



THICKNESS	CUT SPEED	NOZZLE STANDOFF	KERF	PRESSURES					TIMES					CUTTING NOZZLE		HEATING NOZZLE	
				OXYGEN				FUEL GAS (Propane or Natural Gas)		IGNITION	HIGH PREHEAT	MOVING PIERCE	PIERCE RAMP UP				Part #
				LOW PREHEAT	HIGH PREHEAT	PIERCE	CUT	LOW PREHEAT	HIGH PREHEAT					PSI	PSI	s	
Dec.	Frac.	IPM	in	in	PSI	PSI	PSI	PSI	PSI	PSI	s	s	s	s	Part #	Size	Part #
0.125	1/8"	30.71	0.08" - 0.16"	0.035	22	54	28	29	2.9	2.9	5	5	0.1	0.1			
0.1563	5/32"	29.92	0.08" - 0.16"	0.035	22	54	43	44	2.9	2.9	5	5	0.1	0.1	100887	3 - 6	100797
0.1875	3/16"	29.13	0.08" - 0.16"	0.039	22	54	57	58	2.9	2.9	5	5	0.1	0.1	(V0001431)		(V0001305)
0.25	1/4"	27.95	0.08" - 0.16"	0.043	22	54	72	73	2.9	2.9	5	5	0.1	0.1			
0.3125	5/16"	25.59	0.16" - 0.20"	0.067	29	54	79	80	2.9	2.9	5	12	0.1	0.1			
0.375	3/8"	25.20	0.20" - 0.31"	0.071	29	58	86	87	2.9	2.9	5	12	0.1	0.1	100888	7 - 15	100797
0.5	1/2"	23.62	0.20" - 0.31"	0.075	29	58	93	94	2.9	2.9	5	12	0.1	0.1	(V0001432)		(V0001305)
0.625	5/8"	22.24	0.20" - 0.31"	0.079	29	58	101	102	2.9	2.9	5	15	0.5	0.5			
0.625	5/8"	22.24	0.20" - 0.31"	0.083	29	58	86	87	2.9	2.9	5	15	0.5	0.5			
0.75	3/4"	20.28	0.20" - 0.31"	0.087	29	58	93	94	2.9	2.9	5	15	0.5	0.5	100889	15 - 25	100797
1	1"	18.11	0.20" - 0.38"	0.091	29	58	101	102	2.9	2.9	5	15	1	1	(V0001307)		(V0001305)
1	1"	18.11	0.20" - 0.38"	0.094	29	58	86	87	2.9	2.9	5	15	1	1			
1.125	1-1/8"	17.52	0.20" - 0.38"	0.098	29	58	101	102	2.9	2.9	5	20	1	1	100890	25 - 40	100797
1.375	1-3/8"	16.93	0.20" - 0.38"	0.102	29	58	108	109	2.9	2.9	5	20	1	1	(V0001308)		(V0001305)
1.5	1-1/2"	16.14	0.20" - 0.38"	0.106	29	58	108	109	2.9	2.9	5	20	2	2			
1.5	1-1/2"	16.14	0.20" - 0.38"	0.110	29	58	79	80	2.9	2.9	5	20	2	2			
2	2"	14.57	0.20" - 0.38"	0.114	29	58	93	94	2.9	2.9	5	20	2	2	100891	40 - 60	100797
2.375	2-3/8"	13.19	0.25" - 0.38"	0.114	29	58	108	109	2.9	2.9	5	20	2	2	(V0001309)		(V0001305)
2.375	2-3/8"	13.19	0.25" - 0.38"	0.134	29	58	86	87	2.9	2.9	5	20	2	2			
2.75	2-3/4"	12.40	0.25" - 0.38"	0.136	29	58	101	102	2.9	2.9	5	20	2	2			
3	3"	11.81	0.25" - 0.38"	0.138	29	58	108	109	2.9	2.9	5	20	2	2	100892	60 - 100	100797
3.5	3-1/2"	11.00	0.25" - 0.38"	0.138	29	58	115	116	2.9	2.9	5	30	2	2	(V0001310)		(V0001305)
4	4"	10.24	0.32" - 0.50"	0.138	29	58	122	123	4.4	4.4	5	30	2	2			
4	4"	10.24	0.32" - 0.50"	0.138	36	58	101	102	4.4	4.4	5	30	2.5	2.5			
4.75	4-3/4"	10.24	0.32" - 0.50"	0.138	36	65	108	109	4.4	4.4	5	35	2.5	2.5	101081	100-150	100797
5	5"	10.24	0.32" - 0.50"	0.138	36	65	108	109	4.4	4.4	5	35	3	3	(V0001311)		(V0001305)
6	6"	8.86	0.32" - 0.50"	0.138	44	44	N/A	123	4.4	4.4	5	35	N/A	N/A			
7	7"	8.00	0.32" - 0.50"	0.144	44	44	N/A	130	4.4	4.4	5	35	N/A	N/A	101082	100-200	101080
8	8"	7.09	0.32" - 0.50"	0.150	44	44	N/A	130	4.4	4.4	5	35	N/A	N/A	(V0001312)		(V0001306)
8	8"	7.09	0.50" - 0.62"	0.157	51	51	N/A	94	4.4	4.4	5	35	N/A	N/A			
9	9"	6.10	0.50" - 0.62"	0.167	51	51	N/A	109	4.4	4.4	5	35	N/A	N/A	101083	200-250	101080
10	10"	5.12	0.50" - 0.62"	0.177	51	51	N/A	123	4.4	4.4	5	35	N/A	N/A	(V0001313)		(V0001306)
10	10"	5.12	0.50" - 0.62"	0.197	58	58	N/A	94	4.4	4.4	5	35	N/A	N/A			
11	11"	4.50	0.50" - 0.62"	0.217	58	58	N/A	109	4.4	4.4	5	35	N/A	N/A	101084	250-300	101080
12	12"	3.94	0.50" - 0.62"	0.236	58	58	N/A	123	4.4	4.4	5	35	N/A	N/A	(V0001314)		(V0001306)

1 - These cutcharts are a starting point. Adjustments might be necessary due to installation and material variations.

2 - Start by using these parameters and change as necessary. Save cut charts modifications to controller and paper for future use.

3 - When ignition temperature is reached (light red – yellow steel colour, small light sparks flying from the metal), open the cutting oxygen (reduced pressure for piercing, see chart) and start full torch speed movement in the same time. It is recommended nozzle-sheet distance increasing for material thickness above 40mm to avoid slag coming into the nozzle. Never reduce torch speed movement during piercing, keep constant full cutting speed. When the molten steel slag runs into the pierced hole (lot of sparks intensive flying around the machine), the moving speed for piercing can be increased (up to 5-10%). After cutting oxygen runs through the sheet, the speed shall be reduced at the chart-value.

4 - After piercing time is over, cutting oxygen pressure is to be changed to full-pressure value in accordance with chart.

