

## 106 STYLES Standard 2 piece tip with O ring.

### INCHES

Metal Thickness Inch	Tip Size	Cutting Speed in/min	Oxygen Cutting	Oxygen Preheat	Kerf Width	Fuel (PSIG)
1/8"	00	27	20	20	0.04	2.8
1/4"	0	24	30	30	0.05	2.8
3/8"	0	22	30	30	0.06	2.8
1/2"	1	21	40	40	0.07	2.8
3/4"	2	18	45	45	0.08	3.6
1"	2	17	45	45	0.08	3.6
1-1/2"	3	14	45	45	0.09	3.6
2"	4	12.5	45	45	0.11	4.3
2-1/2"	5	11	55	55	0.12	4.3
3"	5	10	55	55	0.12	4.3
4"	6	8	55	55	0.14	5.7
5"	6	7	55	55	0.14	5.7
6"	7	6	65	65	0.16	5.7
8"	7	5	65	65	0.17	5.7
10"	8	3	65	65	0.23	5.7
12"	8	2	65	65	0.27	5.7



## 106 STYLES

Standard 2 piece tip with O ring.

### INCHES

Metal Thickness mm	Tip Size	Pressure kg/cm <sup>2</sup> Oxygen	kg/cm <sup>2</sup> Fuel Gas	Consumption NI/hr			Cutting Speed mm/min
				Cutting Oxygen	Preheat Oxygen	Fuel Gas	
5	00	1.5	0.2	690	1180	310	660
5-10	0	2.0	0.2	1200	1180	310	660-550
10-15	1	2.5	0.2	2100	1180	310	550-490
15-30	2	3.0	0.25	3400	1370	360	490-400
30-40	3	3.0	0.25	4300	1370	360	400-350
40-50	4	3.5	0.3	6500	1860	490	350-320
50-100	5	4.0	0.3	11000	1860	490	320-200
100-150	6	4.0	0.3	15000	3040	800	200-150
150-250	7	4.5	0.4	22000	3720	980	150-80
250-300	8	4.5	0.4	28000	3720	980	80-45



## 106D7 STYLES High speed stainless steel 2 piece insert.

### INCHES

Metal Thickness Inch	Tip Size	Cutting Speed in/min	Oxygen Cutting	Oxygen Preheat	Kerf Width	Fuel (PSIG)
1/8"	00	31.5	100	20	0.03	2.8
1/4"	0	29	100	30	0.04	2.8
3/8"	0	27	100	30	0.05	2.8
1/2"	1	25	100	40	0.05	2.8
3/4"	2	22	100	45	0.06	3.6
1"	2	20	100	45	0.07	3.6
1-1/2"	3	18	100	45	0.08	3.6
2"	4	16	100	45	0.10	4.3
2-1/2"	5	14	100	55	0.11	4.3
3"	5	12.5	100	55	0.11	4.3
4"	6	10	100	55	0.13	5.7
5"	6	9	100	55	0.14	5.7
6"	7	7	100	65	0.14	5.7
8"	7	5.5	100	65	0.18	5.7
10"	8	4	100	65	0.20	5.7
12"	8	3	100	65	0.24	5.7



## 106D7 STYLES High speed stainless steel 2 piece insert.

### METRIC

Metal Thickness mm	Tip Size	Pressure kg/cm <sup>2</sup>		Consumption NI/hr			Cutting Speed mm/min
		Oxygen	Fuel Gas	Cutting Oxygen	Preheat Oxygen	Fuel Gas	
5	00	7.0	0.2	750	1180	310	750
5-10	0	7.0	0.2	1100	1180	310	750-680
10-15	1	7.0	0.2	2500	1180	310	680-600
15-30	2	7.0	0.25	3800	1370	360	600-500
30-40	3	7.0	0.25	5400	1370	360	500-450
40-50	4	7.0	0.3	7300	1860	490	450-400
50-100	5	7.0	0.3	10000	1860	490	400-260
100-150	6	7.0	0.3	14000	3040	800	260-180
150-250	7	7.0	0.4	22000	3720	980	180-100
250-300	8	7.0	0.4	35000	3720	980	100-70



## 106HC STYLES

### INCHES

Metal Thickness inch	Tip Size	Cutting Speed in/min	Oxygen		Kerf Width	Fuel (PSIG)
			Cutting	Preheat		
1/8"	00	27	20	20	0.04	2.8
1/4"	0	24	30	30	0.05	2.8
3/8"	0	22	30	30	0.06	2.8
1/2"	1	21	40	40	0.07	2.8
3/4"	2	18	45	45	0.08	3.6
1"	2	17	45	45	0.08	3.6
1-1/2"	3	14	45	45	0.09	3.6
2"	4	12.5	45	45	0.11	4.3
2-1/2"	5	11	55	55	0.12	4.3
3"	5	10	55	55	0.12	4.3
4"	6	8	55	55	0.14	5.7
5"	6	7	55	55	0.14	5.7
6"	7	6	65	65	0.16	5.7
8"	7	5	65	65	0.17	5.7
10"	8	3	65	65	0.23	5.7
12"	8	2	65	65	0.27	5.7



## 106HC STYLES

### METRIC

Metal Thickness mm	Tip Size	Pressure kg/cm <sup>2</sup>		Consumption NI/hr			Cutting Speed mm/min
		Oxygen	Fuel Gas	Cutting Oxygen	Preheat Oxygen	Fuel Gas	
5	00	1.5	0.2	690	1180	310	660
5-10	0	2.0	0.2	1200	1180	310	660-550
10-15	1	2.5	0.2	2100	1180	310	550-490
15-30	2	3.0	0.25	3400	1370	360	490-400
30-40	3	3.0	0.25	4300	1370	360	400-350
40-50	4	3.5	0.3	6500	1860	490	350-320
50-100	5	4.0	0.3	11000	1860	490	320-200
100-150	6	4.0	0.3	15000	3040	800	200-150
150-250	7	4.5	0.4	22000	3720	980	150-80
250-300	8	4.5	0.4	28000	3720	980	80-45



## 106M STYLES

### INCHES

Metal Thickness inch	Tip Size	Cutting Speed in/min	Oxygen		Kerf Width	Fuel (PSIG)
			Cutting	Preheat		
1/8"	00	27	30	20	0.04	2.8
1/4"	0	24	30	30	0.05	2.8
3/8"	0	22	30	30	0.06	2.8
1/2"	1	21	40	40	0.07	2.8
3/4"	2	18	45	45	0.08	2.8
1"	2	17	45	45	0.08	2.8
1-1/2"	3	14	45	45	0.09	2.8
2"	4	12.5	45	45	0.11	2.8
2-1/2"	5	11	55	55	0.12	3.6
3"	5	10	55	55	0.12	3.6
4"	6	8	55	55	0.14	3.6
5"	6	7	55	55	0.14	3.6
6"	7	6	65	65	0.16	4.3
8"	7	5	65	65	0.17	4.3
10"	8	3	65	65	0.23	4.3
12"	8	2	65	65	0.27	4.3



## 106M STYLES

### METRIC

Metal Thickness mm	Tip Size	Pressure kg/cm <sup>2</sup>		Consumption NI/hr			Cutting Speed mm/min
				Oxygen	Fuel Gas	Preheat Gas	
5	00	1.5	0.2	690	1710	450	660
5-10	0	2.0	0.2	12000	1710	450	660-550
10-15	1	2.5	0.2	21000	1710	450	550-490
15-30	2	3.0	0.2	34000	2470	650	490-400
30-40	3	3.0	0.2	43000	2470	650	400-350
40-50	4	3.5	0.2	65000	2470	650	350-320
50-100	5	4.0	0.25	11000	2890	760	320-200
100-150	6	4.0	0.25	15000	3570	940	200-150
150-250	7	4.5	0.3	22000	3990	1050	150-80
250-300	8	4.5	0.3	28000	3990	1050	80-45





## 107 STYLES

### INCHES

Metal Thickness Inch	Tip Size	Cutting Speed in/min	Oxygen Cutting	Oxygen Preheat	Kerf Width	Fuel (PSIG)
1/8"	00	27	20	20	0.04	2.1
1/4"	0	24	30	30	0.05	2.1
3/8"	0	22	30	30	0.06	2.1
1/2"	1	21	40	40	0.07	2.1
3/4"	2	18	45	45	0.08	2.1
1"	2	17	45	45	0.08	2.1
1-1/2"	3	14	45	45	0.09	2.1
2"	4	12.5	45	45	0.11	2.1
2-1/2"	5	11	55	55	0.12	2.1
3"	5	10	55	55	0.12	2.1
4"	6	8	55	55	0.14	2.1
5"	6	7	55	55	0.14	2.1
6"	7	6	65	65	0.16	2.1
8"	7	5	65	65	0.17	2.1
10"	8	3	65	65	0.23	2.1
12"	8	2	65	65	0.27	2.1



## 107 STYLES

### METRIC

Metal Thickness mm	Tip Size	Pressure kg/cm <sup>2</sup>		Consumption NI/hr			Cutting Speed mm/min
		Oxygen	Fuel Gas	Cutting Oxygen	Preheat Oxygen	Fuel Gas	
5	00	1.5	0.2	690	1180	310	660
5-10	0	2.0	0.2	1200	1180	310	660-550
10-15	1	2.5	0.2	2100	1180	310	550-490
15-30	2	3.0	0.25	3400	1370	360	490-400
30-40	3	3.0	0.25	4300	1370	360	400-350
40-50	4	3.5	0.3	6500	1860	490	350-320
50-100	5	4.0	0.3	11000	1860	490	320-200
100-150	6	4.0	0.3	15000	3040	800	200-150



## 107D7 STYLES

### INCHES

Metal Thickness Inch	Tip Size	Cutting Speed in/min	Oxygen Cutting	Oxygen Preheat	Kerf Width	Fuel (PSIG)
1/8"	00	31.5	100	20	0.03	2.1
1/4"	0	29	100	30	0.04	2.1
3/8"	0	27	100	30	0.05	2.1
1/2"	1	25	100	40	0.05	2.1
3/4"	2	22	100	45	0.06	2.1
1"	2	20	100	45	0.07	2.1
1-1/2"	3	18	100	45	0.08	2.1
2"	4	16	100	45	0.10	2.1
2-1/2"	5	14	100	55	0.11	2.1
3"	5	12.5	100	55	0.11	2.1
4"	6	10	100	55	0.13	2.1
5"	6	9	100	55	0.14	2.1
6"	7	7	100	65	0.14	2.1
8"	7	5.5	100	65	0.18	2.1
10"	8	4	100	65	0.20	2.1
12"	8	3	100	65	0.24	2.1



## 107D7 STYLES

### METRIC

Metal Thickness mm	Tip Size	Pressure kg/cm <sup>2</sup>		Consumption NI/hr			Cutting Speed mm/min
		Oxygen	Fuel Gas	Cutting Oxygen	Preheat Oxygen	Fuel Gas	
5-10	0	7.0	0.15	1100	1350	800	750-680
10-15	1	7.0	0.15	2500	1500	900	680-600
15-30	2	7.0	0.15	3800	1500	900	600-500
30-40	3	7.0	0.15	5400	1700	1000	500-450
40-50	4	7.0	0.15	7300	1700	1000	450-400
50-100	5	7.0	0.15	10000	850	1100	400-260
100-150	6	7.0	0.2	14000	2200	1300	260-180
100-150	6	7.0	0.3	14000	3040	800	260-180

