

# MACHINE TORCH SETUP

## FineCut (Mild Steel)

Air flow rate - slpm/scfh	
Hot	181 / 384
Cold	191 / 404

### Metric

Material Thickness	Current	Torch-to-Work Distance	Initial Pierce Height		Pierce Delay Time	Recommended		
						Cut Speed	Voltage	
mm	A	mm	mm	%	seconds	(mm/min)	Volts	
0.5	40	1.5	2.25	150	0.0	8250	78	
0.6						8250	78	
0.8						8250	78	
1	45				0.2	8250	78	
1.5						0.4	6400	78
2							4800	78
3						2750	78	
4						1900	78	

### English

Material Thickness	Current	Torch-to-Work Distance	Initial Pierce Height		Pierce Delay Time	Recommended		
						Cut Speed	Voltage	
	A	inches	inches	%	seconds	ipm	Volts	
26GA	40	0.06	0.09	150	0.0	325	78	
24GA						325	78	
22GA					0.1	325	78	
20GA						325	78	
18GA	45				0.2	325	78	
16GA						0.4	250	78
14GA							200	78
12GA						0.5	120	78
10GA		95	78					