

**PARTS BY CATEGORY**

| <b>PART #</b>        | <b>TORCHES</b> | <b>DESCRIPTION</b>   |
|----------------------|----------------|----------------------|
| 22N24A               | 22A            | 1/8 Collet           |
| 22N24AL              | 22A            | 1/8 Lg. Lens Collet  |
| 22N24B               | 22B            | 1/8 Collet           |
| 22N24BL              | 22B            | 1/8 Lg. Lens Collet  |
| 2304-0068            | A10HP,A20HP    | Collet 1/8           |
| 2304-0086            | A16HP,A35HP    | Collet .020          |
| 2304-0087            | A16HP,A35HP    | Collet .040          |
| 2304-0088            | A16HP,A35HP    | Collet 1/16          |
| 2304-0089            | A16HP,A35HP    | Collet 3/32          |
| 2304-0090            | A16HP,A35HP    | Collet 1/8           |
| 2304-0091            | A16HP,A35HP    | Collet 5/32          |
| 2304-0135            | A10HP,A20HP    | Collet 3/32          |
| 2304-0136            | A10HP,A20HP    | Collet 1/16          |
| 2304-0137            | A10HP,A20HP    | Collet .040          |
| 2304-0138            | A10HP,A20HP    | Collet .020          |
| 2304-0146            | A10HP,A20HP    | Collet 3/16          |
| 24C332               | 24             | Collet 3/32          |
| 24GLC332             | 24             | Gas Les Collet 3/32  |
| 53N14                | 24             | Collet 1/16          |
| 53N15                | 24             | Collet .020          |
| 53N16                | 24             | Collet .040          |
| 53N62                | 24             | Gas Lens Collet .020 |
| 53N63                | 24             | Gas Lens Collet .040 |
| 53N64                | 24             | Gas Lens Collet 1/16 |
| 54N20                | 18,26          | Collet 5/32          |
| 54N20S               | 18,26          | Stubby Collet 5/32   |
| 57N45                | 27             | Collet .040          |
| 57N46                | 27             | Collet 1/16          |
| 57N47                | 27             | Collet 3/32          |
| 57N48                | 27             | Collet 1/8           |
| 57N49                | 27             | Collet 5/32          |
| 57N50                | 27             | Collet 3/16          |
| 57N51                | 27             | Collet 1/4           |
| 84Z33                | 90HP           | Collet 1/16          |
| 84Z34                | 90HP           | Collet .020          |
| 84Z35                | 90HP           | Collet .040          |
| <b>COLLET BODIES</b> |                |                      |
| 105Z27               | 90HP           | Collet Body          |
| 10N28                | 18,26          | Collet Body 1/8      |
| 10N29                | 17,18,26       | Collet Body .020     |
| 10N30                | 17,18,26       | Collet Body .040     |
| 10N31                | 17,18,26       | Collet Body 1/16     |
| 10N32                | 17,18,26       | Collet Body 3/32     |
| 13N25                | 9,20,25        | Collet Body .020     |
| 13N26                | 9,20,25        | Collet Body .040     |
| 13N27                | 9,20,25        | Collet Body 1/16     |
| 13N28                | 9,20,25        | Collet Body 3/32     |
| 13N29                | 9,20,25        | Collet Body 5/32     |
| 17CB20               | 17,18,26       | Stubby Collet Body   |

| <b>PART #</b> | <b>TORCHES</b> | <b>DESCRIPTION</b>      |
|---------------|----------------|-------------------------|
| 17CB21        | 17,18,26       | Stubby Collet Body .040 |
| 17CB22        | 17,18,26       | Stubby Collet Body 1/16 |
| 17CB23        | 17,18,26       | Stubby Collet Body 3/32 |
| 17CB24        | 17,18,26       | Stubby Collet Body 5/32 |
| 2310-1810     | A10HP,A20HP    | Nose Collet Body        |
| 2310-1938     | A16HP,A35HP    | Nose Collet Body        |
| 24CB332       | 24             | Collet Body 3/32        |
| 406488        | 18,26          | Collet Body 5/32        |
| 53N17         | 24             | Collet Body .020        |
| 53N18         | 24             | Collet Body .040        |
| 53N19         | 24             | Collet Body 1/16        |

**GAS LENS COLLET BODIES**

|           |                    |                                     |
|-----------|--------------------|-------------------------------------|
| 45V0204   | 17,18,26           | .020-.040 Large Dia. Gas Lens C/B   |
| 45V0204C  | 17,18,26           | .020-.040 Large Dia. Copper GL C/B* |
| 45V0204S  | 9,20               | .020-.040 Large Dia. Stubby C/B     |
| 45V0204SC | 9,20               | .020-.040 Lg. Stubby Copper C/B*    |
| 45V116    | 17,18,26           | 1/16 Large Dia. Gas Lens C/B        |
| 45V116C   | 17,18,26           | 1/16 Large Dia. Copper C/B*         |
| 45V116S   | 9,20               | 1/16 Large Dia. Stubby C/B          |
| 45V116SC  | 9,20               | 1/16 Lg. Stubby Copper C/B*         |
| 45V24     | 17,18,26           | .040 Gas Lens Collet Body           |
| 45V24C    | 17,18,26           | .040 Copper GL Collet Body*         |
| 45V24S    | 9,20               | .040 Stubby GL Collet Body          |
| 45V24SC   | 9,20               | .040 Stubby Copper GL C/B*          |
| 45V25     | 17,18,26           | 1/16 Gas Lens Collet Body           |
| 45V25C    | 17,18,26           | 1/16 Copper GL Collet Body*         |
| 45V25S    | 9,20               | 1/16 Stubby GL Collet Body          |
| 45V25SC   | 9,20               | 1/16 Stubby Copper GL C/B*          |
| 45V26     | 17,18,26           | 3/32 Gas Lens Collet Body           |
| 45V26C    | 17,18,26           | 3/32 Copper GL Collet Body*         |
| 45V26S    | 9,20               | 3/32 Stubby GL Collet Body          |
| 45V26SC   | 9,20               | 3/32 Stubby Copper GL C/B*          |
| 45V27     | 17,18,26           | 1/8 Gas Lens Collet Body            |
| 45V27C    | 17,18,26           | 1/8 Copper GL Collet Body*          |
| 45V27S    | 9,20               | 1/8 Stubby GL Collet Body           |
| 45V27SC   | 9,20               | 1/8 Stubby Copper GL C/B*           |
| 45V28     | 17,18,26           | 5/32 Gas Lens Collet Body           |
| 45V28C    | 17,18,26           | 5/32 Copper Collet Body*            |
| 45V28S    | 9,20               | 5/32 Stubby Collet Body             |
| 45V28SC   | 9,20               | 5/32 Stubby Copper GL C/B*          |
| 45V29     | 17,18,26           | .020 Gas Lens Collet Body           |
| 45V29C    | 17,18,26           | .020 Copper Collet Body*            |
| 45V29S    | 9,20               | .020 Stubby Collet Body             |
| 45V29SC   | 9,20               | .020 Stubby Copper C/B*             |
| 45V41     | 9,20,22,24,25,90HP | .020 Gas Lens Collet Body           |
| 45V41C    | 9,20,22,24,25,90HP | .020 Copper GL Collet Body*         |
| 45V42     | 9,20,22,24,25,90HP | .040 Gas Lens Collet Body           |



BASIC TORCH SPECIFICATIONS

**BASIC TORCH SPECIFICATIONS**

|                                  | <b>27A</b>           | <b>27B</b>   |
|----------------------------------|----------------------|--|
| CAPACITY:                        | 500 Amp              | 500 Amp  |
| ELECTRODE RANGE:                 | .040-1/4"            | .040-1/4"  |
| BODY LENGTH:                     |                      |  |
| from shaft knob to end of nozzle | 9" (22.8cm)          | 20" (50.8cm)   |
| HEAD ANGLE:                      | 180 degrees          | 180 degrees  |
| BARREL DIAMETER:                 |                      |  |
| WEIGHT:                          |                      |  |
| w/Torch, barrel, gas lens        | 24 oz. (746.5 grams) | 36 oz. (1119.7 grams)                                  |
| COOLING REQUIREMENTS:            |                      | 2 qt/min (1.9l/min)<br>Max. Pressure: 50 PSI (345 KPa) |

**NOTES**

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**KEY DESCRIPTION PART NO.**

| <b>ELECTRODE DIAMETER</b> | .040"<br>1.0mm | 1/16"<br>1.6mm | 3/32"<br>2.4mm | 1/8"<br>3.2mm | 5/32"<br>4.0 mm                      | 3/16"<br>4.8 mm                      | 1/4"<br>6.4 mm                       |
|---------------------------|----------------|----------------|----------------|---------------|--------------------------------------|--------------------------------------|--------------------------------------|
| <b>NOZZLE SIZE</b>        | #5             | #6             | #7             | #10,#12,#8    | #10,#12,#15                          | #10,#12,#15                          | #10,#12,#15                          |
| 12 Collet                 | 57N45          | 57N46          | 57N47          | 57N48         | 57N49                                | 57N50                                | 57N51                                |
| 14 Gas Lens               | 49V22          | 49V23          | 49V24          | 49V25         | 49V26                                | 49V27                                | 49V28                                |
| 15 Gasket                 | 57N56          | 57N56          | 57N56          | 57N56         | 57N56                                | 57N56                                | 57N56                                |
| 16 Alumina Nozzle         |                | 57N75          |                | 57N74         | 53N88(10)<br>53N57(12)<br>53N89*(15) | 53N88(10)<br>53N57(12)<br>53N89*(15) | 53N88(10)<br>53N57(12)<br>53N89*(15) |

| KEY | DESCRIPTION   | PART No.  | KEY | DESCRIPTION         | PART No.  |
|-----|---|-----------|-----|---------------------|-----------|
| 1A  | Shaft Assy. "A" model incl. shaft, knob,<br>1 ea. 27-13-2 & 27-13-3 O-Rings | 27-13A    | 16  | Alumina Nozzle      | See Chart |
| 1B  | Shaft Assy. "B" model incl. shaft, knob,<br>1 ea. 27-13-2 & 27-13-3 O-Rings | 27-13B    | 17  | Insulating Boot     | 27-12     |
| 2   | O-Ring  | 27-13-2   | 18  | Water Hoses         | 40V83R-3  |
| 3   | O-Ring  | 27-13-3   |     | 3 Ft. (.9m)         | 40V83R    |
| 4A  | Torch Body (9")   | 27A       | 19  | 25 Ft. (7.6m)       | 40V83RL   |
| 4B  | incl. shaft Assy. barrel & boot   |           |     | Power Cables        |           |
|     | Torch Body (20")  | 27B       |     | 3 Ft. (.9m)         | 40V84R-3  |
|     | incl. shaft Assy. barrel & boot   |           |     | 12.5 Ft. (3.8m)     | 40V84R    |
| 5   | #6 bronze lock washer   | 27-11     | 20  | 25 Ft. (7.6m)       | 40V84RL   |
| 6   | 6-32x5/16" screw  | 27-10     |     | Gas Hoses           |           |
| 6A  | 6-32x5/16" screw  | 27-19     |     | 3 Ft. (.9m)         | 40V82R-3  |
| 7   | O-Ring  | 27-2-4    |     | 12.5 Ft. (3.8m)     | 40V82R    |
| 8   | Barrel rack "B" model only  | 27R32     | 21  | 25 Ft. (7.6m)       | 40V82RL   |
|     | 32 pitch (1/4" x 1/4" x 11")  |           |     | Power Cable Adapter |           |
| 9   | Barrel rack "B" model only  | 27R24     |     |                     |           |
|     | 24 pitch (1/4" x 1/4" x 11")  |           |     |                     |           |
| 10  | 6-32x3/16" fillister head screw   | 18R-1     |     |                     |           |
| 11A | Barrel Assy. "A" model incl: 3 ea 27-10<br>screws, 3 ea. 27-11 washers      | 27-10A    |     |                     |           |
| 11B | Barrel Assy. "B" model incl: 3 ea 27-10<br>screws, 3 ea. 27-11 washers      | 27-10B    |     |                     |           |
|     | Barrel Assy. with rack holes  | 27-9B     |     |                     |           |
| 12  | Collet  | See Chart |     |                     |           |
| 13  | O-Ring  | 181W89    |     |                     |           |
| 14  | Gas Lens  | See Chart |     |                     |           |
| 15  | Gasket  | 57N56     |     |                     |           |

TIG