

Prime Cut Industrial Products:

Prime Cut/TK-20 Port-A-Kut

The TK-20 Port-A-Kut is ideal for the shop or field and comes in a sturdy, storage case. It consists of the Industrial Prime Cut torch, 20 feet of 3/8" oxygen hose and power cable, striker plate assembly with 20 feet of power cable, leather shield for piercing operations, 2 battery clamps, welding gloves and 2 collets for adapting either 1/4" or 3/8" rods to the torch. This unit also includes sample Stix Pak of 1/4" x 18" and 3/8" x 18" cutting rods and instruction manual.



Prime Cut PC/A-2 Run-N-Kut

This kit is especially suited for those situations where a self-contained unit is needed. It is ideal for the shop or field and is preferred by locksmiths and fire departments. The PC/A-2 Run-N-Kut consists of the Prime Cut torch with 15 feet of 3/8" oxygen hose and power cable, striker plate assembly with 15 feet of power cable, a 20 cubic foot oxygen cylinder, adjustable regulator with quick-disconnect fitting, battery ignition system (with charger), safety goggles, welding gloves, 1/4" and 3/8" collets and Stix Pak of sample rods, fitted in a durable custom-fitted Pelican case.



Prime Cut PC/TA-60

The PC/TA-60 torch and striker is excellent for maintenance facilities and repair trucks. It consists of 30 feet of 3/8" oxygen hose and 30 feet of power cable. It also includes a 30 foot hose and cable extension to give 60 total feet of reach.



Industrial Ultra-thermic Rods:

These internal rods are recessed at the torch end to prevent burn back into the torch. This feature, unique to the Industrial, makes rods the safest on the market. Circular crimps secure the internal wires. The Industrial Ultra-thermic rods can be bent without restricting oxygen flow or splitting enabling the operator to reach difficult or otherwise inaccessible places, and ensure an even burn.

Prime Cut rods are available in 3/16", 1/4", 3/8" and 1/2" diameters and varying lengths. Size choice makes them efficient and adaptable to specific applications.

All rods are manufactured under rigid quality control standards and inspected prior to packaging to insure reliable performance

Industrial Prime Cut Users Guide:

Cutting rod size	Burn time	Oxygen consumption	Oxygen pressure range	Main uses
3/16" x 18"	30-35 sec	2 cu ft /rod	20si- 60 psi	Removing broken bolts, cutting locks, covers, hasps
1/4" x 18"	35 sec	3-3.5 cu ft /rod	15 psi- 70 psi	Cutting steel to 5/8" thick, removing large bolts, small pins, piercing hard plate
3/8" x 18"*	45-50 sec	4.5- 5 cu ft/rod	30 psi- 80 psi	Cutting steel to 3" thick, removing pins to 8" long
3/8"x 36"***	1 min 30 sec	8.5-9 cu ft/rod	30 psi- 90 psi	Cutting steel plate to 3" thick, cutting steel shafts to 6" diameter.
1/2"x 8"***	2 min 30 sec	20+ cu ft/rod	70 psi- 90 psi	Cutting steel to 6" thick, cutting cast iron to 4" thick,

* The most widely used rod size. cutting cast iron to 1.5" thick removing welds

** Most forced entry cutting is done with this rod. Removing pins 8"+ long, cutting aluminum, melting concrete, cutting cast iron to 2.5" thick.

*** The largest Prime Cut rod. For cutting on thick materials melting holes into concrete or long cuts on moderately thick materials. Cutting shafts to 12" diameter.

Materials	Thickness range	Cutting rate on 1" thickness with 3/8" rod	Comments
Steel	mild to 6" plate	12" round 10"-12" per 18" rod, 45 sec	Easy cut, pierce, gouge.
Steel	stainless to 4" plate	12" round 8"-10" per 18" rod, 45 sec	Rougher edge than mild steel slightly slower cutting rate.
Steel	wear plate to 6" plate	10"-13" per 18" rod, 45 sec	Some wear plate cuts faster than mild steel due to hardening alloys being more combustible.
Cast iron	To 4" thick	4"-6" per 18" rod, 45 sec	Produces much yellow/brown smoke, faster cutting rate if welding power (100 amps) is used with torch negative (-).
Aluminum	To 6" thick	12" round 8"-10" per 18" rod, 45 sec	Use only long rod and/or PC/XT rod extender. Use full head covering and leathers. Much sparking and spalling. Aluminum is very volatile. Thin aluminum cuts very quickly.
Titanium	To 6"+ thick	12"-15" per 18" rod, 45 sec	Very easy to cut, somewhat volatile 12"+ round but much more controlled than aluminum. A good metal for this process.
Concrete	Holes to 8" depth	3" hole per 18" rod Melt holes only	Prefer mechanical method with Prime Cut to get the reinforcement bar. Not practical for cutting. Melt series of holes to weaken concrete, then fracture