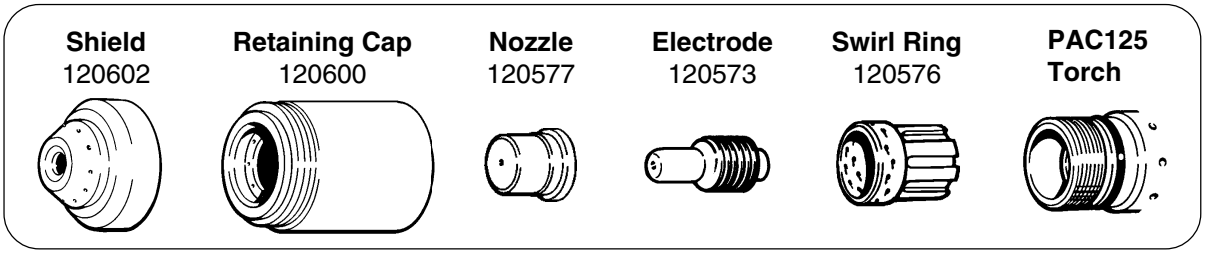
CUT CHART - 55A STANDARD CONSUMABLES

The following recommended settings are for mechanized cutting at 55 amps. Torch-to-work distance for the following cut charts is 1/16 inch (1.6 mm) for all cuts.



Material Thickness (ga. or in.)	(mm)	Material	Arc Current (A)	Arc Voltage (V)	Recommended Travel Speed* (ipm)	(mm/min)	Pierce Delay (S)
16 ga.	1.5	Mild Steel	55	116	330	8380	n/a
10 ga.	3.4	Mild Steel	55	119	160	4060	0.5
1/4"	6.4	Mild Steel	55	120	75	1900	1.0
3/8"	9.5	Mild Steel	55	125	35	890	2.0
1/16"	1.6	Stainless Steel	55	117	315	8000	n/a
1/8"	3.2	Stainless Steel	55	118	140	3560	0.5
1/4"	6.4	Stainless Steel	55	121	55	1400	1.0
3/8"	9.5	Stainless Steel	55	125	28	710	2.0
1/16"	1.6	Aluminum	55	117	550	13970	n/a
1/8"	3.2	Aluminum	55	119	280	7110	0.5
1/4"	6.4	Aluminum	55	125	135	3430	1.0
3/8"	9.5	Aluminum	55	129	55	1400	2.0

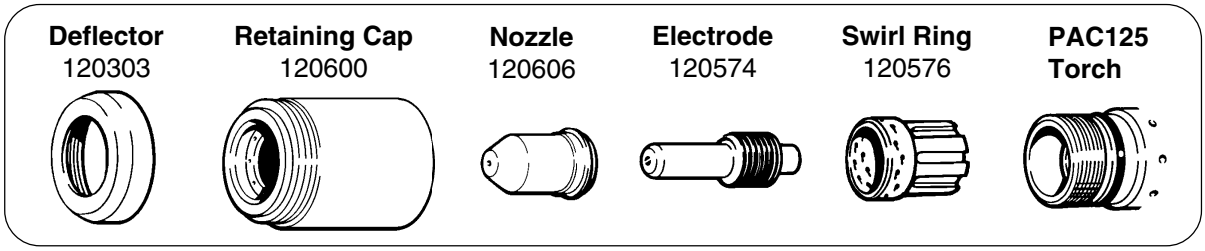
* Recommended travel speeds are 10–20% slower than maximum. These slower speeds will produce optimum cut quality.

WARNING

The voltage between the tip of the torch and the workpiece will exceed 113VDC if shielded consumable parts are not installed in the torch. If using the 400V CE power supply, the hand torch must be operated with shielded parts to maintain the S mark and CE low-voltage compliance for hand held applications. See Section 5: *Consumable Parts - For CE Compliance* **for a list of CE consumable parts. This requirement does not apply to machine torch applications.**

CUT CHART - 35A CONSUMABLES

Use 35 amp consumables on thin material to obtain maximum consumable life, a narrow kerf width and to minimize the heat-affected zone. The following recommended settings are for mechanized cutting. Torch-to-work distance is 1/16 inch (1.6 mm) for all cuts.



Material Thickness (ga. or in.)	(mm)	Material	Arc Current (A)	Arc Voltage (V)	Recommended Travel Speed* (ipm)	(mm/min)	Pierce Delay (S)
26 ga.	0.5	Mild/Galvanized Steel	22	107	490	12450	n/a
20 ga.	0.8	Mild/Galvanized Steel	22	120	250	6350	n/a
18 ga.	1.6	Mild/Galvanized Steel	22	120	190	4830	n/a
14 ga.	2.0	Mild Steel	35	117	220	5590	n/a
10 ga.	3.4	Mild Steel	35	120	110	2790	0.5
26 ga.	0.5	Stainless Steel	22	110	430	10920	n/a
20 ga.	0.8	Stainless Steel	22	119	140	3560	n/a
1/16"	1.5	Stainless Steel	35	118	240	6100	n/a
1/8"	3.2	Stainless Steel	35	120	75	1900	0.5
1/32"	0.8	Aluminum	22	106	450	11430	n/a
1/16"	1.5	Aluminum	35	114	430	10920	n/a
1/8"	3.2	Aluminum	35	115	165	4190	0.5

* Recommended travel speeds are 10–20% slower than maximum. These slower speeds will produce optimum cut quality.

Cut Chart Notes:

The Cut Charts on these pages are optimized to provide the best cut angle, least dross and best cut surface finish. **Remember that cut charts are intended to provide a good starting point for each different cutting assignment. Every cutting system requires "fine-tuning" for each cutting application to the materials on site in order to obtain optimum cut quality.**