

Performance table flame cutting HSD Acetylene - Rapid speed nozzles ZIN437 5/92

CUTTING
WELDING
SINCE 1898



Material- thickness mm	Cutting nozzle HSD A	Heating nozzle HSD A and P	Pressures (bar)			Cutting speed mm / min	Nozzle distance mm	Kerf mm	Consumption ltrs / h																	
			Acetylene	Heating oxygen	Cutting oxygen				Acetylene	Heating oxygen	Cutting oxygen															
3	3 - 6	3 - 100	0.2	1.0	2.5	740	3 - 5	0.9	350	390	550															
5						720																				
6						700																				
6	4.0				710																					
8					670																					
10					620																					
10	10 - 20		0.4	2.0	5.0	640	4 - 8	1.3	400	450	2500															
15						550																				
20						460																				
20	20 - 30				6.0	2.0						480	5 - 10	1.5	400	450	3500									
25												440														
30												400														
30	30 - 45	0.4	2.0	6.0	420	5 - 10	1.7	400	450	4800																
35					400																					
40					380																					
45					360																					
45	45 - 60				0.5						2.5	6.0	380	5 - 10	1.9	400	450	6100								
50													360													
55													340													
60													320													
60	60 - 80												0.5						2.5	6.0	340	5 - 10	2.1	480	530	8000
70																					310					
80																					290					
80	80 - 100																				0.5					
90		270																								
100		250																								

For material thickness exceeding 100 mm. use ZHD-nozzles / Methan (ZIN440).

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 on the torch entry. In case of higher-powered machines. pressure drops in the hose pipes have to be taken into account.