

Cutting Param

Material	Thickness	Speed (m/min)	Focus Position	Height (mm)	↑
Mild Steel	2 mm	3.5	5	0.5	
	3 mm	3	5	0.5	
	4 mm	2.3	5	0.5	
	6 mm	1.3	5	0.5	
	10 mm	0.7	4.5	0.8	
	12 mm	0.5	4.5	0.8	
	14 mm	0.35	4.5	0.8	

D

Material	Thickness	Pierce	渐进时间 (s)	Height	Type fo Gas	Pressure	
Mild Steel	2 mm	1 s		8	Oxygen	0.8	
	3 mm	1 s		8	Oxygen	0.8	
	4 mm	1		8	Oxygen	0.8	
	6 mm	1	0.5 s	8	Oxygen	0.8	
	10 mm	1	1 s		8	Oxygen	0.8
		2	0.5		12	Oxygen	0.8
	12 mm	1	1		8	Oxygen	0.8
		2	1		12	Oxygen	0.8
		3			15	Oxygen	1
	14 mm	1	1		8	Oxygen	0.8
		2	1.5		12	Oxygen	0.8
		3			15	Oxygen	1

Parameters			
Nozzle	Type of Gas	Pressure (bar)	Peak Power (%)
1.2 D	Oxygen	0.6	100
1.2 D	Oxygen	0.6	100
1.2 D	Oxygen	0.6	100
1.2 D	Oxygen	0.6	100
2.0 D	Oxygen	0.75	100
3.0 D	Oxygen	0.75	100
3.0 D	Oxygen	0.75	100

Parameters					
Peak Power (%)	Duty Cycle (%)	Pulse Frequency	Focus Position	Laser-On Delay	Extra Blow
100	45	300	-2	0.2 s	
100	45	300	-2	0.2 s	
100	45	300	-2	0.2 s	
100	45	300	-3	0.2	
100	65	300	-4	0.5	
100	50	35	-3	0.5	
100	70	180	-4	0.7	
100	70	260	-4	0.7	
100	60	55	-2	0.2	
100	70	180	-4	1	
100	70	260	-4	1	
100	60	55	-2	0.2	