

# COMET Type 41 Cutting Nozzles



## Oxy/Acetylene specifications

### Standard speed cutting nozzles



CIGWELD Type 41	Part No.	Size	Plate thickness	Fuel gas flow l/min@100kPa	Total Oxygen flow & pressure l/min@kPa
Standard:	306046	6	1-6	2.0	11(200)
for use	306047	8	6-10	3.5	20(200)
with	306048	12	12-20	4.0	38(200)
COMET 3	306049	15	25-75	7.0	75(350)
and Multi-	306050	20	100-125	9.0	134(400)
purpose	306051*	24	150-200	12.5	232(500)
	306052*	32±	225-300	20.0	420(600)
	306053*	48±	300-400	45.0	945(650)

### Hi-speed speed cutting nozzles



CIGWELD Type 41	Part No.	Size	Plate thickness	Fuel gas flow l/min@100kPa	Total Oxygen flow & pressure l/min@kPa	Cutting speed mm/min†
Hi-speed:	306069	6HS	6-8	6.0	31(650)	700
for use	306070	8HS	8-20	6.0	50(650)	700-550
with	306071	12HS	25-75	10.0	107(650)	500-300
cutting	306072	15HS	75-150	12.0	158(650)	300-200
machines	306073*	20HS	150-250	13.0	250(650)	200-100
	306074*	24HS	250-300	18.0	320(650)	90

NOTE: Preheat oxygen pressure for all hi-speed nozzles = 200kPa

### Gouging nozzles



CIGWELD Type 41	Part No.	Size	Fuel gas flow l/min@100kPa	Total Oxygen flow & pressure l/min@kPa
Gouging:	306035	32GB	15.0	61(500)
for use with	306036*	48GB±	18.0	85(600)
COMET 3 and	306037*	64GB±	20.0	112(650)
Multipurpose	306038	32GS	15.0	61(500)
	306077	60DG		

### Sheet metal nozzle



CIGWELD Type 41	Part No.	Size	Fuel gas flow l/min@100kPa	Total Oxygen flow & pressure l/min@kPa
Sheet Metal:	306067	6SM	1.5	9(200)
for use with				
COMET 3 and				
Multipurpose				

### Rivet cutting nozzle



CIGWELD Type 41	Part No.	Size	Fuel gas flow l/min@100kPa	Total Oxygen flow & pressure l/min@kPa
Rivet Cutting:	306076*	15RC	10.0	80(400)
for use with				
COMET 3 and				
Multipurpose				

\* Manufactured from copper

± For use with COMET Multi-Purpose ONLY

† Cutting speeds are average values for drop cuts on clean plate with nozzles

in good condition-variations could be expected due to actual working conditions.

NB: Cutting nozzles can operate over a range of gas flows (hence plate thicknesses). The values indicated are typical operating conditions & can be increased or decreased to suit particular applications.