

CL-960 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)		0.00	0.00	0.02	0.03	0.05	0.08	0.10	0.20	0.30
	Laser power (Watt)		2000	2000	2000	2000	2000	2000	2000	4000	4000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100
	Z hold distance (inch)		0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From		0.025	0.025	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To		0.025	0.025	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Assist gas type		N2	N2	N2	N2	N2	N2	N2	N2	N2
	Assist gas press (psi)		100	100	100	100	100	100	100	100	100
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)		5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100
	Feedrate (ipm)		3000	2200	1910	1495	1045	905	795	250	200
	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)		0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.008	0.008
	Power burst time (sec)		0.10	0.10	0.00	0.00	0.00	0.00	0.10	0.00	0.00
	Dynamic pwr control		On	On	Off	On	On	On	On	Off	On
	Standoff (inch)		0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.150	0.150
	Opt. 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		160	170	175	175	175	225	225	100	100
	Optional Pressure 2		160	170	175	175	175	225	225	275	275
DPC	DPC feedrate (ipm)		500	500	n/a	n/a	835	635	635	n/a	n/a
	DPC min power (%)		20	20	n/a	n/a	20	20	20	n/a	n/a
Focus	Focus		0.015	-0.005	-0.020	-0.010	0.000	-0.010	0.000	-0.180	-0.220
	Focusing lens (mm)		194	194	194	194	194	194	194	194	194
	Nozzle tip		080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	100 LS	100 LS
	Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std	Std	Std

MILD STEEL

Air 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			
	Pierce time (sec)		0.00	0.00	0.02	0.03	0.05	0.08			
	Laser power (Watt)		2000	2000	2000	2000	2000	2000			
	Frequency (Hz)		5000	5000	5000	5000	5000	5000			
	Duty cycle (%)		100	100	100	100	100	100			
	Z hold distance (inch)		0.1	0.1	0.1	0.1	0.1	0.1			
	Standoff ramp: From		0.025	0.025	0.150	0.150	0.150	0.150			
	Standoff ramp: To		0.025	0.025	0.150	0.150	0.150	0.150			
	Assist gas type		Air	Air	Air	Air	Air	Air			
	Assist gas press (psi)		100	100	100	100	100	100			
Rapid Pierce	Laser power (Watt)		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			
	Pierce time (sec)		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			
	Airblast off time (sec)		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			
	Assist gas press (psi)		n/a	n/a	n/a	n/a	n/a	n/a			
	Ramped Pierce		No	No	n/a	n/a	n/a	n/a			
Cutting	Laser power (Watt)		6000	6000	6000	6000	6000	6000			
	Frequency (Hz)		5000	5000	5000	5000	5000	5000			
	Duty cycle (%)		100	100	100	100	100	100			
	Feedrate (ipm)		3025	2365	1960	1565	1050	910			
	Pre-cut dwell (sec)		0.00	0.00	0.00	0.00	0.00	0.00			
	Kerf width (inch)		0.006	0.006	0.006	0.006	0.006	0.006			
	Power burst time (sec)		0.00	0.10	0.10	0.10	0.00	0.00			
	Dynamic pwr control		On	On	On	On	Off	Off			
	Standoff (inch)		0.035	0.035	0.035	0.035	0.035	0.025			
	Opt. Standoff (inch)		0.035	0.035	0.035	0.035	0.035	0.025			
	Assist gas type		Air	Air	Air	Air	Air	Air			
	Assist gas Pressure 1		120	150	150	150	180	180			
	Optional Pressure 2		120	150	150	150	180	180			
DPC	DPC feedrate (ipm)		500	500	500	500	n/a	n/a			
	DPC min power (%)		20	20	20	20	n/a	n/a			
Focus	Focus		0.000	-0.020	-0.020	-0.040	-0.040	-0.050			
	Focusing lens (mm)		194	194	194	194	194	194			
	Nozzle tip		080 hc	080 hc	080 hc	080 hc	080 hc	080 hc			
	Nozzle tip nut		Std	Std	Std	Std	Std	Std			

MILD STEEL

O2 Assist

	Thickness (inch)		0.188	0.250	0.313	0.375	0.500	0.625	0.750
	Thickness (gage)		3/16"	1/4"	5/16"	3/8"	1/2"	5/8"	3/4"
	Parameters								
Pierce	Pierce mode		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
	Laser power (Watt)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Frequency (Hz)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Duty cycle (%)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Z hold distance (inch)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Standoff ramp: From		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Standoff ramp: To		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	Assist gas type		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
Rapid Pierce	Laser power (Watt)		4000	4000	4000	4000	6000	6000	6000
	Standoff (inch)		0.200	0.250	0.250	0.250	0.250	0.250	0.250
	Pierce time (sec)		0.30	0.30	0.50	0.60	0.60	1.40	1.40
	Cool time (sec)		0.10	0.10	0.10	0.30	0.30	0.20	0.90
	Airblast off time (sec)		0.30	0.30	0.50	0.50	0.60	0.70	0.90
	Airblast on time (sec)		0.10	0.10	0.10	0.40	0.30	0.90	1.40
	Assist gas press (psi)		8	8	8	8	8	8	8
	Ramped Pierce		No	No	No	No	No	No	No
Cutting	Laser power (Watt)		5600	5600	5600	5600	5600	5600	5600
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100
	Feedrate (ipm)		135	125	105	90	65	45	35
	Pre-cut dwell (sec)		0.00	0.00	0.10	0.20	0.20	0.20	0.20
	Kerf width (inch)		0.036	0.034	0.034	0.034	0.034	0.034	0.034
	Power burst time (sec)		0.00	0.00	0.00	0.00	0.00	0.00	0.00
	Dynamic pwr control		Off	Off	Off	Off	Off	Off	Off
	Standoff (inch)		0.030	0.030	0.030	0.030	0.030	0.030	0.030
	Opt. Standoff (inch)		0.030	0.030	0.030	0.030	0.030	0.030	0.030
	Assist gas type		O2	O2	O2	O2	O2	O2	O2
	Assist gas Pressure 1		8	8	8	9	8	10	10
	Optional Pressure 2		8	8	8	9	8	10	10
DPC	DPC feedrate (ipm)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
	DPC min power (%)		n/a	n/a	n/a	n/a	n/a	n/a	n/a
Focus	Focus		0.400	0.380	0.380	0.410	0.400	0.370	0.420
	Focusing lens (mm)		194	194	194	194	194	194	194
	Nozzle tip		060 dbl	060 dbl	060 dbl	060 dbl	060 dbl	060 dbl	080 dbl
	Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std

MILD STEEL (BETTER EDGE QUALITY)

N₂ Assist

	Thickness (inch)		0.105	0.120	0.135	0.188	0.250
	Thickness (gage)		12ga	11ga	10ga	3/16"	1/4"
	Parameters						
Pierce	Pierce mode		Fixed	Fixed			
	Pierce time (sec)		0.05	0.08			
	Laser power (Watt)		2000	2000			
	Frequency (Hz)		5000	5000			
	Duty cycle (%)		100	100			
	Z hold distance (inch)		0.1	0.1			
	Standoff ramp: From		0.150	0.150			
	Standoff ramp: To		0.150	0.150			
	Assist gas type		N2	N2			
	Assist gas press (psi)		100	100			
Rapid Pierce	Laser power (Watt)		n/a	n/a			
	Standoff (inch)		n/a	n/a			
	Pierce time (sec)		n/a	n/a			
	Cool time (sec)		n/a	n/a			
	Airblast off time (sec)		n/a	n/a			
	Airblast on time (sec)		n/a	n/a			
	Assist gas press (psi)		n/a	n/a			
	Ramped Pierce		No	No			
Cutting	Laser power (Watt)		6000	6000			
	Frequency (Hz)		5000	5000			
	Duty cycle (%)		100	100			
	Feedrate (ipm)		730	635			
	Pre-cut dwell (sec)		0.00	0.00			
	Kerf width (inch)		0.006	0.006			
	Power burst time (sec)		0.00	0.00			
	Dynamic pwr control		Off	Off			
	Standoff (inch)		0.025	0.025			
	Opt. Standoff (inch)		0.025	0.025			
	Assist gas type		N2	N2			
	Assist gas Pressure 1		225	225			
	Optional Pressure 2		225	225			
DPC	DPC feedrate (ipm)		n/a	n/a			
	DPC min power (%)		n/a	n/a			
Focus	Focus		0.000	-0.020			
	Focusing lens (mm)		194	194			
	Nozzle tip		062 shr	062 shr			
	Nozzle tip nut		Std	Std			

STAINLESS STEEL

N₂ Assist

	Thickness (inch)		0.036	0.048	0.060	0.075	0.105	0.120	0.135	0.188	0.250	0.375	0.500	0.625	0.750
	Thickness (gage)		20	18	16	14	12	11	10	3/16"	1/4"	3/8"	1/2"	5/8"	3/4"
	Parameters														
Pierce	Pierce mode		No	No	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)		0.00	0.00	0.02	0.03	0.05	0.08	0.10	0.20	0.30	0.40	0.50	0.80	1.00
	Laser power (Watt)		2000	2000	2000	2000	2000	2000	2000	4000	4000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Z hold distance (inch)		0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From		0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To		0.150	0.150	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		N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2
	Assist gas press (psi)		100	100	100	100	100	100	100	100	100	100	100	100	100
Rapid Pierce	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	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	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	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	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	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	n/a
	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	n/a
	Ramped Pierce		No	No	No	No	No	No	No	No	No	No	No	No	No
Cutting	Laser power (Watt)		6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Feedrate (ipm)		3150	2275	1950	1615	1155	935	820	540	200	90	40	32	22
	Pre-cut dwell (sec)		0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.20	0.20	0.20	0.20
	Kerf width (inch)		0.006	0.006	0.008	0.008	0.008	0.008	0.008	0.008	0.012	0.012	0.012	0.012	0.012
	Power burst time (sec)		0.00	0.00	0.00	0.10	0.10	0.10	0.10	0.10	0.00	0.00	0.00	0.00	0.00
	Dynamic pwr control		On	On	On	On	On	On	On	On	Off	Off	Off	Off	Off
	Standoff (inch)		0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.150	0.150	0.150	0.150	0.150	0.150
	Opt. 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	0.025
	Assist gas type		N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2
	Assist gas Pressure 1		135	160	175	175	225	225	225	100	100	100	100	100	100
	Optional Pressure 2		135	160	175	175	225	225	225	225	250	250	300	350	350
DPC	DPC feedrate (ipm)		500	500	500	500	500	750	655	465	n/a	n/a	n/a	n/a	n/a
	DPC min power (%)		50	50	30	30	30	30	10	20	n/a	n/a	n/a	n/a	n/a
Focus	Focus		0.010	0.010	-0.010	-0.020	-0.020	-0.010	-0.010	-0.040	-0.210	-0.280	-0.490	-0.500	-0.500
	Focusing lens (mm)		194	194	194	194	194	194	194	194	194	194	194	194	194
	Nozzle tip		080 hc	080 hc	080 hc	080 hc	080 hc	100 LS	100 LS	100 LS	100 LS	125 SP	125 SP	125 SP	125 SP
	Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std

STAINLESS STEEL

Air Assist

	Thickness (inch)		0.036	0.048	0.060	0.075	0.105	0.120	0.135	0.188	0.250	0.375	0.500	0.625	0.750
	Thickness (gage)		20	18	16	14	12	11	10	3/16"	1/4"	3/8"	1/2"	5/8"	3/4"
	Parameters														
Pierce	Pierce mode		No	No	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)		0.00	0.00	0.02	0.03	0.05	0.08	0.10	0.20	0.30	0.40	0.50	0.80	1.00
	Laser power (Watt)		2000	2000	2000	2000	2000	2000	2000	4000	4000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Z hold distance (inch)		0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From		0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To		0.150	0.150	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		Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air
Rapid Pierce	Assist gas press (psi)		100	100	100	100	100	100	100	100	100	100	100	100	100
	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	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	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	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	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	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	n/a
	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	n/a
Cutting	Ramped Pierce		No	No	No	No	No	No	No	No	No	No	No	No	No
	Laser power (Watt)		6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Feedrate (ipm)		3150	2340	1950	1615	1155	980	860	550	280	125	80	50	30
	Pre-cut dwell (sec)		0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.20	0.20	0.20	0.20
	Kerf width (inch)		0.006	0.006	0.006	0.008	0.008	0.008	0.008	0.008	0.012	0.012	0.012	0.012	0.012
	Power burst time (sec)		0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.10	0.00	0.00	0.00	0.00	0.00
	Dynamic pwr control		On	On	On	Off	Off	Off	Off	On	Off	Off	Off	Off	Off
	Standoff (inch)		0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.150	0.150	0.150	0.150	0.150	0.150
	Opt. 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	0.025
	Assist gas type		Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air
	Assist gas Pressure 1		120	140	160	175	225	175	200	100	100	100	100	100	100
	Optional Pressure 2		120	140	160	175	225	175	200	225	250	250	250	250	275
DPC	DPC feedrate (ipm)		500	500	500	n/a	n/a	n/a	n/a	440	n/a	n/a	n/a	n/a	n/a
	DPC min power (%)		50	50	30	n/a	n/a	n/a	n/a	50	n/a	n/a	n/a	n/a	n/a
Focus	Focus		-0.020	-0.015	-0.020	-0.020	-0.020	-0.040	-0.040	-0.050	-0.200	-0.310	-0.420	-0.440	-0.520
	Focusing lens (mm)		194	194	194	194	194	194	194	194	194	194	194	194	194
	Nozzle tip		080 hc	080 hc	080 hc	080 hc	080 hc	100 LS	100 LS	100 LS	100 LS	100 LS	100 LS	100 LS	100 LS
	Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std

STAINLESS STEEL (BETTER EDGE QUALITY)

N₂ Assist

	Thickness (inch)		0.105	0.120	0.135	0.188	0.250
	Thickness (gage)		12ga	11ga	10ga	3/16"	1/4"
	Parameters						
Pierce	Pierce mode		Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)		0.05	0.08	0.10	0.20	0.30
	Laser power (Watt)		2000	2000	2000	4000	4000
	Frequency (Hz)		5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100
	Z hold distance (inch)		0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From		0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To		0.150	0.150	0.150	0.150	0.150
	Assist gas type		N2	N2	N2	N2	N2
	Assist gas press (psi)		100	100	100	100	100
Rapid Pierce	Laser power (Watt)		n/a	n/a	n/a	n/a	n/a
	Standoff (inch)		n/a	n/a	n/a	n/a	n/a
	Pierce time (sec)		n/a	n/a	n/a	n/a	n/a
	Cool time (sec)		n/a	n/a	n/a	n/a	n/a
	Airblast off time (sec)		n/a	n/a	n/a	n/a	n/a
	Airblast on time (sec)		n/a	n/a	n/a	n/a	n/a
	Assist gas press (psi)		n/a	n/a	n/a	n/a	n/a
	Ramped Pierce		No	No	No	No	No
Cutting	Laser power (Watt)		6000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100
	Feedrate (ipm)		805	470	330	270	140
	Pre-cut dwell (sec)		0.00	0.00	0.00	0.00	0.00
	Kerf width (inch)		0.008	0.008	0.008	0.008	0.012
	Power burst time (sec)		0.00	0.00	0.00	0.00	0.00
	Dynamic pwr control		On	On	On	Off	Off
	Standoff (inch)		0.025	0.025	0.025	0.150	0.150
	Opt. Standoff (inch)		0.025	0.025	0.025	0.025	0.025
	Assist gas type		N2	N2	N2	N2	N2
	Assist gas Pressure 1		225	225	225	100	100
	Optional Pressure 2		225	225	225	250	200
DPC	DPC feedrate (ipm)		500	470	330	n/a	n/a
	DPC min power (%)		20	10	10	n/a	n/a
Focus	Focus		-0.010	-0.030	-0.090	-0.160	-0.290
	Focusing lens (mm)		194	194	194	194	194
	Nozzle tip		062 shr	062 shr	062 shr	062 shr	062 shr
	Nozzle tip nut		Std	Std	Std	Std	Std

ALUMINUM

N₂ Assist

	Thickness (inch)		0.032	0.050	0.063	0.080	0.090	0.100	0.125	0.190	0.250	0.375	0.500	0.625	0.750
	Thickness (gage)														
	Parameters		Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross
Pierce	Pierce mode		No	No	No	No	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)		0.00	0.00	0.00	0.00	0.01	0.01	0.10	0.20	0.40	0.50	1.00	1.20	3.00
	Laser power (Watt)		2000	2000	2000	2000	2000	2000	4000	4000	4000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Z hold distance (inch)		0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From		0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To		0.150	0.150	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		N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2
	Assist gas press (psi)		100	100	100	100	100	100	100	100	100	100	100	100	100
Rapid Pierce	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	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	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	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	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	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	n/a
	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	n/a
	Ramped Pierce		No	No	No	No	No	No	No	No	No	No	No	No	No
Cutting	Laser power (Watt)		6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Feedrate (ipm)		4150	3520	2430	2000	1760	1530	1080	450	185	100	60	42	34
	Pre-cut dwell (sec)		0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.20	0.20	0.20
	Kerf width (inch)		0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
	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	0.00
	Dynamic pwr control		On	On	On	On	On	On	On	Off	Off	Off	Off	Off	Off
	Standoff (inch)		0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.150	0.150	0.150	0.150	0.150	0.150
	Opt. 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	0.025
	Assist gas type		N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2	N2
	Assist gas Pressure 1		100	120	150	175	175	200	225	100	100	100	100	100	100
	Optional Pressure 2		100	120	150	175	175	200	225	240	225	225	250	250	250
DPC	DPC feedrate (ipm)		500	500	500	500	500	500	430	n/a	n/a	n/a	n/a	n/a	n/a
	DPC min power (%)		20	20	20	10	10	10	20	n/a	n/a	n/a	n/a	n/a	n/a
Focus	Focus		0.015	0.005	0.030	0.000	-0.010	-0.020	-0.020	0.000	-0.140	-0.120	-0.180	-0.120	-0.140
	Focusing lens (mm)		194	194	194	194	194	194	194	194	194	194	194	194	194
	Nozzle tip		080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	100 LS	100 LS	125 SP	125 SP	125 SP	125 SP
	Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std

ALUMINUM

AIR Assist

	Thickness (inch)		0.032	0.050	0.063	0.080	0.090	0.100	0.125	0.190	0.250	0.375	0.500	0.625	0.750
	Thickness (gage)														
	Parameters		Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross
Pierce	Pierce mode		No	No	No	No	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)		0.00	0.00	0.00	0.00	0.01	0.01	0.10	0.20	0.40	0.50	1.00	1.20	2.20
	Laser power (Watt)		2000	2000	2000	2000	2000	2000	4000	4000	4000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Z hold distance (inch)		0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From		0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To		0.150	0.150	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		Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air
	Assist gas press (psi)		100	100	100	100	100	100	100	100	100	100	100	100	100
Rapid Pierce	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	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	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	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	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	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	n/a
	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	n/a
	Ramped Pierce		No	No	No	No	No	No	No	No	No	No	No	No	No
Cutting	Laser power (Watt)		6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Feedrate (ipm)		4200	4200	3090	2160	1880	1620	1180	600	185	100	60	30	24
	Pre-cut dwell (sec)		0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.20	0.20	0.20
	Kerf width (inch)		0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
	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	0.00
	Dynamic pwr control		On	On	On	On	On	On	On	Off	Off	Off	Off	Off	Off
	Standoff (inch)		0.035	0.035	0.035	0.035	0.035	0.035	0.035	0.150	0.150	0.150	0.150	0.150	0.150
	Opt. Standoff (inch)		0.035	0.035	0.035	0.035	0.035	0.035	0.035	0.035	0.025	0.025	0.025	0.025	0.150
	Assist gas type		Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air	Air
	Assist gas Pressure 1		80	100	125	150	175	200	200	100	100	100	100	100	100
	Optional Pressure 2		80	100	125	150	175	200	200	225	225	250	250	250	250
	DPC feedrate (ipm)		500	500	500	500	500	500	500	n/a	n/a	n/a	n/a	n/a	n/a
DPC	DPC min power (%)		20	20	20	10	10	10	20	n/a	n/a	n/a	n/a	n/a	n/a
	Focus		0.005	-0.005	-0.010	0.000	-0.015	0.010	0.005	-0.060	-0.180	-0.240	-0.260	-0.320	-0.350
Focus	Focusing lens (mm)		194	194	194	194	194	194	194	194	194	194	194	194	194
	Nozzle tip		080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	100 LS	100 LS	100 LS	100 LS	100 LS	100 LS
	Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std

ALUMINUM O2 Assist

	Thickness (inch)		0.032	0.050	0.063	0.080	0.090	0.100	0.125	0.190	0.250	0.375	0.500	0.625	0.750
	Thickness (gage)														
	Parameters		Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross	Dross
Pierce	Pierce mode		No	No	No	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed	Fixed
	Pierce time (sec)		0.00	0.00	0.00	0.01	0.01	0.01	0.10	0.20	0.40	0.50	1.00	1.20	3.00
	Laser power (Watt)		2000	2000	2000	2000	2000	2000	4000	4000	4000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Z hold distance (inch)		0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1	0.1
	Standoff ramp: From		0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150	0.150
	Standoff ramp: To		0.150	0.150	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	N2	N2	N2	N2	N2	N2
	Assist gas press (psi)		100	100	100	100	100	100	100	100	100	100	100	100	100
Rapid Pierce	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	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	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	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	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	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	n/a
	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	n/a
	Ramped Pierce		No	No	No	No	No	No	No	No	No	No	No	No	No
Cutting	Laser power (Watt)		6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000	6000
	Frequency (Hz)		5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000	5000
	Duty cycle (%)		100	100	100	100	100	100	100	100	100	100	100	100	100
	Feedrate (ipm)		6000	4575	3640	2800	2375	2140	1675	630	260	130	80	50	40
	Pre-cut dwell (sec)		0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.00	0.20	0.20	0.20
	Kerf width (inch)		0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006	0.006
	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	0.00
	Dynamic pwr control		On	On	On	On	On	On	On	Off	Off	Off	Off	Off	Off
	Standoff (inch)		0.025	0.025	0.025	0.025	0.025	0.025	0.025	0.150	0.150	0.150	0.150	0.150	0.150
	Opt. 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	0.025
	Assist gas type		O2	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2	O2
	Assist gas Pressure 1		120	120	150	175	175	200	225	100	100	100	100	100	100
	Optional Pressure 2		120	120	150	175	175	200	225	200	210	210	250	250	250
DPC	DPC feedrate (ipm)		500	500	500	500	500	500	500	n/a	n/a	n/a	n/a	n/a	n/a
	DPC min power (%)		20	20	20	10	20	20	20	n/a	n/a	n/a	n/a	n/a	n/a
Focus	Focus		-0.010	-0.010	0.010	-0.010	-0.010	-0.010	-0.030	-0.140	-0.180	-0.120	-0.140	-0.140	-0.170
	Focusing lens (mm)		194	194	194	194	194	194	194	194	194	194	194	194	194
	Nozzle tip		080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	080 hc	100 LS	100 LS	125 SP	125 SP	125 SP	125 SP
	Nozzle tip nut		Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std	Std