Cutting Speed Chart

Torch Model	SL100®
Recommended Cutting Capacity	3/8” (10mm)
Maximum Pierce Cutting Capacity	5/8” (15mm)
Max Cutting Capacity (edge start)	1-1/4” (30mm)

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.

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