

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	3/8" (10mm)	
Maximum Pierce Cutting Capacity	5/8" (15mm)	
Max Cutting Capacity (edge start)	1-1/4" (30mm)	

Material	Thickness [inch]	Best Cut Speed [IPM]	Current [Amps]	Thickness [mm]	Best Cut Speed [m/min]
Mild Steel					
Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	10 ga.	175	40	3	4.45
	16 ga.	350	60	1.5	8.89
	10 ga.	175		3	4.45
	10 ga.	230	80	3	5.84
	1/4	112		6	2.84
	3/8	55		10	1.40
	1/2	38		12	0.97
	3/4	18		20	0.46
1	10		25	0.25	
Stainless Steel					
Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	10 ga.	175	40	3	4.45
	16 ga.	350	60	1.5	8.89
	10 ga.	175		3	4.45
	10 ga.	200	80	3	5.08
	1/4	112		6	2.84
	3/8	55		10	1.40
	1/2	38		12	0.97
	3/4	18		20	0.46
1	10		25	0.25	
Aluminum					
Air	16 ga.	180	20	1.5	4.57
	16 ga.	240	30	1.5	6.10
	10 ga.	175	40	3	4.45
	16 ga.	350	60	1.5	8.89
	10 ga.	175		3	4.45
	10 ga.	230	80	3	5.84
	1/4	112		6	2.84
	3/8	55		10	1.40
	1/2	38		12	0.97
	3/4	18		20	0.46
1	10		25	0.25	

*1TORCH, ATC and SL100, trademarks of Thermal Dynamics Corporation, are registered with the U.S. Patent and Trademark Office, and are the subject of trademark registrations and pending applications in numerous other countries. For information on tradema