



PROFESSIONAL PRODUCTS...
SUPERIOR RESULTS™

THE HARRIS PRODUCTS GROUP

6290 & 6290S CUTTING TIP FLOW CHART

ACETYLENE

TIP SIZE	PLATE THICKNESS IN INCHES	CUTTING OX PRESSURE PSIG	CUTTING ORIFICE DRILL SIZE	CUTTING OXYGEN FLOW CFH	P.H. OXYGEN FLOW CFH		ACETYLENE PRESSURE PSIG	ACETYLENE FLOW CFH
					6290	6290S		
000	Light Gauge to 3/16"	15 - 20	#68	20-25	15	---	5-15	10-15
00	3/16"-3/8"	20-25	#64	30-35	15	---	5-15	10-15
1 & 1S	5/8"-1"	35-40	#56	75-85	22	25	5-15	15-25
2 & 2S	1"-2"	40-45	#52	160-175	20	30	5-15	20-30
3 & 3S	2"-3"	45-50	#48	250-270	20	35	5-15	20-35
4 & 4S	3"-6"	50-75	#42	425-575	25	40	10-15	25-40
5S	6"-8"	65-80	#35	650-800	35	50	10-15	35-50
6S	8"-12"	70-90	#30	900-1100	40	60	10-15	40-60

NOTES:

Preheat flows are average cutting conditions with hand torches.

6290S tips are heavy preheat tips for unusually rusty, scaled, or heavily painted plate.

Cleaning: Use Harris Tip Cleaner C-9 (PN 9000156) for cleaning preheat holes and cleaning spatter from tip face. Use Harris E-9 (PN 9000160) on 6290AC tips.

Hose: Use 3/8" I.D. hose for tip size 4 or larger and 1/4" I.D. or larger for Tip sizes 1 and 2.