VICTOR®

PROPANE, LPG and NATURAL GAS

CUTTING TIP CHART
Cutting Tip Series GPN and HPN

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	SEE BELOW	3/5	24/28	.04
1/4"	00	20/25		3/5	21/25	.05
3/8"	0	25/30		3/5	20/24	.06
1/2"	0	30/35		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		5/9	12/16	.09
2"	3	40/45		5/9	10/14	.10
2 1/2"	3	45/50		6/10	9/12	.10
3"	4	40/50		8/12	8/11	.12
4"	5	45/55		8/12	7/10	.14
5"	5	50/55		8/12	6/9	.14
6"	6**	45/55		10/15	5/7	.17
8"	6**	55/65		10/15	4/6	.18
12"	8**	60/70		10/15	3/5	.24

** 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.*

**** All pressures are measured at the regulator using a 25' X 1/4" hose through tip size 5 and 25' X 3/8" hose for tip sizes 6 and larger.*

Cutting Tip Series MTHN (High Speed Machine Cutting)

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

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

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

NOTE: *Data compiled used clean mild steel as test material.*

** Pressure is measured at the torch inlet on MTH Series Tips. Torches with flashback arrestors require up to 25% more pressure as tip size increases.*

Form No. 0056-0413 Printed in U.S.A.