



# PROPYLENE

## CUTTING TIP CHART

### Cutting Tip Series GPP and HPP

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)***	Preheat Oxygen (PSIG)*	Preheat Fuel Gas (PSIG)	Speed I.P.M.	Kerf Width
1/8"	000	20/25	FOR 3-HOSE MACHINE TORCHES ONLY SEE REVERSE SIDE	2/5	24/28	.04
1/4"	00	20/25		2/5	21/25	.05
3/8"	0	25/30		3/5	20/24	.06
1/2"	0	25/35		3/5	18/22	.06
3/4"	1	30/35		3/6	15/20	.08
1"	2	35/40		3/6	14/18	.09
1 1/2"	2	40/45		4/8	12/16	.09
2"	3	40/45		4/8	10/14	.10
2 1/2"	3	45/50		5/9	9/12	.10
3"	4	40/50		6/9	8/11	.12
4"	5	45/55		6/9	7/10	.14
5"	5	50/55		6/10	6/9	.14
6"	6**	45/55		6/10	5/7	.17
8"	6**	55/65		8/12	4/6	.18
10"	7**	55/65		8/12	3/5	.34
12"	8**	60/70		10/14	3/4	.41
15"	10**	50/70		10/16	2/4	--
18"	12**	45/65		--	2/3	--

\* Applicable for 3-hose machine cutting torches only. With a 2-hose cutting torch, preheat pressure is set by the cutting oxygen.

\*\* For best results use appropriate capacity torches and 3/8" hose when using tip size 6 or larger. Torches with flashback arrestors require up to 25% more pressure as tip size increases (15 PSI maximum acetylene pressure).

\*\*\* All pressures are measured at the regulator using a 25' X 3/8" hose for tip size 6 and larger.

## **Cutting Tip Series MTHP (High Speed Machine Cutting)**

<b>Metal Thickness</b>	<b>Tip Size</b>	<b>Cutting Oxygen (PSIG)</b>	<b>Preheat Oxygen (PSIG)</b>	<b>Preheat Fuel Gas (PSIG)</b>	<b>Speed I.P.M.</b>	<b>Kerf Width</b>
1/4"	00	85/95	SEE BELOW	SEE BELOW	23/30	.05
3/8"	00	85/95			22/29	.05
1/2"	0	85/95			20/28	.06
3/4"	0	85/95			18/26	.06
1"	1	85/95			17/24	.07
1 1/4"	1	85/95			16/20	.07
1 1/2"	1	85/95			12/16	.07
2"	2	85/95			11/15	.09
2 1/2"	2	85/95			10/13	.09
3"	2	85/95			9/11	.09
4"	3	85/95			7/10	.11
5"	3	85/95			6/8	.11
6"	3	85/95			5/7	.11
7"	4	85/95			5/6	.14
8"	4	85/95			4/6	.14
9"	5	85/95			4/5	.18
10"	5	85/95	3/5	.18		

**NOTE:** The above data applies to all torches with the following exceptions:

<b>Torch Series</b>	<b>Preheat Oxygen</b>	<b>Preheat Fuel</b>
MT200N Series	N/A	8 oz. – up
MT300N Series	10-25 PSIG	8 oz. – up

**NOTE:** These speeds and pressure settings apply only to mild steel in good condition. Torches with flashback arrestors require up to 25% more pressure as tip size increases.

### **CAUTION**

*High gas withdrawal rates may require cylinder manifolding. Consult your gas supplier.*

**[www.thermadyne.com](http://www.thermadyne.com)**