

## CUTTING AND WELDING SYSTEM KM17

ACCORDING TO EN ISO 5172



### SET BOX KM17 A



Oxygen - Acetylene

connection A consisting of:

shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box with AR nozzles

#### Spring lever cutting attachment with short shaft

**23100** for welding 0,5 - 14 mm, for cutting 3 - 100 mm

**23101** for welding 0,5 - 30 mm, for cutting 3 - 100 mm

#### Spring lever cutting attachment with long spindle

**23130** for welding 0,5 - 14 mm, for cutting 3 - 100 mm

**23131** for welding 0,5 - 30 mm, for cutting 3 - 100 mm

### SET BOX KM17 B (BAYONET)



Oxygen - Acetylene

Connection B consisting of:

shank, torch carriage, check rail, cleaning needles, torch wrench, sheet steel box with AR nozzles

#### Spring lever cutting attachment with short shaft

**24100** for welding 0,5 - 14 mm, for cutting 3 - 100 mm

**24101** for welding 0,5 - 30 mm, for cutting 3 - 100 mm

#### Spring lever cutting attachment with long spindle

**24130** for welding 0,5 - 14 mm, for cutting 3 - 100 mm

**24131** for welding 0,5 - 30 mm, for cutting 3 - 100 mm

**23140** sheet steel box empty

### SHANKS KM17



#### Connection A

**23200** shank with connection but

**2320001** connection but

#### Connection B

**24200** shank with connection but

**2420001** connection but

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### SPRING LEVER CUTTING ATTACHMENT KM17



Oxygen - Acetylene  
with short spindle

**For connection A**

**23300** without nozzles

**23301** with cutting and welding nozzle AR H1 + S2

**For connection B**

**24300** without nozzles

**24301** with cutting and welding nozzle AR H1 + S2

### SPRING LEVER CUTTING ATTACHMENT KM17



Oxygen - Acetylene  
with long spindle

**For connection A**

**23310** without nozzles

**23311** with cutting and welding nozzle AR H1 + S2

**For connection B**

**24310** without nozzles

**24311** with cutting and welding nozzle AR H1 + S2

### HOLE CUTTING ATTACHMENT KM17



Oxygen - Acetylene  
with long spindle

**For connection A**

**23321** für block nozzles, without nozzles

**23320** with cutting and welding nozzle AR H1 + S2

**For connection B**

**24420** with cutting and welding nozzle AR H1 + S2

### FLAT HEADED CUTTING ATTACHMENT KM17



Oxygen - Acetylene  
with short spindle

**For connection A**

**23330** with cutting and welding nozzle FK H1 + S2

**For connection B**

**24330** with cutting and welding nozzle FK H1 + S2

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### FLACHKOPF CUTTING ATTACHMENT KM17

Oxygen - Acetylene

With long spindle



Connection B

**24335** with cutting and welding nozzle FK H1 + S2

### SPRING LEVER-CUTTING ATTACHMENT KM17

Oxygen - Acetylene

Connection A



**23340** for AR / ARS nozzles without nozzles

**23343** for AGN nozzles without nozzles

**23344** with cutting and welding nozzle AR H1 + S2

Connection B

**24345** for AR / ARS nozzles, without nozzles

**24341** for block nozzles AB, without nozzles

**24340** with cutting and welding nozzle AR H1 + S2

### WELDING SWAGED NOZZLES KM17

Oxygen - Acetylene

Connection A



Art.-No.	Size		Cons. [m3/h]	Cons. [m3/h]
<b>23401</b>	1	0,5 - 1 mm	0,075	0,08
<b>23402</b>	2	1 - 2 mm	0,15	0,16
<b>23403</b>	3	2 - 4 mm	0,30	0,315
<b>23404</b>	4	4 - 6 mm	0,475	0,5
<b>23405</b>	5	6 - 9 mm	0,75	0,8
<b>23406</b>	6	9 - 14 mm	1,15	1,25
<b>23407</b>	7	14 - 20 mm	1,70	1,8
<b>23408</b>	8	20 - 30 mm	2,50	2,6

Connection B



Art.-No.	Size		Cons. [m3/h]	Cons. [m3/h]
<b>24401</b>	1	0,5 - 1 mm	0,075	0,08
<b>24402</b>	2	1 - 2 mm	0,15	0,16
<b>24403</b>	3	2 - 4 mm	0,30	0,315
<b>24404</b>	4	4 - 6 mm	0,475	0,5
<b>24405</b>	5	6 - 9 mm	0,75	0,8
<b>24406</b>	6	9 - 14 mm	1,15	1,25
<b>24407</b>	7	14 - 20 mm	1,70	1,8
<b>24408</b>	8	20 - 30 mm	2,50	2,6

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### HEATING SWAGED NOZZLES KM17

with multi hole copper tip



**Connection A**                      **Size**

**23409**                                      3                                      2 - 4 mm

**23410**                                      4                                      4 - 6 mm

**Connection B**                      **Size**

**24409**                                      3                                      2 - 4 mm

**24410**                                      4                                      4 - 6 mm

### TUBE NOZZLES KM17

Connection  $\varnothing$  17mm, Cu-tube  $\varnothing$  6 mm, pliable



**Connection A**                      **Size**

**23502**                                      2                                      1 - 2 mm

**23503**                                      3                                      2 - 4 mm

**23504**                                      4                                      4 - 6 mm

**23505**                                      5                                      6 - 9 mm



**Connection B**                      **Size**

**24502**                                      2                                      1 - 2 mm

**24503**                                      3                                      2 - 4 mm

**24504**                                      4                                      4 - 6 mm

**24505**                                      5                                      6 - 9 mm

### TUBE NOZZLES FRONT PART KM17

Cu-tube  $\varnothing$  6 mm, pliable



**Art.-No.**                                      **Size**

**23532**                                      2                                      1 - 2 mm

**23533**                                      3                                      2 - 4 mm

**23534**                                      4                                      4 - 6 mm

**23535**                                      5                                      6 - 9 mm

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### COPPER TIPS KM17

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for welding tips



Art.-No.	Size	Range
2340101	1	0,5 - 1 mm
2340201	2	1 - 2 mm
2340301	3	2 - 4 mm
2340401	4	4 - 6 mm
2340501	5	6 - 9 mm
2340601	6	9 - 14 mm
2340701	7	14 - 20 mm
2340801	8	20 - 30 mm

### MULTI HOLE COPPER TIP KM17

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for heating tips



Art.-No.	Size	Range
2340901	3	2 - 4 mm
2341001	4	4 - 6 mm

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### PREHEATING TORCH KM17 - ACETYLENE

With Material copper

#### Connection A



Art.-No.	Size		Fuel gas pressure	O2 pressure	Fuel gas cons.	O2 cons.
23420	7	14 - 20 mm	0,5	2,5	1,7	1,8
23421	8	20 - 30 mm	0,5	3,0	2,5	2,6
23422	9	30 - 50 mm	0,5	3,0	4,0	4,2

#### Connection B

Art.-No.	Size		Fuel gas pressure	O2 pressure	Fuel gas cons.	O2 cons.
24600	7	14 - 20 mm	0,5	2,5	1,7	1,8
24601	8	20 - 30 mm	0,5	3,0	2,5	2,6
24602	9	30 - 50 mm	0,5	3,0	4,0	2,2

### SPARE PART PREHEATING NOZZLES KM17 - ACETYLENE

Material copper



Art.-No.	Size	
2460011	7	14 - 20 mm
2460111	8	20 - 30 mm
2460211	9	30 - 50 mm

### PREHEATING TORCH KM17 - PROPANE

With copper nozzle



Art.-No.	Size		Fuel gas pressure	O2 press.	Fuel gas cons.	O2 cons.
23414	7	14 - 20 mm	0,3	3,5	1,8	6,0
23415	8	20 - 30 mm	0,3	4,0	2,6	8,5
23416	9	30 - 50 mm	0,5	4,0	4,0	13,0

Art.-No.	Size		Fuel gas pressure	O2 press.	Fuel gas cons.	O2 cons.
24650	7	14 - 20 mm	0,3	3,5	1,8	6,0
24651	8	20 - 30 mm	0,3	4,0	2,6	8,5
24652	9	30 - 50 mm	0,5	4,0	4,0	13,0

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### SPARE PART PREHEATING NOZZLES KM17 - PROPANE

Material copper



Art.-No.	Size	
2465011	7	14 - 20 mm
2465111	8	20 - 30 mm
2465211	9*	30 - 50 mm

head wird angelötet

### HEAVY DUTY PREHEATING ATTACHMENT KM17 - ACETYLENE



Art.-No.	Size	Fuel gas pressure	O2 pressure	Fuel gas cons.	O2 cons.
23640	12	0,5	2,5	3,75	3,8
23645	13	0,5	2,5	4,3	4,4

### SPARE PART HEAVY DUTY PREHEATING NOZZLE KM17 - ACETYLENE

Material copper



Art.-No.	Size
2364012	12
2364013	13

Please kepp in mind:

Using torches with an Acetylene consumption of more than 1 m<sup>3</sup>/h several cylinders have to be coupled.

The maximum consumption per cylinder is limited to 1 m<sup>3</sup>/h. Matching cylinder couplings can be found in our catalog on „Central gas supply“.