



TIPS ON CUTTING



A LINCOLN ELECTRIC COMPANY

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TIP CHART **Pros**



A LINCOLN ELECTRIC COMPANY

Harris Products Group
A Lincoln Electric Company
2345 Murphy Blvd., Gainesville, Georgia 30504
Customer Service: 1.800.733.4043
www.harrisproductsgroup.com

022016
9500688

V1-101 & V3-101 - ACETYLENE

GENERAL PREHEAT SINGLE PIECE "V" SERIES HAND CUTTING TIPS

| TIP SIZE | PLATE THICKNESS INCHES | OPERATING PRESSURES | | CUTTING DRILL SIZE |
|----------|------------------------|---------------------|----------------|--------------------|
| | | OXYGEN PSIG | ACETYLENE PSIG | |
| 000 | LIGHT GAUGE to 1/8" | 20-30 | 5 | #70 |
| 00 | 1/8" - 5/16" | 20-30 | 5 | #69 |
| 0 | 5/16" - 5/8" | 30-40 | 7 | #61 |
| 1 | 5/8" - 1" | 40-50 | 7 | #56 |
| 2 | 1" - 2" | 45-55 | 8 | #53 |
| 3 | 2" - 3" | 50-60 | 9 | #50 |
| 4 | 3" - 4" | 60-75 | 10 | #46 |
| 5 | 4" - 6" | 70-80 | 11 | #39 |
| 6* | 6" | 75-80 | 12 | #31 |

*For best performance use 3/8" I.D. Hose for tip sizes 6 and larger.

1-GPN & 3-GPN - PROPANE/NATURAL GAS

GENERAL PREHEAT TWO PIECE "V" SERIES HAND CUTTING TIPS

| TIP SIZE | PLATE THICKNESS INCHES | OPERATING PRESSURES | | CUTTING DRILL SIZE |
|----------|------------------------|---------------------|---------------|--------------------|
| | | OXYGEN PSIG | FUEL GAS PSIG | |
| 000 | LIGHT GAUGE to 1/8" | 20-25 | 3-5 | #71 |
| 00 | 1/4" | 20-25 | 3-5 | #67 |
| 0 | 3/8" - 1/2" | 25-35 | 3-5 | #60 |
| 1 | 3/4" | 30-35 | 4-6 | #56 |
| 2 | 1" - 1 1/2" | 35-45 | 4-9 | #53 |
| 3 | 2" - 2 1/2" | 40-50 | 5-10 | #50 |
| 4 | 3" | 45-50 | 8-12 | #45 |
| 5 | 4" - 5" | 45-55 | 8-12 | #39 |
| 6* | 6" | 45-55 | 10-15 | #31 |

*For best performance use 3/8" I.D. Hose for tip sizes 6 and larger.

V1-101 AC - ACETYLENE

HEAVY PREHEAT TWO PIECE "V" SERIES • HAND / MACHINE CUTTING TIP

| TIP SIZE | PLATE THICKNESS INCHES | OPERATING PRESSURES | | CUTTING DRILL SIZE |
|----------|------------------------|---------------------|----------------|--------------------|
| | | OXYGEN PSIG | ACETYLENE PSIG | |
| 000 | LIGHT GAUGE to 1/8" | 20-25 | 3-5 | #68 |
| 00 | 1/8" - 1/4" | 20-25 | 3-5 | #64 |
| 0 | 1/4" - 1/2" | 25-35 | 7 | #60 |
| 1 | 1/2" - 3/4" | 30-35 | 3-5 | #56 |
| 2 | 3/4" - 1 1/2" | 35-45 | 3-7 | #53 |
| 3 | 1 1/2" - 3 1/2" | 40-50 | 4-10 | #51 |
| 4 | 1 1/2" - 2 1/2" | 40-50 | 5-10 | #42 |
| 5 | 2 1/2" - 3" | 45-55 | 5-13 | #35 |
| 6* | 5 - 8" | 45-55 | 7-14 | #31 |

*For best performance use 3/8" I.D. Hose for tip sizes 6 and larger.

1-GPP & 3GPP - PROPYLENE

GENERAL PREHEAT TWO PIECE "V" SERIES • HAND CUTTING TIPS

| TIP SIZE | PLATE THICKNESS INCHES | OPERATING PRESSURES | | CUTTING DRILL SIZE |
|----------|------------------------|---------------------|---------------|--------------------|
| | | OXYGEN PSIG | FUEL GAS PSIG | |
| 000 | LIGHT GAUGE to 1/8" | 20-25 | 3-5 | #71 |
| 00 | 1/4" | 20-25 | 3-5 | #67 |
| 0 | 3/8" - 1/2" | 25-35 | 7 | #60 |
| 1 | 3/4" | 30-35 | 3-5 | #56 |
| 2 | 1 1/2" - 1 1/2" | 35-45 | 3-7 | #53 |
| 3 | 2" - 2 1/2" | 40-50 | 4-10 | #50 |
| 4 | 3" | 40-50 | 5-10 | #45 |
| 5 | 4" - 5" | 45-55 | 5-13 | #39 |
| 6* | 6 - 8" | 45-55 | 7-14 | #31 |

*For best performance use 3/8" I.D. Hose for tip sizes 6 and larger.