

Acetylene Cutting Tips Guide Series 1-101 and 3-101

Metal Thickness	Tip Size	Cutting Oxy. (PSIG)	Preheat Oxy. (PSIG)	Acetylene Pressure
1/8"	000	20/25	3/5	3/5
1/4"	00	20/25	3/5	3/5
3/8"	0	25/30	3/5	3/5
1/2"	0	30/35	3/6	3/5
3/4"	1	30/35	4/7	3/5
1"	2	35/40	4/8	3/6
2"	3	40/45	5/10	4/8
3"	4	40/50	5/11	9/12
4"	5	45/55	6/12	6/13
6"	6**	45/55	6/15	8/14
10"	7**	45/55	6/20	10/15
12"	8**	45/55	7/25	10/15

*Tip Nut Connection Wrench Tight. / Mixing valve to Attachment hand tight connection.

**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).