

Cutting Speed Chart

Torch Model	SL100	The cut speeds in the charts below are representative of results when using new consumables, a quality torch height control, and a well maintained plasma system and cutting machine.
Recommended Cutting Capacity	1/4" (6mm)	
Maximum Pierce Cutting Capacity	1/4" (6mm)	
Max Cutting Capacity (edge start)	5/8" (15mm)	

Material	Thickness [inch]	Best Cut Speed [IPM]	Current [Amps]	Thickness [mm]	Best Cut Speed [m/min]
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Mild Steel

Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	20 ga.	300	40	1	7.62
	16 ga.	275		1.5	6.99
	10 ga.	115		3	2.92
	7 ga.	75		5	1.91
	1/4	45		6	1.14
	3/8	20		10	0.51
	1/2	14		12	0.36

Stainless Steel

Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	20 ga.	350	40	1	8.89
	16 ga.	275		1.5	6.99
	10 ga.	75		3	1.91
	7 ga.	55		5	1.40
	1/4	40		6	1.02
	3/8	18		10	0.46
	1/2	10		12	0.25

Aluminum

Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	20 ga.	350	40	1	8.89
	16 ga.	275		1.5	6.99
	10 ga.	100		3	2.54
	7 ga.	70		5	1.78
	1/4	40		6	1.02
	3/8	18		10	0.46
	1/2	10		12	0.25