Programming Cut Parameters for Different Metals
Version 8.26

In order to get the best quality cut from your plasma cutter, it's important to program the correct values. Depending on the type and thickness of metal you're cutting, the following parameters should be programmed to match the material you're cutting:

Recommended amps
Cut Height aka 'Touch-to-Work Distance'
Initial Pierce Height
Pierce Delay Time*
Cut Speed*
Voltage*
Kerf width*

Fortunately, Hypertherm has extensive charts in the back of the owners manuals detailing the recommended settings for different types and thickness of material. In general, switching to a different type of material will require you to program new values for all parameters. However, changing thickness of the same material typically only requires a change of the asterisked items above.

In the CC-M4D Controller:
In the main 'Auto' menu, press 'Z', then enter half the Kerf Width value followed by the enter key.
In the main 'Auto' menu, press '0' to open the 'Spd Set' menu.
    Program the Cut Speed, then press F8 to save the value.
In the main 'Auto' menu, press 'Para' / 'Plasma'.
    Set Arc Voltage - Program Voltage.
    Cutting Height - Program Cut Height.
    Pierce Height - Program Initial Pierce Height.
    Pierce Delay - Program Pierce Delay Time.
    Press the 'F8 / Save' button to exit back to the Auto menu

On your Plasma Cutter:
Set the proper amperage value

Congratulations, you're done!