

# EX-TR AFLAME®

## TORCH SUITABLE FOR OXY-FUEL CUTTING

THERMACUT® developed its own oxy-fuel cutting torch EX-TR AFLAME® in two versions which works with all kinds of fuel gases and brings you these benefits:

- **SPECIAL O-RINGS TO AVOID THE MIXING OF GASES**
- **QUICK-CHANGE SYSTEM WITH STAINLESS STEEL NUT**
- **CHANGEABLE INJECTOR**
- **SEPARATE PARTS (TORCH + VALVES)**
- **HIGH PERFORMANCE CUTTING**

### EX-TR AFLAME®

Uses standard replacement parts suitable for model HARRIS® consumables.

**A-2100-A** for acetylene

**A-2100-PM** for propane and natural gas

Torches A-2100-A and A-2100-PM are available with input fittings which are removable.

### EX-TR AFLAME® PRO

Uses replacement parts suitable for model VADURA® and GRICUT® consumables with our unique design.

Greater cutting speed and lower preheating time.

**A-1100-A** for acetylene

**A-1100-PM** for propane and natural gas



#### Item Description

Item	Description
1	Reductions (9/16 -18 UNF / 9/16 -18 UNF / 9/16 -18 UNF LH) - only for A2100-A/PM
2	Gases input (G 1/4" / G 3/8" / G 3/8" LH)
3	Fixing nut
4	Changeable injector (A - Acetylene, PM - Propane and natural gas)
5	Torch body
6	Torch head
7	Cutting tip
8	Heating nozzle
9	Consumables holder

With each EX-TR AFLAME® torch, THERMACUT® supply a separate convenient "Cut chart" which shows the mm. thickness, gas pressures, and consumptions for gases for that torch.

### EX-TR AFLAME® A-2100-A

#### CUT CHART FOR REPLACEMENT PARTS SUITABLE FOR MODEL HARRIS® 6290-VAX

Work-piece thickness [mm]	Cutting nozzle [Ref. Nr.]	Cutting speed [mm/min.]	Cutting oxygen pressure [bar]	Minimum preheating oxygen pressure [bar]	Fuel gas pressure [bar]	Cutting oxygen consumption [m³/h]	Preheating oxygen consumption [m³/h]	Fuel gas consumption [m³/h]	Cutting kerf width [mm]
0-8	6290-VAX1 OEM	650	2.5-4	1.6	0.1-0.15	0.85-1.25	0.37	0.34	1.6
8-15	6290-VAX2	600	5	1.6	0.15	2.4	0.425	0.4	1.9
15-35	6290-VAX3	550	7	1.6	0.15	4	0.48	0.425	1.9
35-75	6290-VAX4	450	7	1.6	0.15	5	0.54	0.48	2.1
75-150	6290-VAX5	300	5	1.6	0.15	9	0.62	0.57	2.3
150-200	6290-VAX6	150	6.5	1.6	0.15	13.5	0.55	0.76	3.3



**DESCRIPTION:** Two-piece high speed cutting tip for cutting up to 200 mm.

**GASES:** Oxygen - acetylene.

**SUITABLE FOR:** : EX-TR AFLAME®

### EX-TR AFLAME® A-2100-PM

#### CUT CHART FOR REPLACEMENT PARTS SUITABLE FOR MODEL HARRIS® 6290-VVC

Work-piece thickness [mm]	Cutting nozzle [Ref. Nr.]	Cutting speed [mm/min.]	Cutting oxygen pressure [bar]	Minimum preheating oxygen pressure [bar]	Fuel gas pressure [bar]	Cutting oxygen consumption [m³/h]	Preheating oxygen consumption [m³/h]	Fuel gas consumption [m³/h]	Cutting kerf width [mm]
1-4	6290-VVC5/0 OEM	750-550	4	1.6	0.03-0.2	0.65	0.8	0.23	1.3
4-6	6290-VVC4/0 OEM	700-520	2.5	1.6	0.03-0.2	1.13	0.8	0.23	1.5
6-9	6290-VVC3/0	650-480	5	1.6	0.03-0.2	2.26	1	0.3	1.8
9-12.5	6290-VVC2/0	630-450	5	1.6	0.03-0.2	2.574	1	0.3	1.8
12.5-20	6290-VVC0	600-400	6	1.6	0.03-0.2	3.53	1	0.3	2.0
20-35	6290-VVC0 1/2	550-360	7	1.6	0.03-0.2	4	1	0.3	2.0
35-60	6290-VVC1	480-220	7	1.6	0.03-0.2	5.56	1	0.3	2.3
60-75	6290-VVC1 1/2	310-200	6.5	1.6	0.03-0.2	7.07	1	0.3	2.8
75-100	6290-VVC2	280-190	6.5	1.6	0.03-0.2	8	1.13	0.33	3.0
100-125	6290-VVC2	240-180	7	1.6	0.03-0.2	9	1.13	0.33	3.0
125-150	6290-VVC2 1/2	200-160	6.5	1.6	0.03-0.2	11.17	1.13	0.33	3.3
150-175	6290-VVC3	180-150	7	1.6	0.03-0.2	12	1.13	0.33	3.5
175-200	6290-VVC4	180-150	6.5	1.6	0.03-0.2	14.85	1.13	0.33	4.0
200-225	6290-VVC5	150-130	6	1.6	0.03-0.2	16.41	1.3	0.38	5.0
225-250	6290-VVC5 1/2	130-110	6	1.6	0.03-0.2	16.98	1.3	0.38	6.4



**DESCRIPTION:** Two-piece high speed cutting tip for cutting up to 250 mm.

**GASES:** Oxygen - propane, natural gas.

**SUITABLE FOR:** : EX-TR AFLAME®

### EX-TRAFLEAME® PRO

#### CUT CHART FOR REPLACEMENT PARTS SUITABLE FOR MODEL MESSER® VADURA® 9215A

Work-piece thickness [mm]	Cutting nozzle [Ref. Nr.]	Heating nozzle [Ref. Nr.]	Cutting speed [mm/min.]	Torch height [mm]	Cutting oxygen pressure [bar]	Preheating oxygen pressure [bar]	Fuel gas pressure [bar]	Cutting oxygen consumption [m³/h]	Preheating oxygen consumption [m³/h]	Fuel gas consumption [m³/h]	Cutting kerf width [mm]
10	716.16563	716.16550	740	5 - 7	6,5	2,5	0,5	3,25	0,47	0,36	2,1
15	716.16563	716.16550	630	5 - 7	6,5	2,5	0,5	3,22	0,47	0,36	2,1
20	716.16563	716.16550	570	5 - 7	7	2,5	0,5	3,50	0,47	0,36	2,1
25	716.16563	716.16550	520	5 - 7	7,5	2,5	0,5	3,7	0,47	0,36	2,1
25	716.16564	716.16550	520	5 - 7	6,5	2,5	0,5	4,60	0,47	0,36	2,5
30	716.16564	716.16550	500	5 - 7	7,5	2,5	0,5	5,20	0,47	0,36	2,7
35	716.16564	716.16550	460	5 - 7	7,5	2,5	0,5	5,20	0,47	0,36	2,7
40	716.16564	716.16550	440	5 - 7	8	2,5	0,5	5,20	0,47	0,36	2,7
40	716.16565	716.16550	440	5 - 7	6,5	2,5	0,5	5,60	0,47	0,36	2,8
50	716.16565	716.16550	390	5 - 7	7	2,5	0,5	6	0,47	0,36	3
60	716.16565	716.16550	360	5 - 7	8,5	2,5	0,5	7,10	0,47	0,36	3
60	716.16566	716.16550	360	5 - 7	6,5	2,5	0,5	9,10	0,47	0,36	3
80	716.16566	716.16550	300	5 - 7	7,5	2,5	0,5	10,40	0,47	0,36	3
100	716.16566	716.16550	270	5 - 7	8	2,5	0,5	11	0,47	0,36	3
100	716.16567	716.16560	270	7 - 10	6,5	3,5	0,5	12,10	0,62	0,48	3,6
130	716.16567	716.16560	230	7 - 10	7	3,5	0,5	12,90	0,62	0,48	3,6
150	716.16567	716.16560	210	7 - 10	7	3,5	0,5	12,90	0,62	0,48	3,6
150	716.16568	716.16560	210	20	6,5	6,5	0,5	19,40	1,06	0,82	5
200	716.16568	716.16560	180	20	7	7	0,5	20,80	1,10	0,85	5
230	716.16568	716.16560	140	20	7,5	7,5	0,5	22,00	1,14	0,88	5
230	716.16569	716.16560	150	25	6,5	6,5	0,5	28,50	1,08	0,83	6
250	716.16569	716.16560	130	25	7	7	0,5	30,00	1,10	0,85	6
300	716.16569	716.16560	110	25	7,5	7,5	0,5	32,50	1,14	0,88	6



**DESCRIPTION:** High-speed "quick change" two-piece nozzles for machine cutting up to 300 mm.  
**GASES:** Acetylene.  
**SUITABLE FOR:** EX-TRAFLEAME® PRO.

### EX-TRAFLEAME® PRO A-1100-PM

#### CUT CHART FOR REPLACEMENT PARTS SUITABLE FOR MODEL MESSER® GRICUT® 9230-PMYF

Work-piece thickness [mm]	Cutting nozzle [Ref. Nr.]	Heating nozzle [Ref. Nr.]	Cutting speed [mm/min.]	Torch height [mm]	Cutting oxygen pressure [bar]	Preheating oxygen pressure [bar]	Fuel gas pressure [bar]	Cutting oxygen consumption [m³/h]	Preheating oxygen consumption [m³/h]	Fuel gas consumption [m³/h]	Cutting kerf width [mm]
3	716.16551	716.16550	780	2-4	1.0	1.5	0.2	0.6	1.1	0.28	0.9
4	716.16551	716.16550	740	2-4	1.5	1.5	0.2	0.8	1.1	0.28	0.9
5	716.16551	716.16550	720	2-4	2.0	1.5	0.2	1.0	1.1	0.28	1.0
6	716.16551	716.16550	700	2-4	2.5	2.0	0.2	1.2	1.3	0.33	1.1
8	716.16551	716.16550	650	4-5	3.5	2.0	0.2	1.6	1.3	0.33	1.3
10	716.16551	716.16550	600	4-5	5.0	2.0	0.2	2.2	1.3	0.33	1.5
7	716.16552	716.16550	670	4-5	5.0	2.5	0.2	1.8	1.5	0.38	1.6
8	716.16552	716.16550	650	4-5	5.5	2.5	0.2	1.9	1.5	0.38	1.7
10	716.16552	716.16550	630	5-8	6.0	2.5	0.2	2.0	1.5	0.38	1.8
12	716.16552	716.16550	590	5-8	6.5	2.5	0.2	2.2	1.5	0.38	1.9
15	716.16552	716.16550	560	5-8	7.0	2.5	0.2	2.3	1.5	0.38	2.0
15	716.16553	716.16550	560	5-8	6.0	2.5	0.2	2.5	1.5	0.38	2.1
20	716.16553	716.16550	510	5-10	6.5	2.5	0.2	2.8	1.5	0.38	2.2
25	716.16553	716.16550	460	5-10	7.0	2.5	0.2	3.1	1.5	0.38	2.3
25	716.16554	716.16550	460	5-10	6.0	2.5	0.2	3.8	1.5	0.38	2.4
30	716.16554	716.16550	440	5-10	7.0	2.5	0.2	4.3	1.5	0.38	2.5
35	716.16554	716.16550	420	5-10	7.5	2.5	0.2	4.5	1.5	0.38	2.6
40	716.16554	716.16550	400	5-10	7.5	2.5	0.2	4.6	1.5	0.38	2.7
40	716.16555	716.16550	400	5-10	5.5	2.5	0.2	4.2	1.5	0.38	2.8
50	716.16555	716.16550	360	5-10	6.5	2.5	0.2	4.9	1.5	0.38	2.9
60	716.16555	716.16550	340	5-10	7.5	2.5	0.2	5.6	1.5	0.38	2.9
60	716.16556	716.16550	340	6-10	6.0	2.5	0.2	7.6	1.5	0.38	3.4
80	716.16556	716.16550	300	6-10	7.5	2.5	0.2	9.4	1.5	0.38	3.5
100	716.16556	716.16550	270	6-10	8.5	2.5	0.2	10.6	1.5	0.38	3.5



**DESCRIPTION:** Two-piece standard cutting tip for cutting up to 100 mm.  
**GASES:** Oxygen - propane, natural gas, mixed gases.  
**SUITABLE FOR:** EX-TRAFLEAME® PRO.

### EX-TRAFIAME® PRO

#### CUT CHART FOR REPLACEMENT PARTS SUITABLE FOR MODEL THERMACUT® HIGH PERFORMANCE CUTTING TIP

Work-piece thickness [mm]	Cutting nozzle [Ref. Nr.]	Heating nozzle [Ref. Nr.]	Cutting speed [mm/min.]	Torch height [mm]	Cutting oxygen pressure [bar]	Preheating oxygen pressure [bar]	Minimal fuel gas pressure [bar]	Cutting oxygen consumption [m³/h]	Preheating oxygen consumption [m³/h]	Fuel gas consumption [m³/h]	Cutting kerf width [mm]
10	1-1100-PM	716.16550	650	5	9	2	0,2	3,5	1,2	0,33	1,6
15	1-1100-PM	716.16550	580	5	10	2	0,2	4	1,2	0,33	1,6
20	1-1100-PM	716.16550	500	7	11	2	0,2	4,2	1,2	0,33	1,6
25	1-1100-PM	716.16550	500	7	9	2	0,2	4,3	1,2	0,33	2,2
25	2-1100-PM	716.16550	500	7	9,5	2	0,2	4,3	1,2	0,33	2,2
30	2-1100-PM	716.16550	490	7	10	2	0,2	4,5	1,2	0,33	2,2
40	2-1100-PM	716.16550	460	7	10	2	0,2	4,7	1,2	0,33	2,2
50	2-1100-PM	716.16550	390	7	11	2	0,2	5,2	1,2	0,33	2,2
50	3-1100-PM	716.16550	390	7	10	2	0,2	7,4	1,2	0,33	2,4
60	3-1100-PM	716.16550	350	7	10	2	0,2	7,4	1,2	0,33	2,4
75	3-1100-PM	716.16550	320	10	11	2	0,2	8,1	1,2	0,33	2,4
75	4-1100-PM	716.16550	320	10	10	2	0,2	9,3	1,2	0,33	2,7
90	4-1100-PM	716.16550	280	10	10	2	0,2	9,3	1,2	0,33	2,7
100	4-1100-PM	716.16550	270	10	11	2	0,2	10,2	1,2	0,33	2,7



**DESCRIPTION:** Two-piece standard cutting tip for cutting up to 100 mm.

**GASES:** Oxygen - propane, natural gas, mixed gases.

**SUITABLE FOR:** EX-TRAFIAME® PRO torch.

### THERMACUT® SHUT-OFF VALVES

#### - SUITABLE FOR OXYGEN GAS



Item	Part No.	Ref. No.	Description	Packing
*1.	A-1517*	3YR-3R-A01	Connection: G3/8" (cutting oxygen)	1pc
*	A-1519*	3YR-1R-A01	Connection: G1/4" (heating oxygen)	1pc

#### - SUITABLE FOR FUEL GAS



Item	Part No.	Ref. No.	Description	Packing
*1.	A-1518*	3YR-3L-A01	Connection: G3/8" LH	1pc

### THERMACUT® FLASHBACK ARRESTORS

#### - SUITABLE FOR OXYGEN GAS



Item	Part No.	Ref. No.	Description	Packing
*1.	A-1512*	F611-1R	Connection: G1/4" (heating oxygen)	1pc
*	A-1514*	F611-3R	Connection: G3/8" (cutting oxygen)	1pc
	A-1515	F611-9R	Connection: UNF9/16" (cutting and heating oxygen - US market)	1pc

#### - SUITABLE FOR FUEL GAS



Item	Part No.	Ref. No.	Description	Packing
*1.	A-1513*	F611-3L	Connection: BSP3/8" LH	1pc
	A-1516	F611-9L	Connection: UNF9/16" - 18 LH (US market)	1pc

\* SUITABLE FOR EX-TRAFIAME® AND EX-TRAFIAME® PRO TORCH

### THERMACUT® HOSE NIPPLES

- SUITABLE FOR OXYGEN GAS



Item	Part No.	Ref. No.	Description	Packing
*1.	A-1520*	185SN902	Connection: G3/8" (cutting oxygen)	1pc
*	A-1522*	185SN904	Connection: G1/4" (heating oxygen)	1pc

- SUITABLE FOR FUEL GAS



Item	Part No.	Ref. No.	Description	Packing
*1.	A-1521*	185SN903	Connection: G3/8" LH	1pc

### THERMACUT® GAUGES

- SUITABLE FOR OXYGEN GAS

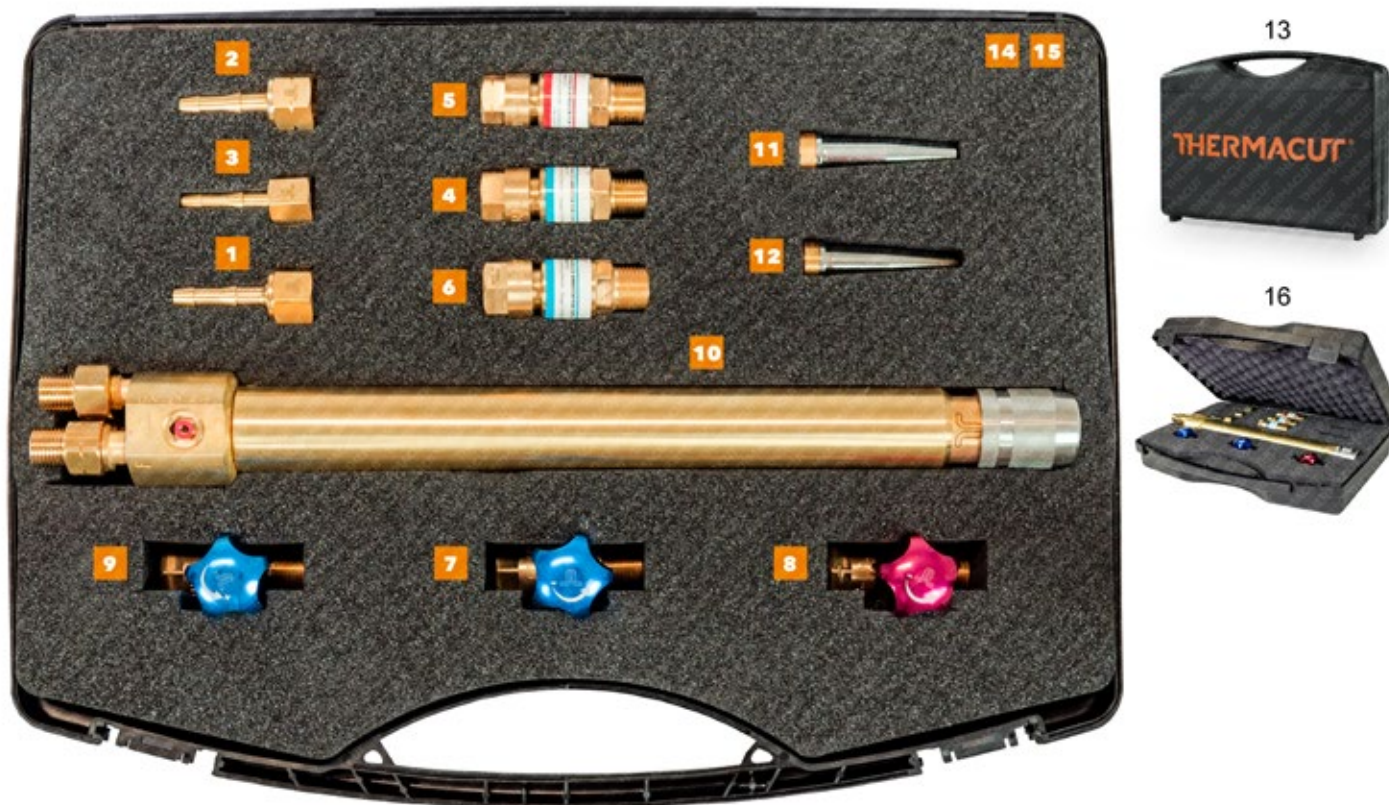


Item	Part No.	Ref. No.	Description	Packing
1.	A-1573	3TG-3R-CZ01	T-connection: G3/8" (Cutting oxygen)	1
	A-1572	3TG-1R-CZ01	T-connection: G1/4" (Heating oxygen)	1

\* SUITABLE FOR EX-TRAFLEAME® AND EX-TRAFLEAME® PRO TORCH

# EX-TRAFIAME® THERMACUT® CONSUMABLE CASE SUITABLE FOR EX-TRAFIAME®

Description: Oxyfuel injector cutting torch in two versions which works with all kinds of fuel gases and cuts materials up to 300 mm. The torch meets Norm ISO 5172.



Item	Part No.	Ref. No.	Description	Packing
1.	A-1520	185SN902	Fitting - Connection: G3/8" (cutting oxygen)	1
2.	A-1521	185SN903	Fitting - Connection: G3/8" LH	1
3.	A-1522	185SN904	Fitting - Connection: G1/4" (heating oxygen)	1
4.	A-1512	F611-1R	Flashback Arrestor - Connection: G1/4" (heating oxygen)	1
5.	A-1513	F611-3L	Flashback Arrestor - Connection: BSP3/8" LH	1
6.	A-1514	F611-3R	Flashback Arrestor - Connection: G3/8" (cutting oxygen)	1
7.	A-1517	3YR-3R-A01	Shut-off Valve - Connection: G3/8" (cutting oxygen)	1
8.	A-1518	3YR-3L-A01	Shut-off Valve - Connection: G3/8" LH	1
9.	A-1519	3YR-1R-A01	Shut-off Valve - Connection: G1/4" (heating oxygen)	1
10.	A-1450 / A-1451	A-2100-A / A-2100-PM	Torch - ACETYLENE / Torch - PROPANE / NAT. GAS / MIXED GASES	1
11.	A-1165	6290-VVC1	Cutting Nozzle - PROPANE / NAT. GAS / MIXED GASES	1
12.	A-1304	6290-VAX1	Cutting Nozzle - ACETYLENE	1
13.	PT-13295		EMPTY Case	1
14.	N-22562		Filling of the Box - down side	1
15.	N-22563		Filling of the Box - upper side	1
16.	A-1566	A-2222-PM	Full Case of EX-TRAFIAME® SET	1

# EX-TRAFIAME® THERMACUT® CONSUMABLE CASE SUITABLE FOR EX-TRAFIAME® PRO

Description: Oxyfuel injector cutting torch in two versions which works with all kinds of fuel gases and cuts materials up to 300 mm. PRO version reaches greater cutting speed and faster preheating.  
The torch meets Norm ISO 5172.



Item	Part No.	Ref. No.	Description	Packing
1.	A-1520	185SN902	Fitting - Connection: G3/8" (cutting oxygen)	1
2.	A-1521	185SN903	Fitting - Connection: G3/8" LH	1
3.	A-1522	185SN904	Fitting - Connection: G1/4" (heating oxygen)	1
4.	A-1512	F611-1R	Flashback Arrestor - Connection: G1/4" (heating oxygen)	1
5.	A-1513	F611-3L	Flashback Arrestor - Connection: BSP3/8" LH	1
6.	A-1514	F611-3R	Flashback Arrestor - Connection: G3/8" (cutting oxygen)	1
7.	A-1517	3YR-3R-A01	Shut-off Valve - Connection: G3/8" (cutting oxygen)	1
8.	A-1518	3YR-3L-A01	Shut-off Valve - Connection: G3/8" LH	1
9.	A-1519	3YR-1R-A01	Shut-off Valve - Connection: G1/4" (heating oxygen)	1
10.	A-1448 / A-1449	A-1100-A / A-1100-PM	Torch - ACETYLENE / Torch - PROPANE / NAT. GAS / MIXED GASES	1
11.	A-1458	716.16553	Cutting Nozzle - PROPANE / NAT. GAS / MIXED GASES	1
12.	A-1370	716.16563	Cutting Nozzle - ACETYLENE	1
13.	A-1361	716.16550	Heating Nozzle	1
14.	PT-13295		EMPTY case	1
15.	N-22561		Filling of the Box - down side	1
16.	N-22563		Filling of the Box - upper side	1
17.	A-1565	A-1111-PM	Full Case of EX-TRAFIAME® PRO SET	1

## A GLOBAL PROVIDER OF ENHANCED THERMAL CUTTING SOLUTIONS

THERMACUT®, THE CUTTING COMPANY®, FHT-EX®, EX-TRAFIRE®, EX-TRACK®, EX-TRABEAM® AND EX-TRAFIAME® ARE REGISTERED TRADEMARKS OF THERMACUT, K.S. AND MAY BE REGISTERED IN CZECH REPUBLIC AND/OR OTHER COUNTRIES. ALL OTHER TRADEMARKS ARE PROPERTIES OF THEIR RESPECTIVE OWNERS. THERMACUT® IS NO WAY AFFILIATED WITH HARRIS® AND MESSER®.

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