

# 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		1/2" (12mm)				
Maximum Pierce Cutting Capacity		3/4" (20mm)				
Max Cutting Capacity (edge start)		1-1/2" (40mm)				
Material	Thickness [inch]	Best Cut Speed [IPM]	Current [Amps]	Thickness [mm]	Best Cut Speed [m/min]	
<b>Mild Steel</b>						
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	129	100	6	3.28	
	3/8	65		10	1.65	
	1/2	49		12	1.24	
	3/4	24		20	0.61	
	1	16		25	0.41	
	1-1/4	10		30	0.25	
	<b>Stainless Steel</b>					
	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		134	100	6	3.40	
3/8		67		10	1.70	
1/2		40		12	1.02	
3/4		22		20	0.56	
1		12		25	0.30	
1-1/4		9		30	0.23	
<b>Aluminum</b>						
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	149	100	6	3.78	
	3/8	99		10	2.51	
	1/2	65		12	1.65	
	3/4	30		20	0.76	
	1	19		25	0.48	
	1-1/4	14		30	0.36	

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