



## Mach1 Ripper

Material Thickness	Tip Size	Gas P.S.I.	Cutting Oxygen P.S.I.
2-4	4	6-8	65-75
6-8	6	9-11	75-85
8-10	8	12-15	85-90
12-15	10	16-18	90-110

Suggested Pressures

## HEATING HEAD CHART

HD Size	Gas P.S.I.	Oxygen P.S.I.	Gas Consumption lbs./Hr	Oxygen Consumption CFH	BTU PER HOUR
HD-1	15-20	60-80	8-11	100-180	250,000
HD-2	15-20	60-80	11-17	200-300	375,000
HD-3	15-20	60-100	17-22	350-460	500,000
HD-4	20-35	90-120	28-39	600-800	875,000
HD-5	30-50	100-150	44-55	900-1150	1,250,000

Suggested Pressures

Not for use with Acetylene  
[www.gasinnovations.com](http://www.gasinnovations.com)  
 281-471-2200



## FS HAND CUTTING CHART

Material Thickness	Tip Size	Gas P.S.I.	Cutting Oxygen P.S.I.	Travel Speed I.P.M
1/8-1/4	0000	3-6	30-50	21-31
3/8	000	3-6	30-50	20-29
1/2	00	6-11	30-50	17-27
5/8	00	6-11	40-50	16-23
3/4	0	6-11	40-50	15-22
7/8	1	6-11	40-50	14-21
1-1 1/2	1	6-11	40-50	13-20
2-2 1/2	2	6-11	50-60	11-14
3	3	6-11	50-60	7-14
4	4	6-11	50-60	6-11
5	5	6-11	60-70	6-11
6	5	6-11	60-70	4-9
7	6	11-16	60-70	4-9
8	6	11-16	60-70	3-7
9	7	11-16	60-70	3-7
10	8	11-16	60-70	3-6
12	9	11-16	60-70	2-5
14	10	11-16	60-80	2-3
Gouging Tip	2,4,6,8	15-20	50-110	



**FSH**

**HIGH SPEED CUTTING CHART**

Material Thickness	Tip Size	Gas P.S.I.	Cutting Oxygen P.S.I.	Travel Speed I.P.M	Kerf Width
1/4	0000	4-6	60-70	23-33	.06
3/8	000	4-6	60-70	23-33	.07
1/2	00	4-6	60-70	21-31	.07
3/4	0	5-9	60-70	20-29	.08
1	1	5-9	60-70	18-28	.08
1 1/2	2	5-9	60-70	13-20	.09
2	2	5-9	60-70	12-18	.10
2 1/2	3	6-11	70-80	10-16	.11
3	3	6-11	70-80	8-14	.11
4	4	8-12	75-100	9-15	.13

Suggested Pressures

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**FSHS**

**HIGH SPEED CUTTING CHART  
 STAINLESS INSERT**

Material Thickness	Tip Size	Gas P.S.I.	Cutting Oxygen P.S.I.	Travel Speed I.P.M	Kerf Width
1/4	0	6-8	60-85	29-33	.04-.05
3/8	0	8-10	60-85	29-33	.04-.05
1/2	1	9-10	60-85	25-31	.05
3/4	2	9-10	60-85	29-18	.06-.07
1	2	9-10	60-85	29-18	.06-.07
1 1/2	3	9-10	60-85	13-20	.08
2	4	9-11	60-85	13-18	.10
2 1/2	5	9-11	60-85	8-15	.11-.13
4-5	6	9-11	80-95	6-14	.13-.14
6-8	7	9-11	110-120	5-7.5	.14-.18
10+	8	9-12	120	3-4	.20-.24

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