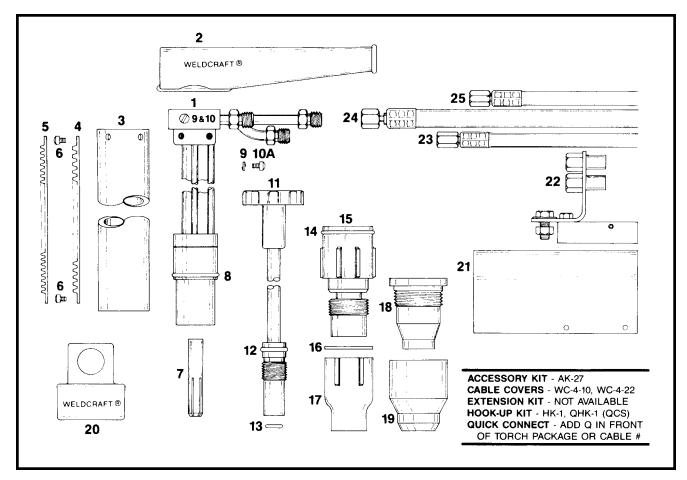


## **WP-27**

500 AMPS • WATER COOLED

## **REPLACEMENT PARTS**



ITEM	STOCK		ITEM	STOCK	DECODUCTION (		
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)		
-		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				
	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 Bracket assy.* includes bracket, insulator		
		Barrel assy. w/rack hole	22	27-10			
4	27R24	Barrel rack "B" model only, 24 pitch (1/4" x 1/4" x 11")			block, insulator cover, mounting hardware:		
5	27R32	Barrel rack "B" model only, 32 pitch (1/4" x 1/4" x 11")			2 ea. $\frac{1}{4}$ -20 x $\frac{3}{4}$ hex hd. brass cap screw		
6	18R-1	6-32 x <sup>3</sup> /16" fillister head screw			1 ea. $\frac{1}{2}$ " -13 x 1" hex hd. brass cap screw 1 ea. $\frac{1}{2}$ " -13 hex brass nut		
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 <sup>5</sup> /16" binding head screw	23		40V82R-3 3 ft. (.9m)		
10A	27-19	6-32 x <sup>5</sup> /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)		
	21 102	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)		
12	27-13-2	O-ring	25	_	Water in hose		
13	181W89	5			40V83R-3 3 ft. (.9m)		
14		O-ring			$40V83R$ $12^{1/2}$ ft. (3.8m)		
	57WCNA	Water cooled nozzle (not shown)			40V83RL 25 ft. (7.6m)		

## 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			

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

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

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

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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