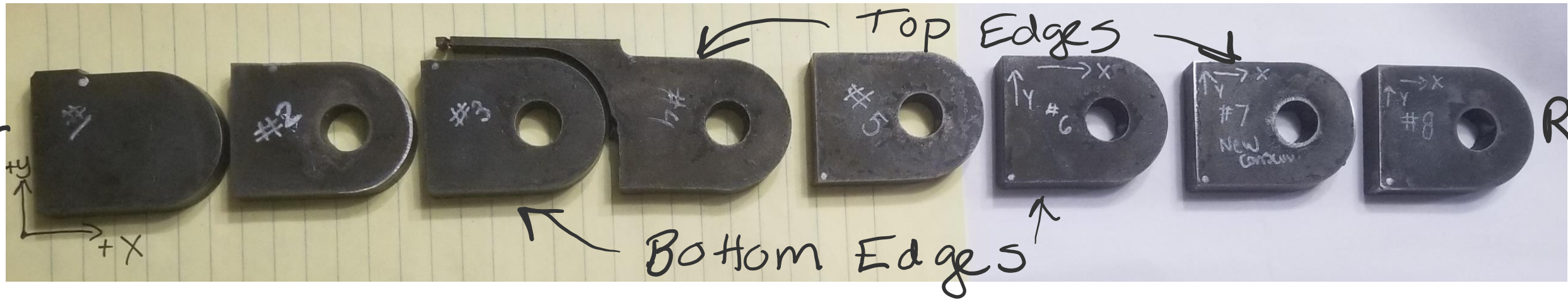
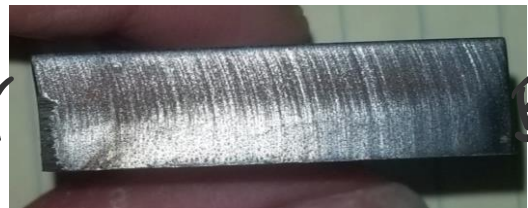


Cut Orientation for all 8 pieces. White dots indicate starting point.



#1
26 ipm, 0.060" Cut Height
Positive Taper on Top & Bottom Edges



#2
23 ipm, 0.060" Cut Height
Negative Taper on Top Edge
Positive Tap on Bottom Edge

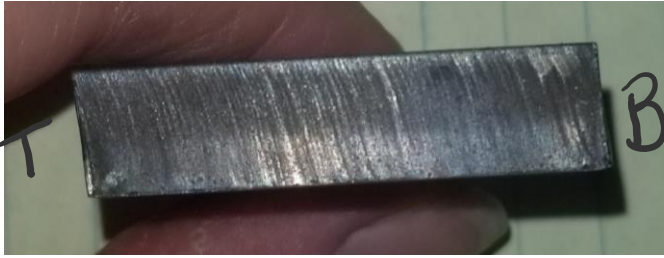


#3
18 ipm, 0.060" Cut Height
Minimal Positive Taper on Top Edge
Negative Taper on Bottom Edge

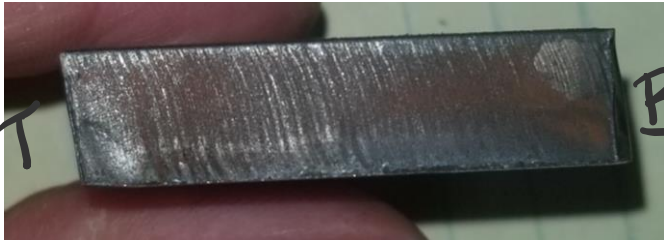
- Parts were cut from a piece of 1.5 wide 3/8" thick Hot Rolled steel bar.
- All 8 pieces were cut individually with slight modifications to settings in an attempt to reduce the taper.
- Taper is most significant on the top and bottom edges (X direction cuts) on every single part.
- Perimeter cut direction was clockwise for all parts.



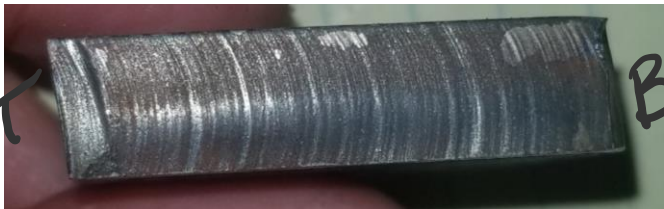
#4
18 ipm, 0.058" Cut Height
Minimal Positive Taper on Top Edge
Negative Taper on Bottom Edge



#5
18 ipm, 0.058" Cut Height, new start pt.
Positive Taper on Top Edge
Negative Taper on Bottom Edge



#6
15 ipm, 0.058" Cut Height
Positive Taper on Top Edge
Negative Taper on Bottom Edge



#7
18 ipm, 0.058" Cut Height, All Brand New Consumables
Positive Taper on Top Edge
Negative Taper on Bottom Edge



#8
18 ipm, 0.058" Cut Height, Adjusted Torch in holder.
Positive Taper on Top Edge
Negative Taper on Bottom Edge