




**Weldclass**  
Be Outstanding



PH: 1300 262 288

# Cutting Chart

## Hypertherm Powermax 85 Plasma

Material	Plasma		THC	SheetCAM Jet Tool Settings							
Thickness (mm)	Torch Parts	Amps	 * Volts	Type	Kerf Width (mm)	Feed Rate (mm/sec)	Pierce Delay (sec)	Pierce Height (mm)	Plunge Rate (mm/s)	Cutting Height (mm)	Pause at End of Cut (mm)

\* Refer to 'Voltage/Height Calibraion' instructions in Operator Guide

### MILD STEEL

0.5	FineCut	40		Plasma	0.7	137.5	0	3.8	17.0	1.5	0.0
0.6	FineCut	40		Plasma	0.7	137.5	0	3.8	17.0	1.5	0.0
0.8	FineCut	40		Plasma	0.7	137.5	0.1	3.8	17.0	1.5	0.0
1	FineCut	45		Plasma	0.7	137.5	0.2	3.8	17.0	1.5	0.0
1.5	FineCut	45		Plasma	1	106.7	0.4	3.8	17.0	1.5	0.0
2	FineCut	45		Plasma	1.3	87.5	0.4	3.8	17.0	1.5	0.0
3	FineCut	45		Plasma	1.3	45.8	0.5	3.8	17.0	1.5	0.0
4	FineCut	45		Plasma	1.4	31.7	0.6	3.8	17.0	1.5	0.0
6	65 Amp	65		Plasma	1.8	42.5	0.5	3.8	17.0	1.5	0.0
8	65 Amp	65		Plasma	1.9	28.3	0.5	3.8	17.0	1.5	0.0
10	65 Amp	65		Plasma	2	18.3	0.7	4.5	17.0	1.5	0.1
12	85 Amp	85		Plasma	2.2	21.3	0.7	4.5	17.0	1.5	0.1
16	85 Amp	85		Plasma	2.4	14.5	1	4.5	17.0	1.5	0.1
20	85 Amp	85		Plasma	2.6	9.5	1.5	6.0	17.0	1.5	0.1

### STAINLESS STEEL

0.5	FineCut	40		Plasma	0.6	137.5	0	2.0	17.0	0.5	0.0
0.6	FineCut	40		Plasma	0.6	137.5	0	2.0	17.0	0.5	0.0
0.8	FineCut	40		Plasma	0.6	137.5	0.1	2.0	17.0	0.5	0.0
1	FineCut	45		Plasma	0.6	137.5	0.2	2.0	17.0	0.5	0.0
1.5	FineCut	45		Plasma	1	102.5	0.4	2.0	17.0	0.5	0.0
2	FineCut	45		Plasma	1.4	80.0	0.4	2.0	17.0	0.5	0.0
3	FineCut	45		Plasma	1.5	42.5	0.5	2.0	17.0	0.5	0.0
4	FineCut	45		Plasma	1.6	17.5	0.6	2.0	17.0	0.5	0.0
6	65 Amp	65		Plasma	1.8	40.8	0.5	3.8	17.0	1.5	0.0
8	65 Amp	65		Plasma	1.9	25.0	0.7	3.8	17.0	1.5	0.0
10	65 Amp	65		Plasma	2	16.0	0.7	4.5	17.0	1.5	0.1
12	85 Amp	85		Plasma	2.3	18.3	0.7	4.5	17.0	1.5	0.1
16	85 Amp	85		Plasma	2.4	11.7	1	4.5	17.0	1.5	0.1

### ALUMINIUM

2	65 Amp	65		Plasma	1.9	146.7	0.1	3.8	17.0	1.5	0.0
3	65 Amp	65		Plasma	1.9	123.3	0.2	3.8	17.0	1.5	0.0
4	65 Amp	65		Plasma	1.9	100.0	0.5	3.8	17.0	1.5	0.0
6	65 Amp	65		Plasma	1.9	53.3	0.5	3.8	17.0	1.5	0.0
8	65 Amp	65		Plasma	2	32.5	0.7	3.8	17.0	1.5	0.0
10	65 Amp	65		Plasma	2.1	20.0	0.7	4.5	17.0	1.5	0.1
12	85 Amp	85		Plasma	2.3	24.2	0.7	4.5	17.0	1.5	0.1
16	85 Amp	85		Plasma	2.5	15.8	1	4.5	17.0	1.5	0.1