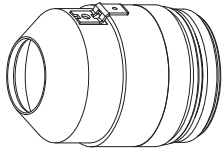


# OPERATION

## Stainless steel F5 Plasma / N<sub>2</sub> Shield 80 A Cutting

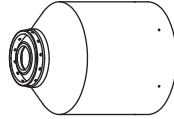
Flow rates - lpm/scfh		
	F5	N <sub>2</sub>
Preflow	0 / 0	67 / 142
Cutflow	31 / 65	87 / 185



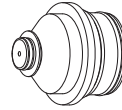
220173



220338



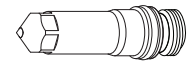
220304



220337



220179



220339

### Metric

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					mm	Volts	
F5	N <sub>2</sub>	35	30	60	75	4	108	3.0	2180	4.5	150	0.2
						6	112	2.5	1225	3.8		0.3
						10	120	3.0	560	4.5		0.5

### English

Select Gases		Set Preflow		Set Cutflow		Material Thickness	Arc Voltage	Torch-to-Work Distance	Cutting Speed	Initial Pierce Height		Pierce Delay Time
Plasma	Shield	Plasma	Shield	Plasma	Shield					in	Volts	
F5	N <sub>2</sub>	35	30	60	75	.135	108	0.120	105	0.180	150	0.2
						3/16	110	0.110	60	0.170		0.3
						1/4	112	0.100	45	0.150		
						3/8	120	0.120	25	0.180		0.5

### Marking

Select Gases		Set Preflow		Set Cutflow		Amperage	Torch-to-Work Distance		Marking Speed		Arc Voltage
N <sub>2</sub>	N <sub>2</sub>	10	10	10	10		mm	in	mm/min	ipm	
N <sub>2</sub>	N <sub>2</sub>	10	10	10	10	15	2.5	0.100	6350	250	95