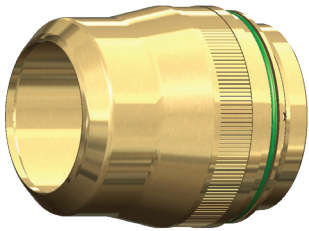


BEVEL 130A MILD STEEL

O₂ PLASMA AIR SHIELD

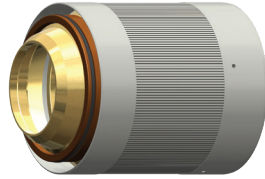
Plasma gas inlet:
120psi/8.4bar
Shield gas inlet:
120psi/8.4bar



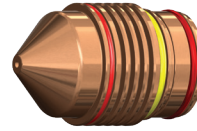
Shield Cap
97-0200



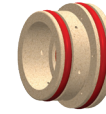
Shield
97-0255



Nozzle Retaining Cap
97-1365



Nozzle
97-0252



Swirl Ring
90-0179



Electrode
97-0249



Water Tube
90-0700

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		
0.135	15	23	84	21	0.08	0.10 - 0.34	240	0.20	200	0.1	
3/16						0.11 - 0.34	190			0.22	0.2
1/4						150	0.24			0.3	
5/16						0.12 - 0.34		132			
3/8						110					
1/2						0.13 - 0.34		80			
5/8						0.15 - 0.34		60			
3/4						45		0.30			1.0
1						0.16 - 0.34					
1-1/4 ^Δ						33					
1-1/2	10	Edge start									

Δ Suggestions for piercing 1-1/4 in (32mm) mild steel:

1. Turn preflow on during IHS
2. Use ohmic contact during IHS
3. Use pierce complete when piercing

† 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.

90-7910

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					
3	15	23	84	21	2.0	2.5 - 8.6	6505	5.0	200	0.1				
4						2.8 - 8.6	5550			5.6	0.2			
5							4795	6.0			0.3			
6						4035								
8						3.0 - 8.6	3360	6.6						
10							2680							
12				3.3 - 8.6		1665	7.6	1.0						
15														
20				3.8 - 8.6		1050	190	1.8						
25														
32 ^Δ				33		15	84	21		4.0 - 8.6	550	10.2	220	4.0
38											4.5 - 8.6	255	Edge start	

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	15	2.5	0.10	6350	250	130
Air	Air	50	10	50	10	15	3.0	0.12	2540	100	75

Δ Suggestions for piercing 32mm (1-1/4 in) mild steel:

1. Turn preflow on during IHS
2. Use ohmic contact during IHS
3. Use pierce complete when piercing

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