

1427 Alternate fuels operating data.

Steel Thickness	Tip Size	Cutting Oxygen (PSIG)	Preheat Oxygen (PSIG)*	Natural Gas (PSIG)	Cutting Speed I.P.M.	Cleaning Drill Size		Gas Consumption cfh		
						Preheat	Cutting	Cutting Oxygen	Preheat Oxygen	Natural Gas
12"	12	75-85	8-10	16-19	4-5	55	31	800-900	100-115	65-75
14"	14	60-70	7-9	8-11	3 1/2-4 4 1/2	54	28	950-1,100	115-140	75-95
16"	16	55-65	9-12	11-15	3-4 4 1/2	53	20	1,150-1,330	145-175	95-115
20"	20	45-55	13-18	17-23	2 1/4	52	8	1,450-1,700	170-225	125-150
24"	24	40-50	21-25	28-33	2-3 1/2	51	C	1,850-2,200	225-285	170-190
28"	28	30-40	28-33	39-45	2-3 1/2	50	K	1,950-2,400	315-350	210-235

1427 Series Tips: Cutting speeds are based on cutting steel at room temperature and have straight cylindrical cutting bores.

