

CL-460 2m x 4m PARAMETER TABLES

MILD STEEL

N₂ Assist

	Thickness (inch)			0.036	0.048	0.060	0.075	0.105	0.120	0.135	0.188	0.250
	Thickness (gage)			20	18	16	14	12	11	10	3/16	1/4
	Parameters											
Pierce	Pierce mode			No	No	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)			n/a	n/a	0.02	0.03	0.05	0.08	0.10	0.20	0.30
	Laser power (Watt)			n/a	n/a	6000	6000	6000	6000	6000	6000	6000
	Beam size			n/a	n/a	160	160	160	160	160	160	160
	Frequency (Hz)			n/a	n/a	2000	2000	2000	2000	2000	2000	2000
	Duty cycle (%)			n/a	n/a	100	100	100	100	100	100	100
	Z hold distance (inch)			n/a	n/a	0.1	0.1	0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From			n/a	n/a	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To			n/a	n/a	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Assist gas type			n/a	n/a	N2	N2	N2	N2	N2	N2	N2
	Assist gas press (psi)			n/a	n/a	30	30	30	30	30	30	30
Pierce Monitor	Beam on time			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Nozzle Reflection			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Detect pierce thru			n/a	n/a	Off	Off	Off	Off	Off	Off	Off
	Pierce thru check time			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
Rapid Pierce	Laser power (Watt)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Standoff (inch)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Pierce time (sec)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Cool time (sec)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Airblast off time (sec)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Airblast on time (sec)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Assist gas press (psi)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Ramped Pierce			No	No	No	No	No	No	No	No	No
Cutting	Laser power (Watt)			6000	6000	6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)			2000	2000	2000	2000	2000	2000	2000	2000	2000
	Duty cycle (%)			100	100	100	100	100	100	100	100	100
	Feedrate (ipm)			485	390	330	300	215	205	175	130	110
	Pre-cut dwell (sec)			0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	Kerf width (inch)			0.008	0.008	0.009	0.009	0.010	0.010	0.010	0.011	0.012
	Power burst time (sec)			0.05	0.05	0.10	0.10	0.10	0.10	0.10	0.10	0.00
	Beam size			160	160	160	160	160	160	160	160	160
	Dynamic pwr control			On	On	On	On	On	On	On	On	Off
	Dynamic assist gas			Off	Off	Off	Off	Off	Off	Off	Off	Off
	Standoff (inch) [NC]			0.025	0.025	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Optional standoff (inch)			0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025
	Assist gas type			N2	N2	N2	N2	N2	N2	N2	N2	N2
	Assist gas Pressure 1			125	120	70	70	70	70	70	70	70
	Optional Pressure 2			125	120	150	170	180	180	200	200	230
Loss of Cut Detect	Loss of Cut Detection			Off	Off	Off	Off	On	On	On	On	On
	Nozzle Reflection			n/a	n/a	n/a	n/a	Med	Med	Med	High	High
	Response Time			n/a	n/a	n/a	n/a	Slow	Slow	Slow	Fast	Fast
DPC	DPC feedrate (ipm)			390	310	265	240	170	165	140	105	n/a
	DPC min power (%)			25	20	20	20	25	10	20	20	n/a
Focus / DAG	Pierce focus ramp			0.000	0.000	0.000	0.000	0.000	0.000	0.000	0.000	0.000
	NF Pierce Focus: From			-0.060	-0.060	-0.090	-0.120	-0.140	-0.140	-0.130	-0.310	-0.220
	FF Pierce Focus: From			-0.040	-0.050	-0.090	-0.070	-0.110	-0.110	-0.090	-0.240	-0.150
	NF Cut focus			-0.060	-0.060	-0.090	-0.120	-0.140	-0.140	-0.130	-0.310	-0.220
	FF Cut focus			-0.040	-0.050	-0.090	-0.070	-0.110	-0.110	-0.090	-0.240	-0.150
	DAG; NF Press 1 (psi)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; FF Press 1 (psi)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; NF Press 2 (psi)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; FF Press 2 (psi)			n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Focusing lens (inch)			5	5	5	5	5	5	5	7.5	7.5
	Nozzle tip			060 hc	060 hc	060 hc	080 hc	080 hc	080 hc	080 hc	100 cfn	100 cfn
	Nozzle tip nut			Std	Std	Std	Std	Std	Std	Std	Std	Std

MILD STEEL

O₂ Assist

	Thickness (inch)	0.075	0.105	0.120	0.135	0.188	0.250	0.313	0.375	0.500	0.625	0.750	1.000
	Thickness (gage)	14	12	11	10	3/16	1/4	5/16	3/8	1/2	5/8	3/4	1
	Parameters												
Pierce	Pierce mode	Fixed	Fixed	Fixed	Fixed	Adapt	Adapt	Adapt	Adapt	Adpt	Adpt	Adpt	Adpt
	Pierce time (sec)	0.15	0.15	0.16	0.20	.50	.70	1.0	2.0	3.0	3.0	6.0	12.0
	Laser power (Watt)	3000	3000	4000	4000	4000	4000	6000	6000	6000	6000	6000	6000
	Beam size	170	170	170	170	180	160	180	180	180	180	170	170
	Frequency (Hz)	2000	2000	2000	2000	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Duty cycle (%)	100	100	100	100	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Z hold distance (inch)	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0	0	0	0
	Standoff ramp: From	0.100	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.200	0.200	0.200
	Standoff ramp: To	0.100	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Assist gas type	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2
	Assist gas press (psi)	8	8	8	8	6	6	6	6	6	6	6	6
Pierce Monitor	Beam on time	n/a	n/a	n/a	n/a	1mSec	1mSec	1mSec	1mSec	1mSec	1mSec	1mSec	1mSec
	Nozzle Reflection	n/a	n/a	n/a	n/a	Med	Med	Med	Med	Med	Med	Med	Med
	Detect pierce thru	Off	Off	Off	Off	On	On	On	On	On	On	On	On
	Pierce thru check time	n/a	n/a	n/a	n/a	0.10	0.20	0.20	0.30	0.50	0.50	0.70	0.70
Rapid Pierce	Laser power (Watt)	n/a	n/a	n/a	n/a	4000	4000	4000	4000	6000	6000	6000	6000
	Standoff (inch)	n/a	n/a	n/a	n/a	0.200	0.200	0.200	0.200	0.200	0.250	0.250	0.250
	Pierce time (sec)	n/a	n/a	n/a	n/a	0.20	0.25	0.80	0.80	1.00	1.10	1.60	2.00
	Cool time (sec)	n/a	n/a	n/a	n/a	0.10	0.10	0.20	0.20	0.20	0.60	1.40	1.50
	Airblast off time (sec)	n/a	n/a	n/a	n/a	0.20	0.20	0.60	0.60	0.50	0.90	1.20	1.50
	Airblast on time (sec)	n/a	n/a	n/a	n/a	0.10	0.10	0.40	0.40	0.70	0.80	1.80	2.00
	Assist gas press (psi)	n/a	n/a	n/a	n/a	6	6	6	6	8	8	8	8
Cutting	Ramped Pierce	No	No	No	No	No	No	No	No	No	No	No	No
	Laser power (Watt)	1000	1250	1250	1500	6000	6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)	5000	5000	5000	5000	500	500	500	500	500	500	500	500
	Duty cycle (%)	100	100	100	100	100	100	100	100	100	100	90	85
	Feedrate (ipm)	200	160	145	125	140	130	110	92	75	62	42	30
	Pre-cut dwell (sec)	0.00	0.00	0.00	0.00	0.10	0.10	0.10	0.20	0.20	0.30	0.70	0.70
	Kerf width (inch)	0.009	0.010	0.018	0.018	0.019	0.019	0.018	0.017	0.018	0.024	0.024	0.024
	Power burst time (sec)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	Beam size	170	170	170	170	180	180	180	180	180	180	220	230
	Dynamic pwr control	On	On	On	On	Off	Off	Off	Off	Off	Off	Off	Off
	Dynamic assist gas	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off
	Standoff (inch) [NC]	0.050	0.050	0.050	0.050	0.030	0.030	0.030	0.030	0.040	0.040	0.050	0.050
	Optional standoff (inch)	0.050	0.050	0.050	0.050	0.030	0.030	0.030	0.030	0.040	0.040	0.050	0.050
	Assist gas type	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2
	Assist gas Pressure 1	60	35	35	35	8	8	8	8	10	12	8	9
	Optional Pressure 2	60	35	35	35	8	8	8	8	10	12	8	9
Loss of Cut Detect	Loss of Cut Detection	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off
	Nozzle Reflection	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Response Time	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
DPC	DPC feedrate (ipm)	200	160	145	125	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DPC min power (%)	20	20	20	20	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
Focus / DAG	Pierce focus ramp	0.000	0.000	0.000	0.000	0.000	0.000	0.000	0.000	0.000	-0.150	-0.200	-0.200
	NF Pierce Focus: From	-0.020	-0.020	-0.020	-0.020	-0.100	-0.100	-0.100	-0.100	-0.100	-0.100	-0.150	-0.150
	FF Pierce Focus: From	-0.040	-0.040	-0.040	-0.040	-0.100	-0.100	-0.100	-0.100	-0.100	-0.100	-0.150	-0.150
	NF Cut focus	-0.020	-0.020	-0.020	-0.020	-0.290	-0.270	-0.260	-0.130	-0.035	-0.020	0.160	0.160
	FF Cut focus	-0.040	-0.040	-0.040	-0.040	-0.280	-0.210	-0.230	-0.040	0.025	-0.020	0.110	0.100
	DAG; NF Press 1 (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; FF Press 1 (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; NF Press 2 (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; FF Press 2 (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Focusing lens (inch)	5	5	5	5	10	10	10	10	10	10	10	10
	Nozzle tip	060 dbl	060 dbl	060 dbl	060 dbl	060 dbl	060 dbl	060 dbl	060 dbl	060 dbl	060 dbl	062 shr	062 shr
	Nozzle tip nut	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std

MILD STEEL

Air Assist

	Thickness (inch)				0.036	0.048	0.06	0.075	0.105
	Thickness (gage)				20	18	16	14	12
	Parameters								
Pierce	Pierce mode								
	Pierce time (sec)								
	Laser power (Watt)								
	Beam size								
	Frequency (Hz)								
	Duty cycle (%)								
	Z hold distance (inch)								
	Standoff ramp: From								
	Standoff ramp: To								
	Assist gas type								
	Assist gas press (psi)								
Pierce Monitor	Beam on time								
	Nozzle Reflection								
	Detect pierce thru								
	Pierce thru check time								
Rapid Pierce	Laser power (Watt)								
	Standoff (inch)								
	Pierce time (sec)								
	Cool time (sec)								
	Airblast off time (sec)								
	Airblast on time (sec)								
	Assist gas press (psi)								
	Ramped Pierce								
Cutting	Laser power (Watt)								
	Frequency (Hz)								
	Duty cycle (%)								
	Feedrate (ipm)								
	Pre-cut dwell (sec)								
	Kerf width (inch)								
	Power burst time (sec)								
	Beam size								
	Dynamic pwr control								
	Dynamic assist gas								
	Standoff (inch) [NC]								
	Optional standoff (inch)								
	Assist gas type								
	Assist gas Pressure 1								
	Optional Pressure 2								
Loss of Cut Detect	Loss of Cut Detection								
	Nozzle Reflection								
	Response Time								
DPC	DPC feedrate (ipm)								
	DPC min power (%)								
Focus / DAG	Pierce focus ramp								
	NF Pierce Focus: From								
	FF Pierce Focus: From								
	NF Cut focus								
	FF Cut focus								
	DAG; NF Press 1 (psi)								
	DAG; FF Press 1 (psi)								
	DAG; NF Press 2 (psi)								
	DAG; FF Press 2 (psi)								
	Focusing lens (inch)								
	Nozzle tip								
	Nozzle tip nut								

STAINLESS STEEL

N₂ Assist

	Thickness (inch)		0.036	0.048	0.060	0.075	0.105	0.120	0.135
	Thickness (gage)		20	18	16	14	12	11	10
Parameters									
Pierce	Pierce mode		No	No	Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)		0.00	0.00	0.02	0.04	0.10	0.15	0.20
	Laser power (Watt)		n/a	n/a	4000	4000	6000	6000	6000
	Beam size		n/a	n/a	160	160	160	160	160
	Frequency (Hz)		n/a	n/a	2000	2000	2000	2000	2000
	Duty cycle (%)		n/a	n/a	100	100	100	100	100
	Z hold distance (inch)		n/a	n/a	0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From		n/a	n/a	0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To		n/a	n/a	0.150	0.150	0.150	0.150	0.150
	Assist gas type		n/a	n/a	N2	N2	N2	N2	N2
	Assist gas press (psi)		n/a	n/a	30	30	30	20	20
Pierce Monitor	Beam on time		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Nozzle Reflection		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Detect pierce thru		n/a	n/a	Off	Off	Off	Off	Off
	Pierce thru check time		n/a	n/a	n/a	n/a	n/a	n/a	n/a
Rapid Pierce	Laser power (Watt)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Standoff (inch)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Pierce time (sec)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Cool time (sec)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Airblast off time (sec)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Airblast on time (sec)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Assist gas press (psi)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Ramped Pierce		No	No	No	No	No	No	No
Cutting	Laser power (Watt)		6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)		2000	2000	2000	2000	2000	2000	2000
	Duty cycle (%)		100	100	100	100	100	100	100
	Feedrate (ipm)		405	350	280	260	200	185	175
	Pre-cut dwell (sec)		0.000	0.000	0.000	0.000	0.000	0.000	0.000
	Kerf width (inch)		0.009	0.009	0.009	0.009	0.009	0.009	0.010
	Power burst time (sec)		0.00	0.00	0.00	0.00	0.05	0.10	0.10
	Beam size		160	160	160	160	160	160	160
	Dynamic pwr control		On	On	On	On	On	On	On
	Dynamic assist gas		Off	Off	Off	Off	Off	Off	Off
	Standoff (inch) [NC]		0.025	0.025	0.150	0.150	0.150	0.150	0.150
	Optional standoff (inch)		0.025	0.025	0.025	0.025	0.025	0.025	0.025
	Assist gas type		N2	N2	N2	N2	N2	N2	N2
	Assist gas Pressure 1		120	130	100	100	100	100	100
	Optional Pressure 2		120	130	140	150	160	175	200
Loss of Cut	Loss of Cut Detection		On	On	On	On	On	On	On
	Nozzle Reflection		Med	Med	Med	Med	Med	Med	Med
	Response Time		Slow	Slow	Slow	Slow	Slow	Fast	Fast
DPC	DPC feedrate (ipm)		325	240	225	220	160	150	140
	DPC min power (%)		15	15	15	15	15	15	15
Focus / DAG	Pierce focus ramp		0.000	0.000	0.000	0.000	0.000	0.000	0.000
	NF Pierce Focus: From		-0.070	-0.060	-0.085	-0.080	-0.130	-0.120	-0.130
	FF Pierce Focus: From		-0.020	-0.020	-0.065	-0.050	-0.110	-0.070	-0.090
	NF Cut focus		-0.070	-0.060	-0.085	-0.080	-0.130	-0.120	-0.130
	FF Cut focus		-0.020	-0.020	-0.065	-0.050	-0.110	-0.070	-0.090
	DAG; NF Press 1 (psi)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; FF Press 1 (psi)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; NF Press 2 (psi)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; FF Press 2 (psi)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Focusing lens (inch)		5	5	5	5	5	5	5
	Nozzle tip		080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	080 hc
	Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std

N₂ / Air Assist

[illegible]

ALUMINUM

N₂ Assist

N ₂	Thickness (inch)	0.020	0.032	0.050	0.063	0.080	0.090	0.100	0.125	0.190	0.250	0.375	0.500
	Thickness (gage)								1/8	3/16	1/4	3/8	1/2
Parameters													
Pierce	Pierce mode	No	No	No	No	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)	n/a	n/a	n/a	n/a	0.05	0.05	0.05	0.10	0.10	0.10	1.00	3.00
	Laser power (Watt)	n/a	n/a	n/a	n/a	6000	6000	6000	6000	6000	6000	6000	6000
	Beam size	n/a	n/a	n/a	n/a	185	175	175	160	160	160	180	180
	Frequency (Hz)	n/a	n/a	n/a	n/a	2000	2000	2000	2000	2000	2000	35	35
	Duty cycle (%)	n/a	n/a	n/a	n/a	100	100	100	100	100	100	80	80
	Z hold distance (inch)	n/a	n/a	n/a	n/a	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.2
	Standoff ramp: From	n/a	n/a	n/a	n/a	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.200
	Standoff ramp: To	n/a	n/a	n/a	n/a	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.200
	Assist gas type	n/a	n/a	n/a	n/a	N2	N2	N2	N2	N2	N2	N2	O2
Pierce Monitor	Assist gas press (psi)	n/a	n/a	n/a	n/a	30	30	30	30	30	30	30	20
	Beam on time	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Nozzle Reflection	n/a	n/a	n/a	n/a	n/a	n/a	n/a	Med	Med	Med	Med	High
	Detect pierce thru	n/a	n/a	n/a	n/a	Off	Off	Off	On	On	On	On	On
Rapid Pierce	Pierce thru check time	n/a	n/a	n/a	n/a	n/a	n/a	n/a	0.10	0.10	0.10	0.10	0.80
	Laser power (Watt)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Standoff (inch)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Pierce time (sec)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Cool time (sec)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Airblast off time (sec)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Airblast on time (sec)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
Ramped	Assist gas press (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Step 0 (Time / Power)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Step 1	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Step 2	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Step 3	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Step 4	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Step 5	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Step 6	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
Cutting	Cooling	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Laser power (Watt)	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)	2000	2000	2000	2000	2000	2000	2000	2000	2000	2000	2000	2000
	Duty cycle (%)	100	100	100	100	100	100	100	100	100	100	100	100
	Feedrate (ipm)	1225	910	650	585	390	340	300	240	140	92	54	32
	Pre-cut dwell (sec)	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00
	Kerf width (inch)	0.007	0.007	0.08	0.08	0.08	0.08	0.009	0.009	0.009	0.009	0.009	0.012
	Power burst time (sec)	0	0	0	0	0	0	0	0.00	0.00	0.00	0.00	0.00
	Beam size	175	175	185	195	185	175	165	160	160	160	160	180
	Dynamic pwr control	On	On	On	On	On	On	On	On	On	On	Off	Off
	Dynamic assist gas	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off	Off
	Standoff (inch) [NC]	0.025	0.025	0.025	0.025	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.200
	Optional standoff (inch)	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.025
	Assist gas type	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2
	Assist gas Pressure 1	50	50	50	70	30	30	30	50	50	50	50	30
	Optional Pressure 2	50	50	50	70	80	80	90	100	120	120	180	200
Loss of Cut Detect	Loss of Cut Detection	On	On	On	On	On	On	On	On	On	On	On	On
	NozzleReflection	Med	Med	Med	Med	Med	Med	Med	Med	Med	Med	High	High
	Response Time	Fast	Fast	Fast	Fast	Fast	Slow	Slow	Slow	Slow	Slow	Slow	Slow
DPC	DPC feedrate (ipm)	500	500	500	465	310	270	240	192	112	72	n/a	n/a
	DPC min power (%)	30	30	30	30	30	30	30	20	30	50	n/a	n/a
Focus / DAG	Pierce focus ramp	0.000	0.000	0.000	0.000	0.000	0.000	0.000	0.000	0.000	0.000	0.000	-0.250
	NF Pierce Focus: From	-0.040	-0.050	-0.070	-0.090	-0.150	-0.150	-0.150	-0.150	-0.245	-0.260	-0.100	-0.200
	FF Pierce Focus: From	-0.030	-0.030	-0.060	-0.080	-0.130	-0.160	-0.140	-0.120	-0.145	-0.160	0.140	-0.200
	NF Cut focus	-0.040	-0.050	-0.070	-0.090	-0.150	-0.150	-0.150	-0.150	-0.245	-0.260	-0.100	0.000
	FF Cut focus	-0.030	-0.030	-0.060	-0.080	-0.130	-0.160	-0.140	-0.120	-0.145	-0.160	0.140	0.000
	DAG; NF Press 1 (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; FF Press 1 (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; NF Press 2 (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DAG; FF Press 2 (psi)	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Focusing lens (inch)	5	5	5	5	5	5	6	5	7.5	7.5	10	10
	Nozzle tip	080 hc	080 hc	080 hc	080 hc	080 Hc	080 Hc	81 Hc	080 hc	100 LS	125 sp	125 sp	125 sp
Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std

ALUMINUM

Air Assist

	Thickness (inch)			0.020	0.032	0.050	0.063	0.080	0.090
	Thickness (gage)								
	Parameters								
Pierce	Pierce mode								
	Pierce time (sec)								
	Laser power (Watt)								
	Beam size								
	Frequency (Hz)								
	Duty cycle (%)								
	Z hold distance (inch)								
	Standoff ramp: From								
	Standoff ramp: To								
	Assist gas type								
	Assist gas press (psi)								
	Beam on time								
Pierce Monitor	Nozzle Reflection								
	Detect pierce thru								
	Pierce thru check time								
Rapid Pierce	Laser power (Watt)								
	Standoff (inch)								
	Pierce time (sec)								
	Cool time (sec)								
	Airblast off time (sec)								
	Airblast on time (sec)								
	Assist gas press (psi)								
	Ramped Pierce								
Cutting	Laser power (Watt)								
	Frequency (Hz)								
	Duty cycle (%)								
	Feedrate (ipm)								
	Pre-cut dwell (sec)								
	Kerf width (inch)								
	Power burst time (sec)								
	Beam size								
	Dynamic pwr control								
	Dynamic assist gas								
	Standoff (inch) [NC]								
	Optional standoff (inch)								
	Assist gas type								
	Assist gas Pressure 1								
	Optional Pressure 2								
Loss of Cut	Loss of Cut Detection								
	NozzleReflection								
	Response Time								
DPC	DPC feedrate (ipm)								
	DPC min power (%)								
Focus / DAG	Pierce focus ramp								
	NF Pierce Focus: From								
	FF Pierce Focus: From								
	NF Cut focus								
	FF Cut focus								
	DAG; NF Press 1 (psi)								
	DAG; FF Press 1 (psi)								
	DAG; NF Press 2 (psi)								
	DAG; FF Press 2 (psi)								
	Focusing lens (inch)								
	Nozzle tip								
	Nozzle tip nut								