

102

For acetylene
Standard tip

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	00	1.5	0.2	690	410	370	~ 660
5 ~ 10	0	2.0		1200			660 ~ 550
10 ~ 15	1	2.5		2100	480	430	550 ~ 490
15 ~ 30	2	3.0		3400			490 ~ 400
30 ~ 40	3			4300			400 ~ 350
40 ~ 50	4	3.5	0.25	6500	550	500	350 ~ 320
50 ~ 100	5	4.0	0.3	11000	690	630	320 ~ 200
100 ~ 150	6		0.35	15000	770	700	200 ~ 150
150 ~ 250	7	4.5	0.4	22000	1060	960	150 ~ 80
250 ~ 300	8			28000			80 ~ 45

102D5

For acetylene

Divergent high speed tip(Cutting oxygen pressure:5Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	(00)	5.0	0.2	850	520	470	~ 700
5 ~ 10	0			1600			700 ~ 625
10 ~ 15	1			2400	600	550	625 ~ 550
15 ~ 30	2			3600			550 ~ 475
30 ~ 40	3			4800			475 ~ 425
40 ~ 50	4			5600			425 ~ 350
50 ~ 100	5		0.25	8800	860	780	350 ~ 250
100 ~ 150	6		0.3	13500	950	860	250 ~ 175
150 ~ 250	7			24000	1330	1210	175 ~ 90
250 ~ 300	8			0.4	31000	1600	1450

102D7

For acetylene

Divergent high speed tip(Cutting oxygen pressure:7Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	(00)	5.0	0.2	850	520	470	~ 750
5 ~ 10	0			1600			750 ~ 680
10 ~ 15	1			2400	600	550	680 ~ 600
15 ~ 30	2			3600			600 ~ 500
30 ~ 40	3			4800			500 ~ 450
40 ~ 50	4			5600			450 ~ 400
50 ~ 100	5		0.25	8800	860	780	400 ~ 260
100 ~ 150	6		0.3	13500	950	860	260 ~ 180
150 ~ 250	7			24000	1330	1210	180 ~ 100
250 ~ 300	8			0.4	31000	1600	1450

103

For ethylene
Standard tip

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	00	1.5	0.2	690	800	460	~ 660
5 ~ 10	0	2.0		1200			660 ~ 550
10 ~ 15	1	2.5		2100			550 ~ 490
15 ~ 30	2	3.0	0.25	3400	900	500	490 ~ 400
30 ~ 40	3			4300			400 ~ 350
40 ~ 50	4	3.5	0.35	6500	1200	660	350 ~ 320
50 ~ 100	5	4.0		11000			320 ~ 200
100 ~ 150	6			4.5	15000	2200	1280
150 ~ 250	7	22000			150 ~ 80		
250 ~ 300	8			28000			80 ~ 45

103D7

For ethylene

Divergent high speed tip(Cutting oxygen pressure:7Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	(00)	7.0	0.2	750	800	460	~ 750
5 ~ 10	0			1100			750 ~ 680
10 ~ 15	1			2500			680 ~ 600
15 ~ 30	2		0.25	3800	900	500	600 ~ 500
30 ~ 40	3			5400			500 ~ 450
40 ~ 50	4		0.35	7300	1200	660	450 ~ 400
50 ~ 100	5			10000			400 ~ 260
100 ~ 150	6			14000			2200
150 ~ 250	7			22000	180 ~ 100		
250 ~ 300	8	35000				100 ~ 70	

106

For LPG gas
Standard tip

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	00	1.5	0.2	690	1180	310	~ 660
5 ~ 10	0	2.0		1200			660 ~ 550
10 ~ 15	1	2.5		2100			550 ~ 490
15 ~ 30	2	3.0	0.25	3400	1370	360	490 ~ 400
30 ~ 40	3			4300			400 ~ 350
40 ~ 50	4	3.5	0.3	6500	1860	490	350 ~ 320
50 ~ 100	5	4.0		11000			320 ~ 200
100 ~ 150	6			15000			200 ~ 150
150 ~ 250	7	4.5	0.4	22000	3720	980	150 ~ 80
250 ~ 300	8			28000			80 ~ 45

106D5

For LPG gas

Divergent high speed tip(Cutting oxygen pressure:5Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	(00)	5.0	0.2	850	1180	310	~ 700
5 ~ 10	0			1600			700 ~ 625
10 ~ 15	1			2400			625 ~ 550
15 ~ 30	2		0.25	3600	1370	360	550 ~ 475
30 ~ 40	3			4800			475 ~ 425
40 ~ 50	4		0.3	5600	1860	490	425 ~ 350
50 ~ 100	5			8800			350 ~ 250
100 ~ 150	6			13500			250 ~ 175
150 ~ 250	7		0.4	24000	3720	980	175 ~ 90
250 ~ 300	8			31000			90 ~ 60

106D7

For LPG gas

Divergent high speed tip(Cutting oxygen pressure:7Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	(00)	7.0	0.2	750	1180	310	~ 750
5 ~ 10	0			1100			750 ~ 680
10 ~ 15	1			2500			680 ~ 600
15 ~ 30	2		0.25	3800	1370	360	600 ~ 500
30 ~ 40	3			5400			500 ~ 450
40 ~ 50	4		0.3	7300	1860	490	450 ~ 400
50 ~ 100	5			10000			400 ~ 260
100 ~ 150	6			14000			260 ~ 180
150 ~ 250	7		0.4	22000	3720	980	180 ~ 100
250 ~ 300	8			35000			100 ~ 70

106M

For LPG gas

Heavy pre-heat oxygen tip

Standard tip

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	00	1.5	0.2	690	1710	450	~ 660
5 ~ 10	0	2.0		1200			660 ~ 550
10 ~ 15	1	2.5		2100			550 ~ 490
15 ~ 30	2	3.0		3400	2470	650	490 ~ 400
30 ~ 40	3			4300			400 ~ 350
40 ~ 50	4			6500			350 ~ 320
50 ~ 100	5	4.0	11000	2890	760	320 ~ 200	
100 ~ 150	6		15000	3570	940	200 ~ 150	
150 ~ 250	7	4.5	22000	3990	1050	150 ~ 80	
250 ~ 300	8		28000			80 ~ 45	

106M7

For LPG gas

Heavy pre-heat oxygen tip

Divergent high speed tip(Cutting oxygen pressure:7Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	(00)	7.0	0.2	750	1710	450	~ 750
5 ~ 10	0			1100			750 ~ 680
10 ~ 15	1			2500			680 ~ 600
15 ~ 30	2			3800			600 ~ 500
30 ~ 40	3			5400			500 ~ 450
40 ~ 50	4			7300			450 ~ 400
50 ~ 100	5		0.25	10000	2890	760	400 ~ 260
100 ~ 150	6			14000	3570	940	260 ~ 180
150 ~ 250	7		0.3	22000	3990	1050	180 ~ 100
250 ~ 300	8			35000			100 ~ 70

106-O

For LPG gas

Only for quick tip-loading/unloading torch

Standard tip

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	00	1.5	0.2	690	1180	310	~ 660
5 ~ 10	0	2.0		1200			660 ~ 550
10 ~ 15	1	2.5		2100			550 ~ 490
15 ~ 30	2	3.0	0.25	3400	1370	360	490 ~ 400
30 ~ 40	3			4300			400 ~ 350
40 ~ 50	4	3.5	0.3	6500	1860	490	350 ~ 320
50 ~ 100	5	4.0		11000			320 ~ 200
100 ~ 150	6			15000			3040
150 ~ 250	7	4.5	0.4	22000	3720	980	150 ~ 80
250 ~ 300	8			28000			80 ~ 45

106-O5

For LPG gas

Only for quick tip-loading/unloading torch

Divergent high speed tip(Cutting oxygen pressure:5Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	(00)	5.0	0.2	850	1180	310	~ 700
5 ~ 10	0			1600			700 ~ 625
10 ~ 15	1			2400			625 ~ 550
15 ~ 30	2		0.25	3600	1370	360	550 ~ 475
30 ~ 40	3			4800			475 ~ 425
40 ~ 50	4		0.3	5600	1860	490	425 ~ 350
50 ~ 100	5			8800			350 ~ 250
100 ~ 150	6			13500			250 ~ 175
150 ~ 250	7		0.4	24000	3720	980	175 ~ 90
250 ~ 300	8			31000			90 ~ 60

106-O7

For LPG gas

Only for quick tip-loading/unloading torch

Divergent high speed tip(Cutting oxygen pressure:7Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	(00)	7.0	0.2	750	1180	310	~ 750
5 ~ 10	0			1100			750 ~ 680
10 ~ 15	1			2500			680 ~ 600
15 ~ 30	2		0.25	3800	1370	360	600 ~ 500
30 ~ 40	3			5400			500 ~ 450
40 ~ 50	4		0.3	7300	1860	490	450 ~ 400
50 ~ 100	5			10000			400 ~ 260
100 ~ 150	6			14000			260 ~ 180
150 ~ 250	7		0.4	22000	3720	980	180 ~ 100
250 ~ 300	8			35000			100 ~ 70

For natural gas

Standard tip

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
~ 5	00	1.5	0.15	690	1000	600	~ 660
5 ~ 10	0	2.0		1200			660 ~ 550
10 ~ 15	1	2.5		2100	1200	700	550 ~ 490
15 ~ 30	2	3.0		3400			490 ~ 400
30 ~ 40	3			4300	1350	800	400 ~ 350
40 ~ 50	4			6500			350 ~ 320
50 ~ 100	5	4.0		11000	1700	1000	320 ~ 200
100 ~ 150	6			15000			200 ~ 150

107D7

For natural gas

Divergent high speed tip (Cutting oxygen pressure: 7Kg/cm²)

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
5 ~ 10	0	7.0	0.15	1100	1350	800	750 ~ 680
10 ~ 15	1			2500	1500	900	680 ~ 600
15 ~ 30	2			3800			600 ~ 500
30 ~ 40	3			5400	1700	1000	500 ~ 450
40 ~ 50	4			7300			450 ~ 400
50 ~ 100	5			10000	1850	1100	400 ~ 260
100 ~ 150	6	0.2	14000	2200	1300	260 ~ 180	

402ST

For acetylene gas

Only for IK-56,64,68

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
5 ~ 10	0	2.0	0.2	1200	380	340	450 ~ 500
10 ~ 15	1	2.5		2100	485	440	400 ~ 450
15 ~ 30	2	3.0		3200			350 ~ 400
30 ~ 40	3			4200	550	500	300 ~ 350
40 ~ 50	4	3.5	0.25	6800	640	580	250 ~ 300
50 ~ 100	5	4.0	0.3	11000	730	660	200 ~ 250

406NT

For LPG gas

Only for IK-56,64,68

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr			Cutting speed
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
5 ~ 10	0	2.0	0.2	1200	1640	410	450 ~ 500
10 ~ 15	1	2.5		2100			400 ~ 450
15 ~ 30	2	3.0		3200			350 ~ 400
30 ~ 40	3			4200	300 ~ 350		
40 ~ 50	4	3.5		6800	2160	560	250 ~ 300
50 ~ 100	5	4.0		11000			200 ~ 250

502A

For acetylene

Only for Skill cut torch (style 100)

Standard type

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr		
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas
~ 5	0	2~3	0.15	420~580	220	200
3 ~ 15	1		0.2	600~800	370	330
5 ~ 20	2	3~4		1300~1600	500	450
10 ~ 50	3	3~4.5	0.25	2500~3500	660	600
40 ~ 100	4	4.5~6		5200~7200		

502L

For acetylene
Only for IK-76
Standard type

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr		
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas
3 ~ 15	1	2~3	0.2	600~800	255	230
5 ~ 20	2	3~4		1300~1600		
10 ~ 50	3	3~4.5	0.25	2500~3500	410	370

506A

For LPG gas

Only for Skill cut torch (style 100)

Standard type

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr		
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas
~ 5	0	2~3	0.15	420~580	1070	280
3 ~ 15	1		0.2	600~800	1370	360
5 ~ 20	2	3~4		1300~1600		
10 ~ 50	3	3~4.5	0.25	2500~3500	1600	420
40 ~ 100	4	4.5~6	0.3	5200~7200	1750	460

506L

For LPG gas
Only for IK-76
Standard type

Plate Thickness	Tip No	Pressure Kg/cm ²		Consumption NI/hr		
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas
3 ~ 15	1	2~3	0.25	600~800	1100	290
5 ~ 20	2	3~4		1300~1600		
10 ~ 50	3	3~4.5		2500~3500		