

Standard Condition(4w)

Up date 2-19-03,latest cutting data 022203.jkf

Assist Gas	Material	Thickness (inches)	Material info	Cutting Head	Lens (inches)	Nozzle	Pierce Type	
Oxygen	Cold Rolled Steel	0.036	Std	HS-Head ↓	5.0 ↓	1.2 Single ↓	M103A6 ↓	
		0.048	Std					
		0.060	Std					
		0.075	Std					
		0.105	Std					
		0.119	Std					
	Hot Rolled Steel	0.134	Thick		7.5 ↓	1.4 Double ↓		M103A7 ↓
		0.187	Thick					
		0.250	Thick					
		0.312	Thick					
		0.375	Thick					
		0.500	Thick					
		0.500Ws	Thick	2.5 Double (WACS) ↓	M103A3 M105X Y ↓			
0.625Ws	Thick							
0.750Ws	Thick							
0.866Ws	Thick	3.8 Double (WACS) ↓						
1.000Ws	Thick							
Nitrogen (EZ-CUT)	Cold Rolled Steel	0.036	Std	HS-Head ↓	5.0 ↓	2.0 Single ↓	M103A6 ↓	
		0.048	Std					
		0.060	Std					
		0.075	Std					
		0.105	Std					
		0.119	Std					
	Hot Rolled Steel	0.187	Clean		7.5 ↓	4.0 Double ↓	M103A3B0.05	
		0.250	Clean					
Nitrogen (EZ-CUT)	Stainless Steel	0.036	Std		5.0 ↓	2.0 Single ↓	M103A6 ↓	
		0.048	Std					
		0.060	Std			3.0 Single ↓		
		0.075	Std					
		0.119	Std					
		0.134	Std					
		0.187	Clean		7.5 ↓	4.0 Double ↓		M103A3B0.05
		0.250	Clean					
		0.312	Clean					
		0.375	Clean					
(0.500)	Clean	10.0						
Nitrogen (EZ-CUT)	Aluminum	0.036	Std		5.0 ↓	2.0 Single ↓	M103A6 ↓	
		0.060	Std					
		0.075	Std					
		0.119	Std					
		0.157	Alumi		7.5 ↓	4.0 Double ↓	M103A3B0.05 ↓	
		0.197	Alumi					
		0.250	Alumi					
		0.312	Alumi					
0.375	Alumi							

Notes:

Maximum recommended material thickness

HRS - 0.750

SS - 0.375

AL - 0.375

EZ CUT Maximum recommended material thickness

HRS - 0.187

SS - 0.187

AL - 0.157