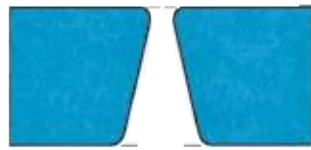


## Adjustment recommendation for perfect machine cutting



### Narrowing of kerf (divergent)

- Forward speed of torch too fast
- Distance between nozzle and sheet metal too big
- Dirty and / or damaged nozzle



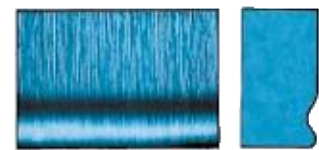
### Narrowing of kerf (convergent)

- Forward speed of torch too fast
- Distance between nozzle and sheet metal too big
- Cutting oxygen pressure too high



### Concave cut surface beneath top edge

- Cutting oxygen pressure too high
- Dirty and / or damaged nozzle
- Distance between nozzle and sheet metal too big



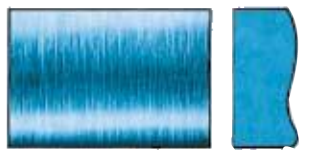
### Step at bottom edge

- Forward speed of torch too fast
- Dirty and / or damaged nozzle



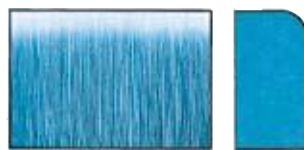
### Concave cut surface profile

- Forward speed of torch too fast
- Dirty and/or damaged nozzle or nozzle size too small for the thickness to be cut
- Cutting oxygen pressure too low



### Irregular cut surface profile

- Cutting oxygen pressure too low
- Dirty and / or damaged nozzle
- Forward speed of torch too fast



### Edge melting on

- Forward speed of torch too slow
- Heating flame too strong
- Distance between nozzle and sheet metal too big to too small
- Nozzle size too big for the thickness to be cut



### String of solidified droplets

- Heating flame too strong
- Distance between nozzle and sheet metal too small
- Scaled or corroded sheet metal surface



### Melted down top edge with adherent slag

- Cutting oxygen pressure too high
- Heating flame too strong
- Distance between nozzle and sheet metal too big



### Lower edge rounded

- Cutting oxygen pressure too high
- Forward speed of torch too fast
- Dirty and / or damaged nozzle



### Excessive cut drag line depth

- Forward speed of torch too fast or irregular
- Distance between nozzle and sheet metal too small
- Heating flame too strong



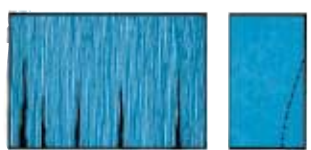
### Irregular depth of cut line

- Forward speed of torch too fast or irregular
- Flame too weak



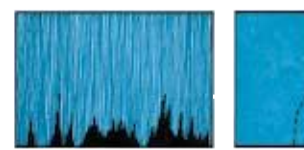
### Single gouges

- Forward speed of torch too slow
- Scaled or corroded or dirty sheet metal surface
- Distance between nozzle and sheet metal too small
- Flame too weak
- Flame extinguished with a bang
- Sheet metal with finely divided inclusions



### Grouped gouge areas

- Forward speed of torch too fast
- Scaled or corroded or dirty sheet metal surface
- Distance between nozzle and sheet metal too small
- Flame too weak



### Grouped gouges in the bottom half of the cut

- Forward speed of torch too slow
- Dirty and / or damaged nozzle



### Firmly adherent slag line at bottom edge

- Forward speed of torch too fast or too slow
- Distance between nozzle and sheet metal too big
- Cutting oxygen pressure too low
- Nozzle size too small for the thickness to be cut
- Flame too weak
- Scaled or corroded or dirty (color) sheet metal surface