

300W Таблица параметров					
Materials	Cutting thickness(m m)	Cutting speed (m /min)	Pressure (MPA)	Gas	Cutting height
Stainless steel	0.5	>12	1	N2	0.6
	1	5.4~7.2	>1.1	N2	0.6
	2	0.96~1.2	>1.5	N2	0.6
Carbon steel	1	7.2~9	1	O2	1
	2	2.1~2.7	0.6~0.8	O2	1
	3	0.9~1.1	0.3~0.5	O2	1
500W Cutting parameters.					
Materials	Cutting thickness(m m)	Cutting speed (m /min)	Pressure (MPA)	Gas	Cutting height
Stainless steel	0.5	>18	1	N2	0.6
	1	8.4~12	>1.1	N2	0.6
	2	1.8~2.4	>1.8	N2	0.6
	3	0.84~1.2	>2.0	N3	0.6
Carbon steel	1	8.4~12	1	O2	1
	2	3~4.2	0.6~0.8	O2	1
	3	1.5~2.1	0.25~0.4	O2	1
	4	1.2~1.5	0.15~0.2	O2	1
	5	0.9~1.2	0.15~0.2	O2	1
	6	0.72~0.96	0.1~0.2	O2	1
750W Cutting parameters					
Materials	Cutting thickness(m m)	Cutting speed (m /min)	Pressure (MPA)	Gas	Cutting height
Stainless steel	0.5	>21	1	N2	0.6
	1	12~18	>1.1	N2	0.6
	2	3.6~4.2	>1.5	N2	0.6
	3	1.2~1.8	>1.8	N3	0.6
	4	0.78~1.2	>2.0	N2	0.6
Carbon steel	1	12~18	1	O2	1
	2	4.2~5.4	0.6~0.8	O2	1
	3	3~3.9	0.25~0.4	O2	1
	4	1.8~2.4	0.15~0.2	O2	1
	5	1.2~1.8	0.15~0.2	O2	1

	6	0.9~1.2	0.10~0.15	O2	1
	8	0.72~1.84	0.10~0.15	O2	1
	10	0.6	0.10~0.15	O2	1
1000W Cutting parameters					
Materials	Cutting thickness(m m)	Cutting speed (m /min)	Pressure (MPA)	Gas	Cutting height
Stainless steel	0.5	>24	1	N2	0.6
	1	17~21	>1.1	N2	0.6
	2	5.4~7.2	>1.5	N2	0.6
	3	2.1~3	>2.0	N2	0.6
	4	0.8~1.5	>2.0	N2	0.6
	5	0.6~0.9	>2.0	N2	0.6
Carbon steel	1	15~18	1	O2	1
	2	5.1~6	0.5~0.8	O2	1
	3	3.5~4.2	0.25~0.4	O2	1
	4	2.3~2.7	0.15~0.2	O2	1
	5	1.7~2.1	0.15~0.2	O2	1
	6	1.2~1.8	0.10~0.15	O2	1
	8	0.9~1.1	0.10~0.15	O2	1
	10	0.6~0.72	0.10~0.15	O2	1
1200W cutting parameters					
Materials	Cutting thickness(m m)	Cutting speed (m /min)	Pressure (MPA)	Gas	Cutting height
Stainless steel	1	24	1	N2	0.6
	2	6	>1.1		0.6
	3	2.8	>1.5		0.6
	4	1.8	>2.0		0.6
	5	0.8	>2.0		0.6
Carbon steel	1	18	1	O2	1
	2	6.6	0.5~0.8		1
	3	4.5	0.25~0.4		1
	4	2	0.15~0.2		1
	5	2	0.15~0.2		1
	6	1.8	0.10~0.15		1
	8	1.3	0.10~0.15		1
	10	0.9	0.10~0.15		1
	12	0.6	0.10~0.16		1
Aluminu m	2	6.6	>1.5	N2	0.6
	3	1.8	>1.5		0.6
1500W cutting parameters					

Materials	Cutting thickness(m m)	Cutting speed (m /min)	Pressure (MPA)	Gas	Cutting height
Stainless steel	1	25	1	N2	0.6
	2	7	1.4		0.6
	3	4	1.8		0.6
	4	2	1.8		0.6
	5	1.3	2		0.6
	6	0.7	2		0.6
Carbon steel	1	25	1	O2	1
	3	4	0.12		1
	6	1.6	0.14		1
	8	1.2	0.14		1
	10	1	0.16		1
	12	0.8	0.18		1
	14	0.6	0.2		1
	16	0.5	0.05		1
Aluminum	1	16	1.2	N2	0.6
	2	6	1.4		0.6
	3	2.5	1.8		0.6
	4	1.3	2		0.6
Brass	2	4	1.6		0.6
	3	1.5	1.8		0.6
Pure copper	2	2	1		0.6

2000W Cutting parameters

Materials	Cutting thickness(m m)	Cutting speed (m /min)	Pressure (MPA)	Gas	Cutting height
Stainless steel	0.5	>30	1	N2	0.6
	1	24~27	>1.1		0.6
	2	9~11	>1.5		0.6
	3	5.1~6	>2.0		0.6
	4	3~3.6	>2.0		0.6
	5	1.5~2.1	>2.0		0.6
	6	0.9~1.2	>2.0		1
	8	0.5~0.6	>2.0		1
Carbon steel	3	4.2~4.8	1	O2	1
	5	3~3.3	0.5~0.8		1
	6	2.1~2.7	0.25~0.4		1
	8	1.2~1.8	0.15~0.2		1
	10	1.1~1.5	0.15~0.2		1

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Carbon steel	12	0.96~1.2	0.10~0.15	02	1
	14	0.9~1.1	0.10~0.15		1
	16	0.78~0.9	0.10~0.15		1
	20	0.6~0.72	0.10~0.15		1

2200W Cutting parameters

Materials	Cutting thickness(m m)	Cutting speed (m /min)	Pressure (MPA)	Gas	Cutting height
Stainless steel	0.5	>30	1	N2	0.6
	1	25~29	>1.1		0.6
	2	10~12	>1.5		0.6
	3	5.1~6	>2.0		0.6
	4	3~3.6	>2.0		0.6
	5	1.5~2.1	>2.0		0.6
	6	0.9~1.2	>2.0		1
	8	0.5~0.6	>2.0		1
Carbon steel	3	4.2~4.8	1	02	1
	5	3~3.3	0.5~0.8		1
	6	2.1~2.7	0.25~0.4		1
	8	1.2~1.8	0.15~0.2		1
	10	1.1~1.5	0.15~0.2		1
	12	0.96~1.2	0.10~0.15		1
	14	0.9~1.1	0.10~0.15		1
	16	0.78~0.9	0.10~0.15		1
	20	0.6~0.72	0.10~0.15		1
	22	0.5~0.68	0.10~0.15		1