							180				
1/2							145				
5/8			80	49		0.14 - 0.30	115	0.35	250	0.5	
3/4							90			0.6	
7/8							75			0.7	
1							65			0.8	
1-1/8			84	49			0.19 - 0.30	55	0.38	200	0.9
1-1/4								45			1.0
1-1/2 ^Δ								35			2.0
1-3/4								22			Edge start
2			15								
2-1/4			12								
2-1/2			8								

Δ See the alternate, thick metal piercing, cut chart if you have a problem with excessive slag on the shield or problems with the torch misfiring.

† 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.

90-7907

METRIC

Thickness mm	Prewflow		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		
6	22	49	76	46	2.0	2.8 - 7.6	6500	8.5	300	0.3	
8							5470				
10							4440				
12							3850				
15			80	49		3.6 - 7.6	3130	9.0	250	0.5	
20							2170			0.6	
22							1930			0.7	
25			84	49		4.8 - 7.6	1685	9.5	200	0.8	
28							1445			0.9	
32							1135			1.0	
38 ^Δ							895			2.0	
44							580			Edge start	
50							405				
58							290				
64							195				

MARKING

Select Gases		Set Prewflow		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	18	2.5	0.10	6350	250	135
Air	Air	30	20	30	20	24	3.0	0.12	2540	100	68

Δ See the alternate, thick metal piercing, cut chart if you have a problem with excessive slag on the shield or problems with the torch misfiring.

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