

GPP

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	For 3-Hose Machine Torches Only See Table On Reverse Side	2/5	24/28	.04
1/4"	00	20/25		2/5	21/25	.05
3/8"	0	25/30		3/5	20/24	.06
1/2"	0	25/35		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		4/8	12/16	.09
2"	3	40/45		4/8	10/14	.10
2 1/2"	3	45/50		5/9	9/12	.10
3"	4	40/50		6/9	8/11	.12
4"	5	45/55		6/9	7/10	.14
5"	5	50/55		6/10	6/9	.14
6"	6 ^{**}	45/55		6/10	5/7	.17
8"	6 ^{**}	55/65		8/12	4/6	.18
10"	7 ^{**}	55/65		8/12	3/5	.34
12"	8 ^{**}	60/70		10/14	3/4	.41
15"	10 ^{**}	50/70		10/16	2/4	--
18"	12 ^{**}	45/65		--	2/3	--



* 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 3/8" hose for tip size 6 and larger.

MTHP High speed machine cutting

Metal Thickness	Tip Size	Cutting Oxygen (PSIG) ^{***}	Preheat Oxygen (PSIG) [*]	Preheat Fuel Gas (PSIG)	Speed I.P.M.	Kerf width
1/4"	00	85/95	See Below	See Below	23/30	.05
3/8"	00				22/29	.05
1/2"	0				20/28	.06
3/4"	0				18/26	.06
1"	1				17/24	.07
1 1/4"	1				16/20	.07
1 1/2"	1				12/16	.07
2"	2				11/15	.09
2 1/2"	2				10/13	.09
3"	2				9/11	.09
4"	3				7/10	.11
5"	3				6/8	.11
6"	3				5/7	.11
7"	4				5/6	.14
8"	4				4/6	.14
9"	5				4/5	.18
10"	5				3/5	.18



NOTE: The above data applies to all torches with the following exceptions:

Torch Series	Preheat Oxygen	Preheat Fuel
MT200N Series	N/A	8 oz. – up
MT300N Series	10-25 PSIG	8 oz. – up

NOTE: These speeds and pressure settings apply only to mild steel in good condition. Torches with flashback arrestors require up to 25% more pressure as tip size increases.

CAUTION: High gas withdrawal rates may require cylinder manifolding. Consult your gas supplier.