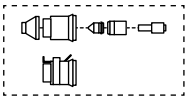
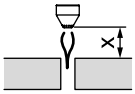
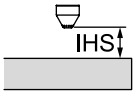
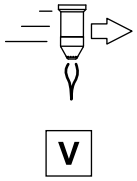
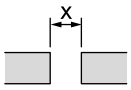
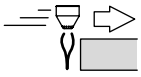
Automatic CNC cutting tables

The following pages contain the cutting tables for each series of consumables for automatic cutting of the following materials:
- Mild steel.
- Stainless steel (CrNi).
- Aluminium.

Each table contains the following information:

I_2	Cutting current setting.
Fe	Carbon steel Fe 430 B - S275JR
CrNi	Stainless steel Aisi 304 / X5 CrNi 18-10
Al	Aluminium
	Torch configuration, complete with codes for consumables to be fitted on the plasma torch.
P	Air pressure setting.
	Indication of the air flow rate (cold air condition).
AIR	Cutting gas indication.
mm	Metric system.
in	Imperial system.
	Thickness of the material to be cut.
	Cutting height. • Shielded consumables: gap between the shield and the piece to be cut. • Non-shielded consumables: gap between the nozzle and the piece to be cut.
	Initial piercing height. This is the initial gap between the shield (shielded consumables) or the nozzle (non-shielded consumables) and the piece to be cut, when the arc is ignited, before going down to the cutting height. The percentage value indicates the increment in cutting height, to obtain the initial piercing height.

	Piercing delay. The period of time for which the torch, with the arc ignited, remains at the initial piercing height, before beginning the cutting movement at the final cutting height.
	Cutting speed and arc voltage settings (THC systems with torch height control), which indicate the starting point for finding the best parameters for achieving the desired result.
PRODUCTION	Production quality. To obtain a good cutting angle (0-10°), and acceptable burrs and surface finish. These parameters make it possible to produce a larger number of cut pieces, but not necessarily with the best quality cut possible.
QUALITY	Maximum quality. To obtain the best cutting angle (*) minimum burrs, and the best cutting surface finish. (*) 0-6° using standard consumables, and 0-4° using CLEAN-CUT consumables.
	"Kerf" cutting width. The values indicated in the cutting tables are indicative and are obtained using the maximum quality settings.
	Starting from the edge.

NOTE: *The arc voltage increases with wearing of the consumables, and so the voltage settings must be increased in order to maintain the correct gap between torch and plating.*

NOTE: *The data in the table was obtained during laboratory tests using new consumables and taking the ISO 9013 international standard as a reference. The precision of plasma cuts depends basically on the interaction between the plasma plant, the guide system, and the height control. The cutting speed also affects the inclination of the cutting surface.*

SHARK 125/M - SHARK 125/MR

I_2	120 A	Fe

487636
(100-125 A)

486029
(100-125 A)

408617
(125 A)

425023

482136
(100-125 A)

486026
(100-125 A)

P	5,5 bar 80 psi	AIR	295 l/min 630 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
6	3	6	200	0,5	5100	150	4260	153	2,1
8	3	6	200	0,6	3910	152	3250	153	2,2
10	3	6	200	0,7	2850	153	2350	153	2,3
12	3	6	200	0,8	2140	152	1750	152	2,4
16	3	7,5	250	1,0	1420	159	1080	157	2,6
20	3	7,5	250	1,2	970	159	840	160	2,8
25	3	7,5	250	1,6	690	162	580	164	3
30	3				480	162	400	164	3,5
32	3				440	167	370	169	3,9
35	3				370	170	300	172	4
40	3				260	173	210	175	4,2

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/4"	0.125"	0.25"	200	0.5	192	150	161	153	0.09"
3/8"	0.125"	0.25"	200	0.7	118	153	97	153	0.095"
1/2"	0.125"	0.25"	200	0.8	79	153	64	153	0.096"
5/8"	0.125"	0.31"	250	1.0	57	159	43	157	0.105"
3/4"	0.125"	0.31"	250	1.2	41	158	36	159	0.11"
7/8"	0.125"	0.31"	250	1.4	32	161	26	163	0.111"
1"	0.125"	0.31"	250	1.6	26	162	19	164	0.125"
1-1/4"	0.125"				18	167	14	169	0.152"
1-1/2"	0.125"				12	172	9	174	0.16"

SHARK 125/M - SHARK 125/MR

I_2	120 A	CrNi

487636
(100-125 A)

486029
(100-125 A)

408617
(125 A)

425023

482136
(100-125 A)

486026
(100-125 A)

P	5,5 bar 80 psi	AIR	295 l/min 630 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
6	3	6	200	0,55	6580	152	5050	151	2
8	3	6	200	0,55	4750	152	3470	152	2,2
10	3	6	200	0,6	3170	152	2170	154	2,3
12	3	6	200	0,6	2310	152	1860	158	2,4
16	3	7,5	250	0,75	1250	157	970	160	2,5
20	3	7,5	250	1,3	880	158	800	162	2,7
25	3				650	161	460	167	2,9
30	3				520	161	430	168	3
32	3				500	164	400	172	3,1
35	3				380	168	270	175	3,3
40	3				180	174	160	180	3,5

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/4"	0.125"	0.25"	200	0.55	247	152	189	151	0.079"
3/8"	0.125"	0.25"	200	0.55	132	152	89	153	0.095"
1/2"	0.125"	0.25"	200	0.6	84	153	67	158	0.105"
5/8"	0.125"	0.31"	250	0.7	50	157	38	160	0.105"
3/4"	0.125"	0.31"	250	1.2	37	158	35	162	0.105"
7/8"	0.125"				30	159	26	163	0.114"
1"	0.125"				25	161	18	168	0.125"
1-1/4"	0.125"				20	164	14	172	0.118"
1-1/2"	0.125"				10	172	8	178	0.139"

SHARK 125/M - SHARK 125/MR

I_2	120 A	Al

487636
(100-125 A)

486029
(100-125 A)

408617
(125 A)

425023

482136
(100-125 A)

486026
(100-125 A)

P	5,5 bar 80 psi	AIR	295 l/min 630 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
6	3	6	200	0,5	7320	151	6550	154	2,2
8	3	6	200	0,7	5220	152	4370	156	2,4
10	3	6	200	0,8	3430	154	2550	158	2,5
12	3	6	200	1,0	2630	157	1830	160	2,6
16	3	7,5	250	1,2	1790	158	1320	164	2,7
20	3	7,5	250	1,4	1290	162	1080	165	2,8
25	3	7,5	250	1,7	900	162	730	169	2,9
30	3				690	162	640	170	3
32	3				660	169	590	177	3,1
35	3				510	171	440	178	3,4
40	3				260	174	230	180	3,6

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/4"	0.125"	0.25"	200	0.5	274	151	243	154	0.092"
3/8"	0.125"	0.25"	200	0.8	142	153	106	158	0.105"
1/2"	0.125"	0.25"	200	1.0	97	157	69	161	0.106"
5/8"	0.125"	0.31"	250	1.2	71	158	52	164	0.112"
3/4"	0.125"	0.31"	250	1.4	53	162	44	165	0.121"
7/8"	0.125"	0.31"	250	1.6	44	162	38	166	0.103"
1"	0.125"	0.31"	250	1.7	35	162	27	170	0.114"
1-1/4"	0.125"				26	169	15	177	0.118"
1-1/2"	0.125"				14	173	10	179	0.142"

SHARK 125/M - SHARK 125/MR

I_2	100 A	Fe

487636
(100-125 A)

486029
(100-125 A)

408612
(105 A)

425023

482136
(100-125 A)

486026
(100-125 A)

P	5,5 bar 80 psi	AIR	285 l/min 605 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

		IHS		sec IHS	PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
6	3	6	200	0.6	4580	146	3720	145	2,1
8	3	6	200	0.8	3480	146	2820	146	2,2
10	3	6	200	0.8	2510	146	2030	146	2,2
12	3	6	200	0.8	1850	149	1520	146	2,2
16	3	6	200	1.2	1170	150	950	150	2,5
20	3	6	200	1.2	840	153	700	153	2,7
25	3				520	159	490	160	3,1
30	3				360	162	330	163	3,6
32	3				330	162	310	167	3,8
35	3				280	166	260	169	3,9
40	3				180	171	170	174	4,1

in

		IHS		sec IHS	PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/4"	0.125”	0.25”	200	0.6	173	146	140	145	0.083"
3/8"	0.125”	0.25”	200	0.8	104	146	85	146	0.088"
1/2"	0.125”	0.25”	200	0.8	68	149	56	147	0.089"
5/8"	0.125”	0.25”	200	1.2	47	150	38	150	0.100"
3/4"	0.125”	0.25”	200	1.2	36	151	30	152	0.101"
7/8"	0.125”	0.25”	200	1.4	27	158	23	155	0.120"
1"	0.125”				20	159	19	161	0.133"
1-1/8"	0.125”				15	161	14	163	0.140"
1-1/4"	0.125”				14	162	13	167	0.150"
1-1/2"	0.125”				9	169	8	172	0.158"

SHARK 125/M - SHARK 125/MR

I_2	100 A	CrNi

487636
(100-125 A)

486029
(100-125 A)

408612
(105 A)

425023

482136
(100-125 A)

486026
(100-125 A)

P	5,5 bar 80 psi	AIR	285 l/min 605 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
		IHS		sec IHS		V		V	X
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
6	3	6	200	0,6	5400	142	4380	140	1,9
8	3	6	200	0,6	3780	143	3110	142	2,1
10	3	6	200	0,6	2400	143	2010	145	2,3
12	3	6	200	0,7	1670	145	1340	149	2,3
16	3	6	200	0,9	970	150	850	150	2,3
20	3	7,5	250	1,4	720	153	590	155	2,6
25	3				470	157	390	159	2,9
30	3				320	161	300	165	3,0
32	3				280	164	270	167	3,1

in

					PRODUCTION		QUALITY		
		IHS		sec IHS		V		V	X
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/4"	0.125"	0.25	200	0.6	202	142	167	140	0.076"
3/8"	0.125"	0.25	200	0.6	101	143	85	144	0.089"
1/2"	0.125"	0.25	200	0.6	61	146	50	149	0.091"
5/8"	0.125"	0.25	200	0.9	39	150	34	150	0.092"
3/4"	0.125"	0.31	250	1.4	31	152	25	154	0.099"
7/8"	0.125"				24	154	20	157	0.105"
1"	0.125"				18	157	15	159	0.113"
1-1/8"	0.125"				14	160	13	163	0.116"
1-1/4"	0.125"				12	164	11	167	0.120"

SHARK 125/M - SHARK 125/MR

I_2	100 A	Al

487636
(100-125 A)

486029
(100-125 A)

408612
(105 A)

425023

482136
(100-125 A)

486026
(100-125 A)

P	5,5 bar 80 psi	AIR	285 l/min 605 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
6	3	6	200	0,6	6380	145	5380	146	2,3
8	3	6	200	0,9	4510	149	3750	150	2,3
10	3	6	200	0,9	2950	152	2370	153	2,4
12	3	6	200	1,2	2200	155	1710	157	2,6
16	3	6	200	1,2	1490	156	1160	158	2,7
20	3	6	200	1,4	1070	163	910	164	3,0
25	3				710	166	590	167	3,5
30	3				510	172	380	174	3,8
32	3				440	174	300	176	4,0

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/4"	0.125"	0.25"	200	0.6	239	146	201	147	0.091"
3/8"	0.125"	0.25"	200	0,9	122	151	99	152	0.092"
1/2"	0.125"	0.25"	200	1.2	82	155	64	157	0.102"
5/8"	0.125"	0.25"	200	1.2	59	156	46	158	0.107"
3/4"	0.125"	0.25"	200	1.4	45	162	39	163	0.111"
7/8"	0.125"				36	164	31	165	0.120"
1"	0.125"				27	166	23	167	0.138"
1-1/8"	0.125"				23	170	18	172	0.145"
1-1/4"	0.125"				18	174	14	176	0.15"

SHARK 125/M - SHARK 125/MR

I_2	85 A	Fe

487635
(45-85 A)

486028
(45-85 A)

408616
(85 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	270 l/min 575 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
3	2	4	200	0,2	8740	121	6460	123	1,7
4	2	4	200	0,3	6930	123	5360	123	1,7
6	2	4	200	0,6	4180	126	3420	124	1,8
8	2	4	200	0,6	2940	128	2370	126	1,9
10	2	4	200	0,6	1960	129	1590	128	2,0
12	2	5	250	0,8	1520	131	1210	131	2,2
16	2	5	250	1,2	880	134	820	135	2,4
20	2	6	300	1,7	640	137	540	138	2,6
25	2				420	142	330	143	3,2
30	2				280	145	190	147	3,7

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
10 GA	0.08"	0.16"	200	0.1	319	122	238	123	0.068"
3/16"	0.08"	0.16"	200	0.3	209	124	176	124	0.071"
1/4"	0.08"	0.16"	200	0.6	152	127	124	124	0.073"
3/8"	0.08"	0.16"	200	0.6	82	128	67	127	0.078"
1/2"	0.08"	0.2"	250	0.6	53	132	43	132	0.090"
5/8"	0.08"	0.2"	250	1.2	35	134	33	135	0.095"
3/4"	0.08"	0.24"	300	1.7	28	136	23	137	0.100"
7/8"	0.08"				21	139	18	140	0.115"
1"	0.08"				16	142	12	143	0,130"
1-1/8"	0.08"				12	144	9	146	0.140"
1-1/4"	0.08"				10	147	7	149	0.146"

SHARK 125/M - SHARK 125/MR

I_2	85 A	CrNi

487635
(45-85 A)

486028
(45-85 A)

408616
(85 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	270 l/min 575 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
3	2	4	200	0,2	8740	121	7120	123	1,6
4	2	4	200	0,3	7120	121	5790	123	1,7
6	2	4	200	0,6	4370	123	3510	123	1,8
8	2	4	200	0,6	2890	125	2320	125	1,9
10	2	5	250	0,6	1800	127	1470	128	2,1
12	2	5	250	0,8	1330	131	1040	132	2,3
16	2	5	250	1,2	720	135	660	136	2,4
20	2				540	138	450	139	2,5
25	2				350	142	280	144	2,6

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
10 GA	0.08"	0.16"	200	0.3	319	121	261	123	0.065"
3/16"	0.08"	0.16"	200	0.3	228	122	190	123	0.068"
1/4"	0.08"	0.16"	200	0.6	156	123	124	123	0.070"
3/8"	0.08"	0.16"	200	0.6	76	126	62	127	0.080"
1/2"	0.08"	0.20"	250	0.6	46	132	34	133	0.094"
5/8"	0.08"	0.20"	250	1.2	29	135	27	136	0.095"
3/4"	0.08"				23	137	19	138	0.096"
7/8"	0.08"				18	140	15	141	0.098"
1"	0.08"				13	142	10	144	0.100"

SHARK 125/M - SHARK 125/MR

I_2	85 A	Al

487635
(45-85 A)

486028
(45-85 A)

408616
(85 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	270 l/min 575 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
3	2	4	200	0,2	8930	122	7600	123	1,8
4	2	4	200	0,3	7600	124	6170	124	1,9
6	2	4	200	0,6	4650	127	3610	127	2,0
8	2	4	200	0,6	3290	130	2510	131	2,0
10	2	5	250	0,6	2370	132	1820	133	2,1
12	2	5	250	0,8	1830	134	1370	135	2,2
16	2	5	250	1,2	1140	138	900	140	2,4
20	2				830	142	570	144	2,6
25	2				510	145	360	147	2,8

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/8"	0.08"	0.16"	200	0.3	342	122	285	123	0.075"
1/4"	0.08"	0.16"	200	0.6	163	128	124	128	0.080"
3/8"	0.08"	0.16"	200	0.6	99	132	76	133	0.085"
1/2"	0.08"	0.2"	250	0.6	65	134	48	136	0.090"
5/8"	0.08"	0.2"	250	1.2	46	138	36	140	0.095"
3/4"	0.08"				35	141	24	143	0.100"
7/8"	0.08"				28	143	19	145	0.105"
1"	0.08"				19	145	13	147	0.110"

SHARK 125/M - SHARK 125/MR

I_2	65 A	Fe

487635
(45-85 A)

486028
(45-85 A)

408615
(65 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	245 l/min 520 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
2	2	4	200	0,2	6650	122	5740	125	1,6
3	2	4	200	0,3	5790	124	4940	126	1,6
4	2	4	200	0,6	4840	125	4030	126	1,7
6	2	4	200	0,6	3070	128	2420	128	1,8
8	2	4	200	0,6	2110	129	1610	130	1,9
10	2	5	250	0,8	1420	130	1040	132	2,0
12	2	5	250	1,4	1080	132	800	135	2,2
16	2	6	300	2,2	610	137	530	139	2,3
20	2				420	143	330	143	3,0
25	2				250	146	190	146	3,4

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
16 GA	0.08"	0.16"	200	0.2	279	122	247	124	0.060"
10 GA	0.08"	0.16"	200	0.2	213	124	181	126	0.065"
3/16"	0.08"	0.16"	200	0.3	160	126	133	127	0.068"
1/4"	0.08"	0.16"	200	0.6	110	128	86	128	0.070"
3/8"	0.08"	0.16"	200	0.8	59	130	43	131	0.076"
1/2"	0.08"	0.20"	250	1.4	38	133	29	136	0.088"
5/8"	0.08"	0.24"	300	2.2	25	137	22	139	0.090"
3/4"	0.08"				18	142	14	142	0.091"
7/8"	0.08"				13	144	11	144	0.115"
1"	0.08"				10	146	8	146	0.134"

SHARK 125/M - SHARK 125/MR

I_2	65 A	CrNi

487635
(45-85 A)

486028
(45-85 A)

408615
(65 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	245 l/min 520 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
2	2	4	200	0,2	9500	122	7690	126	1,4
3	2	4	200	0,3	7840	124	6360	126	1,5
4	2	4	200	0,6	5840	125	4940	126	1,7
6	2	4	200	0,6	2700	127	2320	127	1,8
8	2	4	200	0,8	1760	130	1420	130	1,9
10	2	5	250	0,8	1180	133	910	133	2,0
12	2	5	250	1,4	870	135	710	136	2,2
16	2				470	140	470	140	2,4
20	2				350	144	280	144	2,5

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
16 GA	0.08"	0.16"	200	0.2	405	122	328	125	0.054"
10 GA	0.08"	0.16"	200	0.2	281	124	228	126	0.062"
3/16"	0.08"	0.16"	200	0.3	160	126	147	127	0.068"
1/4"	0.08"	0.16"	200	0.6	91	127	76	127	0.073"
3/8"	0.08"	0.16"	200	0.8	49	132	38	132	0.076"
1/2"	0.08"	0.2"	250	1.4	30	136	25	137	0.090"
5/8"	0.08"				19	140	19	140	0.093"
3/4"	0.08"				14	143	13	143	0.096"

SHARK 125/M - SHARK 125/MR

I_2	65 A	Al

487635
(45-85 A)

486028
(45-85 A)

408615
(65 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	245 l/min 520 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

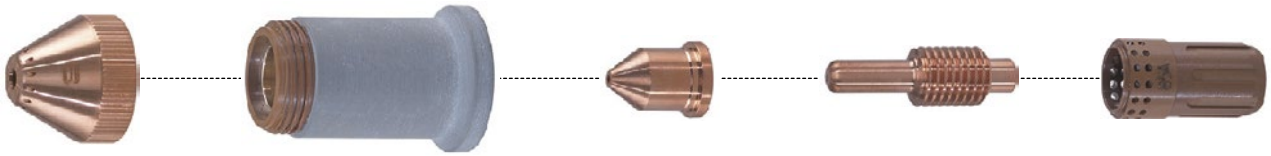
					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
2	2	4	200	0,2	9780	123	8360	122	1,9
3	2	4	200	0,3	8360	125	7030	125	1,9
4	2	4	200	0,6	6980	126	5700	127	1,9
6	2	4	200	0,6	4180	129	3040	131	1,9
8	2	4	200	0,8	2610	131	1850	134	2,0
10	2	5	250	0,8	1560	133	1140	137	2,1
12	2	5	250	1,4	1260	137	950	139	2,3
16	2				760	142	610	144	2,5
20	2				530	146	360	148	2,7

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/16"	0.08"	0.16"	200	0.2	407	122	347	122	0.073"
1/8"	0.08"	0.16"	200	0.2	319	125	266	125	0.074"
1/4"	0.08"	0.16"	200	0.6	144	129	100	132	0.076"
3/8"	0.08"	0.16"	200	0.8	65	132	48	136	0.083"
1/2"	0.08"	0.20"	250	1.4	46	139	33	140	0.091"
5/8"	0.08"				30	142	25	144	0.100"
3/4"	0.08"				23	145	15	147	0.105"

SHARK 125/M - SHARK 125/MR

I_2	45 A	Fe



487635
(45-85 A)

486028
(45-85 A)

408614
(45 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	235 l/min 500 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

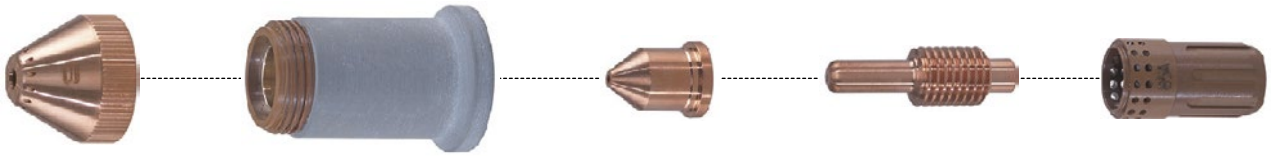
					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
0,5	2,0	4	200	0,1	11870	127	8500	129	1,1
1	2,0	4	200	0,1	10260	129	8500	129	1,1
1,5	2,0	4	200	0,2	9690	130	8500	131	1,3
2	2,0	4	200	0,4	7410	130	6270	131	1,4
3	2,0	4	200	0,5	4650	132	3650	134	1,5
4	2,0	4	200	0,5	3380	132	2090	135	1,6
6	2,0	4	200	0,6	1940	133	1280	138	1,7

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
26GA	0.04"	0.08"	200	0.1	475	129	330	129	0.030"
22GA	0.04"	0.08"	200	0.1	428	129	330	129	0.035"
18GA	0.04"	0.08"	200	0.2	380	129	330	130	0.053"
16GA	0.04"	0.08"	200	0.2	380	130	330	131	0.054"
14GA	0.08"	0.16"	200	0.3	304	130	257	131	0.055"
12GA	0.08"	0.16"	200	0.4	205	132	181	134	0.058"
10GA	0.08"	0.16"	200	0.4	156	132	95	135	0.061"
3/16"	0.08"	0.16"	200	0.5	103	133	67	136	0.065"
1/4"	0.08"	0.16"	200	0.7	69	133	46	138	0.066"

SHARK 125/M - SHARK 125/MR

I_2	45 A	CrNi



487635
(45-85 A)

486028
(45-85 A)

408614
(45 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	235 l/min 500 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

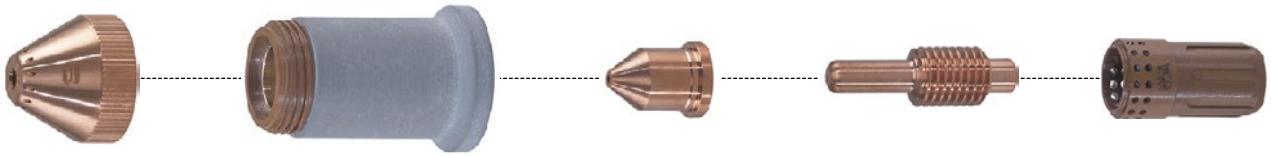
					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
0,5	2	4	200	0,1	11870	130	8500	131	0,9
1	2	4	200	0,1	10260	131	8500	131	1,1
1,5	2	4	200	0,2	9690	131	8500	131	1,3
2	2	4	200	0,4	8220	132	5700	133	1,5
3	2	4	200	0,5	4180	133	2940	133	1,6
4	2	4	200	0,5	2470	135	1900	135	1,7
6	2	4	200	0,6	960	140	850	141	1,8

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
26GA	0.04"	0.08"	200	0.1	475	130	330	131	0.030"
22GA	0.04"	0.08"	200	0.1	428	130	330	131	0.032"
18GA	0.04"	0.08"	200	0,2	380	131	330	131	0.055"
16GA	0.04"	0.08"	200	0,2	380	131	330	131	0.057"
14GA	0.08"	0.16"	200	0,3	342	132	238	133	0.058"
12GA	0.08"	0.16"	200	0,5	196	132	133	133	0.062"
10GA	0.08"	0.16"	200	0,5	127	135	95	134	0.067"
3/16"	0.08"	0.16"	200	0,6	55	136	49	136	0.069"
1/4"	0.08"	0.16"	200	0,7	33	141	29	142	0.070"

SHARK 125/M - SHARK 125/MR

I_2	45 A	Al



487635
(45-85 A)

486028
(45-85 A)

408614
(45 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	235 l/min 500 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

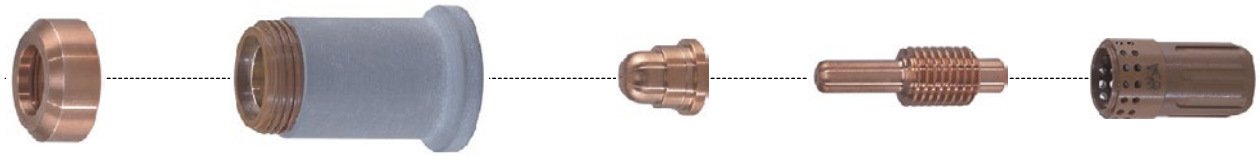
					PRODUCTION		QUALITY		
mm	mm	mm	%	sec	mm/min	V	mm/min	V	mm
1	2	4	200	0,1	10450	137	7830	137	1,5
2	2	4	200	0,2	8740	136	6270	137	1,5
3	2	4	200	0,3	5930	135	2940	140	1,6
4	2	4	200	0,5	4600	136	2090	142	1,6
6	2	4	200	0,6	2660	138	1420	143	1,7

in

					PRODUCTION		QUALITY		
inches	inches	inches	%	sec	ipm	V	ipm	V	inches
1/32"	0.08"	0.16"	200	0.10	428	137	310	137	0.059"
1/16"	0.08"	0.16"	200	0.20	380	137	310	137	0.061"
3/32"	0.08"	0.16"	200	0.30	312	135	190	137	0.063"
1/8"	0.08"	0.16"	200	0.50	213	135	95	141	0.065"
1/4"	0.08"	0.16"	200	0.60	91	138	51	143	0.067"

SHARK 125/M - SHARK 125/MR

I_2	45 A Clean CUT	Fe



482030
(45-85 A)

486028
(45-85 A)

408613
(45 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	225 l/min 475 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

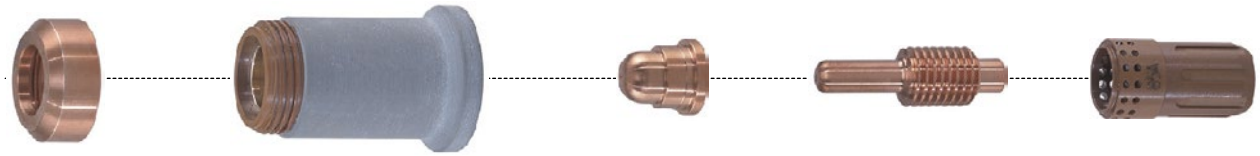
×	I_2	×	IHS		sec IHS		QUALITY V	x
mm	A	mm	mm	%	sec	mm/min	V	mm
0,5	30	1,5	2,25	150	0,10	3600	72	0,60
0,6	30	1,5	2,25	150	0,10	3600	72	0,65
0,8	30	1,5	2,25	150	0,20	3600	74	0,65
1	40	1,5	2,25	150	0,30	3600	75	0,70
1,5	40	1,5	2,25	150	0,50	3600	77	0,70
2	45	1,5	2,25	150	0,50	3500	78	0,75
3	45	1,5	2,25	150	0,60	2600	80	0,80
4	45	1,5	2,25	150	0,60	1800	80	0,85

in

×	I_2	×	IHS		sec IHS		QUALITY V	x
inches	A	inches	inches	%	sec	ipm	V	inches
26GA	30	0.06"	0.09"	150	0.10	145	72	0.024"
24GA	30	0.06"	0.09"	150	0.10	145	72	0.025"
22GA	30	0.06"	0.09"	150	0.20	145	74	0.026"
20GA	30	0.06"	0.09"	150	0.20	145	75	0.028"
18 GA	40	0.06"	0.09"	150	0.30	145	75	0.030"
16GA	40	0.06"	0.09"	150	0.50	145	75	0.031"
14 GA	45	0.06"	0.09"	150	0.50	145	77	0.032"
12GA	45	0.06"	0.09"	150	0.60	115	80	0.033"
10GA	45	0.06"	0.09"	150	0.60	90	80	0.034"

SHARK 125/M - SHARK 125/MR

I_2	45 A Clean CUT	CrNi



482030
(45-85 A)

486028
(45-85 A)

408613
(45 A)

425023

482135
(45-85 A)

486025
(45-85 A)

P	5,5 bar 80 psi	AIR	225 l/min 475 cfh	AIR	**AIR** - Clean, dry, oil-free for ISO 8573-1 Class 1.2.2

mm

	I_2		IHS		sec IHS		QUALITY V	X
mm	A	mm	mm	%	sec	mm/min	V	mm
0,5	30	0,5	2	400	0,10	3600	75	0,50
0,6	30	0,5	2	400	0,10	3600	75	0,55
0,8	30	0,5	2	400	0,20	3600	75	0,60
1	40	0,5	2	400	0,20	3600	75	0,60
1,5	40	0,5	2	400	0,50	2800	75	0,60
2	40	0,5	2	400	0,50	2700	75	0,65
3	45	0,5	2	400	0,60	2500	85	0,65
4	45	0,5	2	400	0,70	1000	85	0,70

in

	I_2		IHS		sec IHS		QUALITY V	X
inches	A	inches	inches	%	sec	ipm	V	inches
26GA	30	0.02"	0.08"	400	0,10	145	75	0.020"
24GA	30	0.02"	0.08"	400	0,10	145	75	0.022"
22GA	30	0.02"	0.08"	400	0,20	145	75	0.023"
20GA	30	0.02"	0.08"	400	0,20	145	75	0.024"
18GA	40	0.02"	0.08"	400	0,30	140	75	0.025"
16GA	40	0.02"	0.08"	400	0,50	110	75	0.026"
14GA	40	0.02"	0.08"	400	0,50	105	75	0.026"
12GA	45	0.02"	0.08"	400	0,60	115	85	0.027"
10GA	45	0.02"	0.08"	400	0,70	73	85	0.028"