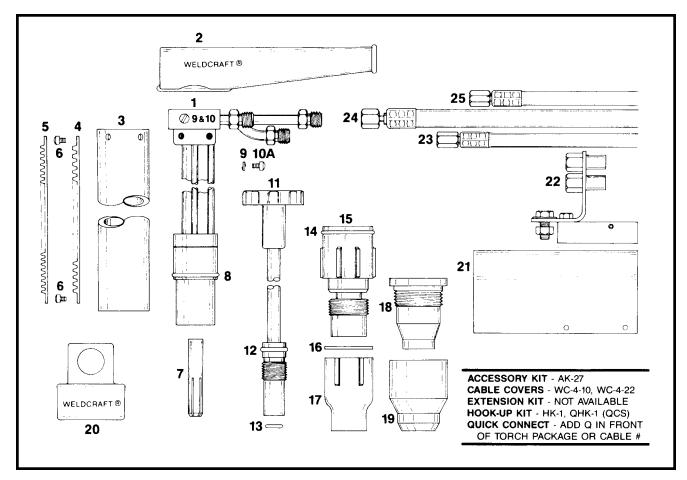


WP-27

500 AMPS • WATER COOLED

REPLACEMENT PARTS



ITEM	STOCK	22001071011	ITEM	STOCK			
NO.	NO.	DESCRIPTION	NO.	NO.	DESCRIPTION		
1	WP-27A	Torch body, (9" long) includes shaft assy, barrel & boot	15	-	Gas lens (See chart A), includes		
	WP-27B	Torch body, (20" long) includes shaft assy, barrel & boot			1 ea. 181W89 O-ring, 1 ea. 57N56 gasket		
2	27-12	Insulating boot	16	57N56	Gasket		
3	27-10A	Barrel assy. "A" model, includes	17	-	Alumina nozzle (See chart B)		
	21 10/1	3 ea. 27-10 screw, 3 ea. 27-11 washer	18	57N76	Metal nozzle adapter		
	27-10B	Barrel assy. "B" model, includes			Metal nozzle (See chart B)		
	27-100	3 ea. 27-10 screw, 3 ea. 27-11 washer	20	45V11	Power cable adapter		
	27-9B		21	27-18-3	Bracket insulating cover		
	27-96 27R24	Barrel assy. w/rack hole	22	21-10	Bracket assy.* includes bracket, insulator		
4		Barrel rack "B" model only, 24 pitch (1/4" x 1/4" x 11")			block, insulator cover, mounting hardware: 2 ea. ¹ / ₄ " -20 x ³ / ₄ " hex hd. brass cap screw		
5	27R32	Barrel rack "B" model only, 32 pitch (1/4" x 1/4" x 11")			1 ea. $\frac{1}{2}$ " -13 x 1" hex hd. brass cap screw		
6	18R-1	6-32 x ³ / ₁₆ " fillister head screw			1 ea. $\frac{1}{2}$ = 13 x T flex fid. blass cap sciew		
7	-	Collet (See chart A)			1 ea. $\frac{1}{2}$ med. steel lock washer		
8	27-2-4	O-ring			1 ea. $\frac{1}{2}$ " plain brass washer		
9	27-11	#6 bronze lock washer	23	_	Gas hose		
10	27-10	6-32 x ⁵ /16" binding head screw	25		40V82R-3 3 ft. (.9m)		
10A	27-19	6-32 x ⁵ /16" binding head nylon screw			$40V82R$ $12^{1/2}$ ft (3.8m)		
11	27-13A	Shaft assy. "A" model includes shaft,			40V82RL 25 ft. (7.6m)		
		knob, 1 ea. 27-13-2 & 27-13-3 O-ring	24	_	Power cable		
	27-13B	Shaft assy. "B" model includes shaft,			40V84R-3 3 ft. (.9m)		
		knob, 1 ea. 27-13-2 & 27-13-3 O-ring			40V84R 12 ¹ / ₂ ft. (3.8m)		
12	27-13-2	O-ring			40V84RL 25 ft. (7.6m)		
13	27-13-3	O-ring	25	-	Water in hose		
14	181W89	O-ring			40V83R-3 3 ft. (.9m)		
	57WCNA	Water cooled nozzle (not shown)			40V83R 12 ¹ / ₂ ft. (3.8m)		
					40V83RL 25 ft. (7.6m)		

*Bracket assy. used on 3 ft. torch pkgs. only.

CHART A • COLLETS • GAS LENS

UNANI A OULL	LIO OAO	LENO					
Electrode	.040	1/16	3/32	1/8	5/32	3/16	1/4
Diameter	(1.0mm)	(1.6mm)	(2.4mm)	(3.2mm)	(4.0mm)	(4.8mm)	(6.4mm)
Collet	57N45	57N46	57N47	57N48	57N49	57N50	57N51
Gas Lens	49V22	49V23	49V24	49V25	49V26	49V27	49V28

CHART B • GAS NOZZLES • HPN - HIGH PERFORMANCE NOZZLES AVAILABLE								
SIZE	6	8	10	12	SHORT*			
Alumina	57N75	57N74	53N88	53N87	53N89			
Metal**	_	_	57N78	57N77	_			

*Not recommended for use with high frequency current. **Requires 57N76 adapter.

Water cooled torches require cooling water flow of 1 quart (.94 liter) to 1-1/2 quarts (1.4 lites) per minute at a maximum of 50 PSI pressure.

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