



CUTTING TIPS

173CP For use with **Oxy-Propylene/MAPP®**

Tip Size	Metal Thickness	Cutting Speed (IN/MIN)	Cutting Oxygen (PSIG)	Cutting Oxygen (SCFH)	Pre-Heat Oxygen (PSIG)*	Pre-Heat Oxygen (SCFH)	Fuel Gas (PSIG)	Fuel Gas (SCFH)
00	1/4"	21 / 25	20 / 25	22/26	20/25	23/108	3 / 5	5 / 7
0	3/8"	20 / 24	25 / 30	45/55	20/25	23/108	3 / 5	8 / 10
0	1/2"	18 / 22	30 / 35	50/55	20/25	23/108	3 / 5	8 / 10
1	3/4"	15 / 20	30 / 35	70/80	20/25	23/108	4 / 6	10 / 12
2	1"	14 / 18	35 / 40	115/125	20/25	23/108	4 / 8	12 / 15
2	1-1/2"	12 / 16	40 / 45	125/135	20/25	23/108	5 / 9	12 / 15
3	2"	10 / 14	40 / 45	150/175	20/25	23/108	5 / 9	14 / 18
3	2-1/2"	9 / 12	45 / 50	175/200	20/25	23/108	6 / 10	14 / 18
4	3"	8 / 11	45 / 50	210/250	20/25	23/108	8 / 12	16 / 20

Torch Series	Pre-Heat Oxygen (PSIG)	Pre-Heat Fuel (PSIG)
MC200F	N/A	.5 to 50 PSI
MC300F	20-25 PSIG	.5 to 50 PSI
161&163 Series	N/A	1 PSIG-UP
162 Series	N/A	5 PSIG-UP

The data above was compiled using Mild Steel as a test material.

Preheat Oxygen PSIG is only for 3 hose machine torches. For a 2 hose torch, the preheat oxygen is obtained from the cutting oxygen setting. For best results, use 3/8" hose when using tip size 6 or larger. Above pressures are measured at the regulator with the following hose attached. Up to Size 5 tip, 25' X 1/4" twin hose. Size 6 tip and up, 25' X 3/8" twin hose. Those torches with a flashback arrestor attached may require up to 25% additional pressure, especially as tip size increases.



High Speed Cutting Tips

173CHP For use with Oxy-Propylene/MAPP®

Tip Size	Metal Thickness	Cutting Speed (IN/MIN)	Cutting Oxygen (PSIG)	Cutting Oxygen (SCFH)	Pre-Heat Oxygen (PSIG)*	Pre-Heat Oxygen (SCFH)	Fuel Gas (PSIG)	Fuel Gas SCFH)
00	1/4"	23 / 33	85 / 100	68/75	10/50	23/140	5 up	12/65
00	3/8"	22 / 31	85 / 100	68/75	10/50	23/140	5 up	12/65
0	1/2"	20 / 30	85 / 100	110/120	10/50	23/140	5 up	12/65
0	3/4"	18 / 28	85 / 100	110/120	10/50	23/140	5 up	12/65
1	1"	17 / 27	85 / 100	145/160	10/50	23/140	5 up	12/65
1	1-1/4"	16 / 23	85 / 100	145/160	10/50	23/140	5 up	12/65
1	1-1/2"	12 / 19	85 / 100	145/160	10/50	23/140	5 up	12/65
2	2"	11 / 17	85 / 100	230/250	10/50	23/140	5 up	12/65
2	2-1/2"	10 / 15	85 / 100	230/250	10/50	23/140	5 up	12/65
2	3"	9 / 13	85 / 100	230/250	10/50	23/140	5 up	12/65
3	4"	7 / 11	85 / 100	285/320	10/50	23/140	5 up	12/65
3	5"	6 / 9	85 / 100	285/320	10/50	23/140	5 up	12/65
3	6"	5 / 8	85 / 100	285/320	10/50	23/140	5 up	12/65

*only applicable for three-hose machine torches.

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