

816 Series Nozzles For Alpha Style Torches *by American Torch Tip*

SPECS

Nozzle Type

Cutting Tip Series
1232 & 1282 Alpha Style

Design

Tapered

Capacity

Up to 300 mm

Sizes

3 mm to 300 mm

Gas Service

Natural Gas / Propane

Innovative Design

New tapered design improves gas flow and reduces turbulence

Materials

Precision machined solid brass inner and swedged copper outer

Improved Cuts

No-Step shoulder means less slag build-up and time spent on secondary clean-up operations

Fast Pre-Heat

Easy Clean

Tapered nozzle and continuous flutes are easier to clean

Less Down Time

Increase your efficiency and productivity by spending less time on consumables replacement

Made In USA

American Torch Tip has been manufacturing oxy-fuel consumables since 1940



See cut quality samples on page 2



816 Series

ATTC Part #	Type	Size	Compatibility
816.16321ATT	Insert (Tapered)	3-10 MM	Use with 816.16320 Outer Nozzle
816.16322ATT	Insert (Tapered)	7-15 MM	Use with 816.16320 Outer Nozzle
816.16323ATT	Insert (Tapered)	15-25 MM	Use with 816.16320 Outer Nozzle
816.16324ATT	Insert (Tapered)	25-40 MM	Use with 816.16320 Outer Nozzle
816.16325ATT	Insert (Tapered)	40-60 MM	Use with 816.16320 Outer Nozzle
816.16326ATT	Insert (Tapered)	60-100 MM	Use with 816.16320 Outer Nozzle
816.16307ATT	Insert (Tapered)	100-200 MM	Use with 816.16300 Outer Nozzle
816.16308ATT	Insert (Tapered)	200-250 MM	Use with 816.16300 Outer Nozzle
816.16309ATT	Insert (Tapered)	250-300 MM	Use with 816.16300 Outer Nozzle
816.16320ATT	Outer Nozzle	3-100 MM	Use with insert sizes 3-100 MM
816.16300ATT	Outer Nozzle	100-300 MM	Use with insert sizes 100-300 MM
816.11301ATT	Torch Cap		All

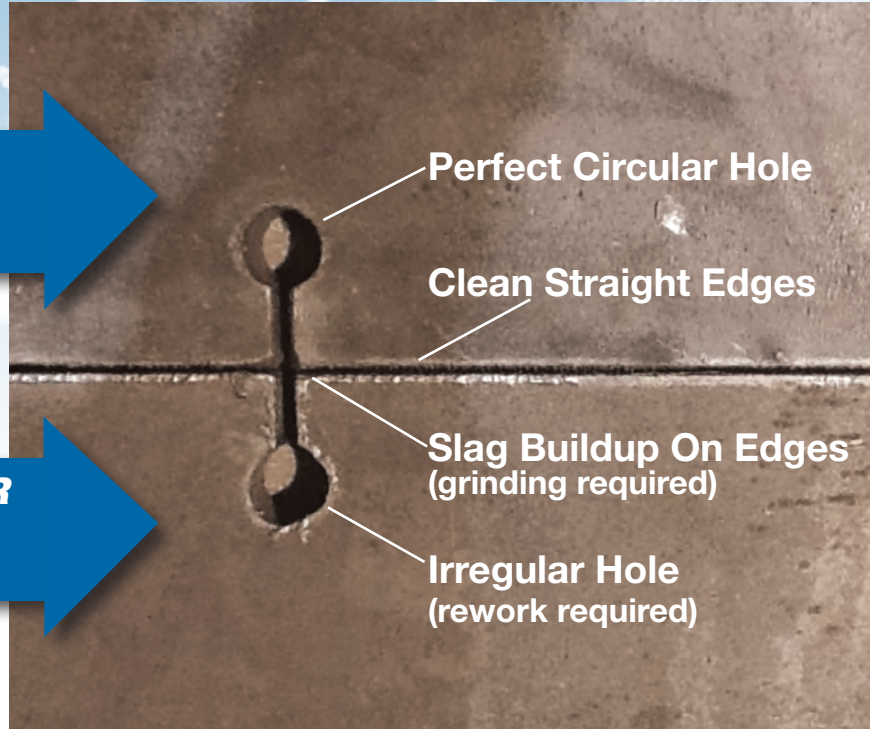
Note: ATTC® 816 Series Insert must be used with 816 Series Outer Nozzle and Torch Cap

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**ATTC®
NOZZLES
816 Series**

**Cut Quality
Test Results**

**COMPETITOR
NOZZLES
716 Series**



Cut Chart – Standard Settings for 816 Series Nozzles

Work piece thickness	Cutting nozzle size	Heating nozzle size	Propane pressure	Heating oxygen pressure	Cutting oxygen pressure	Cutting speed [in/min]	Nozzle clearance	Cutting kerf width	Propane consumption	Heating oxygen consumption	Cutting oxygen consumption	Total oxygen consumption	
IN			PSI	PSI	PSI	IN / MIN	IN	IN	ft ³ / h	ft ³ / h	ft ³ / h	ft ³ / h1	
1/8	1232-PMYF 3 - 10	GRIVA 2-100	10.15	21.76	14.50	30 45/64	5/64 - 5/32	1/32	9.88	38.85	21.19	60.04	
5/32				21.76	21.75	29 9/64	5/64 - 5/32	1/32	9.88	38.85	28.25	67.10	
13/64				21.76	29.00	28 11/32	5/64 - 5/32	3/64	9.88	38.85	35.32	74.16	
15/64				29.00	36.26	27 9/16	5/64 - 5/32	3/64	11.65	45.90	42.38	88.29	
5/16				29.00	50.76	25 19/32	5/32 - 13/64	3/64	11.65	45.90	56.50	102.41	
25/64				29.00	72.50	23 5/8	5/32 - 13/64	1/16	11.65	45.90	77.69	123.60	
9/32				72.50	26 3/8	5/32 - 13/64	1/16				63.57	116.54	
5/16				79.77	25 19/32	5/32 - 13/64	1/16				67.10	120.07	
25/64				87.02	24 51/64	13/64 - 5/16	5/64	13.42	52.97		70.63	123.60	
15/32				94.27	23 15/64	13/64 - 5/16	5/64				77.69	130.66	
19/32	1232-PMYF 10 - 25	GRIVA 2-100	10.15	101.50	22 3/64	13/64 - 5/16	5/64				81.22	134.20	
25/32				87.02	22 3/64	20 13/64 - 5/16	5/64	13.42	52.97		88.28	141.26	
63/64				94.2	5/64	5/16 - 25/64	3/32				98.88	151.85	
63/64				101.52	18 7/64	5/16 - 25/64	3/32				109.48	162.45	
1 3/16				87.02	18 7/64		3/32				134.20	187.17	
1 3/8				101.50	17 21/64	5/16-25/64	3/32	13.42	52.97		151.85	204.83	
1 3/8				108.78	16 17/32		7/64				158.92	211.89	
1 37/64				108.78	15 3/4		7/64				162.45	215.42	
1 37/64				79.77	15 3/4		7/64				148.32	201.29	
1 31/32				94.27	14 11/64	5/16-25/64	7/64	13.42	52.97		173.04	226.01	
2 23/64	108.77	13 25/64		7/64				197.76	250.73				
2 23/64	1232-PMYF 60 - 100	GRIVA 2-100	10.15	87.02	13 25/64	10 15/64-25/64	9/64				268.39	321.36	
3 5/32				108.78	11 13/16	10 15/64-25/64	9/64	13.42	52.97		331.96	384.93	
3 15/16				123.28	5/8		9/64				374.31	427.31	
3 15/16 5	1282-PMYF 100 - 200	GRIVA 2-100	10.15	108.78	10 5/8		9/64				469.69	550.91	
29/32 7 7/8				65.27	123.28	9 1/16	5/16 - 15/32	9/64	21.90	81.22		526.13	607.41
				137.78	7 3/32		5/32				582.69	663.92	
7 7/8 92	1282-PMYF 200 - 250	GRIVA 100-300	10.15	72.52	94.27	7 3/32	5/32				618.01	706.29	
7/32				123.28	5 1/8	15/32- 19/32	11/64	24.01	88.29		776.92	865.21	
9 27/32 11	1282-PMYF 250 - 300	GRIVA 100-300	10.15	72.52	94.27	5 1/8	15/32-19/32	13/64	24.01	88.29		791.05	
13/16				123.28	4 21/64		15/64				995.87	1084.2	