



A LINCOLN ELECTRIC COMPANY

## PROPANE/NATURAL GAS MACHINE CUTTING

**6290-VVC** Cutting Tips - **6290-VVCU** Cutting Tips

**6290-VVCU & NH** Cutting Tips are un-plated

### 6290-VVC & VVCU TIPS FOR PROPANE/NATURAL GAS

PLATE THICKNESS INCHES	6290 TIP SIZE	CUTTING SPEED IN/MIN.	CUTTING OXYGEN PSIG	PREHEAT OXYGEN PRESSURE HIGH/LOW	FUEL GAS PRESSURE PSIG	WIDTH KERF INCHES	CUTTING ORIFICE DRILL SIZE
3/16"	5/0 VVC & VVCU	20-24	40	15/8	4 oz. -2 PSIG	.05	#75
1/4"	4/0 VVC & VVCU	20-22	50	15/10	4 oz. -2 PSIG	.06	#68
3/8"	3/0 VVC & VVCU	18-22	75	35/10	4 oz. -2 PSIG	.07	#64
1/2"	2/0 VVC & VVCU	18-20	75	35/10	4 oz. -2 PSIG	.07	#62
3/4"	0 VVC & VVCU	15-18	90	35/10	4 oz. -2 PSIG	.08	#60
1-1/4"	01-2 VVC & VVCU	14-16	100	35/12	4 oz. -2 PSIG	.08	#58
2"	1 VVC & VVCU	13-15	100	35/12	4 oz. -2 PSIG	.09	#56
3"	1 1/2 VVC & VVCU	9-12	100	35/12	4 oz. -2 PSIG	.11	#54
4"	2 VVC & VVCU	7-9	100	35/12	4 oz. -2 PSIG	.12	#53
5"	2 1/2 VVC & VVCU	6-8	100	35/12	4 oz. -2 PSIG	.13	#51
6"	3 VVC & VVCU	5-7	100	40/12	4 oz. -2 PSIG	.14	#49
7"	4 VVC & VVCU	5-7	100	40/12	4 oz. -2 PSIG	.16	#45
8"	5 VVC & VVCU	4-6	90	40/-	4 oz. -2 PSIG	.20	#41
9"	5 1/2 VVC & VVCU	4-6	90	40/-	4 oz. -2 PSIG	.25	#39
10"	5HN	4-5	60	40/-	4 oz. -2 PSIG	.25	#35
10"	6HN	4-5	60	40/-	4 oz. -2 PSIG	.25	#31
12"	7HN	4-5	60	40/-	4 oz. -2 PSIG	.25	#29
15"	8HN	3-4	60	40/-	4 oz. -2 PSIG	.30	#25

**NOTE:**

- Correct cutting oxygen pressure must be available at torch entry.
- Oxygen preheat pressures are for three hose torches.
- For two hose torches set same gas pressures for both high and low preheat.

Cleaning: Use Harris tip cleaner E-9 (P/N 9000160) for cleaning pre-heat holes and 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.

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