

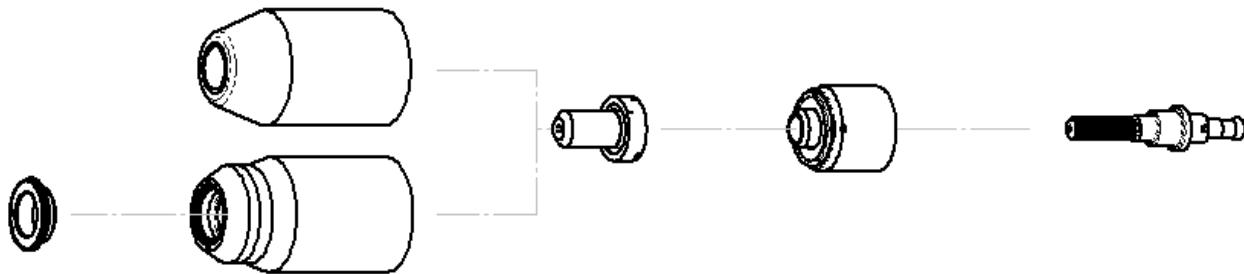
CUTMASTER A40

4T.08 RECOMMENDED CUTTING SPEEDS FOR MACHINE AND AUTOMATED TORCHES WITH EXPOSED TIP

Mild Steel

40A

Air Plasma / Air Shield



Deflector			Standard Shield Cup Maximum Life Shield Cup		Tip	Starter Cartridge Heavy Duty Starter Cartridge		Electrode	
9-8243			9-8218 9-8237		9-8208	9-8213 9-8277		9-8232	
Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)
20		0.036	70 (25') 75 (50')	101	0.14	160	0.18	0.0	0.05
16		0.060		103	0.14	140	0.18	0.0	0.05
14		0.075		105	0.14	120	0.18	0.1	0.06
12		0.105		108	0.14	80	0.18	0.2	0.06
10		0.135		110	0.14	60	0.18	0.3	0.06
	3/16	0.188		111	0.14	55	0.18	0.4	0.06
	1/4	0.250		117	0.14	40	0.18	0.5	0.07
	3/8	0.375		119	0.14	25	0.18	1.2	0.07
	1/2	0.500		120	0.14	15	0.2	2.0	0.07

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	4.8 (7.6m) 5.2 (15.2m)	101	3.6	3990	4.6	0.0	1.1
2		105	3.6	2920	4.6	0.1	1.4
3		109	3.6	1810	4.6	0.3	1.5
4		110	3.6	1470	4.6	0.3	1.6
5		112	3.6	1345	4.6	0.4	1.6
6		116	3.6	1100	4.6	0.5	1.7
8		118	3.6	815	4.6	1.0	1.7
10		119	3.6	595	4.6	1.5	1.8
12		120	3.6	435	5.1	2.0	1.8

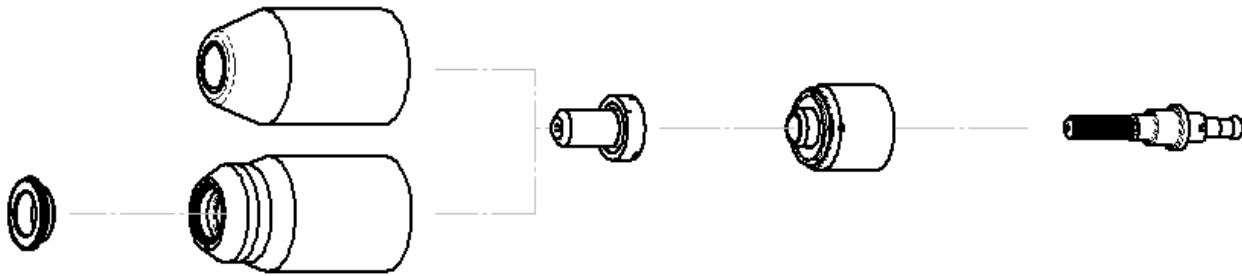
BOLD TYPE indicates maximum piercing parameters.

CUTMASTER A40

Stainless Steel

40A

Air Plasma / Air Shield



Deflector	Standard Shield Cup Maximum Life Shield Cup	Tip	Starter Cartridge Heavy Duty Starter Cartridge	Electrode
9-8243	9-8218 9-8237	9-8208	9-8213 9-8277	9-8232

Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)
18		0.050	75 (25') 80 (50')	110	0.19	60	0.20	0.00	0.07
16		0.063		100	0.19	50	0.20	0.00	0.07
14		0.078		105	0.19	45	0.20	0.10	0.07
12		0.109		110	0.19	40	0.20	0.20	0.07
10		0.141		108	0.19	35	0.20	0.30	0.07
	3/16	0.188		110	0.19	30	0.20	0.40	0.07
	1/4	0.250		120	0.19	18	0.20	0.50	0.08
	3/8	0.375		126	0.19	10	0.20	2.00	0.08
	1/2	0.500		118	0.19	8	<i>Edge start</i>		0.09

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.2 (7.6) 5.5 (15.2)	112	4.8	1670	4.8	0.0	1.7
2		105	4.8	1140	5.1	0.1	1.8
3		109	4.8	980	5.1	0.2	1.8
4		109	4.8	845	5.1	0.3	1.8
5		111	4.8	715	5.1	0.4	1.8
6		118	4.8	525	5.1	0.5	2.0
8		123	4.8	350	5.1	1.5	2.0
10		125	4.8	245	5.1	2.0	2.0
12		120	4.8	215	<i>Edge Start</i>		2.2

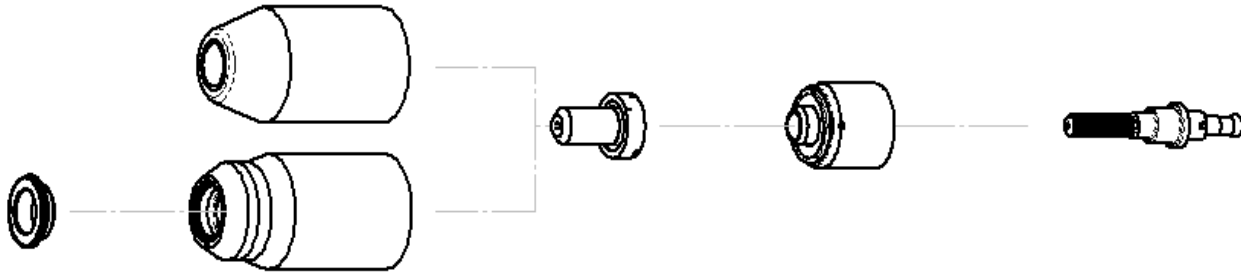
BOLD TYPE indicates maximum piercing parameters. **BOLD ITALIC** indicates edge starts only.

CUTMASTER A40

Aluminum

40A

Air Plasma / Air Shield



Deflector	Standard Shield Cup Maximum Life Shield Cup	Tip	Starter Cartridge Heavy Duty Starter Cartridge	Electrode
9-8243	9-8218 9-8237	9-8208	9-8213 9-8277	9-8232

Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)
20		0.040	70 (25') 75 (50')	95	0.16	300	0.16	0.0	0.06
16		0.063		97	0.16	170	0.16	0.0	0.06
12		0.097		113	0.16	100	0.16	0.2	0.07
11		0.125		115	0.16	90	0.18	0.3	0.07
9		0.160		113	0.18	85	0.18	0.4	0.07
	3/16	0.188		116	0.18	75	0.18	0.5	0.07
	1/4	0.250		128	0.18	30	0.18	1.0	0.08
	3/8	0.375		150	0.18	10	<i>Edge Start</i>		0.09

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1.0	4.8 (7.6m) 5.2 (15.2m)	95	4.1	7620	4.1	0.0	1.5
2.0		104	4.1	3500	4.1	0.2	1.6
3.0		115	4.1	2350	4.6	0.3	1.7
4.0		113	4.6	2170	4.6	0.4	1.7
5.0		118	4.6	1740	4.6	0.5	1.8
6.0		125	4.6	1015	4.6	0.8	1.9
8.0		139	4.6	500	<i>Edge Start</i>		2.0
10.0		153	4.6	180	<i>Edge Start</i>		2.2

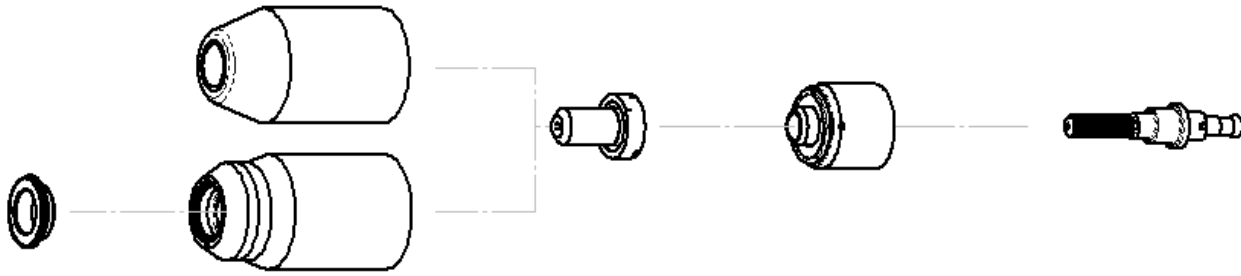
BOLD TYPE indicates maximum piercing parameters. **BOLD ITALIC** indicates edge starts only.

CUTMASTER A40

Mild Steel

60A

Air Plasma / Air Shield



Deflector			Standard Shield Cup Maximum Life Shield Cup		Tip	Starter Cartridge Heavy Duty Starter Cartridge		Electrode		
9-8243			9-8218 9-8237		9-8210	9-8213 9-8277		9-8232		
Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed	
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)	
16		0.060	85 (25')	118	0.19	290	0.19	0.00	0.08	
14		0.075		120	0.19	285	0.19	0.10	0.08	
11		0.120		118	0.19	180	0.19	0.10	0.08	
10		0.135		119	0.19	176	0.19	0.10	0.08	
	3/16	0.188		121	0.19	100	0.19	0.20	0.08	
	1/4	0.250		122	0.19	80	0.19	0.30	0.08	
	3/8	0.375		90 (50')	124	0.19	50	0.19	0.50	0.09
	1/2	0.500			132	0.19	26	0.19	0.75	0.10
	5/8	0.625			135	0.19	19	Edge Start		0.10
	3/4	0.750			136	0.19	14	Edge Start		0.08
	1	1.000	150		0.19	6	Edge Start		0.11	

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.9 (7.6m) 6.2 (15.2m)	115	4.8	7540	4.8	0	2.1
2		120	4.8	7015	4.0	0.10	1.9
3		118	4.8	4570	4.8	0.10	0.1
4		120	4.8	3650	4.8	0.20	1.9
5		121	4.8	2465	4.8	0.20	2.1
6		122	4.8	2145	4.8	0.30	2.0
8		123	4.8	1635	4.8	0.40	2.2
10		125	4.8	1180	4.8	0.60	2.4
12		130	4.8	795	4.8	0.75	2.4
15		134	4.8	530	<i>Edge Start</i>		2.4
20		138	4.8	325	<i>Edge Start</i>		2.2
25		149	4.8	165	<i>Edge Start</i>		2.7

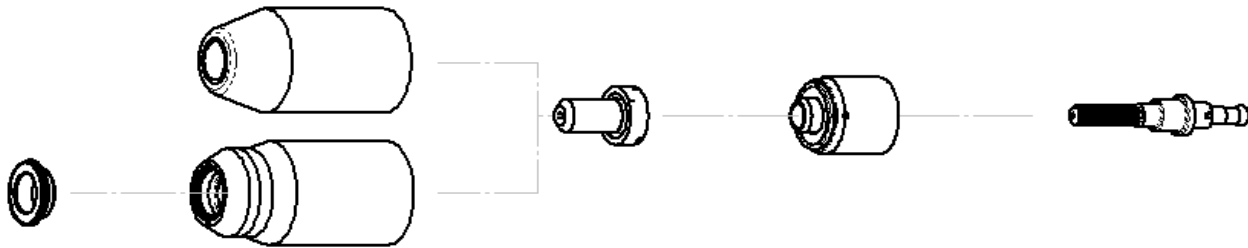
BOLD TYPE indicates maximum piercing parameters. **BOLD ITALIC** indicates edge starts only.

CUTMASTER A40

Stainless Steel

60A

Air Plasma / Air Shield



Deflector	Standard Shield Cup Maximum Life Shield Cup	Tip	Starter Cartridge Heavy Duty Starter Cartridge	Electrode
9-8243	9-8218 9-8237	9-8210	9-8213 9-8277	9-8232

Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed	
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)	
16		0.063	85 (25')	119	0.19	350	0.20	0.00	0.05	
14		0.078		116	0.19	300	0.20	0.10	0.07	
11		0.125		123	0.19	150	0.20	0.10	0.07	
10		0.141		118	0.19	125	0.20	0.10	0.08	
	3/16	0.188		122	0.19	90	0.20	0.20	0.08	
	1/4	0.250		90 (50')	123	0.19	65	0.20	0.30	0.09
	3/8	0.375			130	0.19	30	0.20	0.50	0.09
	1/2	0.500			132	0.19	21	0.20	0.90	0.08
	5/8	0.625			132	0.19	14	<i>Edge Start</i>		0.11
	3/4	0.750			135	0.19	10	<i>Edge Start</i>		0.10

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.9 (7.6m) 6.2 (15.2m)	124	4.8	10890	5.1	0.00	0.8
2		116	4.8	7560	5.1	0.10	1.7
3		122	4.8	4365	5.1	0.10	1.7
4		119	4.8	2865	5.1	0.20	2.1
5		122	4.8	2195	5.1	0.20	2.1
6		123	4.8	1790	5.1	0.30	2.2
8		127	4.8	1190	5.1	0.40	2.2
10		130	4.8	725	5.1	0.50	2.2
12		132	4.8	580	5.1	0.90	2.1
15		132	4.8	405	<i>Edge Start</i>		2.6
20		136	4.8	230	<i>Edge Start</i>		2.5

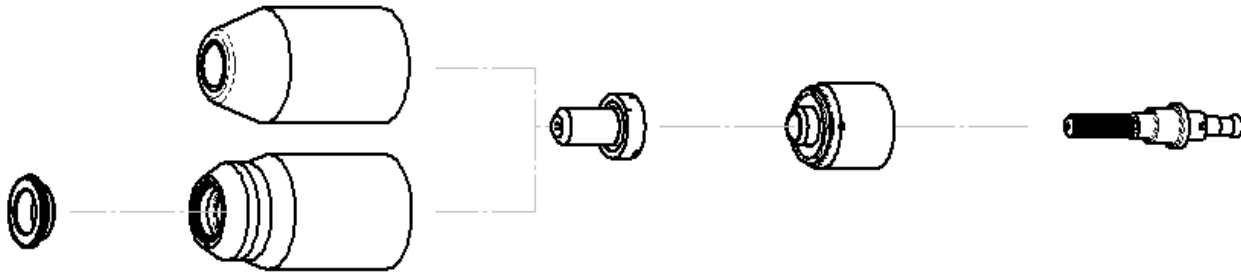
BOLD TYPE indicates maximum piercing parameters. **BOLD ITALIC** indicates edge starts only.

CUTMASTER A40

Aluminum

60A

Air Plasma / Air Shield



Deflector	Standard Shield Cup Maximum Life Shield Cup	Tip	Starter Cartridge Heavy Duty Starter Cartridge	Electrode
9-8243	9-8218 9-8237	9-8210	9-8213 9-8277	9-8232

Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed	
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)	
16		0.064	85 (25')	123	0.25	440	0.25	0.00	0.08	
14		0.079		126	0.25	300	0.25	0.10	0.09	
11		0.120		128	0.25	250	0.25	0.10	0.09	
	3/16	0.188		132	0.25	170	0.25	0.20	0.09	
	1/4	0.250		132	0.25	85	0.25	0.30	0.09	
	3/8	0.375		90 (50')	141	0.25	45	0.25	0.50	0.10
	1/2	0.500		148	0.25	30	0.25	0.80	0.09	
	5/8	0.625		145	0.19	18	<i>Edge Start</i>		0.08	
	3/4	0.750		147	0.19	12	<i>Edge Start</i>		0.10	

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.9 (7.6m) 6.2 (15.2m)	118	6.4	17010	6.4	0.00	1.8
2		126	6.4	7680	6.4	0.10	2.3
3		128	6.4	6410	6.4	0.10	2.3
4		130	6.4	5230	6.4	0.20	2.3
5		132	6.4	4010	6.4	0.20	2.4
6		132	6.4	2640	6.4	0.30	2.4
8		137	6.4	1630	6.4	0.40	2.4
10		142	6.4	1085	6.4	0.60	2.4
12		146	6.4	845	6.4	0.70	2.3
15		146	4.8	540	<i>Edge Start</i>		2.1
20		148	4.8	260	<i>Edge Start</i>		2.5

BOLD TYPE indicates maximum piercing parameters. **BOLD ITALIC** indicates edge starts only.

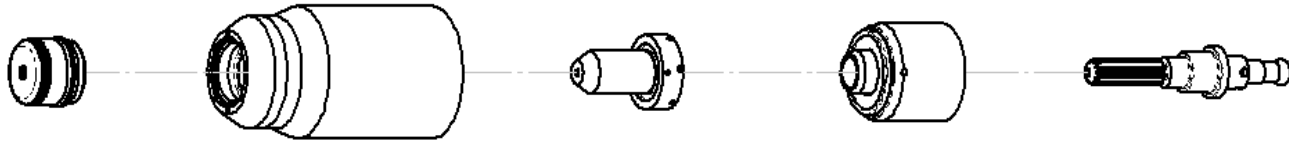
CUTMASTER A40

4T.09 RECOMMENDED CUTTING SPEEDS FOR MACHINE AND AUTOMATED TORCHES WITH SHIELDED TIP

Mild Steel

40A

Air Plasma / Air Shield



Shield Cap	Maximum Life Shield Cup	Tip	Starter Cartridge Heavy Duty Starter Cartridge	Electrode
9-8245	9-8237	9-8208	9-8213 9-8277	9-8232

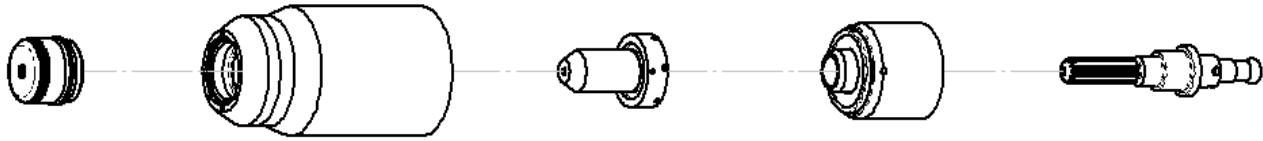
Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed	
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)	
20		0.036	75 (25')	107	0.16	130	0.16	0.0	0.06	
16		0.060		113	0.16	120	0.16	0.0	0.06	
14		0.075		108	0.16	90	0.16	0.1	0.06	
12		0.105		111	0.16	75	0.16	0.2	0.06	
10		0.135		114	0.16	65	0.16	0.3	0.07	
	3/16	0.188		80 (50')	115	0.16	65	0.16	0.4	0.07
	1/4	0.250			118	0.16	45	0.16	0.5	0.07
	3/8	0.375			123	0.16	23	0.16	1.2	0.08
	1/2	0.500			128	0.16	18	0.16	2.0	0.08

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.2 (7.6) 5.5 (15.2)	108	4.1	3266	4.1	0.0	1.4
2		108	4.1	2239	4.1	0.0	1.5
3		112	4.1	1794	4.1	0.1	1.7
4		114	4.1	1651	4.1	0.2	1.7
5		115	4.1	1578	4.1	0.3	1.7
6		117	4.1	1256	4.1	0.4	1.7
8		121	4.1	853	4.1	0.5	1.7
10		124	4.1	565	4.1	1.2	1.8
12		127	4.1	485	4.1	2.0	1.9

BOLD TYPE indicates maximum piercing parameters.

CUTMASTER A40

Stainless Steel
40A
Air Plasma / Air Shield



Shield Cap	Maximum Life Shield Cup	Tip	Starter Cartridge Heavy Duty Starter Cartridge	Electrode
9-8245	9-8237	9-8208	9-8213 9-8277	9-8232

Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)
18		0.050	75 (25') 80 (50')	110	0.16	60	4.1	0.0	0.06
16		0.063		108	0.16	50	4.1	0.1	0.07
14		0.078		114	0.16	45	4.1	0.1	0.07
12		0.109		113	0.16	40	4.1	0.2	0.07
10		0.141		116	0.16	35	4.1	0.3	0.07
	3/16	0.188		115	0.16	30	4.1	0.4	0.07
	1/4	0.250		118	0.16	20	4.1	1.2	0.07
	3/8	0.375		125	0.16	15	4.1	1.8	0.08
	1/2	0.500		127	0.16	10	4.1	2.0	0.08

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.2 (7.6) 5.5 (15.2)	109	4.1	1670	4.1	0.0	1.7
2		114	4.1	1140	4.1	0.1	1.8
3		114	4.1	980	4.1	0.2	1.8
4		116	4.1	845	4.1	0.3	1.8
5		115	4.1	725	4.1	0.4	1.8
6		117	4.1	565	4.1	0.5	2.0
8		122	4.1	440	4.1	1.5	2.0
10		125	4.1	360	4.1	1.8	2.0
12		127	4.1	280	4.1	2.0	2.2

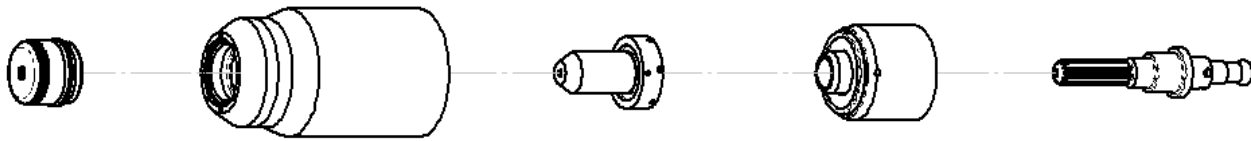
BOLD TYPE indicates maximum piercing parameters.

CUTMASTER A40

Aluminum

40A

Air Plasma / Air Shield



Shield Cap	Maximum Life Shield Cup	Tip	Starter Cartridge Heavy Duty Starter Cartridge	Electrode
9-8245	9-8237	9-8208	9-8213 9-8277	9-8232

Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)
20		0.040	75 (25') 80 (50')	110	0.19	300	0.20	0.0	0.06
16		0.063		113	0.19	170	0.20	0.1	0.07
12		0.097		120	0.19	100	0.20	0.2	0.07
11		0.125		125	0.19	90	0.20	0.3	0.07
9		0.160		126	0.19	85	0.20	0.4	0.07
	3/16	0.188		128	0.19	70	0.20	0.5	0.07
	1/4	0.250		137	0.19	30	0.20	1.0	0.08
	3/8	0.375		145	0.19	10	0.20	2.0	0.09

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1.0	5.2 (7.6) 5.5 (15.2)	110	4.8	7660	5.1	0.0	1.6
2.0		116	4.8	3490	5.1	0.2	1.8
3.0		124	4.8	2350	5.1	0.3	1.8
4.0		126	4.8	2170	5.1	0.4	1.8
5.0		129	4.8	1630	5.1	0.6	1.8
6.0		135	4.8	990	5.1	1.0	1.9
8.0		141	4.8	500	5.1	1.6	2.0
10.0		146	4.8	180	5.1	2.1	2.3

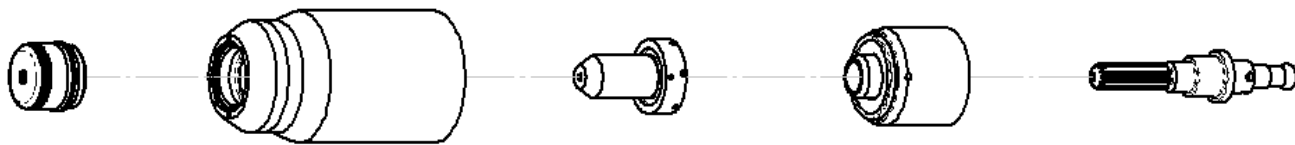
BOLD TYPE indicates maximum piercing parameters.

CUTMASTER A40

Mild Steel

60A

Air Plasma / Air Shield



Shield Cap			Maximum Life Shield Cup		Tip	Starter Cartridge Heavy Duty Starter Cartridge		Electrode	
9-8238			9-8237		9-8210	9-8213 9-8277		9-8232	

Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed	
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)	
16		0.060	85 (25')	128	0.19	250	0.20	0.00	0.09	
14		0.075		129	0.19	237	0.20	0.10	0.09	
11		0.120		126	0.19	200	0.20	0.10	0.08	
10		0.135		128	0.19	142	0.20	0.10	0.09	
	3/16	0.188		132	0.19	115	0.20	0.20	0.09	
	1/4	0.250		134	0.19	80	0.20	0.30	0.08	
	3/8	0.375		90 (50')	132	0.19	34	0.20	0.70	0.10
	1/2	0.500			144	0.19	23	0.20	0.75	0.10
	5/8	0.625			150	0.19	14	<i>Edge Start</i>		0.10
	3/4	0.750			145	0.19	14	<i>Edge Start</i>		0.10
	1	1.000	160		0.19	4	<i>Edge Start</i>		0.12	

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.9 (7.6m) 6.2 (15.2m)	127	4.8	6804	5.1	0	2.2
2		129	4.8	5942	5.1	0.10	2.2
3		126	4.8	5080	5.1	0.10	0.1
4		130	4.8	3316	5.1	0.20	2.3
5		132	4.8	2794	5.1	0.20	2.2
6		134	4.8	2230	5.1	0.30	2.1
8		133	4.8	1425	5.1	0.40	2.3
10		134	4.8	822	5.1	0.60	2.5
12		141	4.8	646	5.1	0.75	2.5
15		148	4.8	419	<i>Edge Start</i>		2.6
20		147	4.8	318	<i>Edge Start</i>		2.7
25		159	4.8	118	<i>Edge Start</i>		3.0

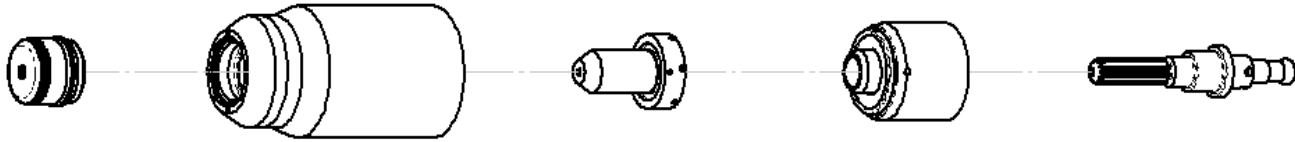
BOLD TYPE indicates maximum piercing parameters. **BOLD ITALIC** indicates edge starts only.

CUTMASTER A40

Stainless Steel

60A

Air Plasma / Air Shield



Shield Cap			Maximum Life Shield Cup			Tip	Starter Cartridge Heavy Duty Starter Cartridge		Electrode	
9-8238			9-8237			9-8210	9-8213 9-8277		9-8232	

Material Thickness			Gas Pressure (Air) PSI (torch lead length)	Arc Voltage Volts	Torch Working Height (in)	Travel Speed (ipm)	Initial Piercing Height (in)	Pierce Delay (sec)	Kerf Width @ Rec. Speed (in)
(GA)	(in)	inch							
16		0.063	85 (25')	110	0.13	165	0.20	0.00	0.06
14		0.078		116	0.13	155	0.20	0.10	0.07
11		0.125		118	0.13	125	0.20	0.10	0.07
10		0.141		126	0.13	80	0.20	0.10	0.09
	3/16	0.188		125	0.13	75	0.20	0.20	0.09
	1/4	0.250		127	0.13	60	0.20	0.30	0.08
	3/8	0.375		134	0.13	28	0.20	0.50	0.08
	1/2	0.500		136	0.19	17	0.25	0.75	0.09
	5/8	0.625		131	0.13	14	<i>Edge Start</i>		0.08
	3/4	0.750		142	0.19	10	<i>Edge Start</i>		0.11

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.9 (7.6m) 6.2 (15.2m)	101	3.3	4590	5.1	0.00	1.2
2		116	3.3	3925	5.1	0.10	1.7
3		118	3.3	3285	5.1	0.10	1.7
4		126	3.3	1985	5.1	0.20	2.2
5		125	3.3	1850	5.1	0.20	2.1
6		127	3.3	1605	5.1	0.30	2.1
8		131	3.3	1100	5.1	0.40	2.1
10		134	3.3	670	5.1	0.50	2.1
12		136	4.8	490	6.4	0.90	2.2
15		132	3.3	375	<i>Edge Start</i>		2.6
20		144	4.8	230	<i>Edge Start</i>		2.5

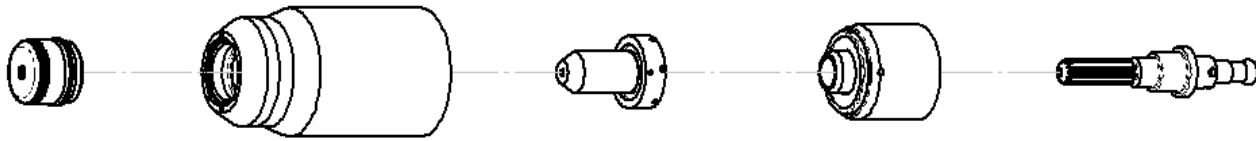
BOLD TYPE indicates maximum piercing parameters. **BOLD ITALIC** indicates edge starts only.

CUTMASTER A40

Aluminum

60A

Air Plasma / Air Shield



Shield Cap	Maximum Life Shield Cup	Tip	Starter Cartridge Heavy Duty Starter Cartridge	Electrode
9-8238	9-8237	9-8210	9-8213 9-8277	9-8232

Material Thickness			Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(GA)	(in)	inch	PSI (torch lead length)	Volts	(in)	(ipm)	(in)	(sec)	(in)
16		0.064	85 (25') 90 (50')	118	0.13	350	0.20	0.00	0.07
14		0.079		118	0.13	350	0.20	0.10	0.08
11		0.120		123	0.13	275	0.20	0.10	0.08
	3/16	0.188		125	0.13	140	0.20	0.20	0.08
	1/4	0.250		132	0.13	80	0.20	0.30	0.08
	3/8	0.375		135	0.13	45	0.20	0.50	0.08
	1/2	0.500		140	0.13	26	0.20	0.80	0.08
	5/8	0.625		148	0.19	18	<i>Edge start</i>		0.10
	3/4	0.750		155	0.19	12	<i>Edge start</i>		0.11

CUTMASTER A40

Material Thickness	Gas Pressure (Air)	Arc Voltage	Torch Working Height	Travel Speed	Initial Piercing Height	Pierce Delay	Kerf Width @ Rec. Speed
(mm)	Bar (torch lead length)	Volts	(mm)	(mm/min)	(mm)	(sec)	(mm)
1	5.9 (7.6m) 6.2 (15.2m)	118	6.4	8890	6.4	0.00	2
2		118	6.4	8890	6.4	0.10	2.0
3		123	6.4	7070	6.4	0.10	2.1
4		124	6.4	5095	6.4	0.20	2.0
5		126	6.4	3335	6.4	0.20	2.0
6		130	6.4	2370	6.4	0.30	2.0
8		134	6.4	1570	6.4	0.40	2.0
10		136	6.4	1070	6.4	0.60	2.0
12		139	6.4	765	6.4	0.70	2.0
15		146	4.8	515	<i>Edge start</i>		2.4
20		157	4.8	260	<i>Edge start</i>		2.7

BOLD TYPE indicates maximum piercing parameters. **BOLD ITALIC** indicates edge starts only.