

GPN, GPNL, HPN

Metal Thickness	Tip Size	Cutting Oxygen (PSIG)	Preheat Oxygen (PSIG)*	Preheat Fuel Gas (PSIG)	Speed I.P.M.	Kerf width
1/8"	000	20/25	See Below	3/5	24/28	.04
1/4"	00	20/25		3/5	21/25	.05
3/8"	0	25/30		3/5	20/24	.06
1/2"	0	30/35		3/5	18/22	.06
3/4"	1	30/35		3/6	15/20	.08
1"	2	35/40		3/6	14/18	.09
1 1/2"	2	40/45		5/9	12/16	.09
2"	3	40/45		5/9	10/14	.10
2 1/2"	3	45/50		6/10	9/12	.10
3"	4	40/50		8/12	8/11	.12
4"	5	45/55		8/12	7/10	.14
5"	5	50/55		8/12	6/9	.14
6"	6**	45/55		10/15	5/7	.17
8"	6**	55/65		10/15	4/6	.18
12"	8**	60/70		10/15	3/5	.24



* Applicable for 3-hose machine cutting torches only. With a 2-hose cutting torch, preheat pressure is set by the cutting oxygen.
 ** For best results use appropriate capacity torches and 3/8" hose when using tip size 6 or larger. Torches with flashback arrestors require up to 25% more pressure as tip size increases (15 PSI maximum acetylene pressure). *** All pressures are measured at the regulator using a 25' X 1/4" hose through tip size 5 and 25' X 3/8" hose for tip size 6 and larger.