

# Cutting Speed Chart

This cutting speed chart includes preliminary data and is subject to change without notice

<b>Torch Model</b>		XT™-301				
<b>Production Piercing &amp; Cutting Capacity</b>		1.25" (35 mm)				
<b>Maximum Piercing &amp; Cutting Capacity</b>		1.50" (40 mm)				
<b>Maximum Edge Start</b>		2.75" (70 mm)				
<b>Material</b>	<b>Thickness Inch</b>	<b>Speed IPM</b>	<b>Amps</b>	<b>Plasma/Shield</b>	<b>Thickness mm</b>	<b>Speed mm/min.</b>
<b>Mild Steel</b>						
	21 ga.	500	55	Air/Air	1	11500
	10 ga.	190			3	5460
	3/16	130			5	3180
	1/4	150	100	Air/Air	6	4150
	1/2	75			12	1960
	3/4	30			20	720
	1	20			25	520
	3/8	130	200	Air/Air	10	3190
	1/2	100			12	2710
	3/4	60			20	1430
	1	35			25	920
	1/2	110	300	Air/Air	12	2790
	3/4	75			20	1960
	1	50			25	1300
	1-1/4	35			35	920
	1-1/2	20			38	510
	2	8			50	220
	2-3/4	4			70	100
<b>Stainless Steel</b>						
	16 ga.	350	55	Air/Air	1.5	9750
	10 ga.	100			4	2180
	3/16	60			5	1450
	1/4	100	100	Air/Air	6	3020
	3/8	65			10	1580
	1/2	45			12	1260
	1/4	60	100	N <sub>2</sub> /H <sub>2</sub> O	6	1750
	3/8	50			10	1210
	1/2	35			12	970
	3/4	50	200	Ar-H <sub>2</sub> /N <sub>2</sub>	20	940
	1	25			25	650
	3/4	100	300	Air/Air	20	3020
	1	60			25	1750
	1-1/4	40			35	1060
<b>Aluminum</b>						
	16 ga.	400	55	Air/Air	2	8790
	3/16	100			5	2360
	1/4	100	100	Air/Air	6	2650
	1/2	45			12	1310
	3/4	35			20	890
	1/4	60	100	N <sub>2</sub> /H <sub>2</sub> O	6	1640
	3/8	50			10	1210
	1/2	35			12	970
	3/4	70	200	Ar-H <sub>2</sub> /N <sub>2</sub>	20	1660
	1	40			25	1060
	3/4	90	300	Air/Air	20	1600
	1	70			25	1490
	1-1/4	45			35	1320

Note: Take care in comparison. The speeds noted above are best cut speeds. Often, competitors show maximum cutting speeds. Although much higher speeds can be achieved, edge quality and bevel angle may be compromised. The capabilities shown in this table were obtained by using new consumables, correct gas and current settings, accurate torch height control and with the torch perpendicular to the workpiece. The operating chart does not list all processes available for the Auto-Cut 300. Please contact Thermal Dynamics for more information.