

TIG ZONE®

Technical Data : 500 A DC, 350 A AC
Watercooled / Duty Cycle : 100 %

AQ-27

CE EN 60 974-7

AQ-27 Series

- Features front or back loading or tightening of the tungsten electrode. Torch does not need to be moved to load or remove the electrode. The adjustment to tighten the electrode can be made with the ribbed sleeve at the nozzle end or by the knob at the back end of torch. Internal tungsten adjustment. The electrode can be raised or lowered within the torch for extremely fine positioning. Axial movement of approximately 1/4" is possible.
- Collet body has integral replaceable gas lens screens.
- Cooling requirements: 2 qt./min. (1.9 L/min.) - air cooled available in 9"- AE-27AAC.
- Maximum pressure 50 PSI (345 kPa).
- Electrode capacity .040" - 1/4" dia. (1,0 - 6,4 mm).
- Torch packages include: body assembly, barrel, shaft assembly, insulating boot, cable and hoses.

Part No.	Description	Max AMPS	Barrel Dia.	Overall Length	Access Kit	Hook-Up Kit
AQ-27A	Torch head					
AQ-27A-3	Torch package w/ bracket assembly	500	1-3/8	230 mm 9"	AK-27	HK-1
AQ-27A-12	Torch package					
AQ-27A-25						
AQ-27B	Torch head	500	1-3/8	510 mm 20"	AK-27	HK-1
AQ-27B-3	Torch package w/ bracket assembly					
AQ-27B-12	Torch package					
AQ-27B-25						

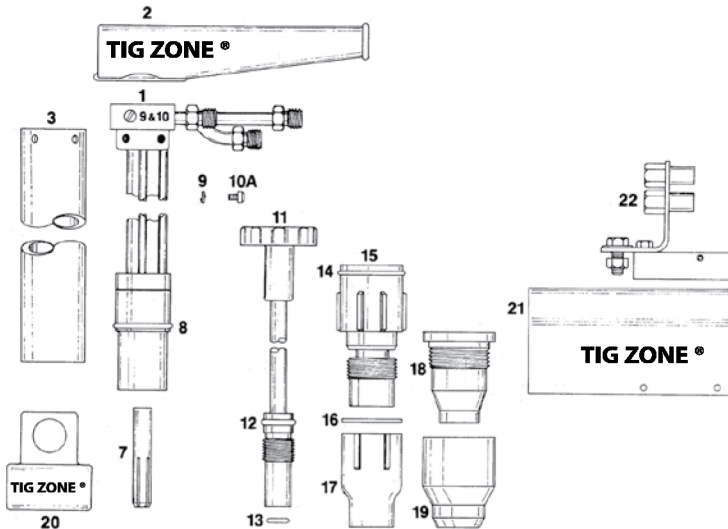


Chart A: Collets, Gas Lens

Electrode Diameter	1/16	3/32	1/8	5/32	3/16	1/4
Collet	57N46	57N47	57N48	57N49	57N50	57N51
Gas Lens	49V23	49V24	49V25	49V26	49V27	49V28

Chart B: Gas Nozzles

Size	6	8	10	12	SHORT*
Alumina	57N75	57N74	53N88	53N87	53N89
Metal**			57N78	57N77	

*Not recommended for use with high frequency current.

**Requires 57N76 adapter.



Part No. AQ-27B

Part No. AQ-27A

#	Part No.	Description
1	AQ-27A	Torch body, (9" long) includes shaft assembly, barrel & boot
	AQ-27B	Torch body, (20" long) includes shaft assembly, barrel & boot
2	27-12	Insulating boot
3	27-10A	Barrel assembly. "A" model, includes 3 ea. 27-10 screw, 3 ea. 27-11 washer
	27-10B	Barrel assembly. "B" model, includes 3 ea. 27-10 screw, 3 ea. 27-11 washer
6	18R-1	6-32 x 3/16" fillister head screw
7	-	Collet (See chart A)
8	27-2-4	O-ring
9	27-11	#6 bronze lock washer
10	27-10	6-32 x 5/16" binding head screw
10A	27-19	6-32 x 5/16" binding head nylon screw
11	27-13A	Shaft assembly. "A" model includes shaft, knob, 1 ea. 27-13-2 & 27-13-3 O-ring
	27-13B	Shaft assembly. "B" model includes shaft, knob, 1 ea. 27-13-2 & 27-13-3 O-ring
12	27-13-2	O-ring
13	27-13-3	O-ring
14	181W89	O-ring 57WCNA Water cooled nozzle (not shown)
15	see chart A	Gas lens, includes 1 ea. 181W89 O-ring, 1 ea. 57N56 gasket
16	57N56	Gasket
17	see chart B	Alumina nozzle
18	57N76	Metal nozzle adapter
19	see chart B	Metal nozzle
20	45V11	Power cable adapter
21	27-18-3	Bracket insulating cover
22	27-18	Bracket assembly.* includes bracket, insulator block, insulator cover, mounting hardware: 1 ea. 1/2"-13 x 1" hex head brass cap screw 1 ea. 1/2"-13 hex brass nut 1 ea. 1/2" medium steel lock washer 1 ea. 1/2" plain brass washer

*Bracket assembly used on 3 ft. torch package only.