Cut settings in 2D Profile Menu:

Tool Tab

Tool:
Select your machine (that you created in the tool library)

Cutting Mode:

Feed **(Use cut chart for your Plasma cutter)**

Preset

Cutting Feedrate

Lead-in Feedrate

Lead-out Feedrate

Geometry Tab

Contour Selection:

This is where you select what Geometry you want to cut.

Select same plane faces:

Hover over this to see Fusions good overview on this.

Loops:

Hover over this to see Fusions good overview on this.

Side:

Hover over this to see Fusions good overview on this.

Tabs:
This is used when you have a part you are cutting and it may tip up and get in the way of the torch when moving to the next cut. Adding tabs keeps this from happening, when done you cut tabs and remove part from sheet.
 Hover over this as Fusion give a good overview of what tabs do.

Heights Tab

Clearance Height:

From: Retract Height
Offset: .4

Retract Height:

From:Stock Top
Offset: .2

Top Height:

From: Stock Top
Offset: 0

Passes Tab

Tolerance:

.0004 is the default which creates a larger file when that is not really needed with plasma cutting.
.004 would be a much smaller file and will work fine for plasma

Sideways compensation:

Compensation type:

Finishing overlap:

This will make the torch continue past the end of the cut. You would use this when cutting thick material over 1/2" to make sure the parts gets completely out.

Outer corner mode:

See fusions Overview on this.

Preserve order:

Stock to leave:

To adjust clearance for a piece of geometry without changing the base design. it can be used as -minus stock to leave to increase clearance of a hole or slot.

Smoothing:

Use this when cutting any art or drawing style type cut. For simple shapes with mostly straight lines its not needed.

Feed Optimization:
Apply it to inside radii under 3/4" in material over 1/8" . mostly bolt holes in thicker materials.

Linking Tab

Lead in

Lead in Radius:

I'll do a smaller radius .02" or greater on most geometry. on thick holes I use about 1/2 the radius of the hole for " lead in radius"

example .30"hole has a radius of .15" so a lead in radius of .075" but once a hole gets larger enough then just treat it as a standard piece of geometry. *you may remove your lead in for bolt holes in thick material and just rely on the lead in radius length.

Lead in sweep angle:

For the angle stick with 60deg unless you have to fit into something very narrow.

On holes in material thicker than 1/8" use 160deg but once a hole gets larger enough then just treat it as a standard piece of geometry.

Lead in distance:

A starting point is double your kerf width, then reduced from there if its needed to fit into smaller geometry.

Lead Out:

Same as lead in:

Piercing

Pierce clearance:

The default length is your Kerf width, but it can be set to zero if you are having trouble fitting it into geometry. (note center line cutting it is always set to zero)

Positions

Entry Positions:

The lead in and out will sometime put a small blemish on the cut in that area we are given. This gives you the option to choose a less noticeable area of our part.