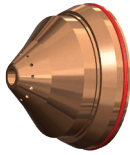


## 260A MILD STEEL BEVEL STANDARD O<sub>2</sub> PLASMA AIR SHIELD

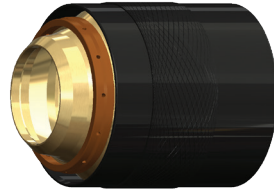
Plasma gas inlet: 120psi/8.4bar  
Shield gas inlet: 120psi/8.4bar



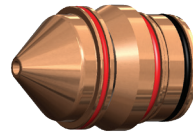
**Shield Cap**  
90-0637



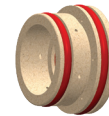
**Shield**  
90-0741



**Nozzle Retaining Cap**  
\*220740



**Nozzle**  
90-0542



**Swirl Ring**  
90-0436



**Electrode**  
90-0541



**Water Tube**  
90-0571

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 <sub>2</sub> Plasma	Air Shield	O <sub>2</sub> Plasma	Air Shield				In	Factor		
1/4	22	49	76	46	0.08	0.11 - 0.30	245	0.33	300	0.3	
5/16							215				
3/8							180				
1/2							145				
5/8			80	49		0.14 - 0.30	115	0.35	250	0.5	
3/4							90			0.6	
7/8							75			0.7	
1							65			0.8	
1-1/8			84	49			0.19 - 0.30	55	0.38	200	0.9
1-1/4								45			1.0
1-1/2 <sup>Δ</sup>								35			2.0
1-3/4								22			Edge start
2						15					
2-1/4						12					
2-1/2			8								

Δ See the alternate, thick metal piercing, cut chart if you have a problem with excessive slag on the shield or problems with the torch misfiring.

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90-7911

METRIC

Thickness mm	Prewflow		Cutflow		Minimum Clearance mm	Torch-to-Work mm	Cutting Speed mm/Minute	Initial Pierce Height		Pierce Delay Sec	
	O <sub>2</sub> Plasma	Air Shield	O <sub>2</sub> Plasma	Air Shield				mm	Factor		
6	22	49	76	46	2.0	2.8 - 7.6	6500	8.5	300	0.3	
8							5470				
10							4440				
12							3850				
15			80	49		3.6 - 7.6	3130	9.0	250	0.5	
20							2170			0.6	
22							1930			0.7	
25			84	49		4.8 - 7.6	1685	9.5	200	0.8	
28							1445			0.9	
32							1135			1.0	
38 <sup>Δ</sup>							895			2.0	
44							580			Edge start	
50							405				
58							290				
64			195								

MARKING

Select Gases		Set Prewflow		Set Cutflow		Amperage	Torch-to-Work		Marking Speed		Arc Voltage
						Amps	mm	Inches	mm/Minute	Inches/Minutes	Volts
N <sub>2</sub>	N <sub>2</sub>	10	10	10	10	18	2.5	0.10	6350	250	135
Air	Air	30	20	30	20	24	3.0	0.12	2540	100	68

*Δ See the alternate, thick metal piercing, cut chart if you have a problem with excessive slag on the shield or problems with the torch misfiring.*

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