

TIPS



Style 45 - 1 Piece Brass

Acetylene Machine Cutting Tips with Divergent Bore. This tip has medium preheat ideal for shape cutting. Six preheat flames.

| Part Number | Material Thickness | Tip Size | Drill Size | Oxygen | | Fuel | | Cutting Speed Range (IPM) |
|---------------|--------------------|----------|------------|--------|------|------|------|---------------------------|
| | | | | PSIG | SCFH | PSIG | SCFH | |
| 813 4500-00-1 | 1/4" | 0 | 74 (.022) | 120 | 70 | 3 | 14 | 24-28 |
| 813 4501-00-1 | 3/8" | 1 | 69 (.029) | 85 | 87 | 3 | 18 | 23-26 |
| 813 4501-00-1 | 1/2" | 1 | 69 (.029) | 100 | 98 | 3 | 18 | 18-22 |
| 813 4502-00-1 | 3/4" | 2 | 65 (.035) | 100 | 122 | 3 | 18 | 17-21 |
| 813 4502-00-1 | 1" | 2 | 65 (.035) | 110 | 130 | 3 | 18 | 16-20 |
| 813 4503-00-1 | 1 1/4" | 3 | 58 (.042) | 85 | 153 | 4 | 25 | 16-19 |
| 813 4503-00-1 | 1 1/2" | 3 | 58 (.042) | 100 | 171 | 4 | 25 | 14-17 |
| 813 4504-00-1 | 2" | 4 | 56 (.046) | 100 | 228 | 4 | 25 | 11-15 |
| 813 4504-00-1 | 2 1/2" | 4 | 56 (.046) | 110 | 244 | 4 | 25 | 9-13 |



Style 119 - 1 Piece

Light-preheat tip, milled on 2 sides for sheet metal cutting and restricted areas. (Two preheat flames)

| Part Number | Materials Thickness (Inches) | Tip Size | Preheat Flames |
|---------------|------------------------------|----------|----------------|
| 854 1900-00-1 | 1/4 | 0 | 2 |
| 854 1901-00-1 | 3/8 | 1 | 2 |
| 854 1902-00-1 | 1/2 | 2 | 2 |
| 854 1903-00-1 | 3/4 | 3 | 2 |



Style 183 - 1 Piece

Medium-preheat tip, with 2 sides milled flat. It has a flared cutting orifice that provides large low velocity Oxygen stream for grooving, gouging and removing imperfect welds. The tip is angled 20°. (Six preheat flames)

| Gas Pressure Settings | | | | |
|-----------------------|---------|-----------|--------|----------|
| Part Number | Depth | Acetylene | Oxygen | Tip Size |
| 854 8306-01-1 | 1/8-1/4 | 3 | 50-65 | 6 |
| 854 8308-01-1 | 1/4-3/8 | 5 | 65-85 | 8 |
| 854 8310-01-1 | 3/8-1/2 | 6 | 85-100 | 10 |
| 854 8312-01-1 | > 1/2 | 6 | 85-100 | 12 |