



A LINCOLN ELECTRIC COMPANY

NEW PRODUCT

Turn to the
TRAKMAX
PORTABLE CUTTING AND WELDING TRACTOR
Pros

TRAKMAX™

PORTABLE CUTTING AND WELDING TRACTOR

SMOOTH. POWERFUL. FAST.

INTRODUCING THE TRAKMAX™ SERIES OF CUTTING AND WELDING TRACTORS FROM HARRIS. THE MODEL 622 TRACTOR IS **THE FIRST EVER PRECISION BELT DRIVEN TRACTOR.**

The precision beltdrive is an innovative new generation drive system that replaces and outperforms cone or gear drives. The tractors precision gear drive eliminates gear lash resulting in a significantly smoother operation without lost motion.

The Trakmax™ is capable of performing multi-applications including oxy-fuel cutting, arc welding and plasma cutting. Optional accessories allow for the use of two or more oxy-fuel torches allowing cutting of multiple or compound bevels in a single pass.

MULTIPLE PROCESSES:

- Oxy-fuel vutting
- ARC welding
- Plasma cutting

INNOVATIVE FEATURES:

- The precision belt drive on the tractor eliminates gear lash resulting in a significantly smoother operation without lost motion.
- Dual voltage
Available in both 115/230 volt versions

TYPES OF CUTS:

- Square/straight
- Y, X, K bevels
- Circle



DESIGNED FROM SCRATCH TO BE THE BEST.

HARRIS PROVES WHY A PRO WOULD PREFER A TRAKMAX™

ADVANTAGE

Unlike most machines currently on the market that require the purchase of two tractors, the Trakmax™ comes standard with dual range speed control with infinite speed control from 0 – 40 inches per minute and 0-110 inches per minute making it one of the fastest most accurate tractors available in the market.

BODY DESIGN

The Trakmax™ has a welded steel, uni-body construction that is integral to the design of the machine (not just a cover). The stainless steel drive wheels and casters are corrosion and abrasion resistant resulting in longer lasting wheels. The large diameter drive wheels are knurled for positive traction. The caster wheels can be locked into position in-line with the drive wheels for straight line cutting – even without the track.

HEAT SHIELDS

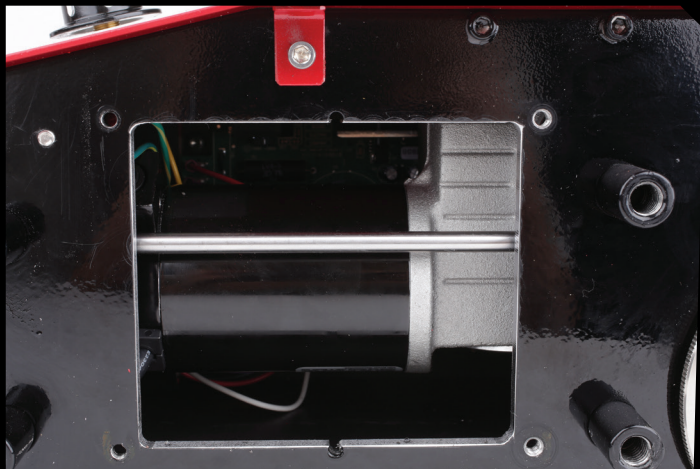
The Trakmax™ is equipped standard with full profile heat shields mounted on each side of the tractor to protect the motor and solid state circuitry from overheating when engaged in heavy cutting or when machine is operating close to the cut.



NO-PLAY GEAR RACK SYSTEM

Exclusive diamond shape design torch suspension system provides smoother gouge-free cuts.





TRAKMAX
PORTABLE CUTTING AND WELDING TRACTOR

DC MOTOR WITH INTEGRAL TRANSMISSION

Permanent magnet high torque (108lbs/in.) DC motor eliminates the need for cooling fan that would draw in foreign debris shortening the motors service life. Current to motor turns off at idle, further extending service life.

PRO INFO

Visit www.harrisproductsgroup.com for complete details on our entire product line.



BELT DRIVE

It is an innovative new generation drive system that replaces and out performs cone or gear drives. Eliminates gear lash or play resulting in a significantly smoother operation with no lost motion.



CONVENIENTLY POSITIONED CONTROLS

Two position toggle switches are easily accessible to the operator from virtually any position around the machine.



4" DIAMETER DRIVE WHEELS

Knurled for positive traction resulting in smoother travel and higher quality cuts.



SOLID STATE CONTROL BOARD

CE®, RoHS® compliant and UL® recognized board is easily accessible and features spade type connectors to facilitate service.



BUILD IN HOSE BLOCK

Standard equipment includes a paddle activated two gas hose block for preheat control.



STAINLESS STEEL DRIVE WHEELS AND CASTERS

Corrosion and abrasion resistant resulting in longer lasting wheels.



MOVABLE AND LOCKABLE CASTER WHEELS

Can be unlocked for circle cutting or locked in line with drive wheels for straightline cutting-even without the track.



CONVENIENT CARRYING HANDLE

Ergonomic aluminum handle for more comfortable, convenient machine positioning and transporting.



LARGE ALUMINUM KNOBS AND LEVERS

allow for use without removing personal protective equipment and they are conveniently located.



DETACHABLE 25' POWER CORD

The oil resistant 3 conductor 4 amp 8 gauge power cord meets SJ00W standards and is equipped with a molded water resistant plug.

CE®, RoHS® and UL® are respective trademarks of their owners.



622

MODEL



DESCRIPTION

The Trakmax™ features all metal construction including steel, aluminum, brass, and stainless steel. It has a welded steel, uni-body construction and a frame that is integral to the design of the machine. Its stainless steel drive wheels and casters are corrosion and abrasion resistant resulting in longer lasting wheels. The large diameter drive wheels are knurled for positive traction. The caster wheels can be locked into position in-line with the drive wheels for track free straight line cutting or left free wheeling for circles.

DETAILS

Cutting Capacity: 30" / 762 mm*
(with appropriate torch equipment)
Weight: 32 lbs/ 14.5 kg. (Tractor Only)
Length: 15" / 381 mm
Height: 6 3/8" / 161.92 mm
Width: 7 1/4" / 184.15 mm
Circle Cutting Range: 2 - 96" / 50.8 - 1371.6 mm with optional radius rod kit
P/N QC25CM2710

Where used:

Straight, square, bevel & circle cutting plasma cutting, and welding

Related items:

BV-98-2 P/N: 1200124
S-98-C P/N: 1200080
TH-98 P/N: 1200090



Shown with Model 98 Torch S-98-C and tip - (not included)

PART#	WEIGHT LBS. (KG)	CARRYING LOAD MAXIMUM LBS.	SPEED RANGE IPM	POWER REQUIREMENTS	STANDARD PACKAGE
QC2SCM1000	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-40/0-110	120 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Portable track machine
QC2SCM2500	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-40/0-110	120 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine and standard rigging kit (cross slide & 24" gear rack, torch holder, connecting block, 3' hose set, flip style hose block)
QC2SCM2502	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-40/0-110	120 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine and standard rigging kit (cross slide & 24" gear rack, torch holder, connecting block, 3' hose set, flip style hose block) and 6' track
QC2SCM2503	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-40/0-110	120 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine and standard rigging kit (cross slide & 24" gear rack, torch holder, connecting block, 3' hose set, flip style hose block), 6' track and 98-6er-32 machine torch
QC2SCM2504	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-40/0-110	120 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine and standard rigging kit (cross slide & 24" gear rack, torch holder, connecting block, 3' hose set, flip style hose block), 6' track and 98-6fr-32 machine torch
QC2SCM2505	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-40/0-110	120 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine, welding/plasma rigging kit (cross slide & 24" gear rack, welding/plasma holder, connecting block (staggered), extension block (4" - 3/4" F x 3/4" M) and 6ft track
INTERNATIONAL (220VAC)					
QC2SCM2518	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-350/0-100	220 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Portable track machine
QC2SCM2520	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-350/0-100	220 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine and standard rigging kit (cross slide & 24" gear rack, torch holder, connecting block, 3' hose set, flip style hose block)
QC2SCM2522	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-350/0-100	220 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine and standard rigging kit (cross slide & 24" gear rack, torch holder, connecting block, 3' hose set, flip style hose block) and 6" track
QC2SCM2523	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-350/0-100	220 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine and standard rigging kit (cross slide & 24" gear rack, torch holder, connecting block, 3' hose set, flip style hose block) , 6" track and 98-6ER-32 machine torch
QC2SCM2524	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-350/0-100	220 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine and standard rigging kit (cross slide & 24" gear rack, torch holder, connecting block, 3' hose set, flip style hose block) , 6" track and 98-6fr-32 machine torch
QC2SCM2525	32lbs. (14.5 kg) (Without Rigging or torch)	500	*0-350/0-100	220 VAC, 1 AMP (Maximum) 50/60 HZ, 1PH	Includes portable track machine, welding/plasma rigging kit (cross slide & 24" gear rack, welding/plasma holder, connecting block (staggered), extension block (4" - 3/4" F x 3/4" M) and 6ft track

* High/low range

(Torch packages do not include tips.)



CUTTING RIGGING KIT (P/N: QC2SCM2575)



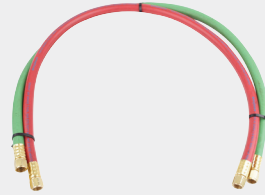
CROSS SLIDE AND 24" GEAR RACK
Horizontal adjustment.



TORCH HOLDER
For mounting 1 3/8" diameter machine cutting torches and controlling the vertical movement of the torch.



CONNECTING BLOCK
Attaches cutting torch or welding/ plasma holders to gear rack.



3' TWIN T-GRADE HOSE
3' twin, grade T, hose to connect the torch to the hose block.



FLIP STYLE HOSE BLOCK
For use with 2 hose torches.

WELDING/PLASMA RIGGING KIT (P/N: QC2SCM2570)



CROSS SLIDE AND 24" GEAR RACK
For horizontal torch adjustment.



WELDING/PLASMA HOLDER
For clamping most shapes, types and brands of plasma, and MIG torches to the connecting block.



CONNECTING BLOCK
Attaches extension block to gear rack.



EXTENSION BLOCK
Attaches holder to connecting block.

PRODUCT OVERVIEW WELDING PLASMA RIGGING KITS



Universal welding / plasma holder is highly adjustable allowing the operator unlimited positioning choices.

ADVANTAGES

Unique clamping device can accommodate virtually any shape plasma or welding torch.



THE TRAKMAX™ ADVANTAGE

1 THE SPEED FOR YOUR NEED

Unlike other competitive products the Trakmax™ features a standard dual range speed control 0-40 and 0-110 inches per minute making it the fastest tractor on the market with no complicated optional speed conversion kit required.

2 THEY ARE MORE THAN JUST WHEELS

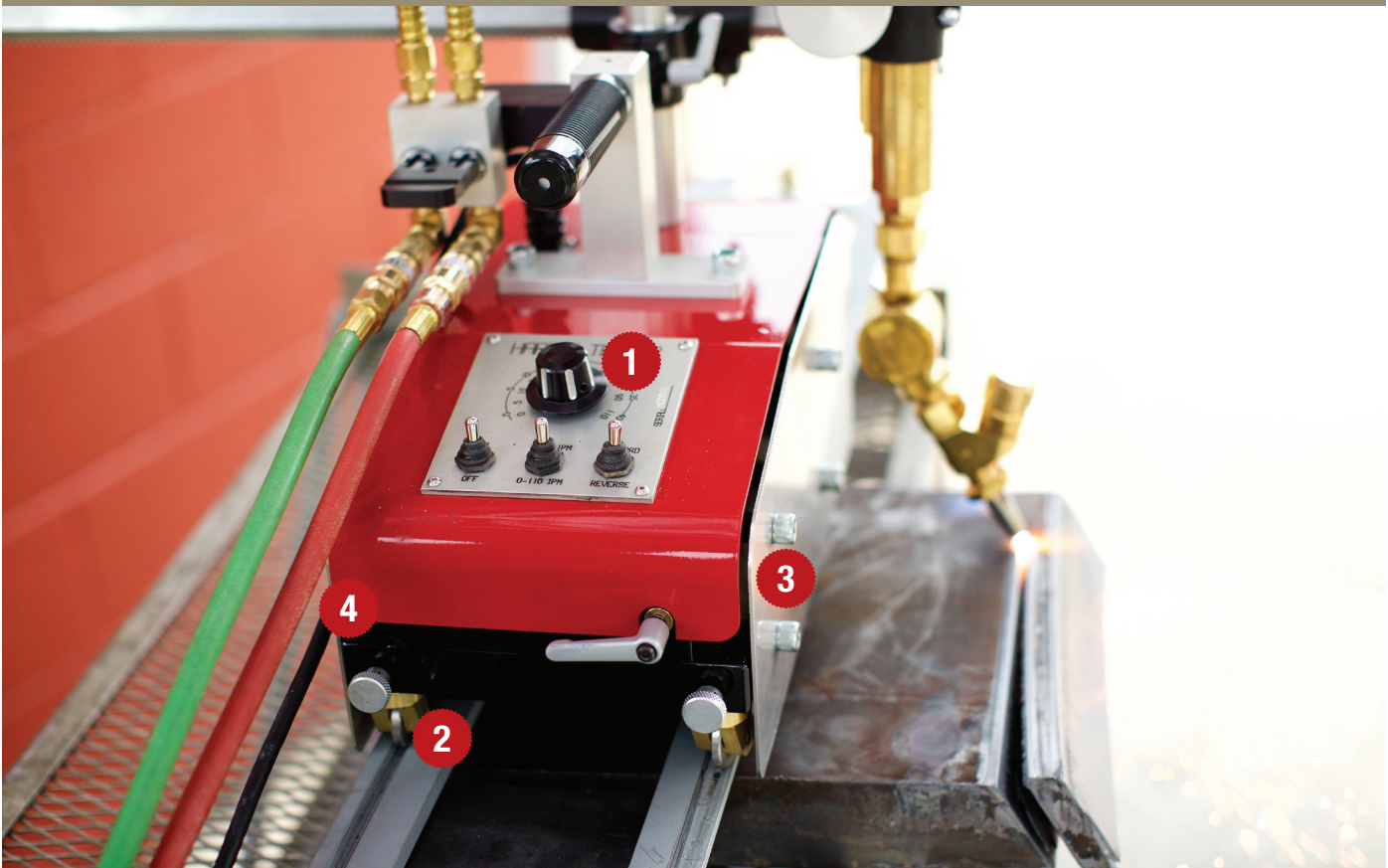
The Trakmax™ features both abrasion, corrosion resistant drive and caster wheels. The extra large 4" diameter drive wheels are knurled for positive traction and effortless travel resulting in the smoothest cuts. Dual function caster wheels can be adjusted for free wheeling circle cutting or locked for track cutting.

3 HEAT PROTECTION IS CRITICAL FOR LONG LIFE

The Trakmax™ is equipped standard with "full profile" heat shields on both sides, mounted close to the cutting surface for the most protection of vital internal components. Tractors not protected do not last when used for heavy continuous cutting and or when tractor is operated at or near the cutting surface.

4 ITS TRUE STRENGTH IS COVERED

The strength and durability of the Trakmax™ is in its unique welded steel uni-body construction. The easily removed cover is just that, a cover but it is specifically designed to protect the critical internal compacts from external sources of heat and dirt.



98-6F

MODEL

1YR
WARRANTY

ALTERNATE FUEL MACHINE CUTTING TORCH

MODEL SHOWN:
98-6TAFR-32

DESCRIPTION

The Model 98-6F machine cutting torch feature has a cutting "F" or (low pressure) for maximum performance using alternate fuels. Model 98 three hose machine cutting torches have a cutting capacity of 15". Two hose 98-6 torches have a barrel diameter of 1 3/8" and 32 pitch, 10.12 TPI rack that will fit any industry standard torch holder. Model 98 10" barrel torches have a cutting lever, and 18" barrel torches have a separate valve knob to actuate the cutting oxygen. The 98-6F is also available in a 3-hose valveless design for pipe beveling and multiple torch beveling.

DETAILS

Capacity: 2 hose - 8",
3 hose - 15"

Certifications: UL® listed

Mixer Type: "F" or low
pressure injector

Duty: Heavy

Where used: Straight and
contour machine cutting

Length: 10", 18" and 5 1/2"

Related items:
BV-98-2 P/N: 1200124
S-98-C P/N: 1200080
TH-98 P/N: 1200090



PART #	MODEL #	STYLE	CUTTING VALVE TYPE	BARREL LENGTH	WEIGHT (LBS.)	RECOMMENDED TIP STYLES	
						ACETYLENE-H ₂	ALTERNATE FUELS*
1101455	98-6FR-32	2 Hose	Lever	10"	3.3	6290	VVC
1101465	98-6TFR-32	3 Hose	Knob	10"	3.3	6290AC	VVCU
1101475	98-6TAFR-32	3 Hose	Knob	18"	4.2	6290S	VVCP
1100231	98-3TFR-32	3 Hose	None	5 1/2"	2.2	6290	VVCM

*Propylene or propane-based fuels and natural gas. NOT FOR USE WITH ACETYLENE.

98-6E

MODEL

1YR
WARRANTY

ACETYLENE MACHINE CUTTING TORCH

MODEL SHOWN:
98-6ER-32

DESCRIPTION

The Harris Model 98-6E machine cutting torch features an "E" or positive equal pressure mixer generally recommended for acetylene. Harris Model 98-6 three hose cutting torches have a cutting capacity of 15" and two hose torches cut to 8". All machine torches have a barrel diameter of 1 3/8" and 32 pitch, 10,12 teeth per inch rack that will fit any industry standard torch holder. Model 98 10" barrel torches have a cutting lever and 18" barrel torches have a separate valve knob to actuate the cutting oxygen.

DETAILS

Capacity: 2 hose - to 8";
3 hose - to 15"

Certifications: UL® listed
Mixer Type: "E" or positive
pressure

Duty: Heavy

Where used: Straight and
contour cutting

Length: 10"-18"

Related items:
S-98-C - P/N: 1200080
TH-98 - P/N: 1200090



PART #	MODEL #	STYLE	CUTTING VALVE TYPE	BARREL LENGTH	WEIGHT (LBS.)	RECOMMENDED TIP STYLES	
						ACETYLENE-H ₂	ALTERNATE FUELS*
1101425	98-6ER-32	2 Hose	Lever	10"	3.3	6290	VVC
1101435	98-6TER-32	3 Hose	Knob	10"	3.3	6290AC	VVCM
1101445	98-6TAER-32	3 Hose	Knob	18"	4.2	6290S	VVCP VVCU

Note: 98-6E torches are generally recommended for Acetylene fuel gases



THE HARRIS PRODUCTS GROUP
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Orders: 1.800.733.4043

80

MODEL



JUMBO MACHINE CUTTING TORCH

MODEL SHOWN:
80-R-32

DESCRIPTION

The Model 80 Jumbo Machine Cutting Torch has a recommended cutting range of 8" to 30". It operates on fuel pressures of 10-15 PSIG. It features a solid head for maximum strength, and requires 1/2" oxygen cutting hose with "C" or 7/8" - 14 connections. Standard barrel diameter is 1 3/8" and the Model 80-A-32 includes a 32 pitch 10.12 teeth per inch rack. The Model 80 is for use with alternate fuels.

DETAILS

Capacity: 30"

Mixer Type: "E" equal or positive pressure

Where used: Heavy straight or contour cutting

Duty: Heavy



				TIP STYLES
PART #	MODEL #	STYLE	CUTTING VALVE TYPE	ALTERNATE FUELS*
1100030	80-R-32	3 Hose, w/ rack	Lever	8090

*Propylene or propane-based fuels and natural gas. Not for use with acetylene.

524

MODEL



ALTERNATE FUEL MACHINE CUTTING TORCH

MODEL SHOWN:
QC1HS524RB-2

DESCRIPTION

The 524 series machine torch is used in all types of applications from general to heavy cutting. The primary design feature of the 524 torch series is positive pressure tip mix design. This design allows for greater flow rates while enhancing safety and maximizing versatility. Torches can be used with alternate fuels (above 5psi) and are available in two hose and three hose models. Two hose models have a cutting range up to 15 inches, while three hose models have a cutting range up to 30". It has a standard 1-3/8" diameter barrel with and includes a 32 pitch 10.12 teeth per inch rack.

DETAILS

Capacity:
2 hose - to 15"; 3 hose - to 30"

Mixer Type:
"E" or positive pressure

Duty: Heavy

Where used:
Straight and contour cutting

Length: 10"-18"

Related items:
TH-98 - P/N: 1200090



PART #	STYLE	HOSE FITTING	CUTTING VALVE TYPE	BARREL LENGTH	WEIGHT (LBS.)	FUEL TYPE	CUT CAPACITY	TIP STYLES
QC1HS524R	3 Hose	B-Ph/ C Cutting	1/4 Turn Ball	20"	6.5 lbs	Alternate	30"	136/139/140
QC1HS524RB-2	2 Hose	B	Lever	20"	5.5 lbs	Alternate	15"	136/139/140
QC1HS524RS	3 Hose	B-Ph/ C Cutting	1/4 Turn Ball	10"	4 lbs	Alternate	30"	136/139/140
QC1HS524RSB-2	2 Hose	B	Lever	10"	3.5 lbs	Alternate	15"	136/139/140



VVC 6290

MODEL



PREMIUM MACHINE CUTTING TIPS

MODEL SHOWN:
6290 VVC

DESCRIPTION

High-speed oxy-propane/natural gas cutting tip with a chrome-plated shell (.088 cup depth).

DETAILS

- Minimizes kerf
- Increased cutting speeds, reduces heat input
- High-quality cut, reduces after work
- Used with low-cost fuel gases
- NH tips listed are not plated and have heat-resistant heavy shell*

Compatible Equipment:

E-9 Tip cleaner P/N: 9000160



PART #	TIP SIZE	PLATE THICKNESS INCHES	CUTTING SPEED I.P.M	CUTTING OXYGEN PSIG	PREHEAT OXYGEN PSIG		PREHEAT FUEL PSIG	CUTTING OXYGEN CONSUMPTION SCFH	LOW PREHEAT OXYGEN CONSUMPTION SCFH	PROPANE CONSUMPTION SCFH	NATURAL GAS CONSUMPTION SCFH	APPROXIMATE KERF INCHES
					HIGH	LOW						
1501310	5/0	3/16	20	40	15	8	4 oz.-2PSIG	15	20 - 30	6	15	.05
1501320	4/0	1/4	20	50	15	10	4 oz.-2PSIG	40	20 - 35	7	18	.06
1501330	3/0	5/16	18	75	35	10	4 oz.-2PSIG	80	20 - 35	7	18	.07
1501340	2/0	1/2	18	75	35	10	4 oz.-2PSIG	90	25 - 35	7	18	.07
1501350	0	3/4	15	90	35	10	4 oz.-2PSIG	125	25 - 35	7	18	.08
1501360	0 1/2	1 1/4	14	100	35	12	4 oz.-2PSIG	170	25 - 40	8	20	.09
1501370	1	2	13	100	35	12	4 oz.-2PSIG	200	25 - 40	8	20	.11
1501380	1 1/2	3	9	100	35	12	4 oz.-2PSIG	250	25 - 40	8	20	.12
1501390	2	4	7	100	35	12	4 oz.-2PSIG	325	25 - 40	8	20	.13
1501400	2 1/2	5	6	100	35	12	4 oz.-2PSIG	395	25 - 40	8	20	.14
1501410	3	6	5	100	40	30	4 oz.-2PSIG	425	25 - 40	8	20	.16
1501420	4	8	5	100	40	35	4 oz.-2PSIG	525	25 - 40	8	20	.20
1501430	5	9	4	90	40	30	4 oz.-2PSIG	580	50 - 100	20	50	.25
1501440	5 1/2	10	4	90	40	30	4 oz.-2PSIG	600	50 - 100	20	50	.25
1501120	5NH*	10	4	60	40	30	4 oz.-2PSIG	600	50 - 100	20	50	.25
1501130	6NH*	11	4	60	40	30	4 oz.-2PSIG	690	50 - 100	20	50	.25
1501140	7NH*	12	4	60	50	40	4 oz.-2PSIG	825	50 - 100	20	50	.25
1501190	8NH*	15	3	60	50	40	4 oz.-2PSIG	925	50 - 100	20	50	.30

NOTES:

- (1) next size larger tip with same PSIG for contour or intricate cutting.
- (2) For thin plate cutting use a highly carbonizing preheat flame.
- (3) Cutting oxygen pressures should be measured at torch entry.
- (4) When using two hose machine torches set oxygen pressure at cutting oxygen PSIG above.



**WHY DO PROS USE
TRAXMAX™
TRACTORS?
BECAUSE PROS
USE THE BEST!**

IT'S JUST THAT SIMPLE.



THE HARRIS PRODUCTS GROUP
www.harrisproductsgroup.com

Orders: 1.800.733.4043

VVCU 6290 MODEL



ECONOMICAL MACHINE CUTTING TIPS

MODEL SHOWN:
6290 VVCU

DESCRIPTION

High-speed oxygen propane/natural gas cutting tip with an unplated shell (.062 cup depth).

DETAILS

- Minimizes kerf
- Increased cutting speeds, reduces heat input
- High-quality cut, reduces after work
- Used with low-cost fuel gases

Compatible Equipment:
E-9 Tip cleaner P/N: 9000160



PART #	TIP SIZE #	PLATE THICKNESS INCHES	CUTTING SPEED I.P.M	CUTTING OXYGEN PSIG	PREHEAT OXYGEN PSIG		PREHEAT FUEL PSIG	CUTTING OXYGEN CONSUMPTION SCFH	LOW PREHEAT OXYGEN CONSUMPTION SCFH	PROPANE CONSUMPTION SCFH	NATURAL GAS CONSUMPTION SCFH	APPROXIMATE KERF INCHES
					HIGH	LOW						
1502120	5/0	3/16	20	40	15	8	4 oz.-2PSIG	15	30	6	15	.05
1502121	4/0	1/4	20	50	15	10	4 oz.-2PSIG	40	35	7	18	.06
1502122	3/0	3/8	18	75	35	10	4 oz.-2PSIG	80	35	7	18	.07
1502123	2/0	1/2	18	75	35	10	4 oz.-2PSIG	90	35	7	18	.07
1502124	0	3/4	15	90	35	10	4 oz.-2PSIG	125	35	7	18	.08
1502125	0 1/2	1 1/4	14	100	35	12	4 oz.-2PSIG	170	40	8	20	.08
1502126	1	2	13	100	35	12	4 oz.-2PSIG	200	40	8	20	.09
1502127	1 1/2	3	9	100	30	25	4 oz.-2PSIG	250	40	8	20	.11
1502128	2	4	7	100	30	35	4 oz.-2PSIG	325	40	8	20	.12
1502129	2 1/2	5	6	100	30	35	4 oz.-2PSIG	395	40	8	20	.13
1502130	3	6	5	100	50	40	4 oz.-2PSIG	425	40	8	20	.14
1502131	4	8	5	100	50	40	4 oz.-2PSIG	525	40	8	20	.16
1502132	5	9	4	90	50	40	4 oz.-2PSIG	580	100	20	50	.20

NOTES:

- (1) Use next size larger tip with same PSIG for contour or intricate cutting.
- (2) For thin plate cutting use a highly carbonizing preheat flame.
- (3) Cutting oxygen pressures should be measured at torch entry.
- (4) When using two hose machine torches set oxygen pressure at cutting oxygen PSIG above.



**PROS AND TRAXMAX™ TRACTORS
THE PERFECT PAIR!**



VVCP 6290

MODEL



PREMIUM HIGH SPEED MACHINE CUTTING TIPS FOR PROPYLENE

DESCRIPTION

High speed oxygen propylene cutting tips with a chrome-plated shell (.034 cup depth). Ideal for machining cutting using propylene-based fuel gases.

DETAILS

- Minimizes kerf
- Increases cutting speed
- Reduces heat input
- High-quality cut reduces after work
- Uses lower-cost fuel gases

Compatible Equipment:

E-9 Tip cleaner P/N: 900160



PART #	TIP SIZE #	PLATE THICKNESS INCHES	CUTTING SPEED I.P.M	CUTTING OXYGEN PSIG	HIGH	LOW	PREHEAT FUEL PSIG	CUTTING OXYGEN CONSUMPTION	LOW PREHEAT OXYGEN CONSUMPTION	PROPYLENE CONSUMPTION SCFH	APPROX. KERF IN.
1502200	5/0	3/16	20	40	12	8	2	15	32	13	.05
1502202	4/0	1/4	20	50	12	8	2	40	32	13	.06
1502204	3/0	3/8	18	75	25	8	2	80	32	13	.08
1502206	2/0	1/2	18	90	25	8	2	90	32	13	.07
1502208	0	3/4	15	100	25	8	2	125	32	13	.08
1502210	0 - 1/2	1 1/4	14	100	25	8	2	170	32	13	.08
1502212	1	2	13	100	25	10	2	200	40	16	.09
1502214	1 1/2	3	9	100	25	10	2	250	40	16	.11
1502216	2	4	7	100	25	10	2	325	40	16	.12
1502218	2 1/2	5	6	100	30	10	2	395	40	16	.13
1502220	3	6	5	100	30	10	2	425	40	16	.14
1502222	4	8	5	100	30	10	2	525	40	16	.16
1502224	5	9	4	90	30	10	2	580	40	16	.20

(1) Use next size larger tip with same PSIG for contour or intricate cutting. (2) For thin plate cutting use a highly carbonizing preheat flame. (3) Cutting oxygen pressures should be measured at torch entry. (4) When using two hose machine torches set oxygen pressure at cutting oxygen PSIG above

GENERAL PREHEAT SINGLE PIECE, STANDARD SPEED CUTTING TIPS

6290

MODEL



DESCRIPTION

A single-piece acetylene cutting tip for cutting relatively clean steel.

DETAILS

Construction: One-piece copper unplated

Preheat Type: General

Where Used: Fabrication, maintenance, etc.

Compatible Equipment:

C-9 Tip cleaner P/N: 9000156



PART #	SIZE	DEPTH OF CUT	O ₂ PSIG	TOTAL O ₂ SCFH	ACETYLENE FUEL PSIG	FUEL SCFH	DRILL CUT SIZE
1500810	000	Light gauge to 3/16"	15 - 20	35 - 40	5 - 15	10 - 15	# 68
1500820	00	3/16" - 3/8"	20 - 25	45 - 50	5 - 15	10 - 15	# 64
1500830	0	3/8" - 5/8"	35 - 40	45 - 50	5 - 15	10 - 15	# 60
1500840	1	5/8" - 1"	35 - 40	100 - 110	5 - 15	15 - 25	# 56
1500850	2	1" - 2"	40 - 45	180 - 195	10 - 15	20 - 30	# 52
1500860	3	2" - 3"	45 - 50	270 - 290	10 - 15	20 - 35	# 48
1500870*	4	3" - 6"	50 - 75	450 - 600	10 - 15	25 - 40	# 42

*To provide proper gas flow, use 3/4" 1D hose for size 4 tip and larger



6290-S

MODEL



HEAVY PREHEAT SINGLE PIECE ACETYLENE TIPS

MODEL SHOWN:
6290-S

DESCRIPTION

A single-piece acetylene tip with a heavy preheat to facilitate cutting steel that is painted, rusted or has a heavily scaled surface.

DETAILS

Construction: One-piece unplated copper

Preheat Type: Heavy

Where Used: Demolition, maintenance, repair, etc.

Compatible Equipment:
C-9 Tip cleaner P/N: 9000156



PART #	SIZE	DEPTH OF CUT	O ₂ PSIG	TOTAL O ₂ SCFH	ACETYLENE FUEL PSIG	FUEL SCFH	DRILL CUT SIZE
1501470	1S	5/8" - 1"	35 - 40	100 - 110	5 - 15	15 - 25	# 56
1501480	2S	1" - 2"	40 - 45	190 - 205	5 - 15	20 - 30	# 52
1501490	3S	2" - 3"	45 - 50	285 - 305	5 - 15	20 - 35	# 48
1501500	4S	3" - 6"	50 - 75	465 - 615	10 - 15	25 - 40	# 42
1501510*	5S	6" - 8"	65 - 80	700 - 850	10 - 15	35 - 40	# 35
1501520*	6S	8" - 12"	70 - 90	960 - 1160	10 - 15	40 - 60	# 30

*To provide proper gas flow, use 3/8" ID hose for Size 4 tip and larger.

6290-AC

MODEL



HEAVY PREHEAT TWO-PIECE ACETYLENE TIPS

MODEL SHOWN:
6290-AC

DESCRIPTION

A two-piece acetylene tip with a heavy preheat to facilitate cutting steel that is painted, rusted or has a heavily scaled surface. Often recommended for acetylene machine cutting because of its unique preheat pattern.

DETAILS

Construction: Two-piece

Preheat Type: Heavy

Where Used: Demolition, maintenance acetylene machine cutting

Compatible Equipment:
E-9 Tip cleaner P/N: 9000160



PART #	SIZE	DEPTH OF CUT	O ₂ PSIG	TOTAL O ₂ SCFH	ACETYLENE FUEL PSIG	FUEL SCFH	DRILL CUT SIZE
1502170	00AC	3/16" - 3/8"	15 - 30	38 - 55	8 - 15	9 - 18	# 64
1502171	0AC	3/8" - 9/16"	20 - 35	45 - 73	8 - 15	9 - 18	# 60
1502172	1AC	5/8" - 1"	30 - 50	73 - 128	8 - 15	18 - 36	# 56
1502173	2AC	1" - 2"	40 - 65	161 - 252	8 - 15	18 - 36	# 53
1502174	3AC	2" - 4"	40 - 65	196 - 287	8 - 15	18 - 36	# 52
1502175	4AC	4" - 7"	50 - 80	338 - 534	8 - 15	18 - 36	# 42
1502176*	5AC	7" - 10"	65 - 80	494 - 625	8 - 15	32 - 54	# 35
1502177	6AC	10" - 12"	70 - 95	565 - 731	8 - 15	32 - 54	# 31

*To provide proper gas flow, use 3/8" ID hose for Size 4 tip and larger.

8090

MODEL



HIGH CAPACITY MACHINE CUTTING TIPS

DESCRIPTION

For Model 8090 Jumbo Machining Torch used with propane and natural gas.* Operates on fuel pressures of 10 to 15 PSIG.

DETAILS

Construction:

Screw in - tip mix

Where Used:

For heaving cutting 8"-30"



PART #	TIP SIZE #	METAL THICKNESS INCHES	SPEED INCHES PER MINUTE	OPERATING PRESSURES PSIG	ORIFICE DIA. INCHES	GAS FLOW CUBIC FEET PER HOUR
1501910	0	8 - 12	6 - 3	CUT. OXYGEN - 30-60	5/32	600 - 1500
1501920	1	-	-	P.H. OXYGEN - 20-40	3/16	200 - 375
				PROPANE - 10-15	-	55 - 105
1501920	1	12 - 16	6 - 3	CUT. OXYGEN - 30-60	3/16	1900 - 3600
1501930	2	-	-	P.H. OXYGEN - 25-50	1/4	250 - 425
				PROPANE - 10-20	-	55 - 125
1501930	2	16 - 20	4 - 2	CUT. OXYGEN - 25-50	1/4	1900 - 3600
1501940	3	-	-	P.H. OXYGEN - 25-50	9/32	250 - 425
				PROPANE - 10-20	-	55 - 125
1501940	3	20 - 25	3 - 1 1/2	CUT. OXYGEN - 25-50	9/32	2100 - 4400
1501950	4	-	-	P.H. OXYGEN - 25-50	5/16	250 - 425
				PROPANE - 10-20	-	55 - 125
1501950	4	OVER 25	3 - 1	CUT/ OXYGEN - 40-90	5/16	2100 - 4400
1501960	4 1/2	-	-	P.H. OXYGEN - 25-50	1 1/32	250 - 425
				PROPANE - 10-20	-	55 - 125

*NOTE: Propylene style available as SPECIAL ORDER. Call Customer Service.

136

MODEL



HEAVY PREHEAT HIGH CAPACITY CUTTING TIPS

MODEL SHOWN:
136-11

DESCRIPTION

A two-piece acetylene tip with a heavy preheat to facilitate cutting steel that is painted, rusted or has a heavily scaled surface.

DETAILS

Construction:

One piece skirted with tip nut

Preheat Type:

Heavy "U" groove splines for alternate fuel

Where Used:

Scrap, demolition & heavy cutting



PART #	DEPTH OF CUT	O ₂ PSIG	TOTAL O ₂ SCFH	ACETYLENE FUEL PSIG	FUEL SCFH	DRILL CUT SIZE
QC13611	12"-19"	60 - 80	950 - 2900	8 - 15	130-350	3/16"
QC13613	19"- 28"	60 - 80	2100-4000	10 - 15	150 - 400	1/4"
QC13615	28"-36"	80 - 100	2500 - 4500	15 - 20	180 - 450	11/32"

Note: Not use with acetylene. Features a heavy shell with shroud, captive nut and standard preheat.



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Orders: 1.800.733.4043

139

MODEL

HIGH CAPACITY HIGH SPEED MACHINE CUTTING TIPS

MODEL SHOWN:
139

DESCRIPTION

Two piece machine cutting tip for with alternate fuel.
Brass internal with precision machined splines for maximum heat transfer.
Heavy-wall, chrome plated solid copper external.

DETAILS

Construction:

Two Piece

Preheat Type:

Medium with 22 Deg. "V" splines for alternate fuel

Where Used:

Machine cutting, slitting & beveling



PART #	TIP SIZE #	PLATE THICKNESS INCHES	CUTTING OXYGEN CONSUMPTION	PREHEAT OXYGEN CONSUMPTION	PROPYLENE CONSUMPTION SCFH	TOTAL OXYGEN CONSUMPTION (CFH)	FUEL GAS CONSUMPTION	CUTTING SPEED	KERF	DRILL SIZE
QC2TIP139-0	0	1/2"	30-55 PSIG	25-30 PSIG	12-15	60-80	13-18	21-26 IPM	0.06	65
QC2TIP139-01	1	3/4"	30-55 PSIG	25-30 PSIG	12-15	110-130	13-18	20-25 IPM	0.07	61
QC2TIP139-02	2	1"	40-50 PSIG	35-40 PSIG	12-15	120-140	13-18	18-23 IPM	0.08	54
QC2TIP139-03	3	2"	55-65 PSIG	35-40 PSIG	15-18	175-195	20-25	13-17 IPM	0.095	51
QC2TIP139-04	4	3"	55-65 PSIG	35-40 PSIG	15-18	275-295	20-25	8-15 IPM	0.105	49
QC2TIP139-05	5	4"	55-65 PSIG	35-40 PSIG	15-18	315-325	20-25	7-13 IPM	0.115	46
QC2TIP139-06	6	6"	60-70 PSIG	50-55 PSIG	15-18	450-480	30-35	6-10 IPM	0.17	39
QC2TIP139-07	7	8"	60-70 PSIG	50-55 PSIG	18-22	590-840	30-35	5-7 IPM	0.18	35
QC2TIP139-08	8	12"	70-80 PSIG	50-55 PSIG	18-22	900-970	30-35	4-6 IPM	0.22	31
QC2TIP139-09	9	16"	70-80 PSIG	55-65 PSIG	18-22	1480-1560	40-55	4-6 IPM	0.3	20
QC2TIP139-10	10	18"	70-80 PSIG	55-65 PSIG	18-22	1890-2240	40-55	2-4 IPM	0.34	8
QC2TIP139-11	11	20"	60-70 PSIG	55-65 PSIG	18-22	2400-2750	40-55	2-4 IPM	0.375	3

NOTE: All pressures are measured at the torch inlet. The tables shown are average values and are to be used as a guide only. The type, quality of steel and its general condition will affect the results.

140

MODEL

HEAVY PREHEAT HIGH CAPACITY MACHINE CUTTING TIPS

MODEL SHOWN:
140

DESCRIPTION

One piece heavy duty cutting tip for alternate fuels.
Versatile tip design allows for applications from scrap cutting, slitting, machine cutting and beveling without the use of auxiliary preheat devices.
V-shaped splines increase gas flow, improves heat transfer and flame stability.
A low cost, straight bore tip with heavy preheat.

DETAILS

Construction: One Piece

Preheat Type: Heavy with 36 Degree "V" splines for alternate Fuel

Where Used: Scrap and machine cutting, slitting and beveling

Related items:

Single-piece requires separate tip nut
P/N: QC1WHP13601P



PART #	MODEL #	DEPTH OF CUT	O ₂ PSIG	O ₂ FLOW SCFH	FUEL PSIG	FUEL SCFH	DRILL CUT SIZE
QC14009	140-09	15"	65-85	1300-1500	12-15	100-120	5/32"
QC14011	140-11	19"	65-85	1700-1950	12-15	130-160	3/16"
QC14012	140-12	20"	65-85	1800-2250	12-15	165-180	7/32"
QC14013	140-13	25"	65-85	2100-2500	15-18	125-210	1/4"

NOTE: Not for use with acetylene. A low cost, straight bore tip with heavy preheat.

ACCESSORIES

MACHINE CUTTING ACCESSORIES



BV-98-2 Beveling Head
P/N: 1200124

Increases speed of quality bevel cuts. Preheat tip swivels for either left or right travel. Equipped with 1390-3H heating tip. Use with natural gas or propane 6290 tips (not included).



S-98-C Adjustable Tip Adapter
P/N: 1200080

Adjust tip to any angle without moving the torch. Use with any 6290 tips (not included).



Model TH-98 Adjustable Twin Tip Holder
P/N: QC1HS524TH-12

For making two cuts simultaneously with one torch. Adjust from 1½" to 12" width. Use with any 6290 tips (not included).



Welding/Plasma Holder*
P/N: QC2SCM0815

Universal holder that securely clamps most shapes, brands and or types of plasma and MIG torches.



Torch Holder
P/N: QC2SCM0800

For mounting 1 3/8" diameter machine cutting torches and controlling the vertical movement of the torch.



Counter Weight
P/N: QC2SCM2700

May be attached to opposite side of gear rack when off balance loading of equipment is encountered such as when running two torches on one side. Standard operation does not require counterweights.



Connecting Block*
P/N: QC2SCM0518

Attaches torch or welding/ plasma holders to gear rack.

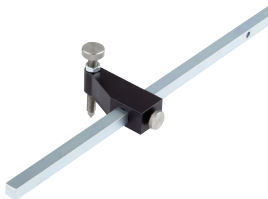
Connections:
3/4" dia. (F) x 3/4" dia. (F)



Extension Block (4")*
P/N: QC2SCM0521

Attaches welding/plasma holder to connecting block.

Connections:
3/4" dia. (F) x 3/4" dia. (M)



Radius Rod Kit
P/N: QC2SCM2710

18" radius bar, sliding pivot pin – cuts 2 – 54" diameter circles. For larger diameter circle cutting contact Harris Products Group.

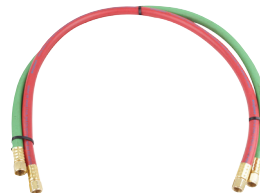


50' 3/8" T Grade Hose
P/N: 4300847

For all fuel gases

100' 3/8" T Grade Hose
P/N: 4300848

For all fuel gases



3' Twin T-Grade Hose
P/N: QC2SCM0400

3' twin, grade T, hose to connect the torch to the hose block

*Component of welding/plasma rigging kit (P/N: QC25CM2570)

ACCESSORIES

MACHINE CUTTING ACCESSORIES



Universal* Connectible Track System

PART #	DESCRIPTION
QC2SCM2600	Track, 6'
QC2SCM2601	Track, 7.5'
QC2SCM2602	Track, 9'
QC2SCM2603	Track, 12'

*Compatible with other domestic track systems



Power Cord, with connector and plug

PART #	DESCRIPTION
QC2SCM2735	Cord, 25' TRC 622 power
QC2SCM2737	Cord, 50' TRC 622 power
QC2SCM2739	Cord, 100' TRC 622 power



Diamond Drive Gear Rack

MODEL SHOWN: P/N: QC2SCM2630

PART #	DESCRIPTION
QC2SCM2630	Gear, 524 30" rack
QC2SCM2648	Gear, 524 48" rack
QC2SCM2650	Gear, 524 24" rack



Hose Blocks

MODEL SHOWN: P/N: QC2SCM2655

PART #	DESCRIPTION
QC2SCM2655	Hose block, 2 hose with flip-valve
QC2SCM2660	Hose block, 3 hose, without valves
QC2SCM2661	Hose block, 3 hose & flip valves
QC2SCM2662	Hose block, 3 hose rack mount
QC2SCM2663	Hose block, 3 hose with flip-valves and rack mount

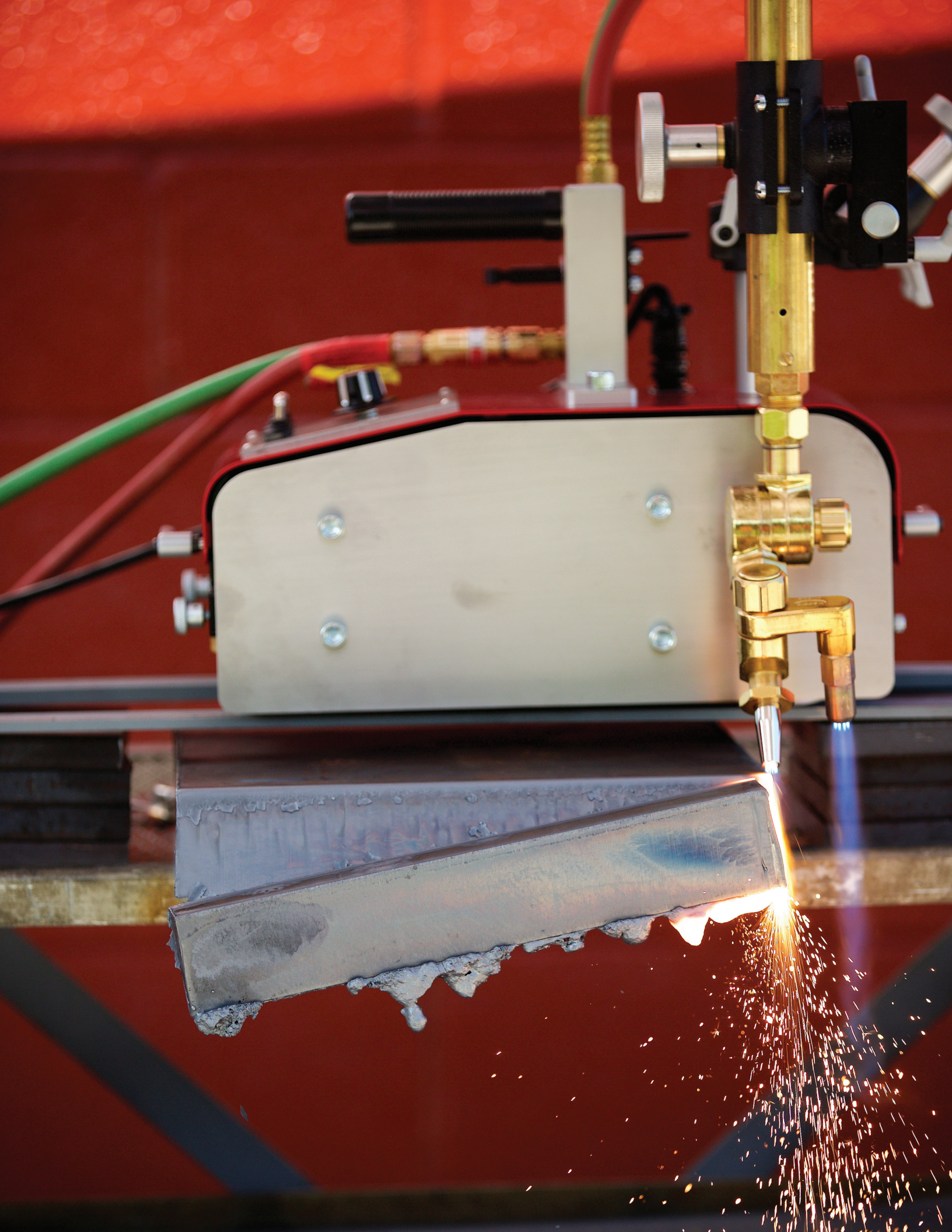


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