

GPN, GPNL, HPN

| Metal Thickness | Tip Size | Cutting Oxygen (PSIG) | Preheat Oxygen (PSIG)* | Preheat Fuel Gas (PSIG) | Speed I.P.M. | Kerf width |
|-----------------|----------|-----------------------|------------------------|-------------------------|--------------|------------|
| 1/8" | 000 | 20/25 | See Below | 3/5 | 24/28 | .04 |
| 1/4" | 00 | 20/25 | | 3/5 | 21/25 | .05 |
| 3/8" | 0 | 25/30 | | 3/5 | 20/24 | .06 |
| 1/2" | 0 | 30/35 | | 3/5 | 18/22 | .06 |
| 3/4" | 1 | 30/35 | | 3/6 | 15/20 | .08 |
| 1" | 2 | 35/40 | | 3/6 | 14/18 | .09 |
| 1 1/2" | 2 | 40/45 | | 5/9 | 12/16 | .09 |
| 2" | 3 | 40/45 | | 5/9 | 10/14 | .10 |
| 2 1/2" | 3 | 45/50 | | 6/10 | 9/12 | .10 |
| 3" | 4 | 40/50 | | 8/12 | 8/11 | .12 |
| 4" | 5 | 45/55 | | 8/12 | 7/10 | .14 |
| 5" | 5 | 50/55 | | 8/12 | 6/9 | .14 |
| 6" | 6** | 45/55 | | 10/15 | 5/7 | .17 |
| 8" | 6** | 55/65 | | 10/15 | 4/6 | .18 |
| 12" | 8** | 60/70 | | 10/15 | 3/5 | .24 |



* Applicable for 3-hose machine cutting torches only. With a 2-hose cutting torch, preheat pressure is set by the cutting oxygen.
 ** For best results use appropriate capacity torches and 3/8" hose when using tip size 6 or larger. Torches with flashback arrestors require up to 25% more pressure as tip size increases (15 PSI maximum acetylene pressure). *** All pressures are measured at the regulator using a 25' X 1/4" hose through tip size 5 and 25' X 3/8" hose for tip size 6 and larger.