

		Intensifier						X-Stream Intensifier			
		60,000 psi			75,000 psi			75,000 psi			
ORIFICE		.010/.030		.013/.040		.015/.045		.010/.030		.016/.045	
WATER		.5 gpm		.82 gpm		1.1 gpm					
ABRASIVE		.6 lb/min		1.0lb/min		1.5 lb/min		.7 lb/min		1.5 lb/min	
Hp		25		37.5		50		50		100	
		Cut Speed	Cost per In	Cut Speed	Cost per In	Cut Speed	Cost per In	Cut Speed	Cost per In	Cut Speed	Cost per In
Aluminum	1/4"	53.9	.005	72.2	.005	90.0	.006	88.6	.005	149.3	.005
	1/2"	24.2	.011	32.3	.012	40.3	.014	39.6	.011	66.8	.012
	1"	10.9	.025	14.5	.027	18.0	.031	17.73	.024	29.9	.034
Stainless 304	1/4"	17.4	.016	23.2	.017	28.9	.019	28.5	.015	48.	.017
	1/2"	7.8	.035	10.4	.038	13.0	.042	12.7	.033	21.5	.038
	1"	3.5	.078	4.7	.084	5.8	.095	5.7	.074	9.6	.084
GrahiteEpoxy	1/4"	110.0	.002	132.8	.003	154.0	.004	151	.001	151	.005
	1/2"	50.6	.005	63.0	.006	77.8	.007	76.4	.002	76.4	.011
	1"	21.2	.013	29.3	.013	36.7	.015	36.1	.006	36.1	.022
Inconel	1/4"	15.4	.019	19.2	.020	25.7	.021	25.3	.017	42.7	.019
	1/2"	6.9	.039	8.6	.046	11.5	.048	11.3	.038	19.1	.042
	1"	3.1	.088	3.9	.101	5.2	.106	5.1	.083	8.6	.094
Marble (Italian White)	1/4"	84.2	.004	101.6	.004	117.9	.005	116	.004	232	.003
	1/2"	38.7	.007	48.2	.008	59.5	.010	58.5	.007	107	.007
	1"	16.3	.017	22.5	.017	28.1	.020	27.7	.016	45	.018
Glass	1/4"	77.8	.003	93.8	.004	108.9	.005	107	.004	215	.004
	1/2"	35.8	.008	44.6	.009	55.9	.010	54.9	.026	98.8	.008
	1"	15.0	.018	20.7	.019	25.9	.022	25.4	.055	41.4	.02
Steel	1/4"	19.3	.014	25.8	.015	32.4	.017	31.6	.014	53.3	.015
	1/2"	8.7	.031	11.6	.034	14.4	.038	14.1	.03	23.9	.034
	1"	3.9	.070	5.2	.076	6.5	.085	6.3	.067	10.7	.076
Titanium	1/4"	27.6	.010	33.5	.012	44.9	.012	44.3	.010	74.7	.011
	1/2"	12.4	.022	15.	.026	20.1	.027	19.8	.021	33.4	.024
	1"	5.5	.050	6.7	.059	9.0	.062	8.9	.048	15.	.054

Notes:

1. Maximum cut speed. For quality surface finish, cut speed will be reduced by 20% to 80%.
2. Costs (\$ per inch) based on:
  - \$0.09 per KWhr - electricity
  - 80 to 120 hr mixing tube life
  - \$.029 per lb - abrasive
  - No labor costs