

PT-27 Manual Torch



- Most compact 80A torch on the market
- Excellent cutting capacity - cuts up to 1 in. (25.4 mm); severs up to 1-1/4 in. (31.75 mm)
- Uses shop air, cylinder air or Nitrogen for superior versatility
- Pilot arc starting - even starts through paint
- Choice of 25 ft. (7.6 m) or 50 ft. (15.2 m) lead length
- Perfect electrode centering
- Intermittent cutting capability for grate or expanded metal applications
- Use with three cutting nozzle sizes for exceptional versatility
- Improved spring-loaded seat eliminates head burn-out

Consoles

The PT-27 can be used with the following older ESAB consoles:

- PCM-80i
- PCM-750i
- PCM-875i
- PCM-1000i
- PCM-1125i

Ordering Information

PT-27, 75° Torch Assembly

25 ft. (7.6 m) lead with ring terminal	21661
50 ft. (15.2 m) lead with ring terminal	21662
25 ft. (7.6 m) "CE"	35548

For use in regions that require "CE" such as Europe, Russia, and Australia.

Cable Leads

25 ft. (7.6 m)	0558005677
50 ft. (15.2 m)	0558006547

Note: All torch assemblies and replacement heads are supplied with the seat installed.

For units manufactured prior to 4/31/1995 (that have 2 twist lock plugs for torch hook-up) order #21620 or #21621.

PT-27, 75°

25 ft. (7.6 m) lead with plug	21620
50 ft. (15.2 m) lead with plug	21621



Designed for superior cutting performance and ease of handling, the PT-27 produces clean, exceptionally high quality cuts.

Improved Seat Design

PT-27 spring-loaded seat dramatically improves the torch head life by making the PT-27 resistant to damage due to improperly tightened consumables. This seat will not correct a torch head that is already burnt out, but it will prevent torch head burnout on functioning torches.

If your PT-27 torch still has the old style valve pin, you will need to retrofit the torch to the improved seat design.

Options & Accessories

Spare Parts Kits

50-70A	21623
80A	21624
Plasma flow measuring kit	0558000739

Torch Guide Kits

Deluxe: 1-3/4 in. (44.5 mm) 42 in. (106 cm) radius .	0558003258
Basic: 1-3/4 in. (44.5 mm) 28 in. (71 cm) radius .	0558002675

Seat

Seat & installation instructions	0558003032
Installation tool	0558003027

Stand-off guide	21420
Gouging nozzle	35442
Gouging shield	35443

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Cutting Nozzle	Part Number	Orifice Size, in. (mm)
30 A	33368	.037" (0.9)
50/70A	33369	.047" (1.2)
80A	33418	.052" (1.3)
Gouging nozzle	35442	.093" (2.4)

¹With feet for dragging on workpiece.

Improved Seat Design



Spare Parts Kit

Description	Part Number	50/70A XT - 21623	80A XT - 21624
Heat shield	21616	2	2
Nozzles (50/70A)	33369	4	-
Nozzles (80A)	33418	-	4
Swirl baffle	33367	1	1
Electrode	33366XL	3	3
Fuse 15A, 600 VDC	952137	1	1
Stand off guide	21420	1	1
Lubricant .25 oz.	0558000443	1	1

Specifications

PT-27	
Cuts, in. (mm)	1 (25.4)
Severs, in. (mm)	up to 1-1/4 (31.75)
Current capacity	80A @ 100% duty cycle
Air supply, cfh @ psig (L/min)	320 @ 65 - 75 (150)
Length of service leads, ft. (m)	25 (7.6) 50 (15.2)
Dimensions, in. (mm)	7.3 (185) length, 3.06 (78) torch head