Material: Mild Steel

Torch: SL100 with Exposed Tip and Deflector **Table: Dry**
Power Supply: CutMaster 151 Automated **Gas: Compressed Air**

Material thickness			Tip	Current	Plasma Press.*	Pierce Height		Pierce Time	Arc voltage	Stand-off Height		Recommended Travel Speed	
In	GA	mm	Cat. #	Amps	PSI	In	mm	SEC	Volts	in	mm	IPM	mm/min
0.036	20	0.9	8-8208	40	65	0.2	4.8	0.00	96	0.19	4.8	341	8661
0.051		1.3	8-8208	40	65	0.2	4.8	0.00	97	0.19	4.8	300	7620
0.060	16	1.5	8-8208	40	65	0.2	4.8	0.10	98	0.19	4.8	265	6731
0.075	14	1.9	8-8208	40	65	0.2	4.8	0.30	100	0.19	4.8	190	4826
0.135	10	3.4	8-8208	40	65	0.2	4.8	0.40	101	0.19	4.8	120	3048
0.141		3.6	8-8208	40	65	0.2	4.8	0.50	102	0.19	4.8	112	2845
0.188		4.8	8-8208	40	65	0.2	4.8	0.60	107	0.19	4.8	60	1524
0.250		6.4	8-8208	40	65	0.2	4.8	1.00	111	0.19	4.8	40	1016
0.375		9.5	8-8208	40	65	NR	NR	NR	119	0.19	4.8	19.7	500
0.500		12.7	8-8208	40	65	NR	NR	NR	123	0.19	4.8	11.1	282
0.625		15.9	8-8208	40	65	NR	NR	NR	127	0.19	4.8	6	152
0.060	16	1.6	9-8210	60	70	0.2	4.8	0.00	110	0.19	4.8	293	7442
0.075	14	1.9	9-8210	60	70	0.2	4.8	0.10	110	0.19	4.8	288	7315
0.120	11	3.0	9-8210	60	70	0.2	4.8	0.10	111	0.19	4.8	273	6934
0.135	10	3.4	9-8210	60	70	0.2	4.8	0.10	111	0.19	4.8	215	5461
0.141		3.6	9-8210	60	70	0.2	4.8	0.15	112	0.19	4.8	177.6	4511
0.188		4.8	9-8210	60	70	0.2	4.8	0.20	114	0.19	4.8	137	3480
0.250		6.4	9-8210	60	70	0.2	4.8	0.30	116	0.19	4.8	82.4	2093
0.375		9.5	9-8210	60	70	0.2	4.8	0.50	118	0.19	4.8	42.4	1077
0.500		12.7	9-8210	60	70	0.2	4.8	0.75	119	0.19	4.8	26.3	668
0.625		15.9	9-8210	60	70	NR	NR	NR	127	0.19	4.8	17.4	442
0.750		19.1	9-8210	60	70	NR	NR	NR	126	0.19	4.8	16	406
1.000		25.4	9-8210	60	70	NR	NR	NR	128	0.19	4.8	12	305
0.047	18	1.2	9-8211	80	65	0.2	4.8	0.05	98	0.19	4.8	289	7341
0.120	11	3.0	9-8211	80	65	0.2	4.8	0.05	100	0.19	4.8	216	5486
0.135	10	3.4	9-8211	80	65	0.2	4.8	0.10	101	0.19	4.8	180	4572
0.188		4.8	9-8211	80	65	0.2	4.8	0.20	102	0.19	4.8	143	3632
0.250		6.4	9-8211	80	65	0.2	4.8	0.30	107	0.19	4.8	102.4	2601
0.375		9.5	9-8211	80	65	0.2	4.8	0.40	111	0.19	4.8	48	1219
0.500		12.7	9-8211	80	65	0.2	4.8	0.60	113	0.19	4.8	32.6	828
0.625		15.9	9-8211	80	65	0.2	4.8	0.75	116	0.19	4.8	24	610
0.750		19.1	9-8211	80	65	NR	NR	NR	121	0.19	4.8	18	457
0.875		22.2	9-8211	80	65	NR	NR	NR	126	0.19	4.8	14	356
1.000		25.4	9-8211	80	65	NR	NR	NR	132	0.19	4.8	10	254
1.250		31.8	9-8211	80	65	NR	NR	NR	136	0.19	4.8	2	51
0.250		6.4	9-8212	100	70	0.2	4.8	0	104	0.19	4.8	129	327
0.375		9.5	9-8212	100	70	0.2	4.8	0	110	0.19	4.8	65	1651
0.500		12.7	9-8212	100	70	0.2	4.8	0	113	0.19	4.8	49	1244
0.750		19.1	9-8212	100	70	0.2	4.8	0	118	0.19	4.8	24	610
1.000		25.4	9-8212	100	70	0.2	4.8	NR	121	0.19	4.8	16	406
1.250		31.8	9-8212	100	70	0.2	4.8	NR	128	0.19	4.8	10	254
1.500		38.1	9-8212	100	70	0.2	4.8	NR	133	0.19	4.8	8	203

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NOTES

** Gas pressure shown is for torches with leads up to 25' / 7.6 m long. For 50' / 15.2 m leads, increase pressure by 5 psi / 0.34 bar.*

This information represents realistic expectations using recommended practices and well - maintained systems. Actual speeds may vary up to 50% from those shown.

Material: Stainless Steel

Torch: SL100 with Exposed Tip and Deflector **Table: Dry**

Power Supply: CutMaster 151 Automated **Gas: Compressed Air**

Material thickness			Tip	Current	Plasma Press.*	Pierce Height		Pierce Time	Arc voltage	Stand-off Height		Recommended Travel Speed	
In	GA	mm	Cat. #	Amps	PSI	In	mm	SEC	Volts	in	mm	IPM	mm/min
0.038	20	1.0	8-8208	40	65	0.2	4.8	0.00	103	0.19	4.80	357	9067.8
0.050	18	1.3	8-8208	40	65	0.2	4.8	0.00	104	0.19	4.80	287	7289.8
0.063	16	1.6	8-8208	40	65	0.2	4.8	0.10	104	0.19	4.80	244	6197.6
0.078	14	2.0	8-8208	40	65	0.2	4.8	0.30	105	0.19	4.80	125	3175.0
0.135		3.4	8-8208	40	65	0.2	4.8	0.40	105	0.19	4.80	106	2692.4
0.141	10	3.6	8-8208	40	65	0.2	4.8	0.50	106	0.19	4.80	104	2641.6
0.188		4.8	8-8208	40	65	0.2	4.8	0.60	106	0.19	4.80	75	1905.0
0.250		6.4	8-8208	40	65	0.2	4.8	1.00	109	0.19	4.80	46.6	1183.6
0.375		9.5	8-8208	40	65	NR	NR	NR	109	0.19	4.80	31.5	800.1
0.500		12.7	8-8208	40	65	NR	NR	NR	112	0.19	4.80	17.4	442.0
0.625		15.9	8-8208	40	65	NR	NR	NR	114	0.19	4.80	10	254.0
0.063	16	1.6	9-8210	60	70	0.2	4.8	0.00	107	0.19	4.80	177	4495.8
0.078	14	2.0	9-8210	60	70	0.2	4.8	0.10	108	0.19	4.80	169	4292.6
0.125	11	3.2	9-8210	60	70	0.2	4.8	0.10	109	0.19	4.80	140	3556.0
0.135		3.4	9-8210	60	70	0.2	4.8	0.10	110	0.19	4.80	117	2971.8
0.141	10	3.6	9-8210	60	70	0.2	4.8	0.15	111	0.19	4.80	103	2616.2
0.188		4.8	9-8210	60	70	0.2	4.8	0.20	112	0.19	4.80	90	2286.0
0.250		6.4	9-8210	60	70	0.2	4.8	0.30	113	0.19	4.80	68.8	1747.5
0.375		9.5	9-8210	60	70	0.2	4.8	0.50	115	0.19	4.80	35	889.0
0.500		12.7	9-8210	60	70	0.2	4.8	0.75	121	0.19	4.80	21.3	541.0
0.625		15.9	9-8210	60	70	NR	NR	NR	127	0.19	4.80	15.9	403.9
0.750		19.1	9-8210	60	70	NR	NR	NR	131	0.19	4.80	12.5	317.5
1.000		25.4	9-8210	60	70	NR	NR	NR	135	0.19	4.80	6	152.4
0.048	18	1.2	9-8211	80	65	0.2	4.8	0.05	102	0.19	4.80	411	10439.4
0.125	11	3.2	9-8211	80	65	0.2	4.8	0.05	104	0.19	4.80	291	7391.4
0.135		3.4	9-8211	80	65	0.2	4.8	0.10	105	0.19	4.80	270	6858.0
0.188		4.8	9-8211	80	65	0.2	4.8	0.20	106	0.19	4.80	171	4343.4
0.250		6.4	9-8211	80	65	0.2	4.8	0.30	107	0.19	4.80	88	2235.2
0.375		9.5	9-8211	80	65	0.2	4.8	0.40	111	0.19	4.80	47	1193.8
0.500		12.7	9-8211	80	65	0.2	4.8	0.60	113	0.19	4.80	28.8	731.5
0.625		15.9	9-8211	80	65	0.2	4.8	0.75	117	0.19	4.80	19.5	495.3
0.750		19.1	9-8211	80	65	NR	NR	NR	120	0.19	4.80	15.6	396.2
0.875		22.2	9-8211	80	65	NR	NR	NR	123	0.19	4.80	12	304.8
1.000		25.4	9-8211	80	65	NR	NR	NR	126	0.19	4.80	10	254.0
1.250		31.8	9-8211	80	65	NR	NR	NR	130	0.19	4.80	6	152.4
0.250		6.4	9-8212	100	70	0.2	4.8	0	104	0.19	4.8	134	3.4
0.375		9.5	9-8212	100	70	0.2	4.8	0	110	0.19	4.8	67	1701.8
0.500		12.7	9-8212	100	70	0.2	4.8	0	113	0.19	4.8	40	1016.0
0.750		19.1	9-8212	100	70	0.2	4.8	0	118	0.19	4.8	22	558.8
1.000		25.4	9-8212	100	70	0.2	4.8	NR	123	0.19	4.8	12	304.8
1.250		31.8	9-8212	100	70	0.2	4.8	NR	129	0.19	4.8	9	228.6
1.500		38.1	9-8212	100	70	0.2	4.8	NR	135	0.19	4.8	6	152.4

NOTES

** Gas pressure shown is for torches with leads up to 25' / 7.6 m long. For 50' / 15.2 m leads, increase pressure by 5 psi / 0.34 bar.*

This information represents realistic expectations using recommended practices and well - maintained systems. Actual speeds may vary up to 50% from those shown.

Material: Aluminum

Torch: SL100 with Exposed Tip **Table: Dry**

Power Supply: CutMaster 151 Automated **Gas: Compressed Air**

Material thickness			Tip	Current	Plasma Press.*	Pierce Height		Pierce Time	Arc voltage	Stand-off Height		Recommended Travel Speed	
In	GA	mm	Cat. #	Amps	PSI	In	mm	SEC	Volts	in	mm	IPM	mm/min
0.040	20	1.0	8-8208	40	65	0.2	4.8	0.00	94	0.19	4.80	440	11176
0.052	18	1.3	8-8208	40	65	0.2	4.8	0.00	96	0.19	4.80	440	11176
0.064	16	1.6	8-8208	40	65	0.2	4.8	0.10	98	0.19	4.80	440	11176
0.079	14	2.0	8-8208	40	65	0.2	4.8	0.30	102	0.19	4.80	297	7544
0.125		3.2	8-8208	40	65	0.2	4.8	0.35	106	0.19	4.80	145.6	3698
0.135		3.4	8-8208	40	65	0.2	4.8	0.40	108	0.19	4.80	135	3429
0.187		4.7	8-8208	40	65	0.2	4.8	0.60	112	0.19	4.80	98	2489
0.250		6.4	8-8208	40	65	0.2	4.8	1.00	115	0.19	4.80	50.4	1280
0.375		9.5	8-8208	40	65	NR	NR	NR	122	0.19	4.80	22	559
0.500		12.7	8-8208	40	65	NR	NR	NR	126	0.19	4.80	13.5	343
0.625		15.9	8-8208	40	65	NR	NR	NR	130	0.19	4.80	8	203
0.034	22	1.6	9-8210	60	70	0.2	5.1	0.00	95	0.19	4.80	440	11176
0.079	14	2.0	9-8210	60	70	0.2	5.1	0.10	98	0.19	4.80	440	11176
0.125		3.2	9-8210	60	70	0.2	5.1	0.10	103	0.19	4.80	440	11176
0.135		3.4	9-8210	60	70	0.2	5.1	0.10	108	0.19	4.80	340	8636
0.141		3.6	9-8210	60	70	0.2	5.1	0.15	111	0.19	4.80	275	6985
0.188		4.8	9-8210	60	70	0.2	5.1	0.20	115	0.19	4.80	170	4318
0.250		6.4	9-8210	60	70	0.2	5.1	0.30	119	0.19	4.80	94.4	2398
0.375		9.5	9-8210	60	70	0.2	5.1	0.50	122	0.19	4.80	57.4	1458
0.500		12.7	9-8210	60	70	0.2	5.1	0.75	128	0.19	4.80	34.4	874
0.625		15.9	9-8210	60	70	NR	NR	NR	131	0.19	4.80	23	584
0.750		19.1	9-8210	60	70	NR	NR	NR	134	0.19	4.80	17.6	447
1.000		25.4	9-8210	60	70	NR	NR	NR	140	0.19	4.80	8	203
0.047	19	1.2	9-8211	80	65	0.2	5.1	0.00	101	0.19	4.80	419	10643
0.125		3.2	9-8211	80	65	0.2	5.1	0.05	101	0.19	4.80	301	7645
0.135		3.4	9-8211	80	65	0.2	5.1	0.10	101	0.19	4.80	280	7112
0.188		4.8	9-8211	80	65	0.2	5.1	0.20	101	0.19	4.80	182	4623
0.250		6.4	9-8211	80	65	0.2	5.1	0.30	108	0.19	4.80	124	3150
0.375		9.5	9-8211	80	65	0.2	5.1	0.40	115	0.19	4.80	65.6	1666
0.500		12.7	9-8211	80	65	0.2	5.1	0.60	118	0.19	4.80	44.8	1138
0.625		15.9	9-8211	80	65	0.2	5.1	0.75	120	0.19	4.80	35	889
0.750		19.1	9-8211	80	65	NR	NR	NR	127	0.19	4.80	20	508
0.875		22.2	9-8211	80	65	NR	NR	NR	140	0.19	4.80	10	254
1.000		25.4	9-8211	80	65	NR	NR	NR	154	0.19	4.80	5	127
1.250		31.8	9-8211	80	65	NR	NR	NR	160	0.19	4.80	2	51
0.250		6.4	9-8212	100	70	0.2	4.8	0	104	0.19	4.8	149	3785
0.375		9.5	9-8212	100	70	0.2	4.8	0	110	0.19	4.8	99	2515
0.500		12.7	9-8212	100	70	0.2	4.8	0	113	0.19	4.8	65	1651
0.750		19.1	9-8212	100	70	0.2	4.8	0	118	0.19	4.8	30	762
1.000		25.4	9-8212	100	70	0.2	4.8	NR	123	0.19	4.8	19	483
1.250		31.8	9-8212	100	70	0.2	4.8	NR	129	0.19	4.8	14	356
1.500		38.1	9-8212	100	70	0.2	4.8	NR	135	0.19	4.8	11	279

NOTES

** Gas pressure shown is for torches with leads up to 25' / 7.6 m long. For 50' / 15.2 m leads, increase pressure by 5 psi / 0.34 bar.*

This information represents realistic expectations using recommended practices and well - maintained systems. Actual speeds may vary up to 50% from those shown.

Material: Mild Steel

Torch: SL100 with Shielded Tip **Table: Dry**

Power Supply: CutMaster 151 Automated **Gas: Compressed Air**

Material thickness			Torch Tip	Shield Cap	Current	Plasma Press.*	Pierce Height		Pierce Time	Arc voltage	Stand-off Height		Recommended Travel speed	
In	GA	mm	Cat. #	Cat. #	Amps	PSI	In	mm	SEC	Volts	in	mm	IPM	mm/min
0.036	20	0.9144	8-8208	9-8245	40	65	1.88	4.8	0.00	102	0.19	4.80	170	4318
0.051		1.30	8-8208	9-8245	40	65	1.88	4.8	0.00	103	0.19	4.80	148	3759.2
0.060	16	1.52	8-8208	9-8245	40	65	1.88	4.8	0.10	104	0.19	4.80	133	3378.2
0.075	14	1.91	8-8208	9-8245	40	65	1.88	4.8	0.30	106	0.19	4.80	95	2413
0.135	10	3.43	8-8208	9-8245	40	65	1.88	4.8	0.40	110	0.19	4.80	65	1651
0.188		4.78	8-8208	9-8245	40	65	1.88	4.8	0.60	113	0.19	4.80	30	762
0.250		6.35	8-8208	9-8245	40	65	1.88	4.8	1.00	117	0.19	4.80	23	584.2
0.375		9.53	8-8208	9-8245	40	65	NR	NR	NR	126	0.19	4.80	10	254
0.500		12.70	8-8208	9-8245	40	65	NR	NR	NR	122	0.19	4.80	7	177.8
0.625		15.88	8-8208	9-8245	40	65	NR	NR	NR	135	0.19	4.80	3	76.2
0.060	16	1.57	9-8210	9-8238	60	70	1.88	4.8	0.00	117	0.19	4.80	235	5969
0.075	14	1.91	9-8210	9-8238	60	70	1.88	4.8	0.10	118	0.19	4.80	190	4826
0.120	11	3.05	9-8210	9-8238	60	70	1.88	4.8	0.10	118	0.19	4.80	218	5537.2
0.135	10	3.43	9-8210	9-8238	60	70	1.88	4.8	0.10	119	0.19	4.80	142	3606.8
0.188		4.78	9-8210	9-8238	60	70	1.88	4.8	0.20	120	0.19	4.80	117	2971.8
0.250		6.35	9-8210	9-8238	60	70	1.88	4.8	0.30	123	0.19	4.80	66	1676.4
0.375		9.53	9-8210	9-8238	60	70	1.88	4.8	0.50	119	0.19	4.80	34	863.6
0.500		12.70	9-8210	9-8238	60	70	1.88	4.8	0.75	121	0.19	4.80	23.4	594.36
0.625		15.88	9-8210	9-8238	60	70	NR	NR	NR	135	0.19	4.80	14	355.6
0.750		19.05	9-8210	9-8238	60	70	NR	NR	NR	130	0.19	4.80	13.6	345.44
1.000		25.40	9-8210	9-8238	60	70	NR	NR	NR	135	0.19	4.80	12.8	325.12
0.047	18	0.05	9-8211	9-8239	80	65	1.88	4.8	0.00	104	0.19	4.80	231	5867.4
0.120	11	0.13	9-8211	9-8239	80	65	1.88	4.8	0.10	106	0.19	4.80	173	4394.2
0.135		3.43	9-8211	9-8239	80	65	1.88	4.8	0.10	106	0.19	4.80	165	4191
0.188	7	4.78	9-8211	9-8239	80	65	1.88	4.8	0.20	103	0.19	4.80	125	3175
0.250		6.35	9-8211	9-8239	80	65	1.88	4.8	0.30	113	0.19	4.80	82	2082.8
0.375		9.53	9-8211	9-8239	80	65	1.88	4.8	0.40	118	0.19	4.80	38	965.2
0.500		12.70	9-8211	9-8239	80	65	1.88	4.8	0.60	115	0.19	4.80	29.6	751.84
0.625		15.88	9-8211	9-8239	80	65	1.88	4.8	0.75	123	0.19	4.80	19	482.6
0.750		19.05	9-8211	9-8239	80	65	NR	NR	NR	128	0.19	4.80	14	355.6
0.875		22.23	9-8211	9-8239	80	65	NR	NR	NR	134	0.19	4.80	11	279.4
1.000		25.40	9-8211	9-8239	80	65	NR	NR	NR	129	0.19	4.80	9.2	233.68
1.250		31.75	9-8211	9-8239	80	65	NR	NR	NR	134	0.19	4.80	5	127
0.250		6.4	9-8212	9-8239	100	70	0.19	4.8	0	104	0.19	4.80	121	3073.4
0.375		9.5	9-8212	9-8239	100	70	0.19	4.8	0	110	0.19	4.80	54	1371.6
0.500		12.7	9-8212	9-8239	100	70	0.19	4.8	0	113	0.19	4.80	40	1016
0.750		19.1	9-8212	9-8239	100	70	0.19	4.8	0	118	0.19	4.80	22	558.8
1.000		25.4	9-8212	9-8239	100	70	0.19	4.8	NR	121	0.19	4.80	11	279.4
1.250		31.8	9-8212	9-8239	100	70	0.19	4.8	NR	128	0.19	4.80	8	203.2
1.500		38.1	9-8212	9-8239	100	70	0.19	4.8	NR	133	0.19	4.80	6	152.4

4

NOTES

** Gas pressure shown is for torches with leads up to 25' / 7.6 m long. For 50' / 15.2 m leads, increase pressure by 5 psi / 0.34 bar.*

This information represents realistic expectations using recommended practices and well - maintained systems. Actual speeds may vary up to 50% from those shown.

Material: Stainless Steel

Torch: SL100 with Shielded Tip **Table: Dry**

Power Supply: CutMaster 151 Automated **Gas: Compressed Air**

Material thickness			Torch Tip	Shield Cap	Current	Plasma Press.*	Pierce Height		Pierce Time	Arc voltage	Stand-off Height		Recommended Travel Speed	
In	GA	mm	Cat. #	Cat. #	Amps	PSI	In	mm	SEC	Volts	in	mm	IPM	mm/min
0.038	20		8-8208	9-8245	40	65	0.2	4.8	0.00	109	0.19	4.8	179	4546.6
0.050	18	1.3	8-8208	9-8245	40	65	0.2	4.8	0.00	109	0.19	4.8	150	3810
0.063	16	1.6	8-8208	9-8245	40	65	0.2	4.8	0.10	110	0.19	4.8	122	3098.8
0.078	14	2.0	8-8208	9-8245	40	65	0.2	4.8	0.30	111	0.19	4.8	66	1676.4
0.135		3.4	8-8208	9-8245	40	65	0.2	4.8	0.40	111	0.19	4.8	66	1676.4
0.141	10	3.6	8-8208	9-8245	40	65	0.2	4.8	0.50	112	0.19	4.8	65	1651
0.187		4.7	8-8208	9-8245	40	65	0.2	4.8	0.60	112	0.19	4.8	38	965.2
0.250		6.4	8-8208	9-8245	40	65	0.2	4.8	1.00	116	0.19	4.8	23	584.2
0.375		9.5	8-8208	9-8245	40	65	NR	NR	NR	116	0.19	4.8	16	406.4
0.500		12.7	8-8208	9-8245	40	65	NR	NR	NR	119	0.19	4.8	9	228.6
0.625		15.9	8-8208	9-8245	40	65	NR	NR	NR	121	0.19	4.8	5	127
0.063	16	1.6	9-8210	9-8238	60	70	0.2	4.8	0.00	113	0.19	4.8	142	3606.8
0.078	14	2.0	9-8210	9-8238	60	70	0.2	4.8	0.10	115	0.19	4.8	134	3403.6
0.125	11	3.2	9-8210	9-8238	60	70	0.2	4.8	0.10	116	0.19	4.8	112	2844.8
0.135		3.4	9-8210	9-8238	60	70	0.2	4.8	0.10	118	0.19	4.8	82	2082.8
0.141	10	3.6	9-8210	9-8238	60	70	0.2	4.8	0.15	118	0.19	4.8	82	2082.8
0.187		4.7	9-8210	9-8238	60	70	0.2	4.8	0.20	119	0.19	4.8	75	1905
0.250		6.4	9-8210	9-8238	60	70	0.2	4.8	0.30	120	0.19	4.8	55	1397
0.375		9.5	9-8210	9-8238	60	70	0.2	4.8	0.50	122	0.19	4.8	28	711.2
0.500		12.7	9-8210	9-8238	60	70	0.2	4.8	0.75	128	0.19	4.8	17	431.8
0.625		15.9	9-8210	9-8238	60	70	NR	NR	NR	135	0.19	4.8	13	330.2
0.750		19.1	9-8210	9-8238	60	70	NR	NR	NR	139	0.19	4.8	10	254
1.000		25.4	9-8210	9-8238	60	70	NR	NR	NR	142	0.19	4.8	4	101.6
0.052	18	0.0	9-8211	9-8239	80	65	0.2	4.8	0.00	108	0.19	4.8	329	8356.6
0.125	11		9-8211	9-8239	80	65	0.2	4.8	0.00	110	0.19	4.8	233	5918.2
0.135		3.4	9-8211	9-8239	80	65	0.2	4.8	0.10	111	0.19	4.8	220	5588
0.172		4.4	9-8211	9-8239	80	65	0.2	4.8	0.20	112	0.19	4.8	137	3479.8
0.250		6.4	9-8211	9-8239	80	65	0.2	4.8	0.30	113	0.19	4.8	71	1803.4
0.375		9.5	9-8211	9-8239	80	65	0.2	4.8	0.40	118	0.19	4.8	38	965.2
0.500		12.7	9-8211	9-8239	80	65	0.2	4.8	0.60	120	0.19	4.8	23	584.2
0.625		15.9	9-8211	9-8239	80	65	0.2	4.8	0.75	124	0.19	4.8	16	406.4
0.750		19.1	9-8211	9-8239	80	65	NR	NR	NR	127	0.19	4.8	12	304.8
0.875		22.2	9-8211	9-8239	80	65	NR	NR	NR	130	0.19	4.8	10	254
1.000		25.4	9-8211	9-8239	80	65	NR	NR	NR	134	0.19	4.8	8	203.2
0.250		6.4	9-8212	9-8239	100	70	0.2	4.8	0	104	0.19	4.8	125	3175
0.375		9.5	9-8212	9-8239	100	70	0.2	4.8	0	110	0.19	4.8	64	1625.6
0.500		12.7	9-8212	9-8239	100	70	0.2	4.8	0	113	0.19	4.8	40	1016
0.750		19.1	9-8212	9-8239	100	70	0.2	4.8	0	118	0.19	4.8	18	457.2
1.000		25.4	9-8212	9-8239	100	70	0.2	4.8	NR	121	0.19	4.8	10	254
1.250		31.8	9-8212	9-8239	100	70	0.2	4.8	NR	128	0.19	4.8	6	152.4
1.500		38.1	9-8212	9-8239	100	70	0.2	4.8	NR	133	0.19	4.8	5	127

4

NOTES

** Gas pressure shown is for torches with leads up to 25' / 7.6 m long. For 50' / 15.2 m leads, increase pressure by 5 psi / 0.34 bar.*

This information represents realistic expectations using recommended practices and well - maintained systems. Actual speeds may vary up to 50% from those shown.

Material: Aluminum

Torch: SL100 with Shielded Tip **Table: Dry**

Power Supply: CutMaster 151 Automated **Gas: Compressed Air**

Material thickness			Torch Tip	Shield Cap	Current	Plasma Press.*	Pierce Height		Pierce Time	Arc voltage	Stand-off Height		Recommended Travel Speed	
In	GA	mm	Cat. #	Cat. #	Amps	PSI	In	mm	SEC	Volts	in	mm	IPM	mm/min
0.04	20	1.0	8-8208	9-8245	40	65	0.2	4.8	0.00	100	0.19	4.8	220	5588.0
0.051		1.3	8-8208	9-8245	40	65	0.2	4.8	0.00	102	0.19	4.8	220	5588.0
0.064	16	1.6	8-8208	9-8245	40	65	0.2	4.8	0.10	104	0.19	4.8	220	5588.0
0.079	14	2.0	8-8208	9-8245	40	65	0.2	4.8	0.30	108	0.19	4.8	149	3784.6
0.125		3.2	8-8208	9-8245	40	65	0.2	4.8	0.35	112	0.19	4.8	73	1854.2
0.135		3.4	8-8208	9-8245	40	65	0.2	4.8	0.40	115	0.19	4.8	69	1752.6
0.187		4.7	8-8208	9-8245	40	65	0.2	4.8	0.60	118	0.19	4.8	50	1270.0
0.250		6.4	8-8208	9-8245	40	65	0.2	4.8	1.00	122	0.19	4.8	25	635.0
0.375		9.5	8-8208	9-8245	40	65	NR	NR	NR	129	0.19	4.8	11	279.4
0.500		12.7	8-8208	9-8245	40	65	NR	NR	NR	134	0.19	4.8	7	177.8
0.625		15.9	8-8208	9-8245	40	65	NR	NR	NR	138	0.19	4.8	4	101.6
0.034	22	1.6	9-8210	9-8238	60	70	0.2	4.8	0.00	101	0.19	4.8	352	8940.8
0.064	16	1.6	9-8210	9-8238	60	70	0.2	4.8	0.10	105	0.19	4.8	352	8940.8
0.125		3.2	9-8210	9-8238	60	70	0.2	4.8	0.10	109	0.19	4.8	352	8940.8
0.135		3.4	9-8210	9-8238	60	70	0.2	4.8	0.10	112	0.19	4.8	272	6908.8
0.141		3.6	9-8210	9-8238	60	70	0.2	4.8	0.15	118	0.19	4.8	220	5588.0
0.187		4.7	9-8210	9-8238	60	70	0.2	4.8	0.20	122	0.19	4.8	136	3454.4
0.250		6.4	9-8210	9-8238	60	70	0.2	4.8	0.30	126	0.19	4.8	76	1930.4
0.375		9.5	9-8210	9-8238	60	70	0.2	4.8	0.50	129	0.19	4.8	46	1168.4
0.500		12.7	9-8210	9-8238	60	70	0.2	4.8	0.75	136	0.19	4.8	28	711.2
0.625		15.9	9-8210	9-8238	60	70	NR	NR	NR	139	0.19	4.8	19	482.6
0.750		19.1	9-8210	9-8238	60	70	NR	NR	NR	142	0.19	4.8	14	355.6
1.000		25.4	9-8210	9-8238	60	70	NR	NR	NR	150	0.19	4.8	4	101.6
0.047	18	0.0	9-8211	9-8239	80	65	0.2	4.8	0.00	107	0.19	4.8	335	8509.0
0.125		0.1	9-8211	9-8239	80	65	0.2	4.8	0.10	107	0.19	4.8	241	6121.4
0.135		3.4	9-8211	9-8239	80	65	0.2	4.8	0.10	107.0	0.19	4.8	225	5715.0
0.187		4.7	9-8211	9-8239	80	65	0.2	4.8	0.20	107	0.19	4.8	146	3708.4
0.250		6.4	9-8211	9-8239	80	65	0.2	4.8	0.30	114	0.19	4.8	99	2514.6
0.375		9.5	9-8211	9-8239	80	65	0.2	4.8	0.40	122	0.19	4.8	52	1320.8
0.500		12.7	9-8211	9-8239	80	65	0.2	4.8	0.60	125	0.19	4.8	36	914.4
0.625		15.9	9-8211	9-8239	80	65	0.2	4.8	0.75	130	0.19	4.8	26	660.4
0.750		19.1	9-8211	9-8239	80	65	NR	NR	NR	135	0.19	4.8	16	406.4
0.875		22.2	9-8211	9-8239	80	65	NR	NR	NR	148	0.19	4.8	8	203.2
1.000		25.4	9-8211	9-8239	80	65	NR	NR	NR	164	0.19	4.8	4	101.6
1.250		31.8	9-8211	9-8239	80	65	NR	NR	NR	170	0.19	4.8	2	50.8
0.250		6.4	9-8212	9-8239	100	70	0.2	4.8	0	104	0.19	4.8	148	3759.2
0.375		9.5	9-8212	9-8239	100	70	0.2	4.8	0	110	0.19	4.8	118	2997.2
0.500		12.7	9-8212	9-8239	100	70	0.2	4.8	0	113	0.19	4.8	79	2006.6
0.750		19.1	9-8212	9-8239	100	70	0.2	4.8	0	118	0.19	4.8	31	787.4
1.000		25.4	9-8212	9-8239	100	70	0.2	4.8	NR	121	0.19	4.8	18	457.2
1.250		31.8	9-8212	9-8239	100	70	0.2	4.8	NR	128	0.19	4.8	14	355.6
1.500		38.1	9-8212	9-8239	100	70	0.2	4.8	NR	133	0.19	4.8	11	279.4

NOTES

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