



**ACCESSORY KIT - AK-27**  
**CABLE COVERS - WC-4-10, WC-4-22**  
**EXTENSION KIT - NOT AVAILABLE**  
**HOOK-UP KIT - HK-1, QHK-1 (QCS)**  
**QUICK CONNECT - ADD Q IN FRONT**  
**OF TORCH PACKAGE OR CABLE #**

ITEM NO.	STOCK NO.	DESCRIPTION	ITEM NO.	STOCK 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)
		3 ea. 27-10 screw, 3 ea. 27-11 washer	18	57N76	Metal nozzle adapter
	27-10B	Barrel assy. "B" model, includes	19	-	Metal nozzle (See chart B)
		3 ea. 27-10 screw, 3 ea. 27-11 washer	20	45V11	Power cable adapter
	27-9B	Barrel assy. w/rack hole	21	27-18-3	Bracket insulating cover
4	27R24	Barrel rack "B" model only, 24 pitch (1/4" x 1/4" x 11")	22	27-18	Bracket assy.* includes bracket, insulator block, insulator cover, mounting hardware:
5	27R32	Barrel rack "B" model only, 32 pitch (1/4" x 1/4" x 11")			2 ea. 1/4" -20 x 3/4" hex hd. brass cap screw
6	18R-1	6-32 x 3/16" fillister head screw			1 ea. 1/2" -13 x 1" hex hd. brass cap screw
7	-	Collet (See chart A)			1 ea. 1/2" -13 hex brass nut
8	27-2-4	O-ring			1 ea. 1/2" med. steel lock washer
9	27-11	#6 bronze lock washer			1 ea. 1/2" plain brass washer
10	27-10	6-32 x 3/16" binding head screw	23	-	Gas hose
10A	27-19	6-32 x 3/16" binding head nylon screw			40V82R-3 3 ft. (.9m)
11	27-13A	Shaft assy. "A" model includes shaft, knob, 1 ea. 27-13-2 & 27-13-3 O-ring			40V82R 12 1/2 ft. (3.8m)
	27-13B	Shaft assy. "B" model includes shaft, knob, 1 ea. 27-13-2 & 27-13-3 O-ring	24	-	40V82RL 25 ft. (7.6m)
12	27-13-2	O-ring			Power cable
13	27-13-3	O-ring			40V84R-3 3 ft. (.9m)
14	181W89	O-ring			40V84R 12 1/2 ft. (3.8m)
	57WCNA	Water cooled nozzle (not shown)	25	-	40V84RL 25 ft. (7.6m)
					Water in hose
					40V83R-3 3 ft. (.9m)
					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

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

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

### 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.