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500 Head

For Use on Orbital Welding Machines

Overview:

Otto Tool Aftermarket Orbital Welding Collets for Arc Machines weld heads are made to the highest quality standards. All our collets are made from stainless steel to give you better wear over Aluminum type collets. We have spent years redesigning our 500 heads and now we have redesigned all the collets from the 750 head to 7500 head.

Our new spring redesign collets will hold oversize, undersize tubing, new or used collet adapter better than ever. These new spring type collets have more flexibility to hold all types of tubing or pipe. Our 500 heads now offer gate screws with springs to hold the wedge up to make closing the upper gate easier. Our one-piece construction on the lower head will give you better alignment on both sides of your tubing. Please give us call for a trial on any of our orbital welding heads, if you decide they do not work for you, you can return them without any questions.

500 Head:

Part Number	Nominal Size
500-125	⅛" Tube
500-25	¼" Tube
500-375	⅜" Tube
500-5	½" Tube

500 Head

Tungsten List for 500 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
1/8" ABW/ATW	.020/.035	TC04-0584-02	.030
1/4" ABW/ATW	.028/.049	TC04-0506-02	.045
1/4" ABW/ATW	.028/.049	TC04-0444-02	.045
.125	.020/.035	TC04-0611-01	.020
.250	.020/.035	TC04-0539-02	.030
.250	.049/.065	TC04-0524-02	.045
.375	.022/.035	TC04-0476-02	.030
.375	.049/.065	TC04-0461-02	.045
.500	.022/.035	TC04-0414-02	.030
.500	.049/.065	TC04-0399-02	.045

Orbital Welding Head Holder

Various Accessories and Parts for 500 Head:

Part Number	Description
500-Window	Replacement window
500-WI	Replacement window screws
500-Screw	Replacement screw for use on 9-500 Head "old"
500-Screw-1	Replacement screw for use on 9-500 Head "new"
500-Holder	Oribital Welding head holders

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750 Head

For Use on Orbital Welding Machines

We now offer two style collets; one is the traditional collet that has been around for years. The second type is a spring design to give room for tubing that is over or undersize.

750 Head:

Part Number	Nominal Size
750-125	⅛"
750-25	¼"
750-375	⅜"
750-5	½"
750-625	⅝"
750-75	¾"
750-875	⅞"
750-25P	¼" Pipe
750-375P	⅜" Pipe
750-5P	½" Pipe

750 Collet

Tungsten List for 750 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
1/8" ABW/ATW	.020/.035	TC04-0890-02	.030
1/4" ABW/ATW	.028/.049	TC06-0860-03	.050
3/8" ABW/ATW	.028/.049	TC06-0745-03	.050
1/2" ABW/ATW	.028/.065	TC06-0677-03	.050
5/8" ABW/ATW	.028/.065	TC06-0612-03	.050
3/4" ABW/ATW	.028/.065	TC06-0546-03	.050
3/4" ABW/ATW	.072/.095	TC06-0526-04	.070
.125	.020/.035	TC04-0917-01	.020
.250	.022/.035	TC06-0845-02	.030
.250	.049/.065	TC06-0825-03	.050
.375	.022/.035	TC06-0782-02	.030
.375	.049/.065	TC06-0762-03	.050
.500	.022/.035	TC06-0720-02	.030
.500	.049/.083	TC06-0700-03	.050
.500	.095/.120	TC06-0680-04	.070
.540(1/2"PIPE)	5-10	TC06-0680-03	.050
.540(1/2"PIPE)	40	TC06-0660-04	.070
.625	.022/.035	TC06-0657-02	.030
.625	.049/.083	TC06-0637-03	.050
.675(1/4"PIPE)	5-10	TC06-0612-03	.050
.675(1/4"PIPE)	40	TC06-0592-04	.070
.750	.022/.035	TC06-0595-02	.030
.750	.049/.083	TC06-0575-03	.050
.750	.095/.120	TC06-0555-04	.070
.840(1/2"PIPE)	5-10	TC06-0530-03	.050

750 Spring Tension Head:

Part Number	Nominal Size
753-25	¼" dia. Tube
753-375	⅜" dia. Tube
753-5	½" dia. Tube
753-625	⅝" dia. Tube
753-75	¾" dia. Tube

Various Accessories & Parts for 750 Head:

750-Window	Replacement window
750-WI	Replacement window screws
750-SI	Replacement SS Collet screws
750-Screw	Replacement screw for use on 9-750 Head
750-Holder	Orbital welding head holders for use on 9-750 Head

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1500 Head

For Use on Orbital Welding Machines

New Product!

Overview:

Collet Adapters - All our collets from 1500 head to the 7500 heads are now designed with our new springs style. This new spring design will hold your oversize or undersize tubing and pipe more firmly in the weld head. All collets are made from harden 17-4 SS. This material has the best memory to have the collet springs back to it original position.

1500 Head:

Part Number	Nominal Size
1503-25	¼" tube
1503-375	⅜" tube
1503-5	½" tube
1503-625	⅝" tube
1503-75	¾" tube
1503-1	1" tube
1503-1.25	1 ¼" tube
1503-1.5	1 ½" tube
1503-5P	½" pipe
1503-75P	¾" pipe
1503-1P	1" pipe

1503 Spring Style Collet

Tungsten List for 1500 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
.250	.022/.035	TC06-1438-02	.030
.250	.049/.065	TC06-1418-03	.050
.375	.022/.035	TC06-1376-02	.030
.375	.049/.065	TC06-1356-03	.050
.500	.022/.035	TC06-1313-02	.030
.500	.049/.083	TC06-1293-03	.050
.500	.095/.120	TC09-1273-04	.070
.540 1/4" PIPE	5-40	TC06-1273-03	.050
.625	.022/.035	TC06-1251-02	.030
.625	.049/.083	TC06-1231-03	.050
.675 3/8" PIPE	5-10	TC06-1206-03	.050
.675 3/8" PIPE	40	TC09-1186-04	.070
.750	.022/.035	TC06-1188-02	.030
.750	.049/.083	TC06-1168-03	.050
.750	.095/.120	TC09-1148-04	.070
.840 1/2" PIPE	5-10	TC06-1123-03	.050
.840 1/2" PIPE	40	TC09-1103-04	.070
1.000	.049/.083	TC06-1043-03	.050
1.000	.095/.120	TC09-1023-04	.070
1.050 3/4" PIPE	5-10	TC06-1018-03	.050
1.050 3/4" PIPE	40	TC09-0998-04	.070
1.250	.049/.083	TC06-0918-03	.050
1.315 1" PIPE	5	TC06-0886-03	.050
1.315 1" PIPE	10-40	TC09-0866-04	.070
1.500	.049/.083	TC06-0793-03	.050
1.500	.095/.120	TC09-0773-04	.070

Tungsten List for 9E-1500 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
.250	.022/.035	TC06-1188-02	.030
.250	.049/.065	TC06-1168-03	.050
.375	.022/.035	TC06-1125-02	.030
.375	.049/.065	TC06-1105-03	.050
.500	.022/.035	TC06-1063-02	.030
.500	.049/.083	TC06-1043-03	.050
.500	.095/.120	TC09-1023-04	.070
.540 1/4" PIPE	5-40	TC06-1023-03	.050
.625	.022/.035	TC06-1001-02	.030
.625	.049/.083	TC06-0981-03	.050
.675 3/8" PIPE	5-10	TC06-0956-03	.050
.675 3/8" PIPE	40	TC09-0936-04	.070
.750	.028/.035	TC06-0938-02	.030
.750	.049/.083	TC06-0918-03	.050
.750	.095/.120	TC09-0898-04	.070
.840 1/2" PIPE	5-10	TC06-0873-03	.050
.840 1/2" PIPE	40	TC09-0853-04	.070
1.000	.049/.083	TC06-0793-03	.050
1.000	.095/.120	TC09-0773-04	.070
1.050 3/4" PIPE	5-10	TC06-0768-03	.050
1.050 3/4" PIPE	40	TC09-0748-04	.070
1.250	.049/.083	TC06-0668-03	.050
1.315 1" PIPE	5	TC06-0638-03	.050
1.315 1" PIPE	10-40	TC09-0616-04	.070

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2000 - 2500 Head

For Use on Orbital Welding Machines

2000 Head:

Part Number	Nominal Size
2003-5	½" tube
2003-.75	¾" tube
2003-1	1" tube
2003-1.5	1 ½" tube
2003-2	2" tube
2003-5P	½" Pipe
2003-375P	⅜" Pipe
2003-.75P	¾" Pipe
2003-1P	1" Pipe
2003-1.5P	1 ½" Pipe

2000 Collet

2500 Head:

Part Number	Nominal Size
2503-75	¾" tube
2503-1	1" tube
2503-1.5	1 ½" tube
2503-2	2" tube
2503-2.5	2 ½" tube
2503-75P	¾" pipe
2503-1P	1" pipe
2503-1.5P	1 ½" pipe
2503-2P	2" pipe

2503 Spring Style Collet

Tungsten List for 2000 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
.500	.022/.035	TC06-1446-02	.030
.500	.049/.083	TC06-1426-03	.050
.500	.095/.120	TC09-1406-04	.070
.540 1/4" PIPE	5-40	TC06-1406-03	.050
.625	.028/.035	TC06-1383-03	.030
.625	.049/.083	TC06-1363-03	.050
.675 3/8" PIPE	5-10	TC06-1338-03	.050
.675 3/8" PIPE	40	TC09-1318-04	.070
.750	.049/.083	TC06-1301-03	.050
.750	.095/.120	TC09-1281-04	.070
.840 1/2" PIPE	5-10	TC06-1256-03	.050
.840 1/2" PIPE	40	TC09-1236-04	.070
1.000	.049/.083	TC06-1176-03	.050
1.000	.095/.120	TC09-1156-04	.070
1.050 3/4" PIPE	5-10	TC06-1151-03	.050
1.050 3/4" PIPE	40	TC09-1131-04	.070
1.250	.049/.083	TC06-1051-03	.050
1.315 1" PIPE	5	TC06-1018-03	.050
1.315 1" PIPE	10-40	TC09-0998-04	.070
1.5000	.049/.083	TC06-0926-03	.050
1.5000	.095/.120	TC09-0906-03	.070
1.660 1-1/4 PIPE	5	TC06-0846-03	.050
1.660 1-1/4 PIPE	10-40	TC09-0826-04	.070
1.900 1-1/2 PIPE	5	TC06-0726-03	.050
1.900 1-1/2 PIPE	10-40	TC09-0706-04	.070
2.000	.049/.083	TC06-0676-03	.050
2.000	.095/.120	TC09-0656-04	.070

Tungsten List for 2500 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
.750	.049/.083	TC06-1765-03	.050
.750	.095/.120	TC09-1745-04	.070
.840 1/2" PIPE	5-10	TC06-1720-03	.050
.840 1/2" PIPE	40	TC09-1700-04	.070
1.000	.049/.083	TC06-1640-03	.050
1.000	.095/.120	TC09-1620-04	.070
1.050 3/4" PIPE	5-10	TC06-1615-03	.050
1.050 3/4" PIPE	40	TC09-1595-04	.070
1.250	.049/.083	TC06-1515-03	.050
1.315 1" PIPE	5	TC06-1482-03	.050
1.315 1" PIPE	10-40	TC09-1462-04	.070
1.500	.049/.083	TC06-1390-03	.050
1.500	.095/.120	TC09-1370-04	.070
1.660 1-1/4" PIPE	5	TC06-1310-03	.050
1.660 1-1/4" PIPE	10-40	TC09-1290-04	.070
1.900 1-1/2" PIPE	5	TC06-1190-03	.050
1.900 1-1/2" PIPE	10-40	TC09-1170-04	.070
2.000	.049/.083	TC06-1140-03	.050
2.000	.095/.120	TC09-1120-04	.070
2.375 2" PIPE	5	TC06-0952-03	.050
2.375 2" PIPE	10-40	TC09-0932-04	.070
2.500	.049/.083	TC06-0870-03	.070
2.500	.095/.120	TC09-0870-04	.070

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3500 - 4000 Head

For Use on Orbital Welding Machines

3500 Head:

Part Number	Nominal Size
3503-1.5	1 ½" tube
3503-2	2" tube
3503-2.5	2 ½" tube
3503-3	3" tube
3503-1.5P	1 ½" pipe
3503-2P	2" pipe
3503-2.5P	2 ½" pipe
3503-3.5	3 ½" tube (3" pipe)

3503 Spring Style Collet

Tungsten List for 3500 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
1.000	.049/.083	TC06-2140-03	.050
1.000	.095/.120	TC09-2120-04	.070
1.050 3/4" PIPE	5-10	TC06-2115-03	.050
1.050 3/4" PIPE	40	TC09-2095-04	.070
1.315 1" PIPE	5	TC06-1982-03	.050
1.315 1" PIPE	10-40	TC09-1962-04	.070
1.500	.049/.083	TC06-1890-03	.050
1.500	.095/.120	TC09-1870-04	.070
1.660 1-1/4" PIPE	5	TC06-1810-03	.050
1.660 1-1/4" PIPE	10-40	TC09-1790-04	.070
1.900 1-1/2" PIPE	5	TC06-1690-03	.050
1.900 1-1/2" PIPE	10-40	TC09-1670-04	.070
2.000	.049/.083	TC06-1640-03	.050
2.000	.095/.120	TC09-1620-04	.070
2.375 2" PIPE	5	TC06-1452-03	.050
2.375 2" PIPE	10	TC09-1432-04	.070
2.500	.065/.083	TC06-1370-03	.070
2.500	.095/.120	TC09-1370-04	.070
2.875 2-1/2" PIPE	5	TC06-1182-03	.070
2.875 2-1/2" PIPE	10	TC09-1182-04	.070
3.000	.065/.083	TC06-1120-03	.070
3.000	.095/.120	TC09-1120-04	.070
3.500	.065/.083	TC06-0870-03	.070
3.500	.095/.120	TC09-0870-04	.070
3.500 3" PIPE	5-10	TC09-0870-04	.070

4000 Head:

Part Number	Nominal Size
4003-1	1" tube
4003-1.5	1 ½" tube
4003-2	2" tube
4003-2.5	2 ½" tube
4003-3	3" tube
4003-3.5	3 ½" tube (3" pipe)
4003-4	4" tube (3 ½" pipe)
4003-4.5	4 ½" tube (4" pipe)
4003-2P	2" pipe
4003-2.5P	2 ½" pipe

4000 Collet

Tungsten List for 4000 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
1.000	.049/.083	TC06-2105-03	.050
1.000	.095/.120	TC09-2085-04	.070
1.050 3/4" PIPE	5-10	TC06-2080-03	.050
1.050 3/4" PIPE	40	TC09-2060-04	.070
1.315 1" PIPE	5	TC06-1947-03	.050
1.315 1" PIPE	10-40	TC09-1927-04	.070
1.500	.049/.083	TC06-1855-03	.050
1.500	.095/.120	TC09-1835-04	.070
1.660 1-1/4" PIPE	5	TC06-1775-03	.050
1.660 1-1/4" PIPE	10-40	TC09-1755-04	.070
1.900 1-1/2" PIPE	5	TC06-1655-03	.050
1.900 1-1/2" PIPE	10-40	TC09-1635-04	.070
2.000	.049/.083	TC06-1605-03	.050
2.000	.095/.120	TC09-1585-04	.070
2.375 2" PIPE	5	TC06-1417-03	.050
2.375 2" PIPE	10-40	TC09-1397-03	.070
2.500	.065/.083	TC06-1335-03	.070
2.500	.095/.120	TC09-1335-04	.070
2.875 2-1/2" PIPE	5	TC06-1147-03	.070
2.875 2-1/2" PIPE	10	TC09-1147-04	.070
3.000	.065/.083	TC06-1085-03	.070
3.000	.095/.120	TC09-1085-04	.070
3.500 3" PIPE	5-10	TC09-0835-04	.070
4.000	.065/.083	TC06-0585-03	.070
4.000	.095/.120	TC09-0585-04	.070
4.000 3-1/2" PIPE	5-10	TC09-0585-04	.070

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4500 - 7500 Head

For Use on Orbital Welding Machines

4500 Head:

Part Number	Nominal Size
4503-1	1" tube
4503-1.5	1 ½" tube
4503-2	2" tube
4503-2.5	2 ½" tube
4503-3	3" tube
4503-3.5	3 ½" tube (3" pipe)
4503-4	4" tube (3 ½" pipe)
4503-4.5	4 ½" tube (4" pipe)
4503-2P	2" pipe
4503-2.5P	2 ½" pipe

4503 Spring Style Head

Tungsten List for 4500 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
1.500	.049/.083	TC06-2637-03	.050
1.500	.095/.120	TC09-2617-04	.070
1.660 1-1/4" PIPE	5	TC06-2557-03	.050
1.660 1-1/4" PIPE	10-40	TC09-2537-04	.070
1.900 1-1/2" PIPE	5	TC06-2437-03	.050
1.900 1-1/2" PIPE	10-40	TC09-2417-04	.070
2.000	.049/.083	TC06-2387-03	.050
2.000	.095/.120	TC09-2367-04	.070
2.375 2" PIPE	5	TC06-2200-03	.050
2.375 2" PIPE	10-40	TC09-2180-04	.070
2.500	.065/.083	TC06-2117-03	.070
2.500	.095/.120	TC09-2117-04	.070
2.875 2-1/2" PIPE	5	TC06-1910-03	.070
2.875 2-1/2" PIPE	10	TC09-1910-04	.070
3.000	.065/.083	TC06-1867-03	.070
3.000	.095/.120	TC09-1867-04	.070
3.500	.065/.083	TC06-1617-03	.070
3.500	.095/.120	TC09-1617-04	.070
3.500 3" PIPE	5	TC06-1617-03	.070
3.500 3" PIPE	10	TC09-1617-04	.070
4.000	.065/.083	TC06-1367-03	.070
4.000	.095/.120	TC09-1367-04	.070
4.000 3-1/2" PIPE	5	TC06-1367-03	.070
4.000 3-1/2" PIPE	10	TC09-1367-04	.070
4.500	.095/.120	TC09-1117-04	.070
4.500 4" PIPE	5	TC06-1117-03	.070
4.500 4" PIPE	10	TC09-1117-04	.070

7500 Head:

Part Number	Nominal Size
7503-3.5	3 ½" tube (3" pipe)
7503-4	4" tube (3 ½" pipe)
7503-4.5	4 ½" tube (4" pipe)
7503-6	6" tube
7503-6P	6" pipe

Tungsten List for 7500 Head:

TUBE O.D.	WALL THICKNESS	PART NUMBER	ARC GAP
2.875 2-1/2" PIPE	5	TC06-3712-03	.070
2.875 2-1/2" PIPE	10	TC09-3712-04	.070
3.000	.065/.083	TC06-3650-03	.070
3.000	.095/.120	TC09-3650-04	.070
3.500	.065/.083	TC06-3400-03	.070
3.500	.095/.120	TC09-3400-04	.070
3.500 3" PIPE	5-10	TC09-3400-04	.070
4.000	.065/.083	TC06-3150-03	.070
4.000	.095/.120	TC09-3150-04	.070
4.000 3"1/2" PIPE	5-10	TC09-3150-04	.070
4.500	.083/.120	TC09-2990-04	.070
4.500 4" PIPE	5-10	TC09-2990-04	.070
5.000	.065/.083	TC06-2650-03	.070
5.000	.095/.120	TC09-2650-04	.070
5.563 5" PIPE	5-10	TC09-2368-04	.070
6.000	.065/.083	TC06-2150-03	.070
6.000	.095/.120	TC09-2150-04	.070
6.625 6" PIPE	5-10	TC09-1837-04	.070
7.000	.095/.120	TC09-1650-04	.070

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Accessories for AMI Orbital Welders

Replacement Window Screws:

Part Number
500-WI
750-WI
1500-WI
2500-WI
3500-WI
4500-WI
7500-WI

500 Head Screws & Window

Replacement Window:

Part Number
500-WINDOW
750-WINDOW
1500-WINDOW
2500-WINDOW
3500-WINDOW
4500-WINDOW
7500-WINDOW

Replacement Window & 750 Thumb Screw

Replacement Filters/Paper:

Part Number	
OW-1107	Replacement Filter for #107 Machine
OW-1207	Replacement Filter for #207 Machine
OW-1000	Printer Paper for #207 Machine

Paper Roll

Head Holders:

Part Number
500-HOLDER For 500 Head Only
750-HOLDER For 750 to 7500 Heads

500 Head Holder

Replacement Thumbscrews:

Part Number
500-SCREW
750-SCREW

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