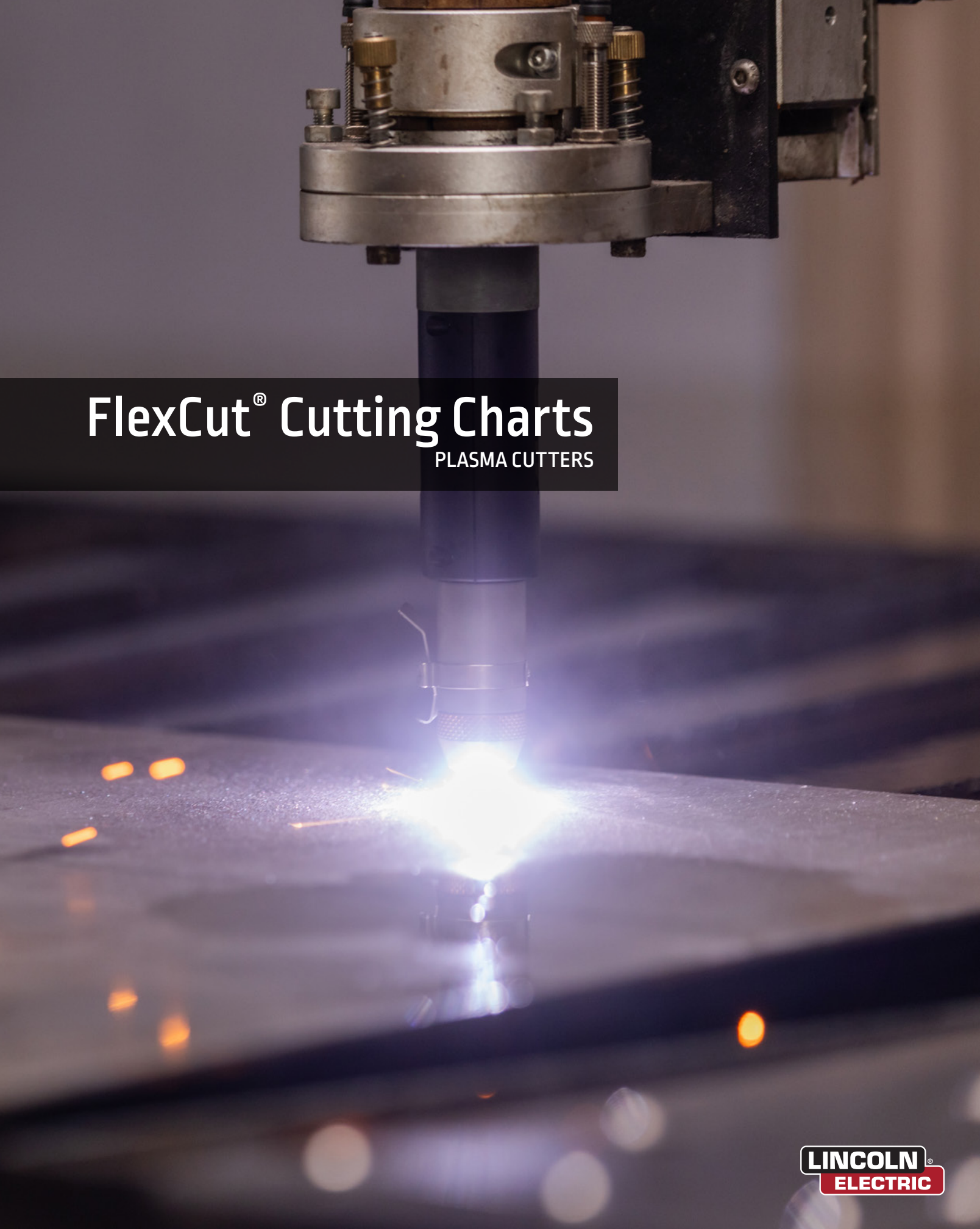
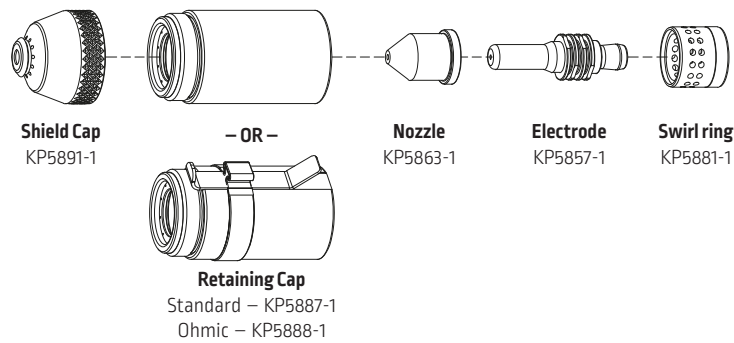




FlexCut[®] Cutting Charts

PLASMA CUTTERS

45 Amps Mechanized



45A MILD STEEL (FlexCut 45)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
26 GA [0.0179]	75	0.120	0.150	0	375	136	510	135	0.040	
22 GA [0.0299]					375	129	475	129	0.030	
18 GA [0.0478]					375	130	450	130	0.030	
16 GA [0.0598]					350	130	385	130	0.034	
14 GA [0.0747]				0.2	285	132	325	132	0.036	
12 GA [0.1046]				0.3	190	132	210	132	0.037	
10 GA [0.1345]				0.4	120	134	160	133	0.040	
3/16				0.5	95	133	120	133	0.044	
1/4				0.7	54	136	74	134	0.058	
3/8				1.0	34	140	38	138	0.066	
1/2				1.5	17	149	18	148	0.075	
5/8			0.120	1.0	10	154	13	151	0.075	Y
3/4					8	157	8	157	0.077	
7/8					5	159	5	159	0.084	
1					4	162	4	162	0.087	

Gas Flow Rate - SCFH

472 Hot (cutflow)
521 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

45A STAINLESS STEEL (FlexCut 45)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
26 GA [0.0187]	75	0.120	0.150	0	350	146	510	146	0.040	
22 GA [0.0312]					350	136	475	134	0.030	
18 GA [0.0500]					350	138	410	136	0.030	
16 GA [0.0625]				0.1	350	134	405	133	0.060	
14 GA [0.0781]				0.2	250	133	300	132	0.060	
12 GA [0.1094]					145	130	155	129	0.060	
10 GA [0.1406]					100	133	134	132	0.060	
3/16					50	135	60	137	0.060	
1/4				0.8	30	140	40	139	0.070	
3/8				0.8	22	142	24	141	0.070	
1/2			0.180	2.5	12	149	16	145	0.070	
5/8				1.0	8	150	12	144	0.070	Y
3/4					6	152	8	149	0.090	
7/8					5	154	6	152	0.090	

Gas Flow Rate - SCFH

543 Hot (cutflow)
565 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

45A ALUMINUM (FlexCut 45)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/32 GA [0.0313]	75	0.120	0.150	0	400	131	490	128	0.070	
1/16 GA [0.0625]				0.1	325	131	410	128	0.075	
3/32 GA [0.0938]					185	136	315	131	0.055	
1/8					180	133	208	130	0.050	
1/4				0.4	60	138	75	137	0.060	
3/8			0.120	1.0	36	145	40	143	0.070	Y
1/2					18	151	22	146	0.070	
5/8				1.5	13	157	14	156	0.070	
3/4					5	167	6	166	0.090	

Gas Flow Rate - SCFH

539 Hot (cutflow)

590 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

45A MILD STEEL (FlexCut 65-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
26 GA [0.0179]	75	0.12	0.15	0	375	129	510	129	0.040	
22 GA [0.0299]						134	475	134	0.030	
18 GA [0.0478]						132	450	131	0.028	
16 GA [0.0598]				0.1	350	133	385	133	0.032	
14 GA [0.0747]				0.2	285		325		0.040	
12 GA [0.1046]				0.3	190		210		0.045	
10 GA [0.1345]				0.4	120	134	160		0.040	
3/16				0.5	95		110		0.052	
1/4				0.7	54		65	136	0.062	

Gas Flow Rate - SCFH

472 Hot (cutflow)

520 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

45A STAINLESS STEEL (FlexCut 65-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
26 GA [0.0187]	75	0.12	0.15	0	350	146	510	146	0.040	
22 GA [0.0312]					350	136	475	134	0.030	
18 GA [0.0500]					350		410	136		
16 GA [0.0625]				0.1	350	134	405	133	0.060	
14 GA [0.0781]				0.2	250	133	285	134		
12 GA [0.1094]					145	130	155	129		
10 GA [0.1406]				0.4	100	133	134	133		
3/16				0.5	50	142	60	140		
1/4				0.8	35	140	45	139	0.070	

Gas Flow Rate - SCFH

543 Hot (cutflow)

565 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

45A ALUMINUM (FlexCut 65-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height		Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
			in	%		Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	%	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/32	75	0.12	0.15	125%	0	400	131	490	128	0.070	
1/16					0.1	325	135	410	132	0.075	
3/32						185	136	315	135	0.055	
1/8						180	137	208			
1/4					0.4	60	143	75	142	0.060	

Gas Flow Rate - SCFH

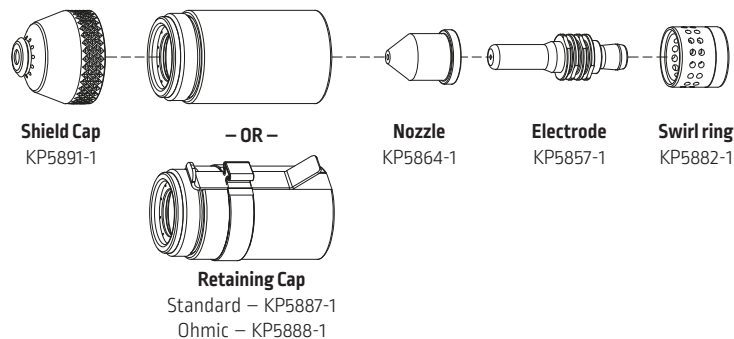
539 Hot (cutflow)

590 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

65 Amps Mechanized



65A MILD STEEL (FlexCut 65-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start	
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage			
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in		
10 GA [0.1345]	75	0.120	0.160	0.2	191	122	210	124	0.053		
3/16					140	126	165		0.055		
1/4				0.5	85		100	125	0.060		
3/8			0.180	0.7	44	131	60	129	0.066		
1/2				1.0	30	134	37	131	0.075		
5/8				2.0	20	142	24	138	0.083	Y	
3/4			0.200		13	145	16	141	0.085		
7/8					10	149	12	147	0.090		
1					8	150	10	147	0.095		

Gas Flow Rate - SCFH

459 Hot (cutflow)

522 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

65A STAINLESS STEEL (FlexCut 65-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
10 GA [0.1406]	75	0.120	0.150	0.1	230	126	250	124	0.048	
3/16				0.2	130	130	145	129	0.055	
1/4			0.200	0.4	65	129	80	127	0.070	
3/8				0.6	37	136	44	134	0.075	
1/2				1.2	20	141	26	138	0.083	
5/8			0.250	2.0	16	138	18	137	0.088	
3/4				1.5	14	143	15	142	0.090	Y

Gas Flow Rate - SCFH

459 Hot (cutflow)

522 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

65A ALUMINUM (FlexCut 65-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/16	75	0.120	0.120	0.1	430	147	480	148	0.067	
1/8			0.200	0.1	240	137	300	132	0.059	
1/4				0.4	90	136	120	134	0.700	
3/8				0.5	54	141	70	139	0.073	
1/2				0.8	37	145	49	141	0.076	
5/8			0.250	2.0	27	141	33	139	0.080	
3/4			0.200	1.5	18	146	23	145	0.085	Y

Gas Flow Rate - SCFH

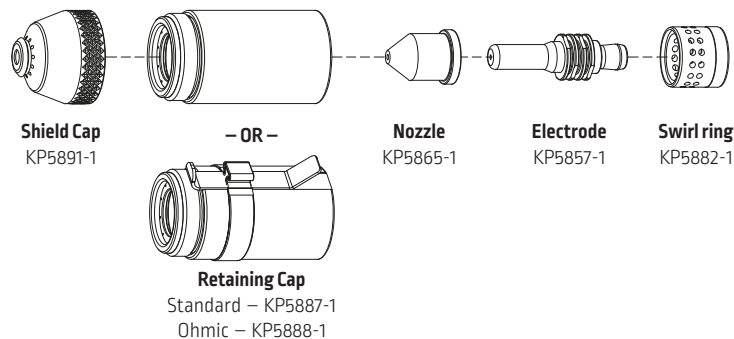
459 Hot (cutflow)

522 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

85 Amps Mechanized



85A MILD STEEL (FlexCut 85-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
10 GA [0.1345]	80	0.120	0.150	0.100	240	125	280	124	0.050	
3/16				0.200	170	124	190	124	0.059	
1/4				0.500	120	125	140	124	0.062	
3/8					75	128	87	127	0.067	
1/2			0.200	0.800	46	136	55	135	0.073	
5/8					35	135	39	133	0.078	
3/4				1.000	25	143	28	141	0.090	
7/8					20	141	22	140	0.090	
1					13	145	16	143	0.090	Y
1-1/4					6	157	8	154	0.112	

Gas Flow Rate - SCFH

545 Hot (cutflow)
624 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

85A STAINLESS STEEL (FlexCut 85-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
10 GA [0.1406]	80	0.120	0.150	0.2	285	124	345	123	0.050	
3/16					210	130	250	129	0.055	
1/4				0.4	120	127	150	125	0.067	
3/8					60	131	70	129	0.080	
1/2			0.200	0.7	32	135	38	133		0.086
5/8				1.2	24	137	30	136	0.090	
3/4			0.200		18	142	21	140		
7/8			1.5	15	144	17	142			
1				12	146	13	142			

Gas Flow Rate - SCFH

545 Hot (cutflow)
624 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

85A ALUMINUM (FlexCut 85-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/8	80	0.120	0.150	0.2	310	129	360	127	0.065	
1/4				0.5	140	132	175	131	0.078	
3/8					84	136	105	134		
1/2			0.200	1.0	54	141	68	138	0.080	
5/8					40	144	50	141	0.085	
3/4				30	146	37	144	0.088		Y
7/8				23	147	26	145			
1			1.2	16	153	20	151	0.093		

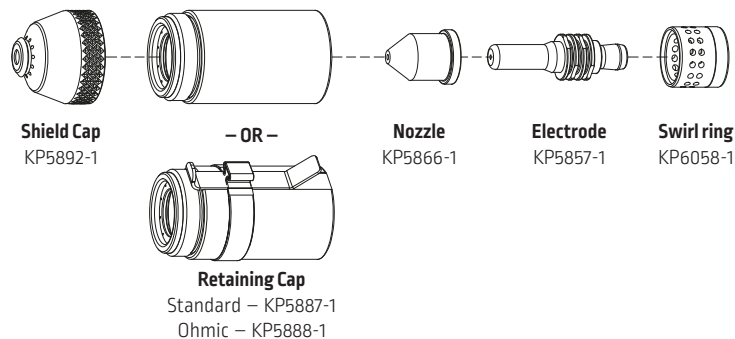
Gas Flow Rate - SCFH

545 Hot (cutflow)
624 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

105 Amps Mechanized



105A MILD STEEL (FlexCut 105-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/4	80	0.120	0.240	0.4	150	138	170	137	0.070	
3/8				0.7	90	141	111	140	0.079	
1/2				0.8	65	142	75	141	0.087	
5/8				1.0	41	146	50	144	0.094	
3/4				1.0	30	149	36	146	0.100	
7/8				1.3	25	151	29	149	0.103	
1				1.5	19	156	20	152	0.105	Y
1-1/4				1.5	13	163	14	162	0.117	
1-1/2				1.5	9	167	10	164	0.130	

Gas Flow Rate - SCFH

490 Hot (cutflow)
604 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

105A STAINLESS STEEL (FlexCut 105-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/4	80	0.180	0.300	0.4	170	146	210	144	0.064	
3/8					80	147	100	145	0.084	
1/2					48	149	60	148	0.094	
5/8					32	152	45	149	0.104	
3/4				1.3	26	153	32	151	0.105	
7/8				1.5	22	154	24	152		Y
1					16	164	19	162		
1-1/4					12	171	13	170		

Gas Flow Rate - SCFH

490 Hot (cutflow)
604 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

105A ALUMINUM (FlexCut 105-125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/4	80	0.180	0.300	0.4	175	145	220	144	0.090	
3/8				0.8	105	150	130	148	0.092	
1/2				1.0	66	153	85	150	0.096	
5/8					50	155	65	152	0.100	
3/4				1.3	41	158	48	155	0.103	
7/8				1.5	34	160	40		0.105	Y
1					25	164	28		0.108	
1-1/4					15	176	16		0.110	

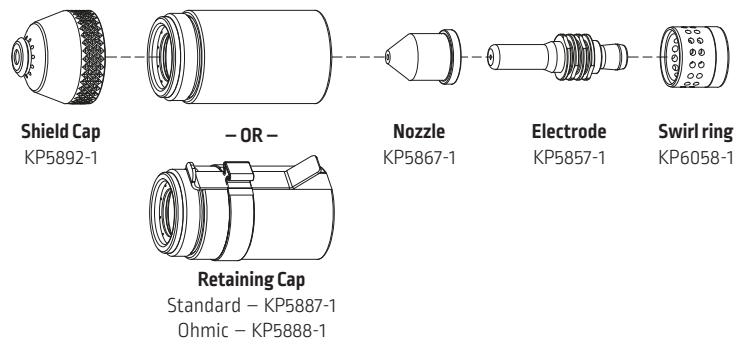
Gas Flow Rate - SCFH

490 Hot (cutflow)
604 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

125 Amps Mechanized



125A MILD STEEL (FlexCut 125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/4	80	0.120	0.200	0.2	136	139	170	138	0.088	
3/8				0.4	100	140	124	139	0.090	
1/2					75	139	88	138		
5/8			0.400	0.5	50	144	60	142	0.105	
3/4				0.6	45	141	48			
7/8				1.2	35	145	38	144	0.100	
1				2.0	24	149	30	147	0.105	
1-1/4			0.200	1.5	16	153	20	150	0.115	Y
1-1/2				1.5	11	161	13	159	0.128	

Gas Flow Rate - SCFH

529 Hot (cutflow)
652 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

125A STAINLESS STEEL (FlexCut 125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start	
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage			
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in		
1/4	80	0.120	0.300	0.2	195	135	244	135	0.068		
3/8					125		156	134	0.085		
1/2					61	143	76	141	0.095		
5/8			0.400	0.7	48	146	60	145			
3/4					1.2	35	147	43	147	0.110	
7/8					2.0	26	150	32	148		
1			0.200	1.5		18	157	22	154	0.112	Y
1-1/4						11	160	18		0.119	
1-1/2						9	165	14	157		

Gas Flow Rate - SCFH

529 Hot (cutflow)
652 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

125A ALUMINUM (FlexCut 125)

Material Thickness	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Production Settings		Kerf Width	Edge Start
					Cut Speed	Arc Voltage	Cut Speed	Arc Voltage		
in	psi	in	in	seconds	(in/min)	Volts	(in/min)	Volts	in	
1/4	80	0.120	0.240	0.1	175	141	260	137	0.094	
3/8				0.3	112	146	150	140	0.096	
1/2				0.4	75	149	110	143	0.098	
5/8				0.6	55	151	77	146	0.104	
3/4				0.8	40	152	60	148	0.110	
7/8		0.180	0.400	1.5	33	165	40	155	0.111	
1				2.0	26	174	38	163	0.113	
1-1/4				1.0	16	181	25	175	0.115	Y
1-1/2					13	184	16	179	0.118	

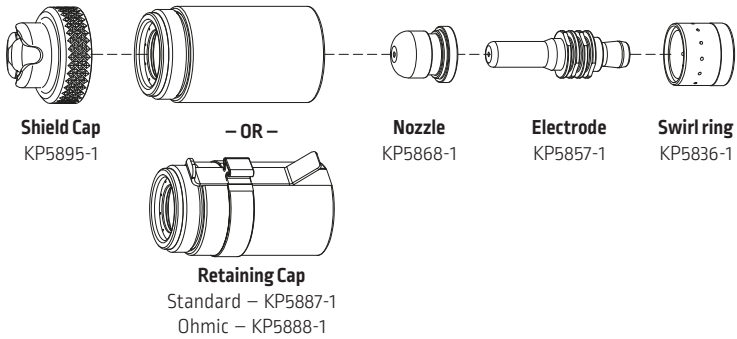
Gas Flow Rate - SCFH

529 Hot (cutflow)
652 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Production: Optimized for increased output (faster cut speed), with reduced cut quality when compared to Best Quality.

Precision



45A MILD STEEL - Precision Cut (FlexCut 45-125)

Material Thickness	Amperage	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Kerf Width	Edge Start
						Cut Speed	Arc Voltage		
in	A	psi	in	in	seconds	(in/min)	Volts	in	
26 GA (0.0179)	40	75	0.08	0.15	0.1	350	80	0.025	
24GA [0.0239]								0.028	
22 GA (0.0299)					0.2		75	0.030	
20GA (0.0359)								0.035	
18 GA (0.0478)	45				250	80	0.040		
16 GA (0.0598)								85	
14 GA (0.0747)					120				
12 GA (0.1046)						95	0.050		
10 GA (0.1345)									

Gas Flow Rate - SCFH

504 Hot (cutflow)
526 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

45A STAINLESS STEEL - Precision Cut (FlexCut 45-125)

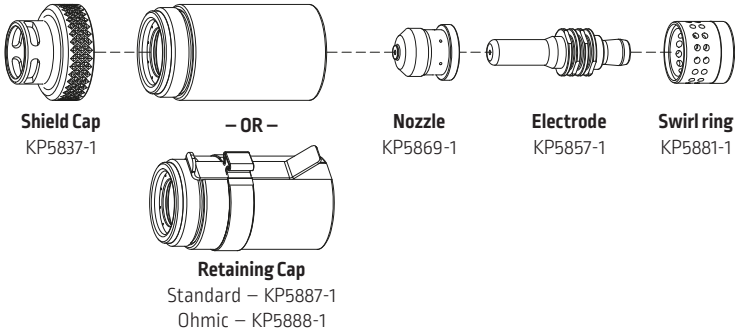
Material Thickness	Amperage	Pressure	Cut Height	Initial Pierce Height	Pierce Delay	Best Quality Settings		Kerf Width	Edge Start		
						Cut Speed	Arc Voltage				
in	A	psi	in	in	seconds	(in/min)	Volts	in			
26 GA (0.0187)	40	75	0.06	0.15	0.1	375	83	0.030			
24GA (0.0250)											
22 GA (0.0312)											
20GA (0.0375)											
18 GA (0.0500)	45						0.2	325	78	0.025	
16 GA (0.0625)											
14 GA (0.0781)											
12 GA (0.1094)											
10 GA (0.1406)											

Gas Flow Rate - SCFH

504 Hot (cutflow)
526 Cold (postflow)

Best Quality: Optimized starting point for less bevel angle, minimal dross, and smooth cut face. Small adjustments may be needed to achieve the best cut quality for your system.

Marking



FlexCut Marking Parameters

	Amp	Cut Height (in)	Pressure (PSI)	Expected Material Removal (in)
FlexCut 45	15	0.1	75	0.001
FlexCut 65	20	0.25		0.002
FlexCut 85	25			0.004
FlexCut 105	30	0.25	80	0.005
FlexCut 125				

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