

KOIKE



Quality Gas Cutting Tips For Accurate, Economical & Safer Cutting

102 Series for Acetylene



106 Series for LPG



102		• Standard Tip • For Acetylene					
Metric							
Plate thickness	Tip No.	Pressure kg/cm ²		Consumption NI/hr.			Cutting speed mm/min.
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
- 5	00	1.5		690	410	370	- 660
5 - 10	0	2.0		1200			660 - 550
10 - 15	1	2.5	0.2	2100			550 - 490
15 - 30	2		3.0	3400	480	430	490 - 400
30 - 40	3			4300			400 - 350
40 - 50	4	3.5	0.25	6500	550	500	350 - 320
50 - 100	5		0.3	11000	690	630	320 - 200
100 - 150	6	4.0	0.35	15000	770	700	200 - 150
150 - 250	7			22000			150 - 80
250 - 300	8	4.5	0.4	28000	1060	960	80 - 45

102D5		• Divergent High Speed • Cutting Oxygen Pressure 5kg/cm ²					
Metric							
Plate thickness	Tip No.	Pressure kg/cm ²		Consumption NI/hr.			Cutting speed mm/min.
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
- 5	(00)			850	520	470	- 700
5 - 10	0			1600			700 - 625
10 - 15	1		0.2	2400			625 - 550
15 - 30	2			3600	600	550	550 - 475
30 - 40	3			4800			475 - 425
40 - 50	4			5600	750	680	425 - 350
50 - 100	5		0.25	8800	860	780	350 - 250
100 - 150	6			13500	950	860	250 - 175
150 - 250	7		0.3	24000	1330	1210	175 - 90
250 - 300	8		0.4	31000	1600	1450	90 - 60

102D7		• Divergent High Speed • Cutting Oxygen Pressure 7kg/cm ²					
Metric							
Plate thickness	Tip No.	Pressure kg/cm ²		Consumption NI/hr.			Cutting speed mm/min.
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
- 5	(00)			750	520	470	- 750
5 - 10	0			1100			750 - 680
10 - 15	1		0.2	2500			680 - 600
15 - 30	2			3800	600	550	600 - 500
30 - 40	3			5400			500 - 450
40 - 50	4			7300	750	680	450 - 400
50 - 100	5		0.25	10000	860	780	400 - 260
100 - 150	6			14000	950	860	260 - 180
150 - 250	7		0.3	22000	1330	1210	180 - 100
250 - 300	8		0.4	35000	1600	1450	100 - 70

106		• Standard Tip • For LPG					
Metric							
Plate thickness	Tip No.	Pressure kg/cm ²		Consumption NI/hr.			Cutting speed mm/min.
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
- 5	00	1.5		690			- 660
5 - 10	0	2.0		1200	1180	310	660 - 550
10 - 15	1	2.5	0.2	2100			550 - 490
15 - 30	2		0.25	3400	1370	360	490 - 400
30 - 40	3			4300			400 - 350
40 - 50	4	3.5		6500			350 - 320
50 - 100	5		0.3	11000	1860	490	320 - 200
100 - 150	6	4.0		15000	3040	800	200 - 150
150 - 250	7			22000			150 - 80
250 - 300	8	4.5	0.4	28000	3720	980	80 - 45

106D5		• Divergent High Speed • Cutting Oxygen Pressure 5kg/cm ²					
Metric							
Plate thickness	Tip No.	Pressure kg/cm ²		Consumption NI/hr.			Cutting speed mm/min.
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
- 5	(00)			850			- 700
5 - 10	0			1600	1180	310	700 - 625
10 - 15	1		0.2	2400			625 - 550
15 - 30	2			3600	1370	360	550 - 475
30 - 40	3		0.25	4800			475 - 425
40 - 50	4			5600			425 - 350
50 - 100	5		0.3	8800	1860	490	350 - 250
100 - 150	6			13500	3040	800	250 - 175
150 - 250	7		0.4	24000	3720	980	175 - 90
250 - 300	8			31000			90 - 60

106D7		• Divergent High Speed • Cutting Oxygen Pressure 7kg/cm ²					
Metric							
Plate thickness	Tip No.	Pressure kg/cm ²		Consumption NI/hr.			Cutting speed mm/min.
		Oxygen	Fuel gas	Cutting oxygen	Preheat oxygen	Fuel gas	
- 5	(00)			750			- 750
5 - 10	0			1100	1180	310	750 - 680
10 - 15	1		0.2	2500			680 - 600
15 - 30	2			3800	1370	360	600 - 500
30 - 40	3		0.25	5400			500 - 450
40 - 50	4			7300			450 - 400
50 - 100	5		0.3	10000	1860	490	400 - 260
100 - 150	6			14000	3040	800	260 - 180
150 - 250	7		0.4	22000	3720	980	180 - 100
250 - 300	8			35000			100 - 70