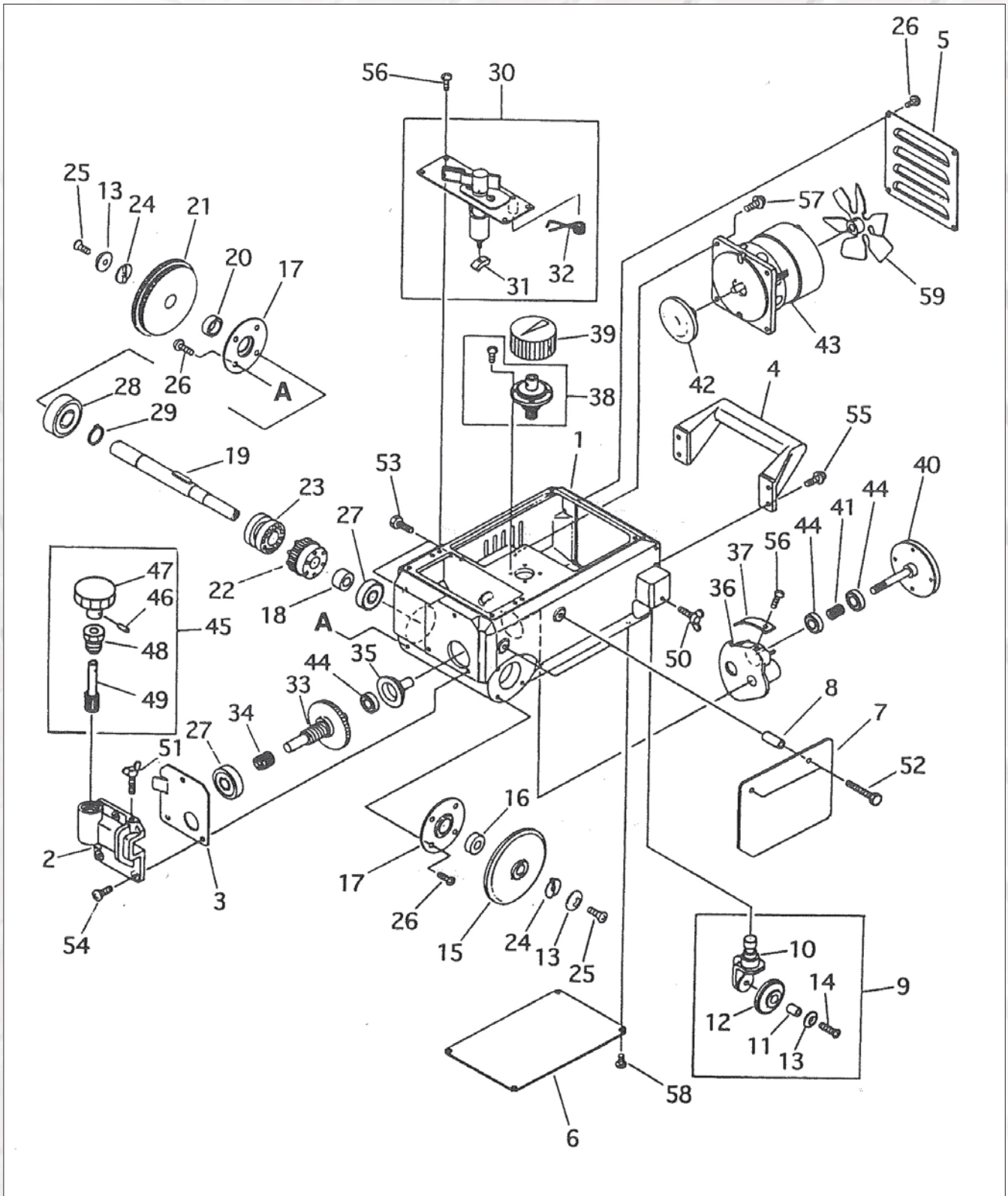


GAS-CHAMP

10.1 Main Unit



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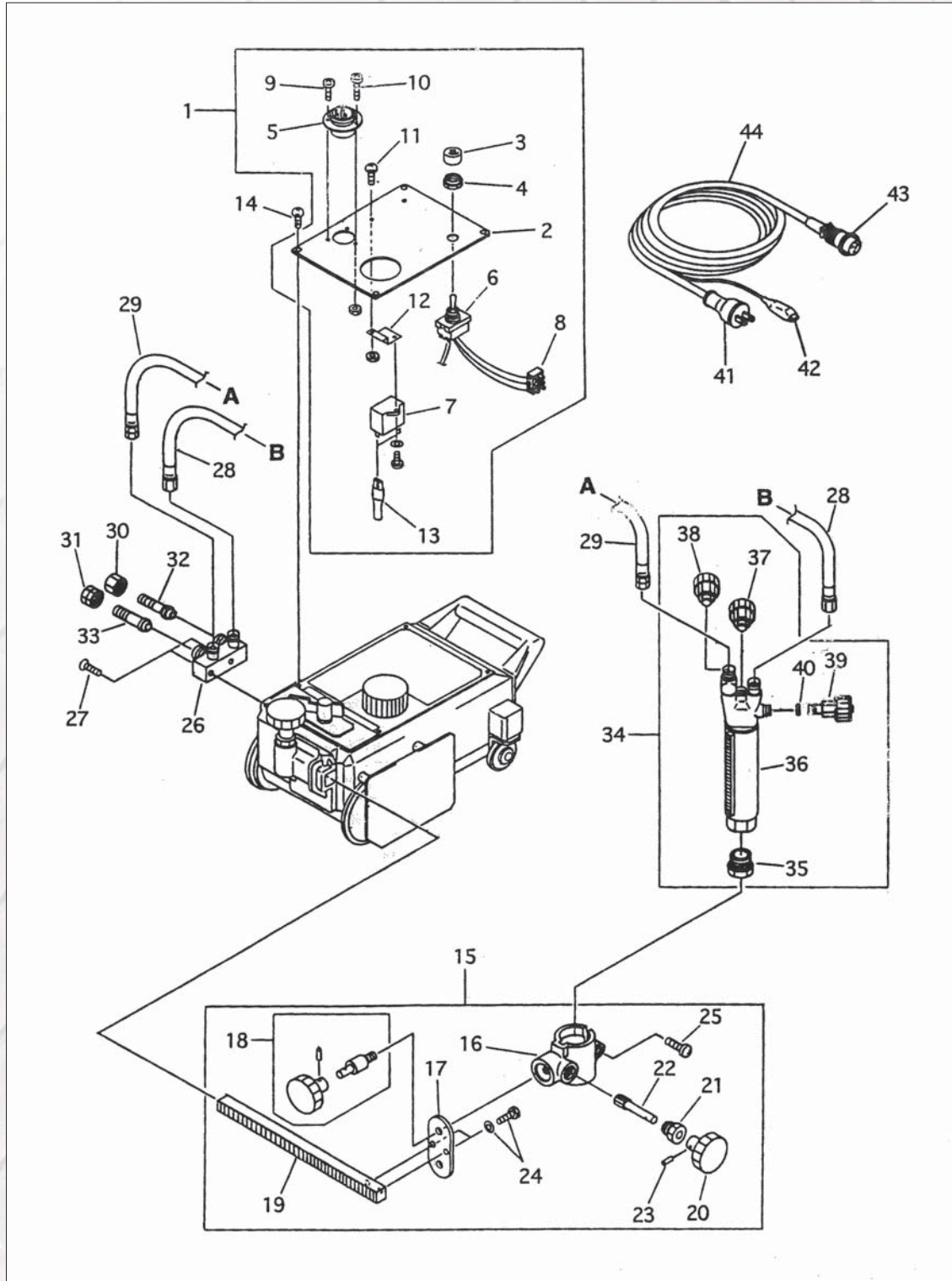
10.1 Main Unit

No.	Description	Part No.	Qty
1	Case	60031802	1
2	Cross feed holder	60031803	1
3	Cross feed liner	60031804	1
4	Handle	60031805	1
5	Fan cover	60031806	1
6	Bottom plate	60031807	1
7	Heat shield	60031808	1
8	Heat shield collar	60031809	2
9	Idle wheel unit	60031810	1
10	Idle wheel bracket	60031811	1
11	Roller shaft	60031812	1
12	Roller	60030213	1
13	Washer	60030241	3
14	Screw (SM-5X25)	6C510525	1
15	Idle wheel	60031813	1
16	Collar (A)	60031814	1
17	Bearing retainer	60031815	2
18	Collar (B)	60031816	1
19	Drive wheel shaft w/key	60031817	1
20	Collar (C)	60031818	1
21	Drive wheel	60031819	1
22	Worm wheel	60030247	1
23	Clutch	60030246	1
24	Washer	60030242	2
25	Screw (SM-5X15)	6C510515	2
26	Screw (SP-5X8)	6C520508	12
27	Bearing (6300ZZ)	60031836	2
28	Bearing (6302ZZ)	60030819	1
29	Stop ring (STW-15)	6B520150	1
30	Clutch lever assembly	60031820	1
31	Slider	60030265	1
32	Clutch spring	60031821	1
33	Worm shaft assembly	60031822	1
34	Worm spring	60031823	1
35	Speed adjusting shaft	60031824	1
36	Speed adjusting bracket	60031825	1
37	Rack	60031826	1

No.	Description	Part No.	Qty
38	Speed adjusting handle	60031827	1
39	Speed adjusting knob	60031828	1
40	Speed adjusting cone assembly	60031860	1
41	Cone spring	60031829	1
42	Motor disk	60031868	1
43	Motor (230V-240)	60031833	1
44	Bearing (608ZZ)	60030269	3
45	Cross feed pinion unit	60031835	1
46	Spring pin (PR-2.5X16)	6B022516	1
47	Handle (Ø 40)	60030823	1
48	Pinion metal	60030318	1
49	Pinion	60030319	1
50	Wing bolt (BS-6X15)	6C110615	1
51	Wing bolt (BS-6X25)	6C110625	1
52	Hexagon bolt (BH-6X30)	6C010630	2
53	Hexagon bolt (BH-6X18)	6C010618	2
54	Screw (SP-6X14)	6C520614	3
55	Screw (SP-5X15) with washer	6C530515	4
56	Screw (SP-4X10)	6C520410	10
57	Screw (SP-4X15)	6C520415	4
58	Screw (SP-4X8)	6C520408	8
59	Motor fan w/screw	60030289	1

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10.2 Electrical, gas and torch slide holder units



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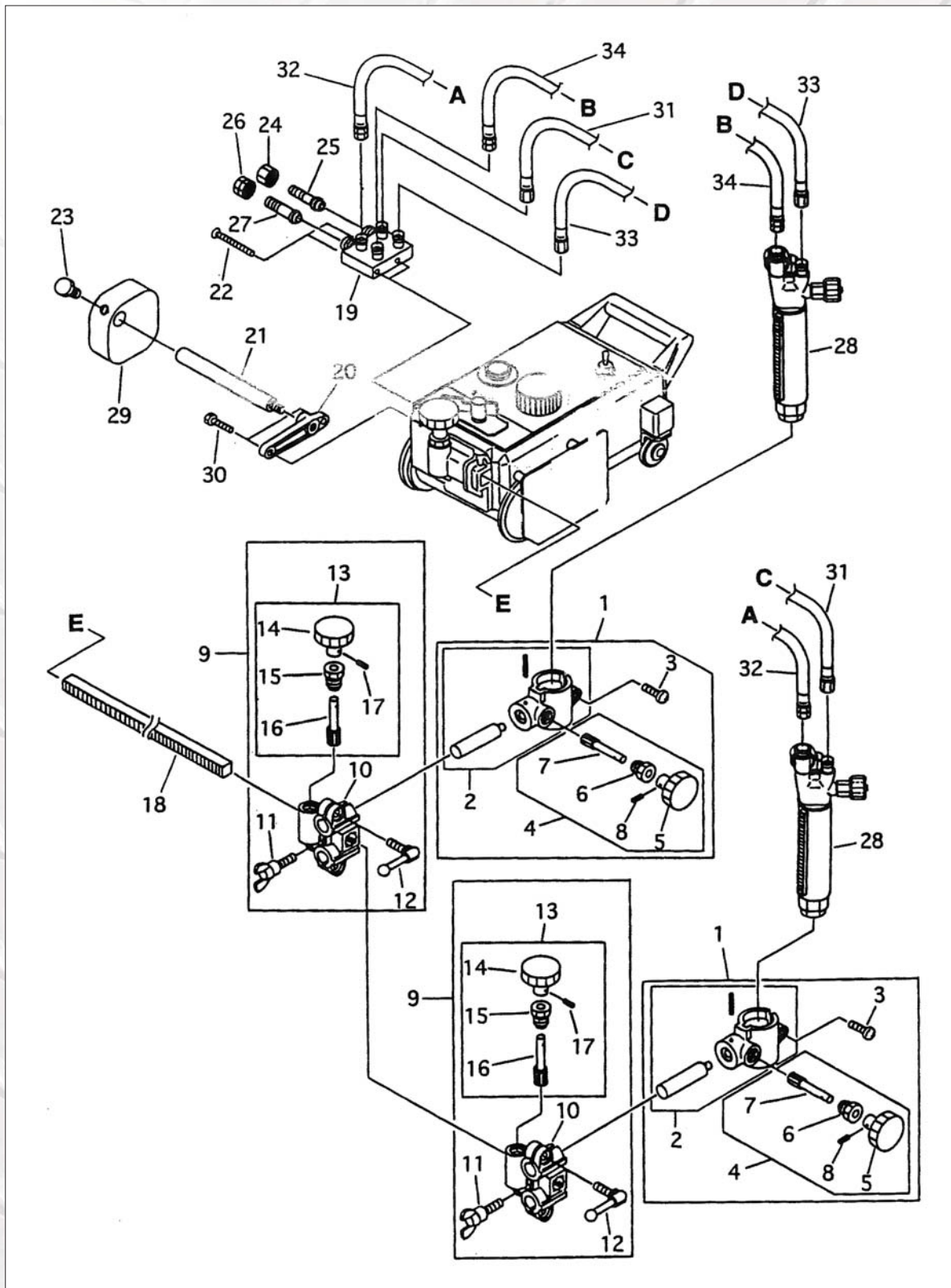
10.2 Electrical, gas and torch slide holder units

No.	Description	Part No.	Qty
1	Panel assembly (200V-240V)	60031695	1
2	Panel	60031837	1
3	Cap for dust protector	60032431	1
4	Nut for dust protector	60035017	1
5	Metal socket (3P)	60030273	1
6	Switch (200V-240V)	60031859	1
7	Condenser (230V-240V)	60035209	1
8	Terminal (200V-240V) 4P	60030656	1
9	Screw (SM-3X6)	6C510306	2
10	Screw (SM-3X8) with nut	6C620308	1
11	Screw (SP-3X6) with nut	6C610306	2
12	Condenser fixing plate	60032389	1
13	Faston terminal	60035211	2
14	Screw (SP-4X8)	6C520408	4
15	Torch holder assembly	60031801	1
16	Torch holder	60031842	1
17	Torch holder fixing plate	60031843	1
18	Holder fixing handle	60031844	1
19	Rack bar	60031845	1
20	Handle (Ø 40)	60030223	1
21	Pinion metal	60030909	1
22	Pinion	60030910	1
23	Spring pin (PR-2.5X16)	6B022516	1
24	Hexagon bolt (BC-5X14)	6C400514	2
25	Screw (SP-6X25)	6C520625	1
26	Distributor (IWWS)	60031846	1
27	Screw (SM-5X25)	6C510525	2
28	Hose for oxygen (IWWS)	OXY600	1
29	Hose for gas - ACET IWWS	ACET600	1
	Hose for gas - LPG IWWS	LPG600	1
30	Nut oxygen IWWS	RHN	1
31	Nut for fuel gas IWWS	LHN	1
32	Hose connector oxy IWWS	NP	1
33	Hose connector fuel gas IWWS	NP	1
34	Torch - 3 seat tips (KE) IWWS	60010050KT	1

No.	Description	Part No.	Qty
	Torch - 2 seat tips (CW) IWWS	600100510CT	1
35	Tip fixing nut	60005020	1
36	Rack w/screw	60010056	1
37	Valve for preheat oxygen	60015355	1
38	Valve for gas	60015356	1
39	Valve for jet for oxygen	60015402	1
40	O-ring	60005026	1
41	Rubber plug	60030279	1
42	Earth clip	60030995	1
43	Metal plug 3P	60030910-43	1
44	Cabtyre cord assembly 3P	60030201	1

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10.3 Two Torch Unit



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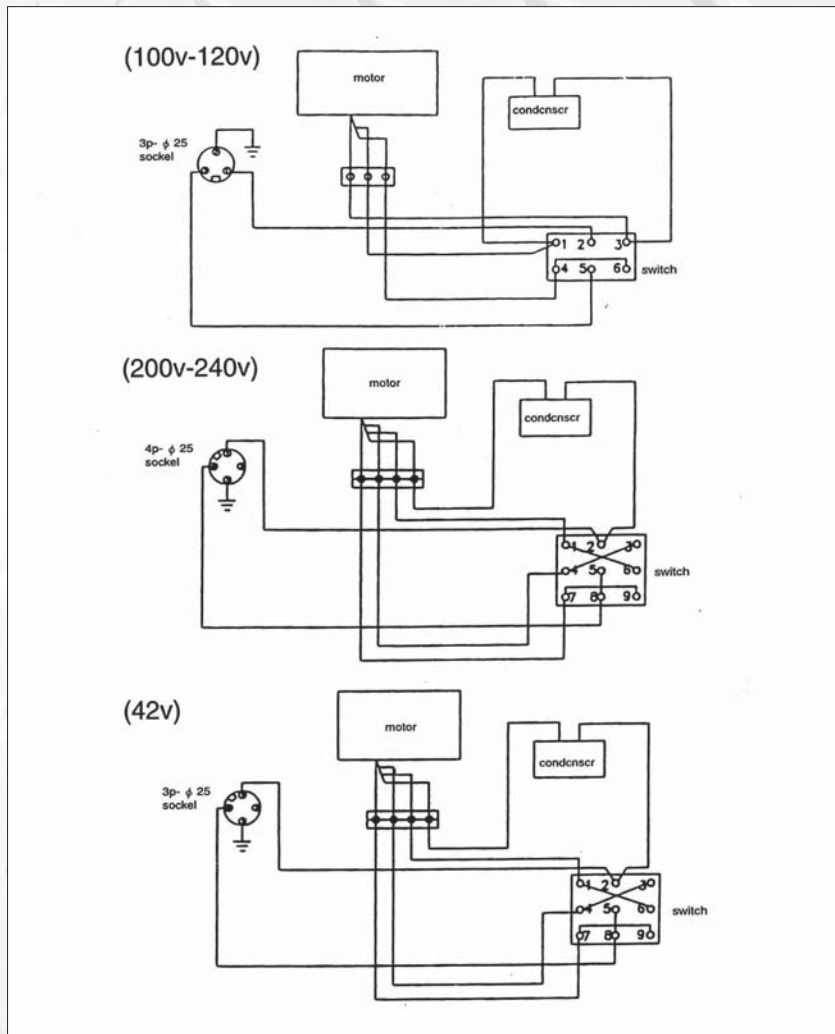
10.3 Two Torch Unit

No.	Description	Part No.	Qty
1	Torch holder assembly	60031848	2
2	Torch holder	60031856	2
3	Screw (SP-6X25)	60030625	2
4	Torch up/down handle	60030908	2
5	Handle (Ø 40)	60030223	5
6	Pinion metal	60030909	2
7	Pinion	60030273	2
8	Spring pin (PR-2.5X16)	60022516	2
9	Torch cross feed holder	60031849	2
10	Cross feed holder	60031857	2
11	Wing bolt	60031877	2
12	Crank handle	60030313	2
13	Cross feed pinion unit	60031835	2
14	Handle (Ø 40)	60030223	2
15	Pinon metal	60030318	2
16	Pinion	60030319	2
17	Spring pin (PR-2.5X16)	6B022516	2
18	Rack bar	60031850	1
19	Distributor (IWWS)	60031846	1
N/A	Distributor Y-Oxy R/H IWWS	IWR121	1
N/A	Distributor Y-Fuel Gas L/H IWWS	IWR215	1
20	Fitting	60031854	1
21	Weight supporter	60031855	1
22	Screw (SM-5X55)	6C510555	2
23	Hexagon bolt (BH-10X35)	6C011035	1
24	Nut for oxygen IWWS	RHN	1
25	Hose connector oxy IWWS	NP	1
26	Nut for fuel gas IWWS	LHN	1
27	Hose connector gas IWWS	NP	1
28	Torch - 3 seat tips (KE) IWWS	60010050KT	2
	Torch - 2 seat tips (CW) IWWS	60010510CT	2
29	Weight	60030381	1
30	Hexagon bolt (BH-6X40)	6C010640	2

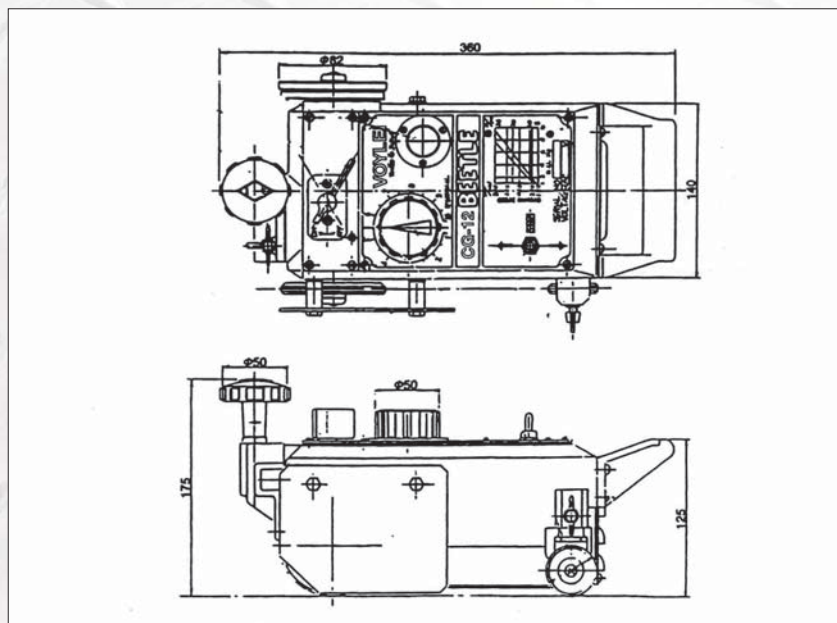
No.	Description	Part No.	Qty
31	Hose for oxygen IWWS	OXY600	1
32	Hose for gas - ACET IWWS	ACET600	1
	Hose for gas - LPG IWWS	LPG600	1
33	Hose for oxygen IWWS	OXY600	1
34	Hose for gas - ACET IWWS	ACET600	1
	Hose for gas - LPG IWWS	LPG600	1

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Wiring diagram



Assembly drawing of CG-12 Beetle



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GAS-CHAMP

106 (Standard Speed) for Propane Metric System

Plate Thickness (mm)	Tip Size	Cutting Speed (mmv min)	Oxygen Pressure (kg/cm ²) / (Mpa)		Fuel Gas Pressure (kg/cm ²) / (Mpa)	Kerf Width (mm)
			Cutting	Pr-Heat		
3	00	680	1.5 / 0.15	1.5 / 0.15	0.2 / 0.02	1.0
6	0	610	2.0 / 0.2	2.0 / 0.2	0.2 / 0.02	1.3
10	1	560	2.0 / 0.2	2.0 / 0.2	0.2 / 0.02	1.0
12.5	2	530	2.5 / 0.25	2.5 / 0.25	0.2 / 0.02	1.5
19	2	460	3.0 / 0.3	3.0 / 0.3	0.25 / 0.25	2.0
25	3	430	3.0 / 0.3	3.0 / 0.3	0.25 / 0.25	2.0
38	4	355	3.0 / 0.3	3.0 / 0.3	0.25 / 0.25	2.3
50	5	320	3.0 / 0.3	3.0 / 0.3	0.25 / 0.25	2.8
60	5	280	1.0 / 0.4	4.0 / 0.4	0.3 / 0.03	3.0
75	5	250	1.0 / 0.4	4.0 / 0.4	0.3 / 0.03	3.0
100	6	200	1.0 / 0.4	4.0 / 0.4	0.3 / 0.03	3.6
125	6	180	4.0 / 0.4	4.0 / 0.4	0.4 / 0.04	3.6
150	7	150	4.5 / 0.45	4.5 / 0.45	0.4 / 0.04	4.1
200	7	130	4.5 / 0.45	4.5 / 0.45	0.4 / 0.04	4.3
250	8	80	4.5 / 0.45	4.5 / 0.45	0.4 / 0.04	5.6
300	8	50	4.5 / 0.45	4.5 / 0.45	0.4 / 0.04	6.6

Inch System

Plate Thickness (inches)	Tip Size	Cutting Speed (mmv min)	Oxygen P.S.I.G		Fuel Gas P.S.I.G	Kerf Width (inches)
			Cutting	Pr-Heat		
1/8	00	27	20	20	2.8	0.04
1/4	0	24	30	30	2.8	0.05
3/8	1	22	30	30	2.8	0.06
1/2	2	21	40	40	2.8	0.07
3/4	2	18	45	45	3.6	0.08
1	3	17	45	45	3.6	0.08
1-1/2	4	14	45	45	3.6	0.09
2	5	12.5	45	45	4.3	0.11
2-1/2	5	11	55	55	4.3	0.12
3	5	10	55	55	4.3	0.12
4	6	8	55	55	5.7	0.14
5	6	7	55	55	5.7	0.14
6	7	6	65	65	5.7	0.16
8	7	5	65	65	5.7	0.17
10	8	3	65	65	5.7	0.23
12	8	2	65	65	5.7	0.27

Note:

1. All pressures are torch inlet pressures
2. Oxygen purity is minimum of 99.7%, propane is minimum of JIS Grade 3
3. Depending on the surface condition of the steel plate (scale, paint) either increase the fuel gas pressure or decrease cutting speed.
Also, when precision cutting is required, adjust all data.



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GAS-CHAMP

102-D7 (High Speed) for Acetylene

Metric System

Plate Thickness (mm)	Tip Size	Cutting Speed (mmv min)	Oxygen Pressure (kg/cm ²) / (Mpa)		Fuel Gas Pressure (kg/cm ²) / (Mpa)	Kerf Width (mm)
			Cutting	Pr-Heat		
3	00	880	7.0 / 0.7	1.5 / 0.15	0.2 / 0.02	0.8
6	0	740	7.0 / 0.7	2.0 / 0.2	0.2 / 0.02	1.0
10	1	680	7.0 / 0.7	2.0 / 0.2	0.2 / 0.02	1.3
12.5	2	630	7.0 / 0.7	2.5 / 0.25	0.2 / 0.02	1.3
19	2	560	7.0 / 0.7	3.0 / 0.3	0.25 / 0.25	1.5
25	3	510	7.0 / 0.7	3.0 / 0.3	0.25 / 0.25	1.8
38	4	460	7.0 / 0.7	3.0 / 0.3	0.25 / 0.25	2.0
50	5	410	7.0 / 0.7	3.0 / 0.3	0.25 / 0.25	2.6
60	5	360	7.0 / 0.7	4.0 / 0.4	0.3 / 0.03	2.8
75	5	320	7.0 / 0.7	4.0 / 0.4	0.3 / 0.03	2.8
100	6	250	7.0 / 0.7	4.0 / 0.4	0.3 / 0.03	3.3
125	6	230	7.0 / 0.7	4.0 / 0.4	0.4 / 0.04	3.6
150	7	180	7.0 / 0.7	4.5 / 0.45	0.4 / 0.04	3.6
200	7	140	7.0 / 0.7	4.5 / 0.45	0.4 / 0.04	4.6
250	8	100	7.0 / 0.7	4.5 / 0.45	0.4 / 0.04	5.1
300	8	80	7.0 / 0.7	4.5 / 0.45	0.4 / 0.04	6.1

Inch System

Plate Thickness (inches)	Tip Size	Cutting Speed (mmv min)	Oxygen P.S.I.G		Fuel Gas P.S.I.G	Kerf Width (inches)
			Cutting	Pr-Heat		
1/8	00	31.5	100	20	2.8	0.03
1/4	0	29	100	30	2.8	0.04
3/8	1	27	100	30	2.8	0.05
1/2	2	25	100	40	2.8	0.05
3/4	2	22	100	45	3.6	0.06
1	3	20	100	45	3.6	0.07
1-1/2	4	18	100	45	3.6	0.08
2	5	16	100	45	4.3	0.10
2-1/2	5	14	100	55	4.3	0.11
3	5	12.5	100	55	4.3	0.11
4	6	10	100	55	5.7	0.13
5	6	9	100	55	5.7	0.14
6	7	7	100	65	5.7	0.14
8	7	5.5	100	65	5.7	0.18
10	8	4	100	65	5.7	0.20
12	8	4	100	65	5.7	0.24

Note:

1. All pressures are torch inlet pressures
2. Oxygen purity is minimum of 99.7%, propane is minimum of JIS Grade 3
3. Depending on the surface condition of the steel plate (scale, paint) either increase the fuel gas pressure or decrease cutting speed.
Also, when precision cutting is required, adjust all data.



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