# Performance table flame cutting
# Block nozzles Mapp / Tetrene
## ZIN416 6/87

CUTTING WELDING SINCE 1898 ZINSER

| Material thickness mm | Nozzle | Heating nozzle HSD Y | Pressures (bar) | | Cutting speed mm / min | Consumption ltrs / h | |
|---|---|---|---|---|---|---|---|
| | | | Mapp / Tetrene | Oxygen | | Mapp / Tetrene | Oxygen |
| 3 | 3 - 10 | 3 - 100 | 0.2 - 0.3 | 1.0 - 1.5 | 690 - 770 | 160 | 2000 |
| 5 | | | | | 670 - 740 | | |
| 6 | | | | | 650 - 730 | | |
| 8 | | | | | 550 - 650 | | |
| 10 | | | | | 500 - 610 | | |
| 10 | 10 - 30 | | 0.2 - 0.3 | 1.5 - 2.5 | 530 - 590 | 220 | 3150 |
| 15 | | | | | 420 - 490 | | |
| 20 | | | | | 470 - 530 | | |
| 25 | | | | | 420 - 480 | | |
| 30 | | | | | 370 - 410 | | |
| 30 | 30 - 60 | | 0.2 - 0.3 | 2.5 - 3.5 | 320 - 340 | 280 | 4870 |
| 40 | | | | | 300 - 330 | | |
| 45 | | | | | 280 - 320 | | |
| 50 | | | | | 250 - 290 | | |
| 60 | | | | | 200 - 260 | | |
| 60 | 60 - 100 | | 0.2 - 0.3 | 3.5 - 4.5 | 210 - 250 | 330 | 7520 |
| 80 | | | | | 200 - 230 | | |
| 100 | | | | | 180 - 200 | | |
| 100 - 160 | 100 - 160 | 100 - 300 | 0.5 | 8.5 - 9.5 | 235 - 190 | 600 | 22000 |
| 160 - 230 | 160 - 230 | | | 7.0 - 8.5 | 190 - 150 | | |
| 230 - 300 | 230 - 300 | | | 6.5 - 8.5 | 140 - 110 | | |

The indicated values are approximate values and refer only to unalloyed steel up to 0.3 % C and if using oxygen with a purity of 99.5 % minimum.

The indicated cutting speeds refer to straight cuts with a rust-free surface. Cutting areas of a quality class I according to DIN 2310 will be obtained.

The indicated cutting speeds have to be reduced for shaping cuts with small radii by approx. 10%, for angular cuts of 30° by approx. 25 %, for angular cuts of 45° by approx. 45 %.

Nozzle size and the appropriate adjusting values have to correspond to the effective cutting thickness.

The indicated pressures are overpressures in bar, each measured at the torch entry. In case of higher-powered machines pressure drops in the hose pipe have to be taken into account.