

**VAX  
VPM  
NHM**  
**6290**  
MODEL

## MACHINE CUTTING TIPS

### FEATURES:

- ▶ High-speed oxy-fuel gas cutting tips
- ▶ Minimize kerf
- ▶ Increased cutting speeds, reduced heat input
- ▶ High quality machine cuts, reduces afterwork
- ▶ 6290-VAX & 6290-VPM plated shell, 6290-NHM unplated



### OXY-ACETYLENE CUTTING

PART NO.	PLATE THICKNESS (mm)	CUTTING SPEED (mm/min)	CUTTING OXY PRESSURE (bar)	CUTTING OXY FLOW (l/h)	PREHEAT OXY FLOW (l/h)	ACETYLENE FLOW (l/h)	HEATING POWER (Kcal/h)
6290-1VAX	0 - 8	650	2,5 - 4,0	850 - 1250	400	350	4740
6290-2VAX	8 - 15	600	5,0	2400	450	420	5690
6290-3VAX	15 - 35	550	7,0	4000	500	440	5960
6290-4VAX	35 - 75	450	7,0	5000	580	500	6780
6290-5VAX	75 - 150	300	5,0	9000	660	600	8130
6290-6VAX	150 - 200	150	6,5	13500	600	800	10840

Use maximum 0,2 bar fuel gas pressure for injector equipment.  
Use minimum 0,3 bar fuel gas pressure for equilibrated pressure torches.

### OXY-MAPP<sup>®</sup>\*, TETRENE AND PROPYLENE CUTTING

PART NO.	PLATE THICKNESS (mm)	CUTTING SPEED (mm/min)	CUTTING OXY PRESSURE <sup>1</sup> (bar)	PREHEAT OXY PRESSURE (HIGH - LOW) (bar)	PREHEAT OXY FLOW (LOW PRESSURE) (l/h)	CUTTING OXY FLOW (l/h)	PREHEAT FUEL FLOW <sup>2</sup> (l/h)	HEATING POWER (LOW) (Kcal/h)	KERF WIDTH (mm)
6290-0VPM	1 - 4	750	3,0	0,8 - 0,5	600	810	300	6300	1,3
6290-1VPM	4 - 8	700	3,5	0,8 - 0,5	1200	810	300	6300	1,5
6290-2VPM	8 - 15	620	5,0	1,7 - 0,5	2400	840	330	6930	1,8
6290-3VPM	15 - 35	550	7,0	1,7 - 0,5	4200	900	360	7560	2,0
6290-4VPM	35 - 75	450	7,0	1,7 - 0,7	5100	1020	400	8390	2,5
6290-5VPM	75 - 150	300	7,0	1,7 - 0,7	8400	1080	420	8820	3,0
6290-6VPM	150 - 200	150	7,0	2,0 - 0,7	14400	1140	450	9450	4,0
6290-7NHM	200 - 300	125	4,0	0,7 - 2,5	22300	1140	450	9450	6,9

<sup>1</sup> Cutting oxygen pressure are measured at torch inlet.  
<sup>2</sup> Preheat flows are calculated for propylene / oxygen at 2.6 / 1 ratio.  
Use minimum 0,3 bar fuel gas pressure for equal pressure torches.  
Use maximum 0,2 bar fuel gas pressure for injector equipment.  
\* MAPP<sup>®</sup> is a registered trademark of Messer Group GmbH.

## E-9

Machine cutting tips cleaning instructions: The wire brush included with tip cleaner E-9 should be used for cleaning preheat slots and for removing spatter from the tip face.

When cleaning the preheat slots, do not brush across the slots as this motion can damage the slots. Always brush along the length of the slot to remove dirt or spatter.



E9 Tip Cleaner