

Cutting Speed Chart

Torch Model	PCH-120				
Genuine Cut	1 1/2" (38.1mm)				
Pierce Capacity	1" (25 mm)				
Material	Thickness [inches]	Speed [IPM]	Current [Amps]	Thickness [mm]	Speed [m/min]
Mild Steel					
Air/Air	1/16	275	35	1.5	7.0
	1/8	80		3.0	2.1
	1/4	75	70	5.0	3.5
	3/8	80	120	10.0	2.0
	1/2	55		12.0	1.5
	5/8	40		15.0	1.1
Stainless Steel					
Air/Air	1/16	40	35	1.5	1.0
	1/8	30		3.0	0.8
	1/4	65	70	5.0	2.5
	3/8	80	120	10.0	2.0
	1/2	40		12.0	1.1
	5/8	30		15.0	0.8
ArH2/Nitrogen	1/2	35	120	12.0	0.9
	5/8	25		15.0	0.7
	1	15		25.0	0.4
Aluminum					
Air/Air	1/16	125	35	1.5	3.0
	1/8	60		3.0	1.5
	1/4	65	70	5.0	2.1
	3/8	70	120	10.0	1.8
	1/2	35		12.0	1.0
	5/8	30		15.0	0.8
ArH2/Nitrogen	3/8	70	120	10.0	1.8
	1/2	60		12	1.6