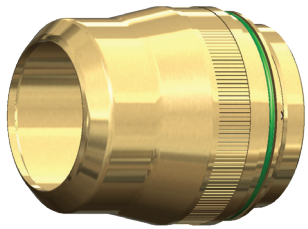
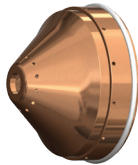


**400A MILD STEEL - O<sub>2</sub> PLASMA / AIR SHIELD**

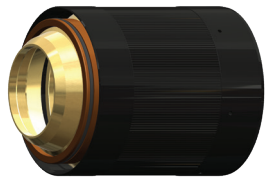
Plasma gas inlet:  
120psi/8.4bar  
Shield gas inlet:  
120PSI/8.4bar



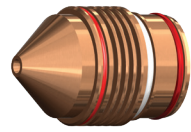
**Shield Cap**  
97-0200



**Shield**  
97-4002



**Nozzle Retaining Cap**  
97-0365



**Nozzle**  
90-0632



**Swirl Ring**  
220631\*



**Electrode**  
90-0530



**Water Tube**  
90-0571

ENGLISH

Thickness	Prewlow		Cutflow		Arc Voltage	Torch-to-Work	Cutting Speed	Initial Pierce Height	Factor	Pierce Delay
	O <sub>2</sub> Plasma	Air Shield	O <sub>2</sub> Plasma	Air Shield	AV	Inches	Inches/Minute	In	%	Sec
1/2	24	50	60	50	140	0.14	170	0.28	200	0.4
5/8					143		150			0.5
3/4					145		115			0.6
7/8					148	100	0.8			
1					151	85	0.9			
1-1/4					153	65	1.2			
1-1/2					157	0.18	48	0.45	250	1.6
1-3/4					160		40			2.5
2					168	0.25	30	0.75	360	5.5
2-1/4					171		25			
2-1/2					175		20			
3					193	0.31	10	Edge Start Recommended		

† 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.

**METRIC**

Thickness	Prewlow		Cutflow		Arc Voltage	Torch-to-Work	Cutting Speed	Initial Pierce Height	Factor	Pierce Delay
mm	O <sub>2</sub> Plasma	Air Shield	O <sub>2</sub> Plasma	Air Shield	AV	mm	mm/Minute	mm	%	Sec
12	24	50	60	50	139	3.6	4430	7.2	200	0.4
15					142		3950			0.5
20					146		2805			0.7
22					148	2540	0.8			
25					150	2210	0.9			
30					153	1790	1.1			
40					158	1160	1.9			
50					167	795	5.2			
60					173	580	Edge Start Recommended			
70					183	380				
80	197	180								

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