XTR Cutting Tips

Operating Information

Currently there is no standard method among Original Equipment Manufacturers (OEM) to designate tip sizes. The following charts are designed to provide operational data for the user, regardless of OEM, by utilizing the common denominators, “Oxygen Orifice Drill Size” and “Metal Thickness.” Using information you have available, the following charts can help find information you need.

Standard Pressure Tip Size Cross Reference Guide (OEM Size to Oxygen Orifice Drill Size)

O.E.M.		Oxygen Orifice, Drill Size Chart																		
		74	71	68	64	62	60	58	56	54	52	50	48	44	39	31	28	25	19	13
	Inches	0.023	0.026	0.031	0.036	0.038	0.040	0.042	0.047	0.055	0.064	0.070	0.076	0.086	0.100	0.120	0.141	0.150	0.166	0.185
	MM	0.572	0.660	0.787	0.914	0.965	1.016	1.067	1.181	1.397	1.613	1.778	1.930	2.184	2.527	3.048	3.569	3.797	4.216	4.699
Airco®	•144			00		0			1	2	3		4	5	6					
	•164			00		0			1	2	3		4	5	6	8	9		10	
Harris®	•6290NX			000	00		0		1		2		3	4	5	6	7	8		
	•6290NFF								1	2	3		4		5	6				
	•6290			00	00		0		1		2		3	4						
Purox®	•4202			3			4			5		7		9		13				
Victor®	•1GPN		000	00			0		1	2		3	3	4	5	6	7		8	10
	•3GPN		000	00			0		1	2		3	3	4	5					
	•1-101		000	00			0		1		2		3	4	5	6	7	8		
	•3-101			00			0		1		2		3	4	5	6				

You Know the Tip Size: Use the Cross Reference Chart to find drill size of OEM style tip to be used, and then refer to Operation and Performance Chart to determine operating parameters. Check “Metal Thickness” column to be sure tip is correct size for the cut.

You Know the Metal Thickness: Use the Operational and Performance Chart to determine drill size needed to cut specific thickness of metal. Select OEM style tip and size from Cross Reference Chart.

Color Codes for Gas Type:

- (Red) Acetylene
- (Blue) Propane/Natural Gas
- (Yellow) Propylene

XTRweld does not source or make MAPP specific tips.
Propylene tips may be used if needed

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General Operation & Performance Data for XTR Cutting Tips
Standard Pressure

Metal Thickness (Inches")	Tip Size		Drill Cleaner Size	WYPO® Cleaner #	Oxygen O2		** Fuel Gas P.S.I.	* Speed I.P.M.	KERF Width (Inches")
	#	Cutting Orifice Drill Size			Cutting P.S.I.	Preheat P.S.I.			
1/4	***000***	68	69	10	30—40	5—9	3—5	17—24	0.050
3/8	00	64	65	14	35—45	5—10	3—5	17—23	0.060
1/2	1/2	62	63	15	35—45	5—10	3—6	16—22	0.060
5/8	***0***	60	61	15	35—45	5—10	3—6	15—20	0.070
3/4	1/2	58	59	17	35—50	5—10	3—6	15—19	0.070
1	***1***	56	57	18	35—50	5—10	3—6	14—18	0.080
1½	1½	54	55	22	40—55	10—17	4—8	12—16	0.090
2	***2***	52	53	24	40—55	10—17	4—8	10—14	0.100
2½	2½	50	51	26	40—55	10—17	5—9	9—13	0.110
3	***3***	48	49	28	45—60	10—17	6—10	8—11	0.110
4	4	44	45	32	50—65	10—17	6—10	7—10	0.130
5	4	44	45	32	50—65	10—17	6—10	6—9	0.130
6	***5***	39	36	42	60—75	10—17	8—12	5—8	0.150
8	***6***	31	32	44	60—85	30—43	9—15	4—6	0.190
10	7	28	29		30—60	30—43	9—15	3—5	0.220
12	8	25	26		25—55	30—43	9—15	3—4	0.240
14	9	19	20		25—55	30—43	9—15	2—3	0.260
15	10	13	14		25—50	30—43	10—18	2—3	0.340
16	11	9	10		25—50	30—43	10—18	1½—2 ½	0.370
18	12	5	6		25—45	30—43	10—18	1—2	0.400

** Acetylene not to exceed 15 P.S.I

*If using propylene, use high side range of this chart. If using natural gas use low side of range.

NOTE: Data was compiled using mild steel as test material. This data should be used as a guide only. Your specific job may require slightly different pressures and speeds.

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