

## 4T.08 Recommended Cutting Speeds for Mechanized Torch With Exposed Tip

Type Torch: SL60 With Exposed Tip							Type Material: Mild Steel								
Type Plasma Gas: Air					Type Secondary Gas: Single Gas Torch										
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts (VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.036	0.9	9-8208	104	40	340	8.64	0.19	4.8	70	4.8	55	170	0.00	0.2	5.1
0.06	1.5	9-8208	108	40	250	6.35	0.19	4.8	70	4.8	55	170	0.10	0.2	5.1
0.075	1.9	9-8208	108	40	190	4.83	0.19	4.8	70	4.8	55	170	0.30	0.2	5.1
0.135	3.4	9-8208	110	40	105	2.67	0.19	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	113	40	60	1.52	0.19	4.8	70	4.8	55	170	0.60	0.2	5.1
0.25	6.4	9-8208	111	40	40	1.02	0.19	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	124	40	21	0.53	0.19	4.8	70	4.8	55	170	NR	NR	NR
0.500	12.7	9-8208	123	40	11	0.28	0.19	4.8	70	4.8	55	170	NR	NR	NR
0.625	15.9	9-8208	137	40	7	0.18	0.19	4.8	70	4.8	55	170	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Stainless Steel								
Type Plasma Gas: Air					Type Secondary Gas: Single Gas Torch										
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts (VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.036	0.9	9-8208	103	40	355	9.02	0.125	3.2	70	4.8	55	170	0.00	0.2	5.1
0.05	1.3	9-8208	98	40	310	7.87	0.125	3.2	70	4.8	55	170	0.00	0.2	5.1
0.06	1.5	9-8208	98	40	240	6.10	0.125	3.2	70	4.8	55	170	0.10	0.2	5.1
0.078	2.0	9-8208	100	40	125	3.18	0.125	3.2	70	4.8	55	170	0.30	0.2	5.1
0.135	3.4	9-8208	120	40	30	0.76	0.187	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	124	40	20	0.51	0.187	4.8	70	4.8	55	170	0.60	0.2	5.1
0.25	6.4	9-8208	122	40	15	0.38	0.187	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	126	40	10	0.25	0.187	4.8	70	4.8	55	170	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Aluminum								
Type Plasma Gas: Air					Type Secondary Gas: Single Gas Torch										
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts (VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.032	0.8	9-8208	110	40	440	11.18	0.187	4.8	70	4.8	55	170	0.00	0.2	5.1
0.051	1.3	9-8208	109	40	350	8.89	0.187	4.8	70	4.8	55	170	0.10	0.2	5.1
0.064	1.6	9-8208	112	40	250	6.35	0.187	4.8	70	4.8	55	170	0.10	0.2	5.1
0.079	2.0	9-8208	112	40	200	5.08	0.19	4.8	70	4.8	55	170	0.30	0.2	5.1
0.125	3.2	9-8208	118	40	100	2.54	0.19	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	120	40	98	2.49	0.187	4.8	70	4.8	55	170	0.60	0.2	5.1
0.250	6.4	9-8208	123	40	50	1.27	0.187	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	134	40	16	0.41	0.187	4.8	70	4.8	55	170	NR	NR	NR