

Performance table flame cutting ZHD Mapp / Tetrene - Heavy-duty nozzles ZIN442 5/92



Material-thickness mm	Cutting nozzle ZHD P and Y	Heating nozzle ZHD 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	1.5	760	3 - 5	0.9	300	750	500					
5					2.0	730										
6					2.5	710										
6	6 - 10				4.0	700		1.1	300	750	1300					
8					4.5	680										
10					5.0	650										
10	10 - 20		0.3	1.5	6.5	660	4 - 8	1.8	350	900	3300					
15					7.5	570										
20					8.5	530										
20	20 - 30				8.0	540		2.1	350	900	3800					
25					8.5	510										
30					9.0	440										
30	30 - 45	0.4	2.0	8.5	440	5 - 10	2.3	350	900	4200						
35				9.0	420											
40				9.0	400											
45				9.5	380											
45				45 - 60	8.0						380	2.4	350	900	5400	
50	8.5				360											
55	8.5				350											
60	60 - 80			9.0	330		2.5	400	1070	8300						
60				8.5	320											
70				9.0	300											
80				8.5	290											
80	80 - 100			0.5	3.5		8.5	270	8 - 12	4.0	600	1900	16300			
90		8.5	270													
100		9.0	260													
100		100 - 160	8.5			235	5.0	600						2650	22000	
120	9.0		220													
140	9.0		215													
160	9.5		190													
160	160 - 230	0.5	3.5			8.5	190	10 - 15		6.0	600	2650	26500			
180						7.0	180									
200						7.5	165									
230						8.5	150									
230	230 - 300					4.0	4.0							6.5	140	6.0
250				7.0	130											
280				7.5	120											
300				8.5	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 on the torch entry. In case of higher-powered machines, pressure drops in the hose pipes have to be taken into account.