

HARRIS PRODUCTS GROUP AUSTRALIA



ABN 45 102 938 876

VVC TIPS CUTTING CHART TABLE

Cutting Thickness	Tip Size No.	Speed mm/min	Kerf Width	Pressure bar	Consumption lt/hr	Prop. Consump. Lt/hr	Oxy. Consump. lt/hr
2 - 4	5/0VVC	550-750	0.85	4.0	650	230	800
4 - 6	4/0VVC	520-700	1.55	2.5	1100	230	800
6 - 9	3/0VVC	480-650	1.65	5.0	1950	300	1000
9 - 12.5	2/0VVC	450-630	1.9	5.0	2550	300	1000
12.5 - 20	0VVC	400-600	1.9	6.0	3200	300	1000
20 - 35	0.5VVC	360-550	1.9	7.0	3900	300	1000
35 - 60	1VVC	250-480	1.9	7.0	5000	300	1000
50 - 60	1VVC	220-400	2.05	7.0	5550	300	1000
60 - 75	1.5VVC	200-310	2.05	6.5	6800	300	1000
75 - 100	2VVC	150-280	2.3	6.5	8000	330	1100
100 - 125	2VVC	180-240	2.3	7.0	8700	330	1100
125 - 150	2.5VVC	160-200	2.3	6.5	11000	330	1100
150 - 175	3VVC	150-180	2.8	7.0	13600	330	1100
175 - 200	4VVC	150-180	3.3	6.5	15500	330	1100
200 - 225	5VVC	130-150	3.8	6.0	15800	380	1300
225 - 250	5.5VVC	110-130	4.3	6.0	16700	380	1300

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***Use minimum 0.015 bar (1.5kpa) Fuel gas pressure (100kpa = 1 Bar)**

***Use approx. 0.7 bar (70kpa) Pre-heat Oxygen pressure when on low.**

***High Pre-heat Oxygen, max 350kpa.**