

## MACHINE TORCH SETUP

### Low Speed 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	30	1.5	2.25	150	0.0	3800	69		
0.6						3800	68		
0.8					3800	70			
1 *	40						0.2	3800	72
1.5 *							0.4	3800	75
2	45				3700	76			
3					0.5	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	30	0.06	0.09	150	0.0	150	70	
24GA						150	68	
22GA					150	70		
20GA	0.2						150	71
18GA							40	150
16GA *	0.4				150	75		
14GA *					45	150	76	
12GA	0.5					120	78	
10GA		95	78					

\*Not a dross-free cut.