



Heavy Shell Style 219 - 2 Piece

This precision made two-piece hand or machine cutting tip features excellent preheat flames and a cutting oxygen stream or "Stinger" which is significantly better than with conventional cutting tips. Sizes 00 through 5 feature a 22° "V" spline design that provides maximum heat transfer and flame stability. Sizes 6, 7 and 8 employ a 36° "V" spline design to provide increased gas flows and extra secondary flame length required on thicker plate.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Natural Gas		Propane		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	PSI	CFH	
813-2190	¼	00	72 (.025)	35	65	2-4	18	2	8	20-24
813-2190	⅜	0	72 (.025)	40	86	3-5	25	3	11	19-23
813-2191	½	1	68 (.031)	45	115	3-5	28	3	12	19-23
813-2192	1	2	62 (.038)	55	177	3-5	28	3	12	14-19
813-2193	1 ½	3	56 (.046)	55	235	4-7	30	4	14	12-16
813-2194	2 ½	4	54 (.055)	55	300	4-7	30	4	14	9-13
813-2195	3	5	52 (.063)	50	365	5-8	35	5	16	8-11
813-2196	6	6	39 (.089)	60	610	5-8	35	5	16	5-8
813-2196	8	6	39 (.089)	65	635	5-8	35	5	16	4-6
813-2197	10	7	30 (.169)	65	900	5-8	50	6	18	3-5
813-2197	12	7	30 (.169)	70	975	5-8	50	6	18	3-5
813-2197	14	8	18 (.169)	70	1290	5-8	50	6	18	2-4



Heavy Shell Style 319 - 2 Piece

The 319 is identical to the 219, except the cutting oxygen bore is diverged to allow higher cutting oxygen pressure for increased speed in machine cutting operation. For plates over 4" use Style 219.

Stock No.	Material Thickness	Tip Size	Drill Size	Oxygen		Natural Gas		Propane		Cutting Speed Range (IPM)
				PSI	CFH	PSI	CFH	PSI	CFH	
813-3190	⅜	0	68 (.031)	70	62	2-4	25-33	2-3	11-14	20-22
813-3191	½	1	62 (.038)	80	115	3-5	30-40	3-4	12-16	18-22
813-3191	⅝	1	62 (.038)	85	121	3-5	30-40	3-4	12-16	18-21
813-3192	1	2	56 (.046)	95	133	3-5	30-40	3-4	12-16	18
813-3193	1 ½	3	54 (.055)	90	186	4-8	35-45	4-5	14-18	16
813-3194	2 ½	4	52 (.063)	90	270	4-8	35-45	4-5	14-18	12
813-3195	3	5	49 (.073)	90	380	5-7	40-50	5-6	16-20	11
813-3195	4	5	49 (.073)	90	380	5-7	40-50	5-6	16-20	10



CHT Cutting Tips

CHT Cutting Tips (concentrated heat tip) are a series of tips designed to bevel cut with propane or natural gas without the use of auxiliary preheat devices. For bevels up to 75°. NOTE: Intended for beveling only. CHT tips require special use procedure.

Materials Thickness (Inches)	Tip Size	Stock Number	Drill Size
1	3	813-2813	56 (.046)
1 ½	4	813-2814	54 (.055)
2 ½	5	813-2815	52 (.063)
4	6	813-2816	49 (.073)
6	7	813-2817	39 (.099)
8	8	813-2818	30 (.128)
10	9	813-2819	18 (.169)