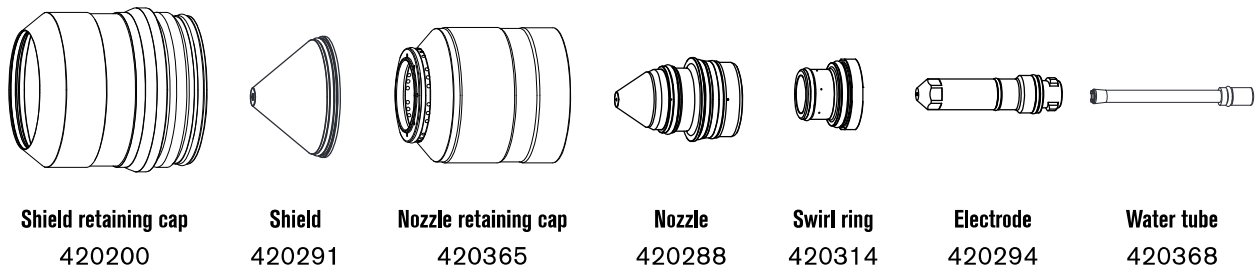


Cut charts for non-ferrous (aluminum) processes – above water

Aluminum – 40 A – Air Plasma / Air Shield – above water (Core, VWI, OptiMix)



Flow rate (lpm/scfh)		
	N ₂	Air
Pre flow	17 / 35	32 / 67
Pierce flow	–	54 / 115
Cut flow	–	66 / 141

Metric

Material thickness mm	Cut category	SYSTEM SETTINGS				CNC SETTINGS						
		XPR process ID	Shield pierce setting	Cutflow		Cut speed mm/min	Arc voltage volts	Transfer height mm	Pierce height mm	Pierce delay seconds	Cut height mm	Kerf compensation mm
				Plasma gas	Shield gas							
1.5	3	2019	30	90	85	4799	137	5.08	5.08	0.2	3.05	1.5
2					3964	135	1.4					
2.5	1	2018			68	3230	133					0.3
3					2596	132	1.3					
4	2	2017			64	1632	131			0.6	2.54	1.2
5		2016			55	1070	131					1.3
6			911	135	1.4							