

HPG PERFORMANCE PARTS

Flame Cutting with Standard Pressure (FS) Tips

PLATE SIZE	SP OR FS TIP SIZES	DRILL SIZES	HPG PRESSURE	OXYGEN PRESSURE	CUTTING SPEED	KERF WIDTH
3/16	000	68	3-7	30-50	24-34	.05
1/4	00	64	5-10	30-50	22-32	.055
3/8	0	60	5-10	30-50	20-30	.06
1/2	0	60	5-10	30-50	18-28	.06
3/4	1	56	5-10	40-50	16-22	.07
1	1	56	5-10	40-50	14-20	.07
2	2	52	5-10	40-50	10-15	.08
3	3	48	5-10	50-60	8-13	.10
4	4	44	5-10	50-60	7-12	.13
6	5	42	5-10	70-80	5-9	.15
8	6	39	10-15	60-80	4-8	.19
10	7	31	10-15	60-70	4-6	.22
12	8	28	10-15	40-70	3-5	.24
14	9	25	10-15	50-85	2-4	.26
15	10		10-15	50-90	2-3	.34
16	11		10-15	50-90	1-2.5	.37
18	12		10-15	50-90	1-2	.40
Bent Gougers			10	55+		
Rivet Bulkhead			10	55+		

Machine Cutting with High Pressure (FSH) Tips

PLATE SIZE	SP OR FS TIP SIZES	HPG PRESSURE	OXYGEN PRESSURE	CUTTING SPEED	KERF WIDTH
3/16	000	3-5	60-70	26-36	.05
1/4	00	3-5	60-70	25-34	.06
3/8	0	3-5	70-90	23-31	.07
1/2	0	3-5	70-90	22-30	.07
3/4	1	4-8	70-90	20-29	.08
1	1	4-8	70-90	17-28	.08
2	2	4-8	70-90	12-18	.10
2-1/2	3	5-10	75-100	10-16	.11
3	3	5-10	75-100	8-14	.11
4	4	8-15	50-90	7-13	.14

PLEASE NOTE: All speeds shown above were measured in tests using clean, mild, steel plate and a machine in good working order. Use the lower speeds for dirty plate or lesser conditions. Use oxidizing preheats on thin plate and carbonizing preheats for thicker plate. Top of plate should be clean and show no rolled edges at proper speed.

TIP SIZE CROSS-REFERENCE
O.E.M. SIZE TO HPG TIP SIZE

Sect the O.E.M. Tip and Size. Read HPG Size at top of column.

Tip Sizes for HPG Standard Pressure Tips

HPG TIP SIZES	000	00	0	1	2	3	4	5	6	7	8	9
AIRCO/	261	0	1	2			5	7	8			10
(CONOCA)	263		0	1	2	3	4	5	7	8		10
MAPP (FS)	68	65	60	56	52	49	44	38	31	29	19	10
STINGER	0			2	4	5		6	7			8
NX(M)	000	00	0	1	2	3	4	5	6	7	8	
NF				1	3	4		5	6			
NH (M)								5	6	7	8	
103	00		0	1	2	3	4	5	6	7	8	
KOIKE	106	00		0	1	2	4	5	6	7	8	
107	00		0	2	4	6	7	8				
MECO	LM			1	3	4		5				
OXWELD	1534	3	4				8	10	12			16
1567	1/4	1/2	3/4		2		5	10		14		
PUROX	4213	3	4			7	8	10				
SMITH	SC 40, 50,											
60, 90	00			1	3		4	5	6	7	8	
GP (N,P,M)	00		0	1		3	4	5	6	7	8	
BT (N,P,M)							4	5	6			
HP (N,P,M)				1		3	4	5	6	7	8	
3GP (N,P,M)	00		0	1		3	4	5				

Tip Sizes for HPG High Pressure Tips

HPG TIP SIZES		000	00	0	1	2	3	4
AIRCO/ (CONOCA)	361	1	2		3	6	8	
	363		1	2	4	5	6	
	MAPP (FH)	68	65	60	56	52	49	44
STINGER	(375)	0			2	4	5	
HARRIS	WC(M)	4/0	000	0	1	2	3	4
KOIKE	103D7			2	3	5	6	
	106D7		1	2	3	5	6	
	107D7		1	2	3	5	6	
OXWELD	1535	31		40	47	60	80	
	1566	1/2	3/4	1	1-1/2	4	6	8
SMITH	SC21A	0	1		3		6	8
VICTOR	MTH (N,P,M)	00		0	1	2	3	4



Propylene Cutting Tips

**WESTERN**
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CUTTING TIPS

Tips for Airco, Concoa and Koike Equipment

STYLE	DESCRIPTION	STOCK SIZES
AFS	Standard Pressure Fine Spline	00000-9
AFSH	High Pressure Fine Spline	000-4
AGFB	Fine Spline Bent Gouging Tip	2,4,6,8
APRB	Rivet – Bulkhead Tip	2,3,4,6
AHT	Fine Spline Heating Tip	



Tips for Harris Equipment

STYLE	DESCRIPTION	STOCK SIZES
HFS	Standard Pressure Fine Spline	00000-9
HFSH	High Pressure Fine Spline	000-4
HGFB	Fine Spline Bent Gouging Tip	2,4,6,8
HPRB	Rivet – Bulkhead Tip	2,3,4,6
HHT	Fine Spline Heating Tip	



Tips for Mecro Equipment

STYLE	DESCRIPTION	STOCK SIZES
MFS	Standard Pressure Fine Spline	000-9



Tips for Oxweld Equipment

STYLE	DESCRIPTION	STOCK SIZES
OFS	Standard Pressure Fine Spline	0000-9
OFSH	High Pressure Fine Spline	000-4
OGFB	Fine Spline Bent Gouging Tip	2,4,6,8
OPRB	Rivet – Bulkhead Tip	2,3,4,6
OHT	Fine Spline Heating Tip	



CUTTING TIPS

Tips for Purox Equipment

STYLE	DESCRIPTION	STOCK SIZES
PFS	Standard Pressure Fine Spline	0000-9
PGFB	Fine Spline Bent Gouging Tip	2,4,6,8
PPRB	Rivet – Bulkhead Tip	2,3,4,6
PHT	Fine Spline Heating Tip	



Tips for Smith Equipment

STYLE	DESCRIPTION	STOCK SIZES
SFS	Standard Pressure Fine Spline	00000-9
MCFS	Std. Pres. Fine Spline for MC Series	000-3
SFSH	High Pressure Fine Spline	000-4
SGFB	Fine Spline Bent Gouging Tip	2,4,6,8
SPRB	Rivet – Bulkhead Tip	2,3,4,6
SHT	Fine Spline Heating Tip	



Tips for Victor Equipment

STYLE	DESCRIPTION	STOCK SIZES
2VFS	Standard Pressure Fine Spline	00000-9
2VFSH	High Pressure Fine Spline	000-4
2VGFB	Fine Spline Bent Gouging Tip	1,2,4,6,8
2VPRB	Rivet – Bulkhead Tip	2,3,4,6
2VHT	Fine Spline Heating Tip	
2VFS Stubbie	1-3/8" Fine Spline Standard Pressure	0-4
2VFH Stubbie	1-1/2" Fine Spline High Pressure	0-3
3VFS	Med. Size Std. Pressure Fine Spline	0000-9
3VGFB	Fine Spline Bent Gouging Tip	2,4,6,8

