

DOUBLE BEVEL CUTTING

75 Degree Bevel 3" both sides



Customer Situation:

Using propylene and a GPP Victor Tip

1. Cuts had groves
2. Had to preheat plate
3. Grind to smooth out groves
4. Flip over plate and start again
5. Travel speed 4 to 5 ipm.

Solution:

Used # 4 Mach 1 RIPPER TIP with Stainless Insert

Replaced Oxygen Regulator to a GI High Flow Stainless Diaphragm

Set Ox to 90 psi, Propylene Fuel gas to 10 but gauge was reading correctly

Travel speed to 10 ipm

Removed double flashback arrestors causing restrictions.

RESULTS:

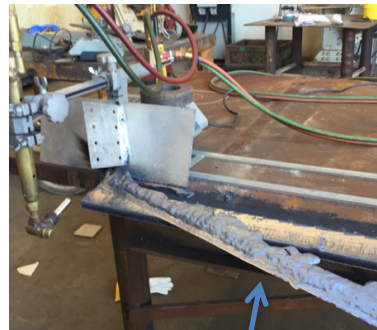
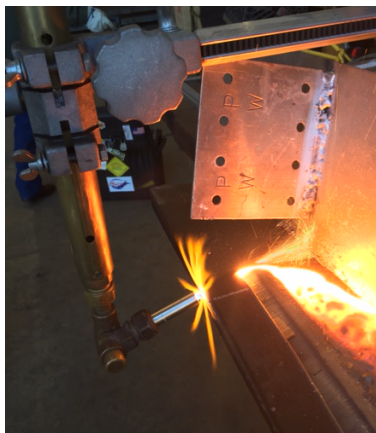
SUBSTANTIAL SAVINGS IN TIME LABOR,
NO GRINDING OR PRE HEATING WITH
EXCELLENT QUALITY.

1. DOUBLED CUTTING SPEED
2. NO PREHEAT REQUIRED
3. NO GRINDING
4. ELIMINATED FLIPPING PLATE OVER TO DO SECOND BEVEL.

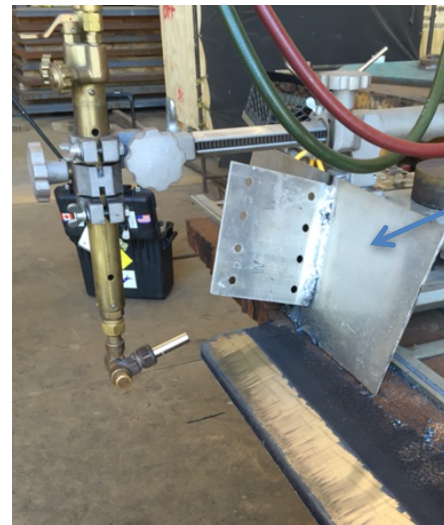
USED HEAT DEFLECTOR
TO KEEP SLAG OFF
TRACK BURNER

SLAG LITTERALLY DROPE OFF
EDGES SHARP NO ROLL OVER.
AND NO PREHEAT REQUIRED
ALL CUT CUT COLD.

FINISHED CUT PERFECTLY CLEAN, NO GRINDING REQUIRED AND
PLATE DID NOT HAVE TO BE FLIPPED OVER.



SLAG ROLLS OFF



SLAG DEFLECTION PLATE

SECOND BEVEL CUT GOING RIGHT TO LEFT.
FIRST BEVEL CUT UNDERNEATH WENT LEFT TO RIGHT.

DOUBLE BEVEL CUTTING

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RECOMMENDED EQUIPMENT REQUIRED:

1. USE RIPPER TIP # 4 & 6 TO DO ALL BEVEL CUTTING
2. REPLACE BOTH OXYGEN AND FUEL GAS REGULATORS. EXISTING REGULATORS HAVE INSUFFICIENT FLOW AND ARE SURGERING CAUSING GRIVES IN BEVEL.
3. ONLY USE ONE FLASH BACK ARRESTOR ON THE FUEL GAS WITH A THERMAL SHUT OFF AND HIGH FLOW.

TIPS, REGULATORS & HIGH FLOW FLASHBACK ARRESTORS FOR ALL PROPYLENE CUTTING:

RIPPER TIP



VSR-450-540

Heavy Duty Oxygen
Stainless Steel Diaphragm
Mechanical Seat
CGA 540
2 1/2" Gauges



PART #
VSR-450-540

VSR-461-510

Heavy Duty Fuel Gas
Stainless Steel Diaphragm
Mechanical Seat
CGA 510
2 1/2" Gauges



PART #
VSR-461-510

HIGH FLOW

Flashback arraster
UL approved for
Propylene. Viton seals,
Thermal shut off



PART #
GIW53PR

| | | |
|-------------|--|---|
| V-SS-RIP-4 | VICTOR MACH 1 RIPPER STAINLESS INSERT Bevel & Scrap Cutting - 4 | 4 |
| V-SS-RIP-6 | VICTOR MACH 1 RIPPER STAINLESS INSERT Bevel & Scrap Cutting - 6 | 6 |
| VSR-450-540 | HEAVY DUTY OXYGEN REGULATOR | 1 |
| VSR-461-510 | HEAVY DUTY PROPYLENE GAS REGULATOR | 1 |
| GIW53PR | R53N PROPYLENE REGULATOR FBA "B" WITH VITON SEALS | 1 |

LEFT G WAVE WITH THE FOLLOWING EQUIPMENT TO
CONTINUE DOING BEVELS:
REQUIRE A PO FOR THE FOLLOWING.

1. VSS-RIP-4
1. VSS-RIP 6
1. VSR-450-540 HIGH FLOW REGULATOR.
2. TOTAL. \$ 119.66.