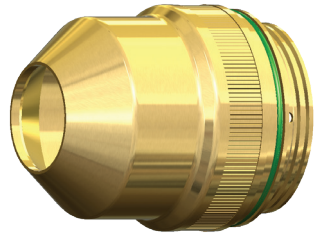


100A MILD STEEL

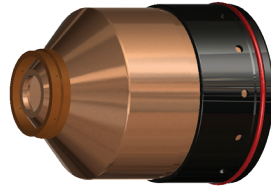
O₂ PLASMA AIR SHIELD



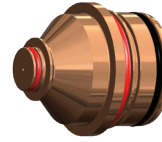
Shield Cap
90-0747



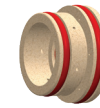
Shield
90-0183



Nozzle Retaining Cap
90-0756



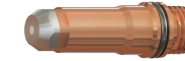
Nozzle
90-0182



Swirl Ring
90-0179



Electrode
90-0187



CleanCut™ Electrode
90-0566



Water Tube
90-0340

Thickness	Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed	Cutting Height	Pierce Height	Pierce Time	Kerf Width
inches	psi	psi	psi	psi	volts	ipm	inches	inches	msec	inches
1/4	25	83	26	81	125	150	.090	.200	300	0.070
3/8					130	100	.130	.250	400	0.078
1/2					65	.155	.300	500	0.085	
5/8					47	.185	.325	800	0.092	
3/4					35	.350	1000	0.098		

ENGLISH

† American Torch Tip Company is in no way affiliated with the above-named manufacturer(s). References to the above-named machines, torches and numbers are for your convenience only. American Torch Tip is not necessarily authorized by the above-named manufacturer(s) to provide replacement parts. Most parts advertised for sale are made by, or for, American Torch Tip Company and other parts, as indicated, are original parts manufactured by the above-named OEM and are simply being resold by American Torch Tip Company. Part numbers followed by an * are manufactured by the respective OEM.

For Kaliburn Spirit system
90-100 L & R

METRIC

Thickness	Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed	Cutting Height	Pierce Height	Pierce Time	Kerf Width
mm	psi	psi	psi	psi	volts	mm/m	mm	mm	msec	mm
6	25	83	26	81	124	3950	2.1	4.9	300	1.8
10					130	2405	3.3	6.5		500
12						1850	3.7	7.3	1000	
16					143	1180	4.7	8.3		2.3
20					145	800		9.0		2.5

MARKING

Type of Gas		Preflow	Plasma	Shield	Postflow	Arc Voltage	Travel Speed		Marking Height		Initial Height		Pierce Time
Plasma Shield		psi	psi	psi	psi	volts	ipm		inches		inches		msec
Nitrogen	Nitrogen	NA	25	25	NA	130	250	6350	.100	2.5	.100	2.5	0
Argon	Air	NA	50	25	NA	60	100	2540	.100	2.5	.100	2.5	0

WARNING: Do not connect H17 (combustible gas) to the gas inputs (Pre/Postflow, Plasma, or Shield) at the same time as Oxygen or Air.

Use an arc transfer height (ignition height) of .150" (3.8 mm) for cutting and .100" (2.5 mm) for marking.

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**For Kaliburn Spirit system
90-100 L & R**