



## Torchmate CNC cut parameters for Tomahawk 625

### Mild Steel 40 Amp Standard Consumables:

Material Thickness (Inches)	Standoff Height (Inches)	Cut Speed (Inches/Min)	Tool Compensation (Inches)
20 GA. (0.0359")	0.06"	315 in/min *	0.025"
18 GA. (0.0478")	0.06"	245 in/min *	0.025"
16 GA. (0.0598")	0.08"	225 in/min *	0.025"
14 GA. (0.0747")	0.08"	150 in/min	0.028"
12 GA. (0.1046")	0.08"	105 in/min	0.030"
1/8" (0.125")	0.1"	90 in/min	0.033"
3/16" (0.1875")	0.1"	40 in/min	0.038"
1/4" (0.250")	0.1"	22 in/min	0.055"
3/8" (0.375")	0.1"	12 in/min	0.091"

### Stainless Steel 40 Amp Standard Consumables:

Material Thickness (Inches)	Standoff Height (Inches)	Cut Speed (Inches/Min)	Tool Compensation (Inches)
20 GA. (0.0375")	0.06"	305 in/min *	0.025"
18 GA. (0.050")	0.06"	230 in/min *	0.025"
16 GA. (0.0625")	0.08"	210 in/min *	0.025"
14 GA. (0.0781")	0.08"	130 in/min	0.029"
12 GA. (0.1094")	0.08"	95 in/min	0.033"
1/8" (0.125")	0.1"	85 in/min	0.034"
3/16" (0.1875")	0.1"	35 in/min	0.039"
1/4" (0.250")	0.1"	18 in/min	0.056"

### Aluminum 40 Amp Standard Consumables:

Material Thickness (Inches)	Standoff Height (Inches)	Cut Speed (Inches/Min)	Tool Compensation (Inches)
20 GA. (0.0320")	0.06"	345 in/min *	0.025"
18 GA. (0.0403")	0.06"	320 in/min *	0.029"
16 GA. (0.0508")	0.08"	300 in/min *	0.029"
14 GA. (0.0641")	0.08"	245 in/min*	0.031"
12 GA. (0.0808")	0.08"	200 in/min*	0.032"
10 GA. (0.109")	0.08"	130 in/min	0.035"
1/8" (0.125")	0.1"	95 in/min	0.041"
3/16" (0.1875")	0.1"	45 in/min	0.049"

\* Where cut speed is greater than 150 in/min it is recommended to reduce cut amperage to allow the cut speed to be set below 150 in/min for optimal shape quality.