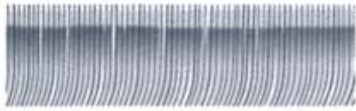
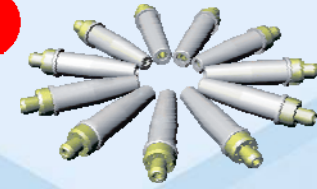


GAS INNOVATIONS

OXY-FUEL CUTTING REFERENCE CHART



PERFECT CUT - Regular surface with slightly sloping drag lines marks a perfect cut. A slight amount of scale at the top of the cut is caused by preheat flames and is easily removed. This surface can be used for many purposes without machining.



PRODUCTION CUT - Moderately sloping drag lines and a reasonably smooth surface characterize a production cut. For production operations a cut of this type represents the best combination of quality and economy.

CUTTING SPEED



EXTREMELY FAST - Rake angle of drag lines shows extremely fast cutting speed. Top edge is good and cut face is smooth. However, slag adheres to the bottom side and there is danger of losing the cut. Not enough time is allowed for slag to blow out of the kerf. Cut face often slightly concave.



EXTREMELY SLOW - Pressure marks indicate too much oxygen for cutting conditions. Either the tip is too big, cutting oxygen pressure too high, or speed is too slow as shown by a rounded or beaded top edge as in this case. As oxygen volume nears correct proportions, pressure marks appear closer to the bottom edge until they finally disappear.



SLIGHTLY TOO FAST - Drag lines incline backwards, but a "drop cut" is still attained. Top edge is good, cut face is smooth and slag free. Quality is satisfactory for much production work.



SLIGHTLY TOO SLOW - Cut is high quality although there is some surface roughness caused by vertical drag lines. Top edge is usually slightly beaded. Quality is generally acceptable, but faster speeds are more desirable.



DIRTY TIP - Dirt or scale in the tip will deflect the oxygen stream and cause one or more of the following problems: Excess slag on the steel, an irregular cut surface, pitting and undercutting.



TIP DISTANCE

TOO CLOSE - Grooves and deep drag lines caused by unstable cutting action. Part of preheat cone burns inside kerf where normal gas expansion deflects oxygen cutting stream.



TOO HIGH - Top edge is beaded or rounded, cut face is not smooth and often is slightly beveled when preheat effectiveness is partially lost due to the tip being held too high. Cutting speed is reduced because of the danger of losing the cut.



GAS ADJUSTMENT

TOO MUCH CUTTING OXYGEN - Pressure marks are caused by too much cutting oxygen. When more oxygen is supplied than can be consumed in oxidation, the remainder goes around the slag creating gouges, or pressure marks. Correct this fault by lowering cutting oxygen pressure, increasing speed, or using a smaller tip. As oxygen volume nears correct proportion, pressure marks appear closer to the bottom edge until they finally disappear.



TOO HOT PREHEAT - Rounded top edge caused by too much preheat. Excess preheat does not increase cutting speed. It only wastes gases.



WHAT TO LOOK FOR IN BEVEL CUTTING

GOOD QUALITY - Top edge is excellent and cut face extremely smooth. Slag should be easy to remove and the cut part dimensionally accurate. Cutting speed is slower than vertical cutting because preheat effect is partially deflected from plate.



POOR QUALITY - Gouging is the most common fault, and is caused by either speed too fast or preheat flame too mild. Another fault is a rounded top edge, caused by too much preheat indicating excessive gas consumption.

GAS INNOVATIONS

GAS INNOVATIONS PROPYLENE

Hand Cutting - Standard Pressure Tip Chart

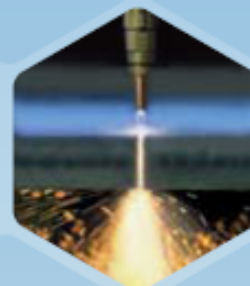
Material Thickness Inches	Tip Size	Propylene Pressure P.S.I.	Cutting Oxygen P.S.I.	Cutting Speed I.P.M.	Kerf Width Inches
GAUGE	5/0	3-6	30-50	23/33	.035
1/8 - 1/4	4/0	3-6	30-50	21/31	.04
3/8	000	3-6	30-50	20/29	.07
1/2	00	6-11	30-50	17/27	.07
5/8	00	6-11	40-50	16/23	.08
3/4	0	6-11	40-50	15/22	.08
7/8	1	6-11	40-50	14/21	.08
1 - 1 1/2	1	6-11	40-50	13/20	.09
2 - 2 1/2	2	6-11	50-60	11/14	.10
3	3	6-11	50-60	7/14	.11
4	4	6-11	50-70	6/11	.13
5	5	6-11	60-70	6/11	.14
6	5	6-11	60-70	4/9	.15
7	6	11-16	60-70	4/9	.18
8	6	11-16	60-70	3/7	.19
9	7	11-16	60-70	3/7	.20
10	8	11-16	60-70	3/6	.22
12	9	11-16	60-70	2/5	.24
14	10	11-16	60-80	2/3	.26



For Inquiries or to order Call:

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GAS INNOVATIONS PROPYLENE

Machine Cutting - High Pressure Tip Chart

Material Thickness Inches	Tip Size	Propylene Pressure P.S.I.	Cutting Oxygen P.S.I.	Cutting Speed I.P.M.	Kerf Width Inches
1/4	4/0	4-6	60-70	23-33	.06
3/8	000	4-6	60-70	23-33	.07
1/2	00	4-6	60-70	21-31	.07
3/4	0	5-9	60-70	20-29	.08
1	1	5-9	60-70	18-28	.08
1 1/2	2	5-9	60-70	13-20	.09
2	2	5-9	60-70	12-18	.10
2 1/2	3	6-11	70-80	10-16	.11
3	3	6-11	70-80	8-14	.11
4	4	8-12	75-100	9-15	.13

Gas Innovations / WWS Chrome Cutting Tips are Specifically Designed for High Performance Propylene Fuel Gas



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