





**OA7**

- For acetylene
- Only for Oxyweld type torch
- Divergent high speed type  
(Cutting oxygen pressure: 7kg/cm<sup>2</sup>)

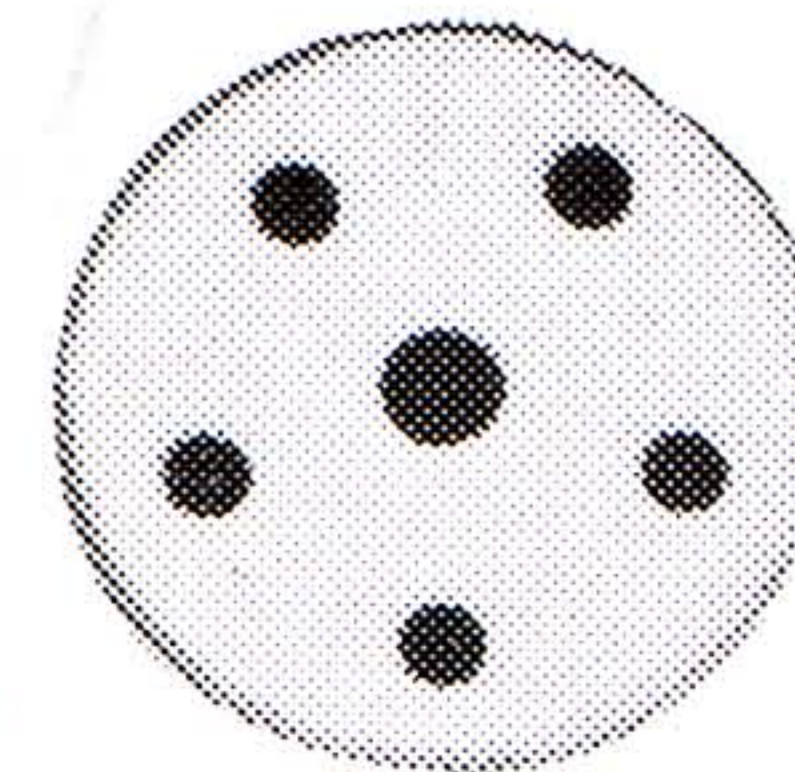
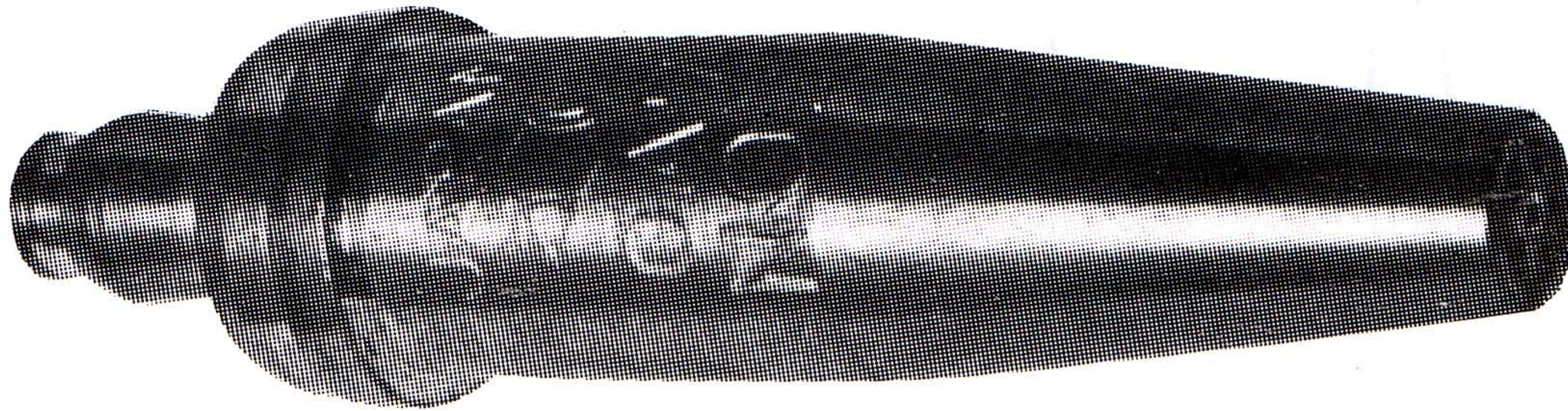
**Inch**

Plate Thickness	Tip No.	Cutting Speed In/Min.	Oxygen P.S.I.G		Fuel P.S.I.G	Kerf Width
			Cutting	PR-Heat*		
1/8	00	31.5	100	20	1.4-3.6	0.03
1/4	0	29	100	30	1.4-3.6	0.04
3/8	0	27	100	30	1.4-3.6	0.05
1/2	1	25	100	40	1.4-3.6	0.05
3/4	2	22	100	45	1.4-3.6	0.06
1	2	20	100	45	1.4-3.6	0.07
1-1/2	3	18	100	45	1.4-3.6	0.08
2	4	16	100	45	2.1-4.3	0.10
2-1/2	5	14	100	55	2.1-4.3	0.11
3	5	12.5	100	55	2.1-4.3	0.11
4	6	10	100	55	2.1-4.3	0.13
5	6	9	100	55	2.1-4.3	0.14
6	7	7	100	65	2.9-5.7	0.14
8	7	5.5	100	65	2.9-5.7	0.18
10	8	4	100	65	2.9-5.7	0.20
12	8	3	100	65	2.9-5.7	0.24

**Metric**

Plate thickness	Tip No.	Pressure kg/cm <sup>2</sup>		Cutting speed
		Oxygen	Fuel gas	
— 5	00	7	0.1 — 0.25	— 750
5 — 10	0	7	0.1 — 0.25	750 — 680
10 — 15	1	7	0.1 — 0.25	680 — 600
15 — 30	2	7	0.1 — 0.25	600 — 500
30 — 40	3	7	0.1 — 0.25	500 — 450
40 — 50	4	7	0.15 — 0.3	450 — 400
50 — 100	5	7	0.15 — 0.3	400 — 260
100 — 150	6	7	0.15 — 0.3	260 — 180
150 — 250	7	7	0.2 — 0.4	180 — 110
250 — 300	8	7	0.2 — 0.4	110 — 100

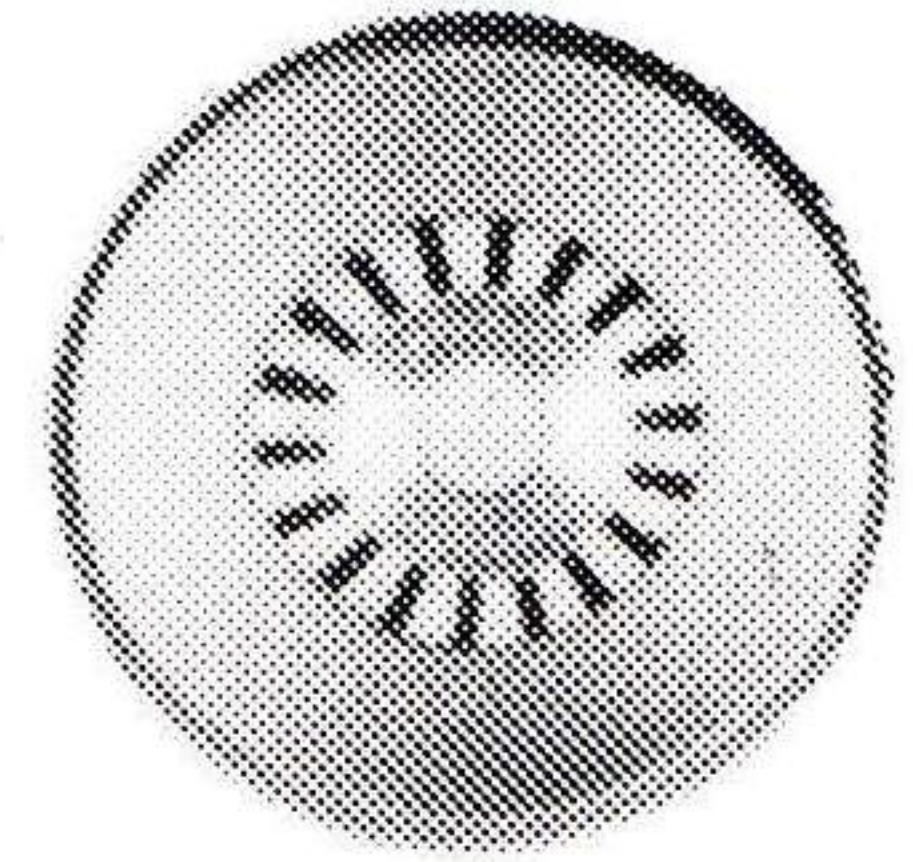
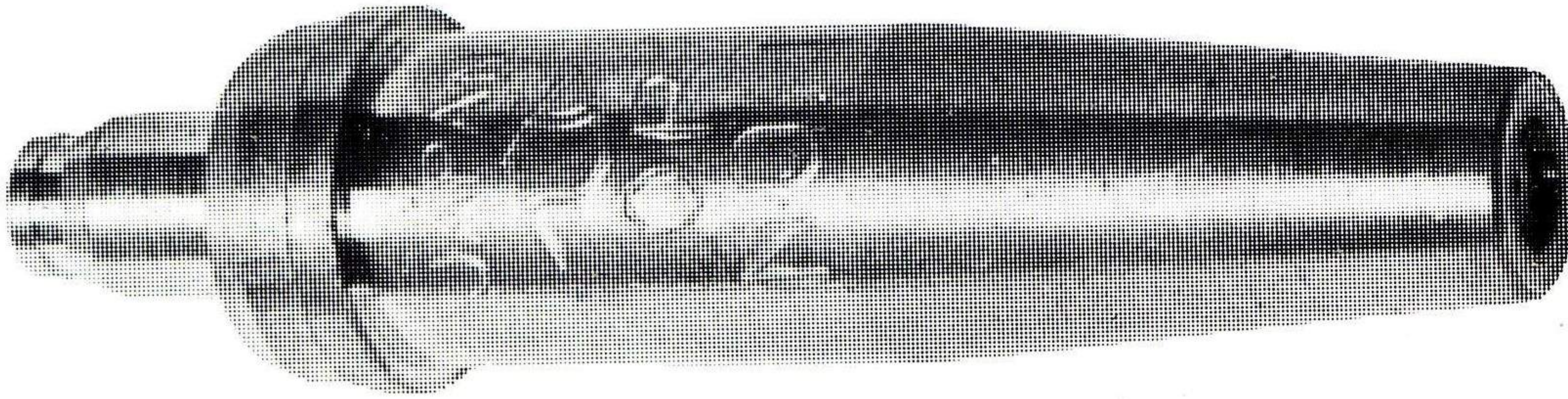






**OP**

- For LPG gas
- Only for Oxweld type torch
- Standard type



**Inch**

Plate Thickness	Tip No.	Cutting Speed In/Min.	Oxygen P.S.I.G		Fuel P.S.I.G	Kerf Width
			Cutting	PR-Heat*		
1/8	00	27	20	20	1.4-3.6	0.04
1/4	0	24	30	30	2.9-3.6	0.05
3/8	0	22	30	30	2.9-3.6	0.06
1/2	1	21	40	40	2.9-3.6	0.07
3/4	2	18	45	45	2.9-3.6	0.08
1	2	17	45	45	2.9-3.6	0.08
1-1/2	3	14	45	45	2.9-3.6	0.09
2	4	12.5	45	45	2.9-5.7	0.11
2-1/2	5	11	55	55	2.9-5.7	0.12
3	5	10	55	55	2.9-5.7	0.12
4	6	8	55	55	5-7.1	0.14
5	6	7	55	55	5-7.1	0.14
6	7	6	65	65	5-7.1	0.16
8	7	5	65	65	5-7.1	0.17
10	8	3	65	65	5-7.1	0.23
12	8	2	65	65	5-7.1	0.27

**Metric**

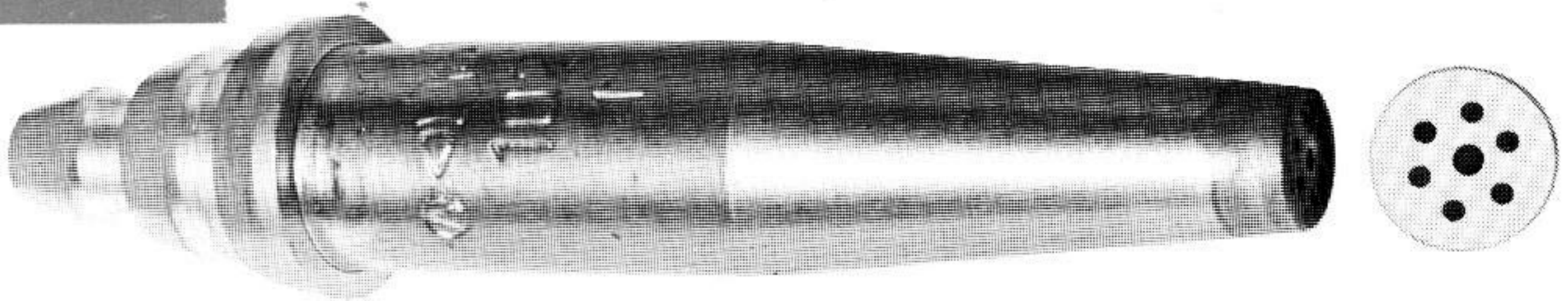
Plate thickness	Tip No.	Pressure kg/cm <sup>2</sup>		Cutting speed
		Oxygen	Fuel gas	
— 5	00	1.5	0.1 — 0.3	— 660
5 — 10	0	2.0	0.2 — 0.3	660 — 550
10 — 15	1	2.5	0.2 — 0.3	550 — 490
15 — 30	2	3.0	0.2 — 0.3	490 — 400
30 — 40	3	3.0	0.2 — 0.3	400 — 350
40 — 50	4	3.0	0.2 — 0.4	350 — 320
50 — 100	5	4.0	0.2 — 0.4	320 — 200
100 — 150	6	4.0	0.35 — 0.5	200 — 150
150 — 250	7	4.5	0.35 — 0.5	150 — 90
250 — 300	8	4.5	0.35 — 0.5	90 — 80







- For acetylene
- Standard tip



Inch

Plate Thickness	Tip No.	Cutting Speed In/Min.	Oxygen P.S.I.G		Fuel P.S.I.G	Kerf Width
			Cutting	PR-Heat*		
1/8	00	27	20	20	2.8	0.04
1/4	0	24	30	30	2.8	0.05
3/8	0	22	30	30	2.8	0.06
1/2	1	21	40	40	2.8	0.07
3/4	2	18	45	45	2.8	0.08
1	2	17	45	45	2.8	0.08
1-1/2	3	14	45	45	2.8	0.09
2	4	12.5	45	45	3.6	0.11
2-1/2	5	11	55	55	4.3	0.12
3	5	10	55	55	4.3	0.12
4	6	8	55	55	5.0	0.14
5	6	7	55	55	5.0	0.14
6	7	6	65	65	5.7	0.16
8	7	5	65	65	5.7	0.17
10	8	3	65	65	5.7	0.23
12	8	2	65	65	5.7	0.27

\* Preheat oxygen pressure: for 3 hose torch only

Metric

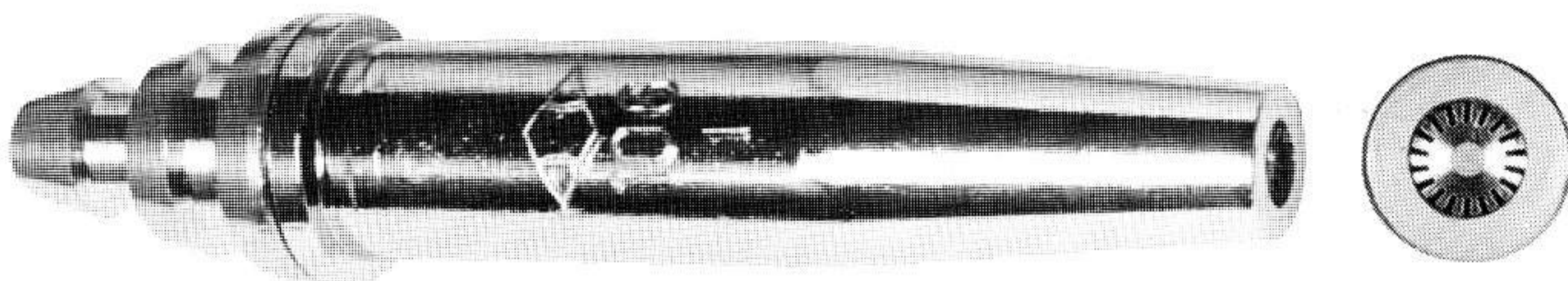
Plate thickness	Tip No.	Pressure kg/cm <sup>2</sup>		Consumption NI/hr.			Cutting speed mm/min.
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
- 5	00	1.5	0.2	690	410	370	- 660
5 - 10	0	2.0		1200			660 - 550
10 - 15	1	2.5		2100	480	430	550 - 490
15 - 30	2	3.0	3400	490 - 400			
30 - 40	3		4300	400 - 350			
40 - 50	4	3.5	0.25	6500	550	500	350 - 320
50 - 100	5	4.0	0.3	11000	690	630	320 - 200
100 - 150	6		0.35	15000	770	700	200 - 150
150 - 250	7	4.5	0.4	22000	1060	960	150 - 80
250 - 300	8			28000			80 - 45







- For LPG gas
- Standard tips



## Inch

Plate Thickness	Tip No.	Cutting Speed In/Min.	Oxygen P.S.I.G		Fuel P.S.I.G	Kerf Width
			Cutting	PR-Heat*		
1/8	00	27	20	20	2.8	0.04
1/4	0	24	30	30	2.8	0.05
3/8	0	22	30	30	2.8	0.06
1/2	1	21	40	40	2.8	0.07
3/4	2	18	45	45	3.6	0.08
1	2	17	45	45	3.6	0.08
1-1/2	3	14	45	45	3.6	0.09
2	4	12.5	45	45	4.3	0.11
2-1/2	5	11	55	55	4.3	0.12
3	5	10	55	55	4.3	0.12
4	6	8	55	55	5.7	0.14
5	6	7	55	55	5.7	0.14
6	7	6	65	65	5.7	0.16
8	7	5	65	65	5.7	0.17
10	8	3	65	65	5.7	0.23
12	8	2	65	65	5.7	0.27

## Metric

Plate thickness	Tip No.	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		690			- 660
5 - 10	0	2.0	0.2	1200	1180	310	660 - 550
10 - 15	1	2.5		2100			550 - 490
15 - 30	2	3.0	0.25	3400	1370	360	490 - 400
30 - 40	3			4300			400 - 350
40 - 50	4	3.5		6500	1860	490	350 - 320
50 - 100	5	4.0	0.3	11000			
100 - 150	6					15000	3040
150 - 250	7	4.5	0.4	22000	3720	980	150 - 80
250 - 300	8			28000			