

Heavy Duty Hand Cutting Torches

Designed for rugged environments and customized the way you want it.

Hand cutting torches suggested for scrap yards, mills and foundries.



6500 SERIES CUTS UP TO 8" OF STEEL

7500 SERIES CUTS UP TO 14" OF STEEL



8600 SERIES CUTS UP TO 36" OF STEEL



9600 SERIES CUTS UP TO 48" OF STEEL



LADLE SKULLS

SCRAP COILS



HC48L SERIES CUTS UP TO 48" OF STEEL

SAFER, LIGHTER & STRONGER



See our complete selection of acetylene & alternate fuel gas tips. Ask about our famous Scorpion® Tips!

2621-90 TORCH CUTS UP TO 8", FOR USE WITH ANY GAS

COMPATIBLE WITH VICTOR® SERIES 1 CUTTING TIPS



Flame Tech's Scorpion 2621-90 torch is designed for heavy duty hand held applications for the fabshop, foundry or scrap yard environment where up to 8" cutting is required. Universal mixer provides optimal performance with any fuel gas.

BUILT-IN FLASHBACK ARRESTORS & CHECK VALVES

- Replace with Flame Tech flashback arrestor/check valve cartridges *only*.
- DO NOT use other brand cartridges, as they may not seal correctly and cause gas leaks.

SOLID BRASS FORGED HEAD

- Forged brass head for long life
- Maximum service with minimum maintenance

UNIVERSAL MIXER

- Provides optimal performance with any fuel gas

OEM COMPATIBILITY

- Compatible with Victor® Series 1 cutting tips

HEAVY DUTY, STAINLESS TUBES

Do **NOT** use this torch without the built-in flashback arrestor cartridges!

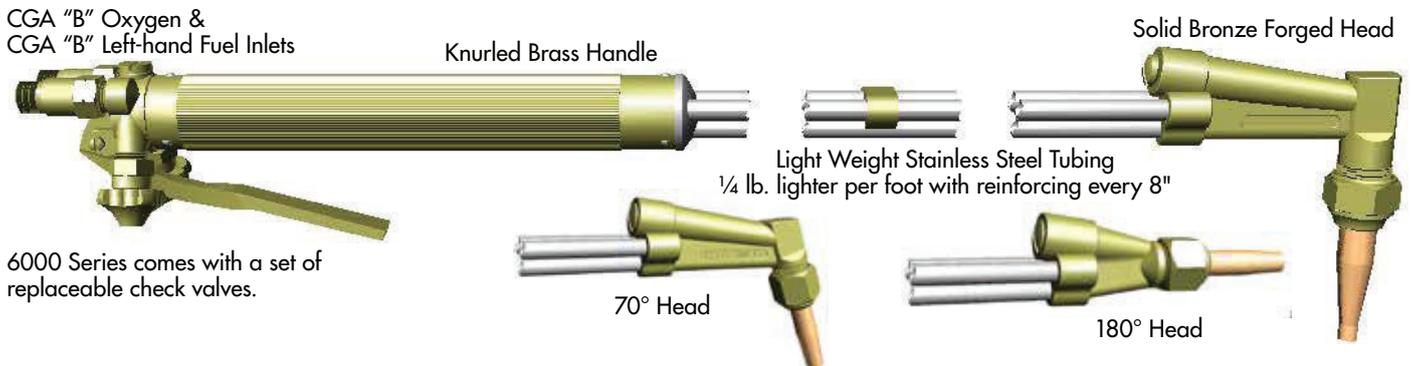


Use only Flame Tech branded flashback arrestor cartridges!



Flashback Arrestor/Check Valves Cartridges
Fuel: 77100010, Oxygen: 77100020

6000 SERIES—CUTS UP TO 8", GAS TYPE IS MODEL DEPENDENT
(SEE BELOW)



6000 Series comes with a set of replaceable check valves.

SOLID BRONZE FORGED HEAD

- Long life, resists distortion from abuse
- Maximum service with minimum maintenance

INJECTOR/MIXER

- Mixer in head to reduce burn back in tubes
- Safer than tube mixing designs

EXTERNAL CHECK VALVES

- Easily replaced on the job & prevents reverse flow.
- Flame Tech® recommends flash arrestors style GG/DGN
 See check valves & flash arrestors section in this catalog.

LIGHT WEIGHT, STAINLESS TUBES

- Maximum design strength—1/4 lb. per foot lighter

MODELS & SIZES

Flame Tech's 6000 series torches are designed for heavy duty hand held applications for the steel mill, foundry or scrap yard environment where up to 8" cutting is required. These torches come in 21, 27, 36, 48, 72, 96, & 120 inch lengths. Custom lengths are also available upon request. See our 7000, 8000 and 9000 series for 14", 36" & 48" cutting capabilities. These torches have built-in mixers, and as such must be ordered according to the gas type to be used. Different gas usage requires a different torch. See "Part Numbering Example."

ORDERING & PART NUMBERS

Flame Tech® uses an identification system that consists of numbers and letters to identify the manufacture model, size, gas, and style head on our torches. Below are examples for our Heavy Duty Hand Torches. See our price list for complete offering.

OEM COMPATIBILITY

- 6200 Series—Compatible with Harris® Seat
- 6300 Series—Compatible with Victor® Seat
- 6400 Series—Compatible with Oxweld® Seat



PART NUMBERING EXAMPLE

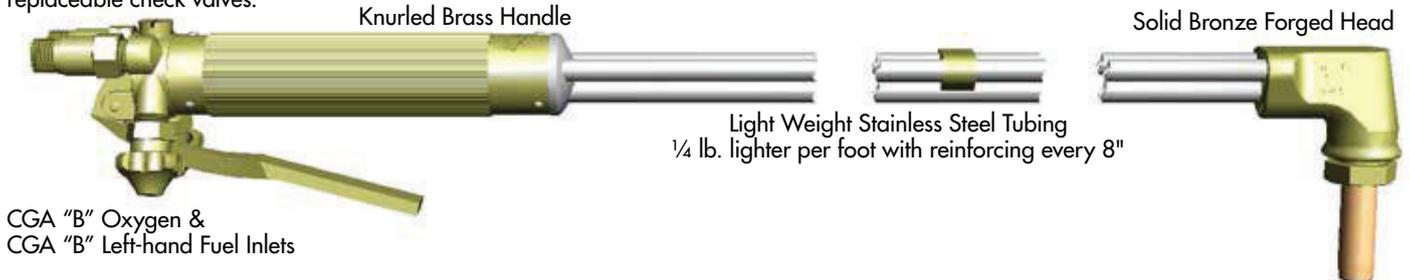
- 6321-A90 = "63" indicates the series of torch you are ordering (Victor® compatible torch)
- 6321-A90 = "21" indicates the length of torch you are ordering (21" long)
- 6321-A90 = "A" indicates Acetylene gas
 "F" indicates alternate Fuel gases only (not for acetylene) for maximum performance
- 6321-A90 = "90" indicates the degree of the head (70°, 90°, or 180°* available)

*Flame Tech does not offer 180° heads for use with with acetylene.

» **SEE PAGE 40 FOR SCRAPER TIP INFORMATION**

6500 SERIES—CUTS UP TO 8", USES ACETYLENE OR ALT. FUEL GASES

6500 Series comes with a set of replaceable check valves.



CGA "B" Oxygen &
CGA "B" Left-hand Fuel Inlets

FEATURES

- Solid Bronze Head
- Heavy Duty Tip-Mixing Torch
- Three Stainless Tubes in Triangular Format
- Light Weight Multi-Tasking Torch

BENEFITS

- Safety First – Reduced Flashback
- Maximum Strength, Greater Rigidity
- Low Maintenance, Longer Lasting
- Ease of Operation

CAPABILITIES

Flame Tech's 6500 Hand Cutting Torch is a heavy duty torch designed for rugged environments. This torch features a safe, tip-mix design. The 6500 series torch uses Flame Tech's "A-Scraper" or Airco® compatible cutting tips, and is ideal for heavy cutting in scrap yards and steel mill operations. This heavy duty torch when using these tips can hand cut up to 8" of steel.

- Can be used with any Fuel Gas
- Single lever actuated torch control
- Uses common CGA "B" size oxygen supply and LH CGA "B" size fuel supply to minimize the hose and regulator requirements.

PART NUMBERING EXAMPLE

- 6548-70 = "65" indicates the torch series you are ordering
- 6548-70 = "48" indicates the length of the torch you are ordering (48" long)
- 6548-70 = "70" indicates the degree of the head (70°, 90°, or 180°)

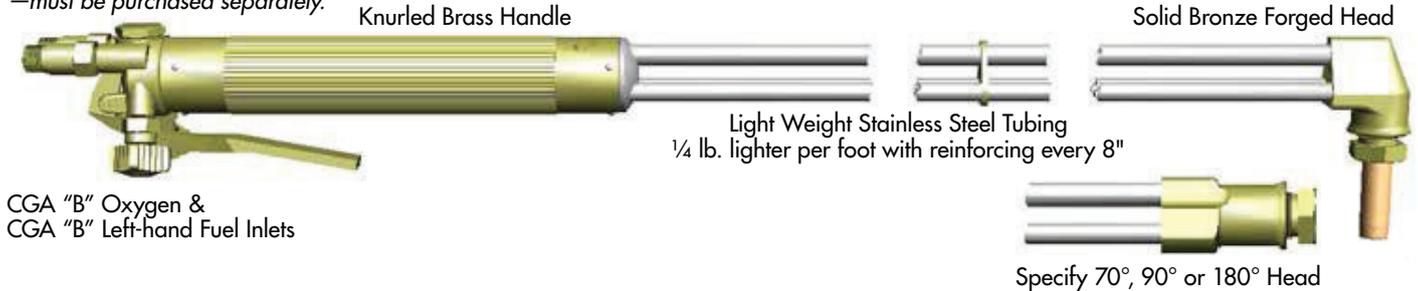
Standard lengths are 21, 27, 36, 48, 60, 72, 96 & 120 inches. Custom lengths available. 70°, 90° or 180° available.

» SEE PAGE 40 FOR SCRAPER TIP INFORMATION



7500 SERIES—CUTS UP TO 14", USES ACETYLENE OR ALT. FUEL GASES

Check valves are recommended
—must be purchased separately.



FEATURES

- Solid Bronze Head
- Heavy Duty Nozzle Mixing Torch
- Three Stainless Tubes in Triangular Format
- Light Weight Multi-Tasking Torch

BENEFITS

- Safety First – Reduced Flashback
- Maximum Strength, Greater Rigidity
- Low Maintenance, Longer Lasting
- Ease of Operation

CAPABILITIES

Flame Tech’s 7500 Hand Cutting Torch is a heavy duty torch designed for rugged environments. This torch features a safe, tip-mix design. The 7500 series torch uses Flame Tech’s “A-Scraper” or Airco® compatible cutting tips, and is ideal for heavy cutting in scrap yards and steel mill operations. This heavy duty torch when using these tips can hand cut up to 14" of steel.

- Can be used with any Fuel Gas
- Single lever actuated torch control
- Uses common CGA “B” size oxygen supply and LH CGA “B” size fuel supply to minimize the hose and regulator requirements

PART NUMBERING EXAMPLE

- 7548-70 = “75” indicates the torch series you are ordering
- 7548-70 = “48” indicates the length of the torch you are ordering (48" long)
- 7548-70 = “70” indicates the degree of the head (70°, 90° or 180°)

Standard lengths are 21, 27, 36, 48, 60, 72, 96 & 120 inches. Custom lengths available. 70°, 90° or 180° available.

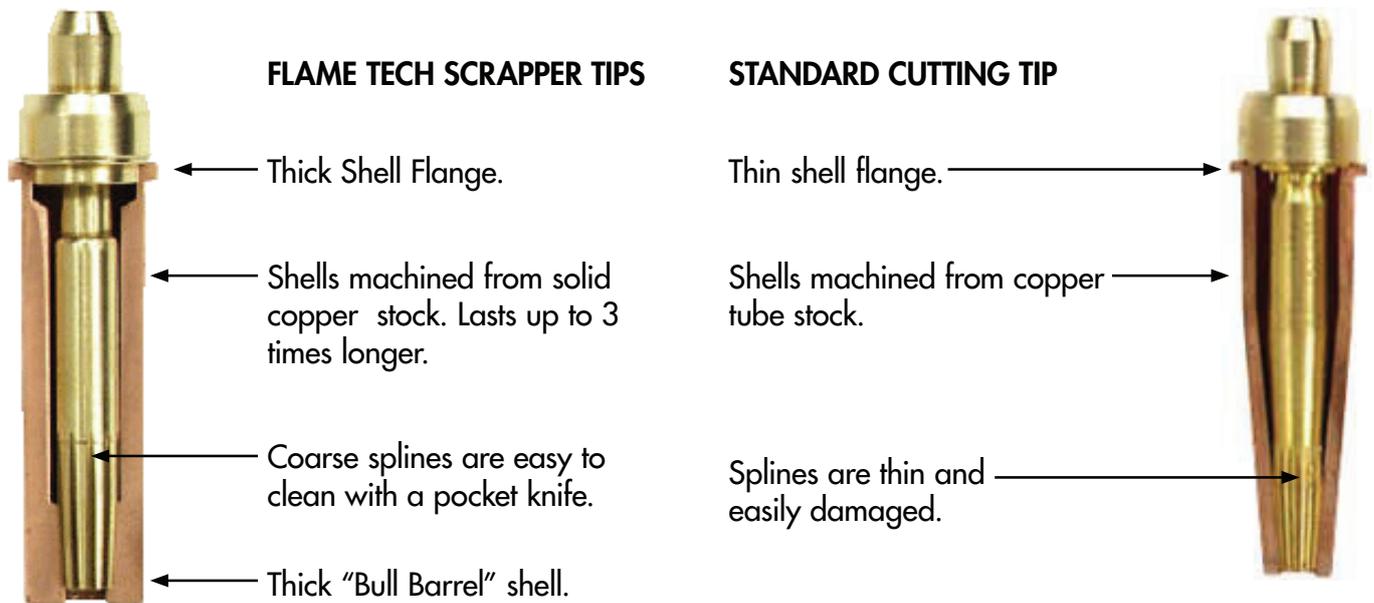
» SEE PAGE 40 FOR SCRAPER TIP INFORMATION



FLAME TECH® SCRAPPER TIPS—6000, 6500 & 7500 SERIES TORCHES

SEE THE DIFFERENCE YOURSELF WITH FLAME TECH'S FAMOUS "SCRAPPER" CUTTING TIPS

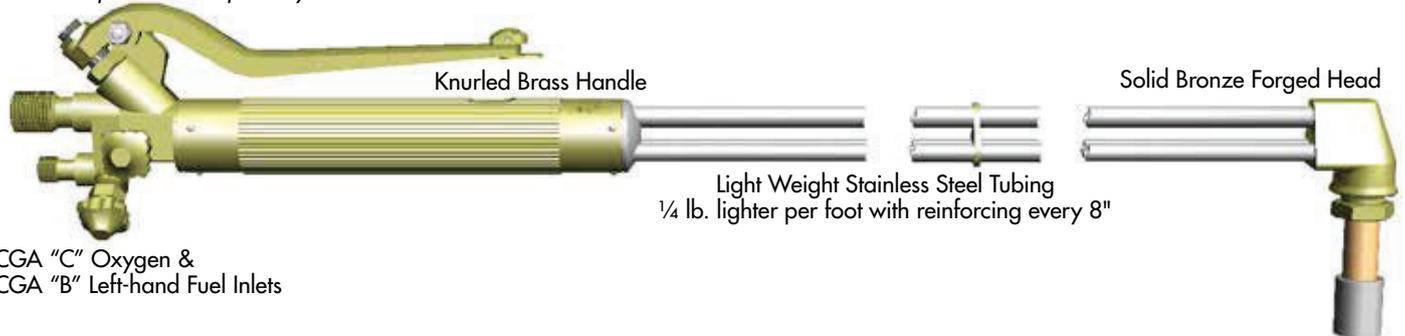
- Larger preheats reduce start time and help to "maintain the cut."
- Coarse "V" internal splines do not clog easily and can be cleaned with a pocket knife.
- Ideal for working on rusty, scaly, painted surfaces.
- Compatible with standard OEM torches.



METAL THICKNESS (INCHES)	TIP SIZE	DRILL SIZE	CUTTING OXYGEN		FUEL GAS		SPEED IPM	KERF WIDTH
			PSI	SCFH	PSI	SCFH		
2	2	52	40-50	150-200	6-12	12-65	10-14	.10
2½	2½	50	40-50	150-200	6-12	12-65	9-13	.105
3	3	48	40-50	150-200	6-12	12-65	8-11	.11
4	4	44	40-50	210-250	6-12	12-65	7-10	.13
6	5	39	45-55	300-360	6-12	12-65	5-8	.15
8	6	31	55-65	450-500	6-12	12-65	4-6	.19
9	7	28	55-65	450-500	6-12	22-110	3-5	.22
10	8	25	60-70	750-850	10-18	22-110	3-4	.24
12	10	13	45-60	1000-1200	10-18	22-110	2-3	.34
14	12	5	40-55	1150-1350	10-18	22-110	1-2	.40

8600 SERIES—CUTS UP TO 36", USES BI-METAL & TRI-METAL TIP SERIES

Check valves are recommended
—must be purchased separately.



FEATURES

- Solid Bronze Head
- Heavy Duty Nozzle Mixing Torch
- Three Stainless Tubes in Triangular Format
- Uses Flame Tech® Designed BI-METAL or TRI-METAL 80 Series Tip-Mixing Nozzles
- Light Weight Multi-Tasking Torch

BENEFITS

- Safety First – Reduced Flashback
- Maximum Strength, Greater Rigidity
- Low Maintenance, Longer Lasting
- Ease of Operation

CAPABILITIES

Flame Tech’s 8600 Hand Cutting Torch is a heavy duty torch designed for rugged environments. This torch features a safe, tip-mix design. The 8600 series torch uses Flame Tech’s proprietary BI-METAL or TRI-METAL cutting nozzles, and is ideal for heavy cutting in scrap yards and steel mill operations. This heavy duty torch, when using the BI-METAL or TRI-METAL 80 series nozzles, can hand cut up to 36" of steel.

- Single lever actuated torch control.
- Uses CGA "C" size oxygen supply and LH CGA "B" size fuel supply to minimize the hose and regulator requirements.
- For alternative fuel only – NOT FOR ACETYLENE.

PART NUMBERING EXAMPLE

- 8648-70 = "86" indicates the torch series you are ordering
- 8648-70 = "48" indicates the length of the torch you are ordering (48" long)
- 8648-70 = "70" indicates the degree of the head (70°, 90° or 180°)

Standard lengths are 36, 48, 60, 72, 96 & 120 inches. Custom lengths available. 70°, 90° or 180° available.

» SEE PAGE 42 FOR 80 SERIES BI-METAL & TRI-METAL TIP INFORMATION



80 SERIES BI-METAL & TRI-METAL TIP-MIX CUTTING NOZZLES



HOSE & REGULATOR REQUIREMENTS

When cutting over 20", use 1/2" ID hose.

Oxygen supply and oxygen regulator must be capable of flows mentioned on cutting tip chart shown below.



← Brass seat for longer life and better structural integrity. Brass increases quality over copper in the drilling of the seat mixer.

← Copper barrel for better transfer and dissipation of heat away from the cutting zone.

← Stainless wear ring for longer life.

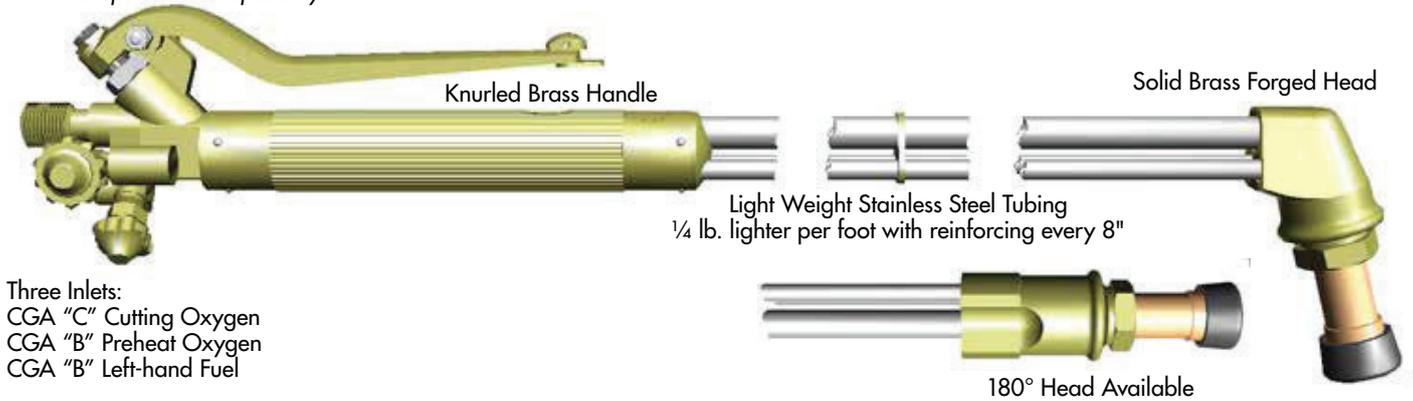


CAUTION
 ALWAYS USE
FLASHBACK ARRESTORS
 (purchased separately)

80 SERIES NOZZLES				GAS PRESSURE (PSI)		GAS CONSUMPTION (CFH)	
SIZE	BI-METAL P/N	TRI-METAL P/N	METAL THICKNESS	OXYGEN	FUEL GAS	OXYGEN	FUEL GAS
12	BM80-12	TM80-12	10-12	60-100	5-15	750-1650	80-120
16	BM80-16	TM80-16	12-16	60-100	5-15	1000-1950	80-120
20	BM80-20	TM80-20	16-20	60-100	5-15	1600-2500	100-160
24	BM80-24	TM80-24	20-24	60-100	5-15	1800-3000	100-160
36	BM80-36	TM80-36	24-36	60-100	5-15	2100-3600	100-160

9600 SERIES—CUTS UP TO 48", USES BI-METAL & TRI-METAL TIP SERIES

Check valves are recommended
—must be purchased separately.



FEATURES

- Solid Brass Head
- Heavy Duty Nozzle Mixing Torch
- Three Stainless Tubes in Triangular Format
- Uses Flame Tech® Designed BI-METAL or TRI-METAL 90 Series Tip-Mixing Nozzles
- Light Weight Multi-Tasking Torch

BENEFITS

- Safety First – Reduced Flashback
- Maximum Strength, Greater Rigidity
- Low Maintenance, Longer Lasting
- Ease of Operation

CAPABILITIES

Flame Tech’s 9600 Hand Cutting Torch is a heavy duty torch designed for rugged steel mill environments. This heavy duty torch features a safe, tip-mix design. The 9600 series torch uses the Flame Tech’s BI-METAL or TRI-METAL nozzles can hand cut up to 48" of steel.

- Three hose input into tail body.
- Uses common CGA "C" cutting oxygen supply , CGA "B" preheat oxygen, LH CGA "B" fuel inlets.
- Single lever actuated torch control.
- For alternative fuel only – NOT FOR ACETYLENE

PART NUMBERING EXAMPLE

- 9648-70 = 96 indicates the torch series you are ordering
- 9648-70 = 48 indicates the length of the torch you are ordering (48" long)
- 9648-70 = 70 indicates the degree of the head (70° or 180°)

Standard lengths are 36, 48, 60, 72, 96 & 120 inches. Custom lengths available. 70° and 180° only.

» **SEE PAGE 44 FOR 90 SERIES BI-METAL & TRI-METAL TIP INFORMATION**



90 SERIES BI-METAL & TRI-METAL TIP-MIX CUTTING NOZZLES



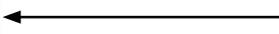
HOSE & REGULATOR REQUIREMENTS

When cutting over 20", use 1/2" ID hose.

Oxygen supply and oxygen regulator must be capable of flows mentioned on cutting tip chart shown below.

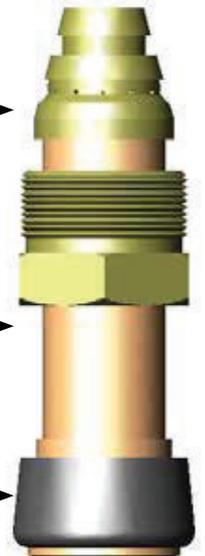


Brass seat for longer life and better structural integrity. Brass increases quality over copper in the drilling of the seat mixer.



Copper barrel for better transfer and dissipation of heat away from the cutting zone.

Stainless wear ring for longer life.

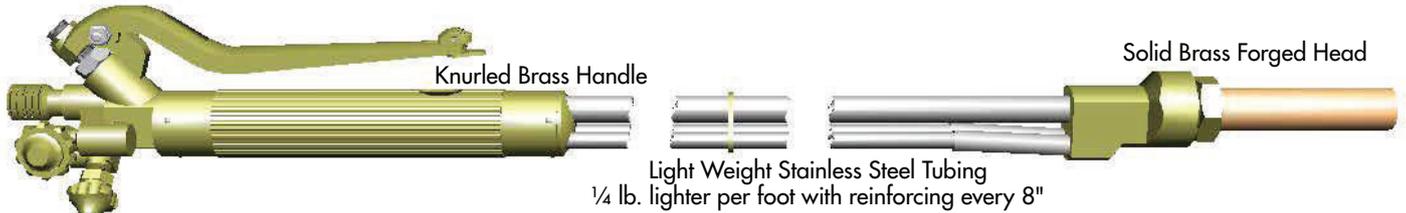


CAUTION
 ALWAYS USE
FLASHBACK ARRESTORS
 (purchased separately)

90 SERIES NOZZLES				GAS PRESSURE (PSI)			GAS CONSUMPTION (CFH)	
SIZE	BI-METAL P/N	TRI-METAL P/N	METAL THICKNESS	OXYGEN	PRE-HEAT OXYGEN	FUEL GAS	OXYGEN	FUEL GAS
24	BM90-24	TM90-24	18-24	25-45	25-50	13-25	2200-3400	80-160
30	BM90-30	TM90-30	24-30	20-40	25-50	13-25	2200-3800	80-160
36	BM90-36	TM90-36	30-36	20-40	25-50	13-25	2300-4400	80-160
48	BM90-48	TM90-48	36-48	15-35	25-50	13-25	2400-5000	80-160

HC48 HIGH CAPACITY SCRAPER TORCH—CUTS UP TO 48"

Check valves are recommended
—must be purchased separately.



Three Inlets:
CGA "C" Cutting Oxygen
CGA "B" Preheat Oxygen
CGA "B" Left-hand Fuel

FEATURES

- Three Stainless Tubes in Triangular Format
- Separate cutting & preheat oxygen—decreases preheat time and increases cutting speed
- Suitable replacement for Victor® HC 1500
- Cuts up to 48 inches of steel with 2-285 series cutting nozzles (alternate fuel gases)
- *Not for use with acetylene!*



AVAILABLE WITH BALL VALVE
For ball valve style,
remove "L" from part
number (see below.)

HIGH CAPACITY HAND CUTTING TORCH FOR VICTOR® COMPATIBLE 2-285N NOZZLES

Flame Tech's HC series hand cutting torch is designed for rugged, heavy duty applications in foundries, scrap yards and steel mills. It is ideal for emergency billet cutting, removes skulls and risers or any heavy hand cutting requirements. Off-set 180° head allows the operator to widen the cut kerf by rotating the head and deepening the cut.

ORDERING INFORMATION

- HC48L-60-180 = 60" long, 180° Head with Lever
- HC48-60-180 = 60" long, 180° Head with Ball Valve

Standard length is 60 inches. Custom lengths available. 180° only.

» SEE PAGE 47 FOR HIGH CAPACITY CUTTING NOZZLES



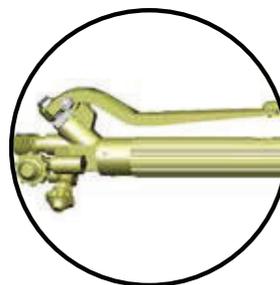
HC60 HIGH CAPACITY SCRAPPER TORCH—CUTS UP TO 48"

Check valves are recommended
—must be purchased separately.



FEATURES

- Three Stainless Tubes in Triangular Format
- Separate cutting & preheat oxygen—decreases preheat time and increases cutting speed
- Suitable replacement for Oxweld® C-63
- Cuts up to 48 inches of steel with Oxweld® C-63 1808 style cutting nozzles (propane/NG)
- *Not for use with acetylene!*



AVAILABLE WITH LEVER
For lever style, add "L" to part number (see below.)

HIGH CAPACITY HAND CUTTING TORCH FOR ESAB® AND VICTOR® COMPATIBLE 1808 NOZZLES

Flame Tech's HC series hand cutting torch is designed for rugged, heavy duty applications in foundries, scrap yards and steel mills. It is ideal for emergency billet cutting, removes skulls and risers or any heavy hand cutting requirements. Off-set 180° head allows the operator to widen the cut kerf by rotating the head and deepening the cut.

ORDERING INFORMATION

- HC60L-60-180 = 60" long, 180° Head with Lever
- HC60-60-180 = 60" long, 180° Head with Ball Valve

Standard length is 60 inches. Custom lengths available. 180° only.

» SEE PAGE 47 FOR HIGH CAPACITY CUTTING NOZZLES



HIGH CAPACITY CUTTING NOZZLES—HC SERIES TORCHES

2-285N CUTTING NOZZLE

2-285N series nozzles are made from two pieces, with a solid copper shell & a brass internal, designed for fast starts and lower gas consumption. For use with alternate fuel gases only. *Not for use with acetylene!*



NOZZLE			GAS PRESSURE (PSI)			GAS CONSUMPTION (CFH)		
CUTTING OXYGEN DIAMETER	P/N	METAL THICKNESS	CUTTING OXYGEN	FUEL GAS	PRE-HEAT OXYGEN	CUTTING OXYGEN	FUEL GAS	PRE-HEAT OXYGEN
.250	.250-2-285N	14"-20"	25-45	15-25	25-50	1500-2400	60-120	250-400
.312	.312-2-285N	20"-26"	25-45	15-25	25-50	2300-3500	60-120	250-401
.375	.375-2-285N	26"-34"	25-45	15-25	25-50	2300-3900	60-121	250-402
.437	.437-2-285N	34"-48"	25-45	15-25	25-50	2400-4500	60-122	250-403

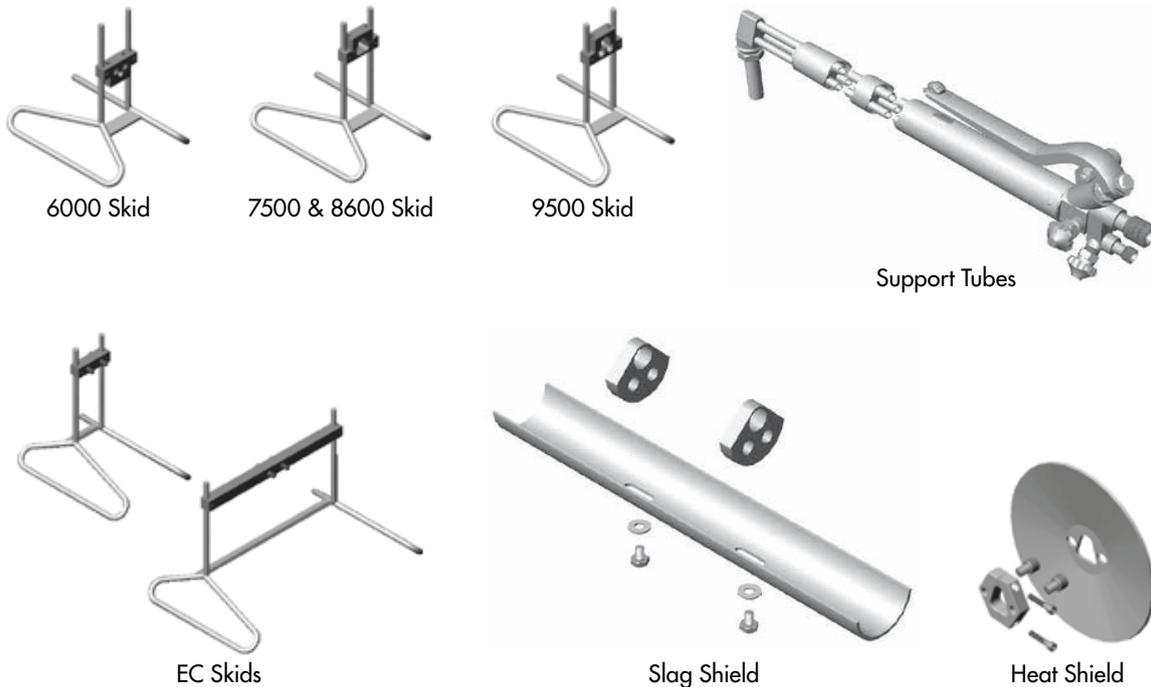
1808 CUTTING NOZZLE

1808 series nozzles are single piece solid copper nozzles. The single piece solid copper design allows for rapid heat transfer and longer rugged life. For use with Propane or Natural Gas only. *Not for use with acetylene!*



NOZZLE			GAS PRESSURE (PSI)		GAS CONSUMPTION (CFH)		CLEANING DRILL SIZE	
SIZE	P/N	METAL THICKNESS	OXYGEN	NATURAL GAS	OXYGEN	NATURAL GAS	PREHEAT	CUTTING
30	1808-30	20"-40"	65	21	5400	330	#50	19/64"
40	1808-40	40"-50"	70	23	7700	360	#49	"X"
50	1808-50	OVER 50"	75	24	9700	375	#47	1/2"

CUTTING TORCH SKID ASSEMBLIES & ACCESSORIES



PART #	DESCRIPTION
84925003	SKID ASSEMBLY FOR 9500 & 9600 SERIES TORCHES
84901011	SKID CLAMP ONLY FOR 9500 & 9600 SERIES TORCHES
84925002	SKID ASSEMBLY FOR 6500, 8600 & 7500 SERIES
84901010	SKID CLAMP ONLY FOR 6500, 8600 & 7500 SERIES TORCHES
84980001	SKID ASSEMBLY FOR 6000 SERIES TORCHES, EXCEPT 6500
84901012	SKID CLAMP ONLY FOR 6000 SERIES TORCHES, EXCEPT 6500
84901005	SKID ONLY FOR 6000, 7500, 8500, 8600, 9500 & 9600 TORCHES
EC-SKID	SKID ASSEMBLY FOR EC SERIES TORCH
84901013	SKID ONLY FOR EC TORCH - WIDE
84901007	CLAMP ONLY FOR EC TORCH - WIDE
EC-L-SKID	SKID ASSEMBLY FOR EC SERIES 34" LONG FOR "I" BEAM BILLETS
84901009	SKID ONLY FOR 34" LONG FOR EC-L TORCH
84901015	CLAMP ONLY FOR EC 34 FOR EC-L TORCH
83900002	SLAG SHIELD
93001129	SUPPORT TUBE
82700005	HEAT SHIELD ASSEMBLY
82700002	HEAT SHIELD CLAMP ONLY FOR 82700005
82700001	HEAT SHIELD ONLY FOR 82700005