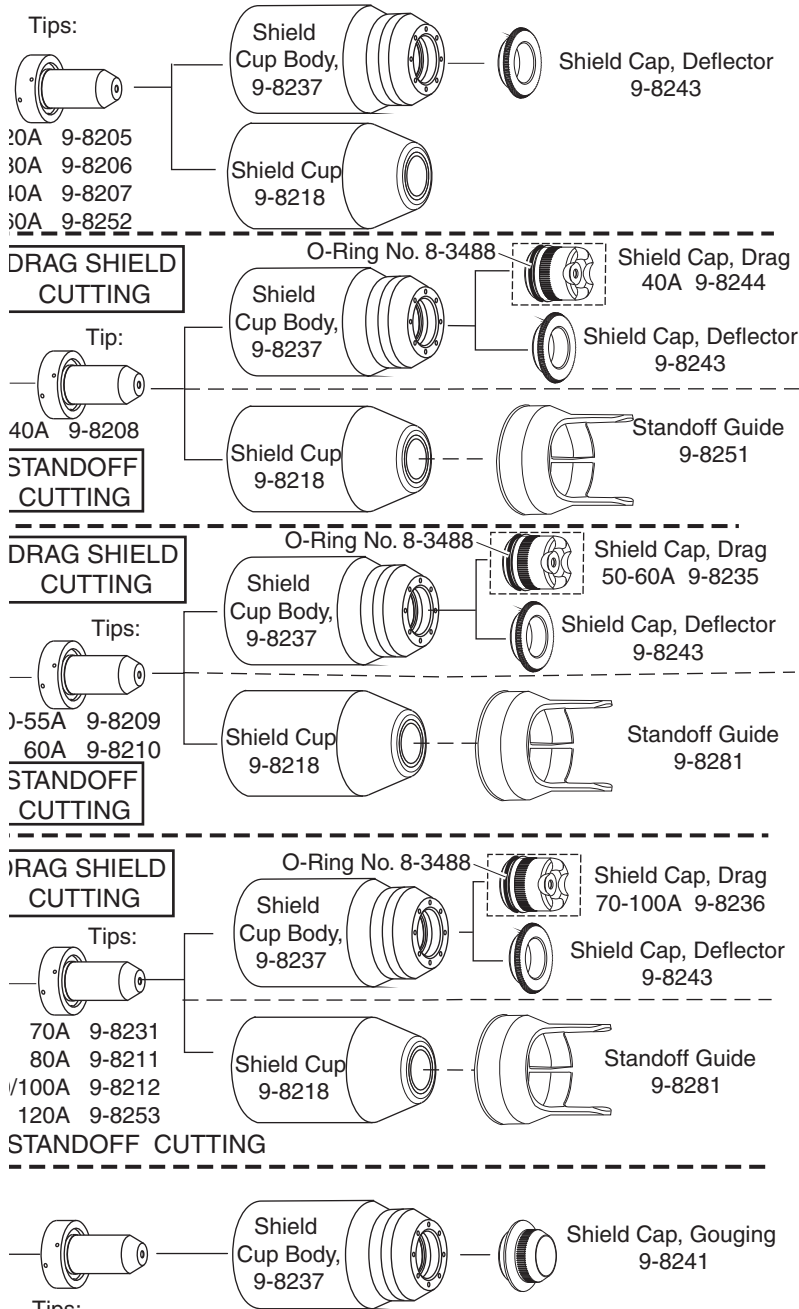


## 4T.07 Parts Selection for Manual and Mechanized Torch Cutting



- A 9-8225 (40 Amps Max.)
- B 9-8226 (50 - 100 Amps)
- C 9-8227 (60 - 120 Amps)
- D 9-8228 (60 - 120 Amps)
- E 9-8254 (60 - 120 Amps)

**NOTE**  
 CutMaster 52 uses 60A and less  
 CutMaster 82 uses 80A and less  
 CutMaster 102 uses 100A and less  
 CutMaster 152 uses 120A and less

**4T.08 Recommended Cutting Speeds for Mechanized Torch With Exposed Tip**

Type Torch: SL60 With Exposed Tip							Type Material: Mild Steel								
Type Plasma Gas: Air					Type Secondary Gas: Single Gas Torch										
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.036	0.9	9-8208	104	40	340	8.64	0.19	4.8	70	4.8	55	170	0.00	0.2	5.1
0.06	1.5	9-8208	108	40	250	6.35	0.19	4.8	70	4.8	55	170	0.10	0.2	5.1
0.075	1.9	9-8208	108	40	190	4.83	0.19	4.8	70	4.8	55	170	0.30	0.2	5.1
0.135	3.4	9-8208	110	40	105	2.67	0.19	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	113	40	60	1.52	0.19	4.8	70	4.8	55	170	0.60	0.2	5.1
0.25	6.4	9-8208	111	40	40	1.02	0.19	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	124	40	21	0.53	0.19	4.8	70	4.8	55	170	NR	NR	NR
0.500	12.7	9-8208	123	40	11	0.28	0.19	4.8	70	4.8	55	170	NR	NR	NR
0.625	15.9	9-8208	137	40	7	0.18	0.19	4.8	70	4.8	55	170	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Stainless Steel								
Type Plasma Gas: Air					Type Secondary Gas: Single Gas Torch										
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.036	0.9	9-8208	103	40	355	9.02	0.125	3.2	70	4.8	55	170	0.00	0.2	5.1
0.05	1.3	9-8208	98	40	310	7.87	0.125	3.2	70	4.8	55	170	0.00	0.2	5.1
0.06	1.5	9-8208	98	40	240	6.10	0.125	3.2	70	4.8	55	170	0.10	0.2	5.1
0.078	2.0	9-8208	100	40	125	3.18	0.125	3.2	70	4.8	55	170	0.30	0.2	5.1
0.135	3.4	9-8208	120	40	30	0.76	0.187	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	124	40	20	0.51	0.187	4.8	70	4.8	55	170	0.60	0.2	5.1
0.25	6.4	9-8208	122	40	15	0.38	0.187	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	126	40	10	0.25	0.187	4.8	70	4.8	55	170	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Aluminum								
Type Plasma Gas: Air					Type Secondary Gas: Single Gas Torch										
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.032	0.8	9-8208	110	40	440	11.18	0.187	4.8	70	4.8	55	170	0.00	0.2	5.1
0.051	1.3	9-8208	109	40	350	8.89	0.187	4.8	70	4.8	55	170	0.10	0.2	5.1
0.064	1.6	9-8208	112	40	250	6.35	0.187	4.8	70	4.8	55	170	0.10	0.2	5.1
0.079	2.0	9-8208	112	40	200	5.08	0.19	4.8	70	4.8	55	170	0.30	0.2	5.1
0.125	3.2	9-8208	118	40	100	2.54	0.19	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	120	40	98	2.49	0.187	4.8	70	4.8	55	170	0.60	0.2	5.1
0.250	6.4	9-8208	123	40	50	1.27	0.187	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	134	40	16	0.41	0.187	4.8	70	4.8	55	170	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Mild Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.060	1.5	9-8210	110	60	290	7.37	0.19	4.8	75	5.2	90	245	0.00	0.19	4.8
0.075	1.9	9-8210	120	60	285	7.24	0.19	4.8	75	5.2	90	245	0.10	0.19	4.8
0.120	3.0	9-8210	120	60	180	4.57	0.19	4.8	75	5.2	90	245	0.10	0.19	4.8
0.135	3.4	9-8210	119	60	170	4.32	0.19	4.8	75	5.2	90	245	0.10	0.19	4.8
0.188	4.8	9-8210	121	60	100	2.54	0.19	4.8	75	5.2	90	245	0.20	0.19	4.8
0.250	6.4	9-8210	119	60	80	2.03	0.19	4.8	75	5.2	90	245	0.30	0.19	4.8
0.375	9.5	9-8210	124	60	50	1.27	0.19	4.8	75	5.2	90	245	0.50	0.19	4.8
0.500	12.7	9-8210	126	60	26	0.66	0.19	4.8	75	5.2	90	245	0.75	0.19	4.8
0.625	15.9	9-8210	127	60	19	0.48	0.19	4.8	75	5.2	90	245	NR	NR	NR
0.750	19.1	9-8210	134	60	14	0.36	0.19	4.8	75	5.2	90	245	NR	NR	NR
1.000	25.4	9-8210	140	60	6	0.15	0.19	4.8	75	5.2	90	245	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Stainless Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.06	1.5	9-8210	119	60	350	8.91	0.19	4.8	75	5.2	90	245	0.00	0.20	5.1
0.075	1.9	9-8210	116	60	300	7.64	0.19	4.8	75	5.2	90	245	0.10	0.20	5.1
0.120	3.0	9-8210	123	60	150	3.82	0.19	4.8	75	5.2	90	245	0.10	0.20	5.1
0.135	3.4	9-8210	118	60	125	3.18	0.19	4.8	75	5.2	90	245	0.10	0.20	5.1
0.188	4.8	9-8210	122	60	90	2.29	0.19	4.8	75	5.2	90	245	0.20	0.20	5.1
0.250	6.4	9-8210	120	60	65	1.65	0.19	4.8	75	5.2	90	245	0.30	0.20	5.1
0.375	9.5	9-8210	130	60	30	0.76	0.19	4.8	75	5.2	90	245	0.50	0.20	5.1
0.500	12.7	9-8210	132	60	21	0.53	0.19	4.8	75	5.2	90	245	0.75	0.20	5.1
0.625	15.9	9-8210	130	60	15	0.38	0.19	4.8	75	5.2	90	245	NR	NR	NR
0.750	19.1	9-8210	142	60	12	0.31	0.25	6.4	75	5.2	90	245	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Aluminum								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.060	1.5	9-8210	110	60	440	11.18	0.25	6.4	75	5.2	90	245	0.00	0.25	6.4
0.075	1.9	9-8210	110	60	440	11.18	0.25	6.4	75	5.2	90	245	0.10	0.25	6.4
0.120	3.0	9-8210	116	60	250	6.35	0.25	6.4	75	5.2	90	245	0.10	0.25	6.4
0.188	3.4	9-8210	116	60	170	4.32	0.25	6.4	75	5.2	90	245	0.20	0.25	6.4
0.250	6.4	9-8210	132	60	85	2.16	0.25	6.4	75	5.2	90	245	0.30	0.25	6.4
0.375	9.5	9-8210	140	60	45	1.14	0.25	6.4	75	5.2	90	245	0.50	0.25	6.4
0.500	12.7	9-8210	143	60	30	0.76	0.25	6.4	75	5.2	90	245	0.80	0.25	6.4
0.625	15.9	9-8210	145	60	20	0.51	0.25	6.4	75	5.2	90	245	NR	NR	NR
0.750	19.1	9-8210	145	60	18	0.46	0.25	6.4	75	5.2	90	245	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Mild Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.060	1.5	9-8211	113	80	320	8.13	0.19	4.8	70	4.8	115	340	0.00	0.19	4.8
0.120	3.0	9-8211	113	80	230	5.84	0.19	4.8	70	4.8	115	340	0.10	0.19	4.8
0.135	3.4	9-8211	115	80	180	4.57	0.19	4.8	70	4.8	115	340	0.10	0.19	4.8
0.188	4.8	9-8211	114	80	140	3.56	0.19	4.8	70	4.8	115	340	0.20	0.19	4.8
0.250	6.4	9-8211	114	80	100	2.54	0.19	4.8	70	4.8	115	340	0.30	0.19	4.8
0.375	9.5	9-8211	117	80	42	1.07	0.19	4.8	70	4.8	115	340	0.40	0.19	4.8
0.500	12.7	9-8211	120	80	33	0.84	0.19	4.8	70	4.8	115	340	0.60	0.19	4.8
0.625	15.9	9-8211	133	80	22	0.56	0.19	4.8	70	4.8	115	340	0.75	0.19	4.8
0.750	19.1	9-8211	128	80	18	0.46	0.19	4.8	70	4.8	115	340	NR	NR	NR
0.875	22.2	9-8211	133	80	10	0.25	0.19	4.8	70	4.8	115	340	NR	NR	NR
1.000	25.4	9-8211	132	80	9	0.23	0.19	4.8	70	4.8	115	340	NR	NR	NR

Type Torch: SL60 With Exposed Tip							Type Material: Stainless Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.060	1.5	9-8211	120	80	340	8.64	0.25	6.4	70	4.8	115	340	0.00	0.25	6.4
0.120	3.0	9-8211	120	80	300	7.62	0.25	6.4	70	4.8	115	340	0.10	0.25	6.4
0.135	3.4	9-8211	120	80	280	7.11	0.25	6.4	70	4.8	115	340	0.10	0.25	6.4
0.188	4.8	9-8211	120	80	140	3.56	0.25	6.4	70	4.8	115	340	0.20	0.25	6.4
0.250	6.4	9-8211	120	80	100	2.54	0.25	6.4	70	4.8	115	340	0.30	0.25	6.4
0.375	9.5	9-8211	126	80	50	1.27	0.25	6.4	70	4.8	115	340	0.40	0.25	6.4
0.500	12.7	9-8211	129	80	28	0.71	0.25	6.4	70	4.8	115	340	0.80	0.25	6.4
0.625	15.9	9-8211	135	80	20	0.51	0.25	6.4	70	4.8	115	340	1.00	0.25	6.4
0.750	19.1	9-8211	143	80	10	0.25	0.25	6.4	70	4.8	115	340	NR	NR	NR
0.875	22.2	9-8211	143	80	9	0.23	0.25	6.4	70	4.8	115	340	NR	NR	NR
1.000	25.4	9-8211	146	80	8	0.20	0.25	6.4	70	4.8	115	340	NR	NR	NR

Type Torch: SL60 with Exposed Tip							Type Material: Aluminum								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.06	1.5	9-8211	120	80	350	8.89	0.25	6.4	70	4.8	115	340	0.00	0.25	6.4
0.12	3.0	9-8211	124	80	300	7.62	0.25	6.4	70	4.8	115	340	0.10	0.25	6.4
0.188	4.8	9-8211	124	80	180	4.57	0.25	6.4	70	4.8	115	340	0.20	0.25	6.4
0.250	6.4	9-8211	128	80	110	2.79	0.25	6.4	70	4.8	115	340	0.30	0.25	6.4
0.375	9.5	9-8211	136	80	55	1.40	0.25	6.4	70	4.8	115	340	0.40	0.25	6.4
0.500	12.7	9-8211	139	80	38	0.97	0.25	6.4	70	4.8	115	340	0.60	0.25	6.4
0.625	15.9	9-8211	142	80	26	0.66	0.25	6.4	70	4.8	115	340	0.75	0.25	6.4
0.750	19.1	9-8211	145	80	24	0.61	0.25	6.4	70	4.8	115	340	NR	NR	NR
0.875	22.2	9-8211	153	80	10	0.25	0.25	6.4	70	4.8	115	340	NR	NR	NR
1.000	25.4	9-8211	162	80	6	0.15	0.25	6.4	70	4.8	115	340	NR	NR	NR

**NOTE**

\* Gas pressure shown is for torches with leads up to 25' / 7.6 m long. For 50' / 15.2 m leads, set gas pressure to 70 psi / 4.8 bar.

\*\* Total flow rate includes plasma and secondary gas flow.

## 4T.09 Recommended Cutting Speeds for Mechanized Torch With Shielded Tip

Type Torch: SL60 With Shielded Tip							Type Material: Mild Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts (VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.036	0.9	9-8208	114	40	170	4.32	0.19	4.8	70	4.8	55	170	0.00	0.2	5.1
0.06	1.5	9-8208	120	40	90	2.29	0.19	4.8	70	4.8	55	170	0.10	0.2	5.1
0.075	1.9	9-8208	121	40	80	2.03	0.19	4.8	70	4.8	55	170	0.30	0.2	5.1
0.135	3.4	9-8208	122	40	75	1.91	0.19	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	123	40	30	0.76	0.19	4.8	70	4.8	55	170	0.60	0.2	5.1
0.25	6.4	9-8208	125	40	25	0.64	0.19	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	138	40	11	0.28	0.19	4.8	70	4.8	55	170	NR	NR	NR
0.500	12.7	9-8208	142	40	7	0.18	0.19	4.8	70	4.8	55	170	NR	NR	NR
0.625	15.9	9-8208	152	40	3	0.08	0.19	4.8	70	4.8	55	170	NR	NR	NR

Type Torch: SL60 With Shielded Tip							Type Material: Stainless Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.036	0.9	9-8208	109	40	180	4.57	0.125	3.2	70	4.8	55	170	0.00	0.2	5.1
0.05	1.3	9-8208	105	40	165	4.19	0.125	3.2	70	4.8	55	170	0.00	0.2	5.1
0.06	1.5	9-8208	115	40	120	3.05	0.125	3.2	70	4.8	55	170	0.10	0.2	5.1
0.078	2.0	9-8208	120	40	65	1.65	0.187	4.8	70	4.8	55	170	0.30	0.2	5.1
0.135	3.4	9-8208	125	40	25	0.64	0.187	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	132	40	20	0.51	0.187	4.8	70	4.8	55	170	0.60	0.2	5.1
0.25	6.4	9-8208	130	40	15	0.38	0.187	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	130	40	10	0.25	0.187	4.8	70	4.8	55	170	NR	NR	NR

Type Torch: SL60 With Shielded Tip							Type Material: Aluminum								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.032	0.8	9-8208	116	40	220	5.59	0.187	4.8	70	4.8	55	170	0.00	0.2	5.1
0.051	1.3	9-8208	116	40	210	5.33	0.187	4.8	70	4.8	55	170	0.00	0.2	5.1
0.064	1.6	9-8208	118	40	180	4.57	0.187	4.8	70	4.8	55	170	0.10	0.2	5.1
0.079	2.0	9-8208	116	40	150	3.81	0.19	4.8	70	4.8	55	170	0.30	0.2	5.1
0.125	3.2	9-8208	130	40	75	1.91	0.19	4.8	70	4.8	55	170	0.40	0.2	5.1
0.188	4.8	9-8208	132	40	60	1.52	0.187	4.8	70	4.8	55	170	0.60	0.2	5.1
0.250	6.4	9-8208	134	40	28	0.71	0.187	4.8	70	4.8	55	170	1.00	0.2	5.1
0.375	9.5	9-8208	143	40	11	0.28	0.187	4.8	70	4.8	55	170	NR	NR	NR

Type Torch: SL60 With Shielded Tip							Type Material: Mild Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts (VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.060	1.5	9-8210	124	60	250	6.35	0.19	4.8	75	5.2	90	245	0.00	0.2	5.1
0.075	1.9	9-8210	126	60	237	6.02	0.19	4.8	75	5.2	90	245	0.10	0.2	5.1
0.120	3.0	9-8210	126	60	230	5.84	0.19	4.8	75	5.2	90	245	0.10	0.2	5.1
0.135	3.4	9-8210	128	60	142	3.61	0.19	4.8	75	5.2	90	245	0.10	0.2	5.1
0.188	4.8	9-8210	128	60	125	3.18	0.19	4.8	75	5.2	90	245	0.20	0.2	5.1
0.250	6.4	9-8210	123	60	80	2.03	0.19	4.8	75	5.2	90	245	0.30	0.2	5.1
0.375	9.5	9-8210	132	60	34	0.86	0.19	4.8	75	5.2	90	245	0.50	0.2	5.1
0.500	12.7	9-8210	137	60	23	0.58	0.19	4.8	75	5.2	90	245	0.75	0.2	5.1
0.625	15.9	9-8210	139	60	14	0.36	0.19	4.8	75	5.2	90	245	NR	NR	NR
0.750	19.1	9-8210	145	60	14	0.36	0.19	4.8	75	5.2	90	245	NR	NR	NR
1.000	25.4	9-8210	156	60	4	0.10	0.19	4.8	75	5.2	90	245	NR	NR	NR

Type Torch: SL60 With Shielded Tip							Type Material: Stainless Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.06	1.5	9-8210	110	60	165	4.19	0.13	3.2	75	5.2	90	245	0.00	0.20	5.1
0.075	1.9	9-8210	116	60	155	3.94	0.13	3.2	75	5.2	90	245	0.10	0.20	5.1
0.120	3.0	9-8210	115	60	125	3.18	0.13	3.2	75	5.2	90	245	0.10	0.20	5.1
0.135	3.4	9-8210	118	60	80	2.03	0.13	3.2	75	5.2	90	245	0.10	0.20	5.1
0.188	4.8	9-8210	120	60	75	1.91	0.13	3.2	75	5.2	90	245	0.20	0.20	5.1
0.250	6.4	9-8210	121	60	60	1.52	0.13	3.2	75	5.2	90	245	0.30	0.20	5.1
0.375	9.5	9-8210	129	60	28	0.71	0.13	3.2	75	5.2	90	245	0.50	0.20	5.1
0.500	12.7	9-8210	135	60	17	0.43	0.19	4.8	75	5.2	90	245	0.75	0.20	5.1
0.625	15.9	9-8210	135	60	14	0.36	0.19	4.8	75	5.2	90	245	NR	NR	NR
0.750	19.1	9-8210	142	60	10	0.25	0.19	4.8	75	5.2	90	245	NR	NR	NR

Type Torch: SL60 With Shielded Tip							Type Material: Aluminum								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.060	1.5	9-8210	105	60	350	8.89	0.13	3.2	75	5.2	90	245	0.00	0.20	5.1
0.075	1.9	9-8210	110	60	350	8.89	0.13	3.2	75	5.2	90	245	0.10	0.20	5.1
0.120	3.0	9-8210	110	60	275	6.99	0.13	3.2	75	5.2	90	245	0.10	0.20	5.1
0.188	3.4	9-8210	122	60	140	3.56	0.13	3.2	75	5.2	90	245	0.20	0.20	5.1
0.250	6.4	9-8210	134	60	80	2.03	0.19	4.8	75	5.2	90	245	0.30	0.20	5.1
0.375	9.5	9-8210	140	60	45	1.14	0.19	4.8	75	5.2	90	245	0.50	0.20	5.1
0.500	12.7	9-8210	144	60	26	0.66	0.19	4.8	75	5.2	90	245	0.80	0.20	5.1
0.625	15.9	9-8210	145	60	19	0.48	0.19	4.8	75	5.2	90	245	NR	NR	NR
0.750	19.1	9-8210	150	60	15	0.38	0.19	4.8	75	5.2	90	245	NR	NR	NR

Type Torch: SL60 With Shielded Tip							Type Material: Mild Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.060	1.5	9-8211	128	80	280	7.11	0.19	4.8	70	4.8	115	340	0.00	0.2	5.1
0.120	3.0	9-8211	126	80	203	5.16	0.19	4.8	70	4.8	115	340	0.10	0.2	5.1
0.135	3.4	9-8211	128	80	182	4.62	0.19	4.8	70	4.8	115	340	0.10	0.2	5.1
0.188	4.8	9-8211	128	80	137	3.48	0.19	4.8	70	4.8	115	340	0.20	0.2	5.1
0.250	6.4	9-8211	131	80	100	2.54	0.19	4.8	70	4.8	115	340	0.30	0.2	5.1
0.375	9.5	9-8211	134	80	40	1.02	0.19	4.8	70	4.8	115	340	0.50	0.2	5.1
0.500	12.7	9-8211	136	80	36	0.91	0.19	4.8	70	4.8	115	340	0.60	0.2	5.1
0.625	15.9	9-8211	145	80	21	0.53	0.19	4.8	70	4.8	115	340	0.75	0.2	5.1
0.750	19.1	9-8211	144	80	14	0.36	0.19	4.8	70	4.8	115	340	NR	NR	NR
0.875	22.2	9-8211	149	80	11	0.28	0.19	4.8	70	4.8	115	340	NR	NR	NR
1.000	25.4	9-8211	162	80	8	0.20	0.19	4.8	70	4.8	115	340	NR	NR	NR

Type Torch: SL60 With Shielded Tip							Type Material: Stainless Steel								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.060	1.5	9-8211	110	80	340	8.50	0.125	3.2	70	4.8	115	340	0.00	0.2	5.1
0.120	3.0	9-8211	115	80	260	6.50	0.125	3.2	70	4.8	115	340	0.10	0.2	5.1
0.135	3.4	9-8211	113	80	250	6.25	0.125	3.2	70	4.8	115	340	0.10	0.2	5.1
0.188	4.8	9-8211	114	80	170	4.25	0.125	3.2	70	4.8	115	340	0.20	0.2	5.1
0.250	6.4	9-8211	116	80	85	2.13	0.125	3.2	70	4.8	115	340	0.30	0.2	5.1
0.375	9.5	9-8211	123	80	45	1.13	0.125	3.2	70	4.8	115	340	0.40	0.25	6.4
0.500	12.7	9-8211	133	80	18	0.45	0.125	3.2	70	4.8	115	340	0.75	0.25	6.4
0.625	15.9	9-8211	135	80	16	0.40	0.125	3.2	70	4.8	115	340	1.00	0.25	6.4
0.750	19.1	9-8211	144	80	8	0.20	0.125	3.2	70	4.8	115	340	NR	NR	NR
0.875	22.2	9-8211	137	80	8	0.20	0.125	3.2	70	4.8	115	340	NR	NR	NR
1.000	25.4	9-8211	140	80	8	0.20	0.125	3.2	70	4.8	115	340	NR	NR	NR

Type Torch: SL60 With Shielded Tip							Type Material: Aluminum								
Type Plasma Gas: Air							Type Secondary Gas: Single Gas Torch								
Thickness		Tip	Output	Amperage	Speed (Per Minute)		Standoff		Plasma Gas Press		Flow (CFH)		Pierce	Pierce Height	
Inches	mm	(Cat. No.)	Volts(VDC)	(Amps)	Inches	Meters	Inches	mm	psi*	bar	Plasma	Total**	Delay (Sec)	Inches	mm
0.06	1.5	9-8211	115	80	320	8.13	0.13	3.2	70	4.8	115	340	0.00	0.25	6.4
0.12	3.0	9-8211	120	80	240	6.10	0.13	3.2	70	4.8	115	340	0.10	0.25	6.4
0.188	4.8	9-8211	120	80	165	4.19	0.13	3.2	70	4.8	115	340	0.20	0.25	6.4
0.250	6.4	9-8211	124	80	100	2.54	0.13	3.2	70	4.8	115	340	0.30	0.25	6.4
0.375	9.5	9-8211	138	80	60	1.52	0.19	4.8	70	4.8	115	340	0.40	0.25	6.4
0.500	12.7	9-8211	141	80	36	0.91	0.19	4.8	70	4.8	115	340	0.60	0.25	6.4
0.625	15.9	9-8211	142	80	26	0.66	0.19	4.8	70	4.8	115	340	0.75	0.25	6.4
0.750	19.1	9-8211	150	80	18	0.46	0.19	4.8	70	4.8	115	340	NR	NR	NR
0.875	22.2	9-8211	156	80	8	0.20	0.19	4.8	70	4.8	115	340	NR	NR	NR
1.000	25.4	9-8211	164	80	6	0.15	0.19	4.8	70	4.8	115	340	NR	NR	NR

**NOTE**

\* Gas pressure shown is for torches with leads up to 25' / 7.6 m long. For 50' / 15.2 m leads, set gas pressure to 70 psi / 4.8 bar.

\*\* Total flow rate includes plasma and secondary gas flow.