

**Performance table flame cutting**  
**HSD Mapp / Tetrene - Rapid speed nozzles**  
**ZIN439 5/92**

CUTTING  
WELDING  
SINCE 1898



Material- thickness mm	Cutting nozzle HSD P and Y	Heating nozzle HSD Y	Pressures (bar)			Cutting speed mm / min	Nozzle distance mm	Kerf mm	Consumption ltrs / h		
			Mapp / Tetrene	Heating oxygen	Cutting oxygen				Mapp / Tetrene	Heating oxygen	Cutting oxygen
3	3 - 6	3 - 100	0.1	1.0	2.5	700	3 - 5	0.9	300	750	550
5						680					
6						650					
6	4.0				670						
8					620						
10					590						
10	10 - 20		0.3	1.5	5.0	600	4 - 8	1.3	350	900	2500
15						530					
20						450					
20	20 - 30				460						
25					430						
30					390						
30	30 - 45	0.4	2.0	6.0	400	5 - 10	1.7	350	900	4800	
35					380						
40					370						
45					350						
45	45 - 60				360						
50					330						
55				320							
60				300							
60	60 - 80			320							
70				300							
80				280							
80	80 - 100			280							
90		260									
100		240									

For material thickness exceeding 100 mm. use ZHD-nozzles / Acetylene (ZIN442)

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.