Raycus 200W Cutting Parameters					
Material	Thickness(mm)	Speed(mm/s)	Gas Pressure(MPa)	Gas	Cutting Height
Stainless Steel	0.5	80~90	>1.2	N2	0.4
	1	60~70	1.2~1.5	N2	0.4
	2	10~15	>1.2	N2	0.4
Carbon Steel	1	100~120	0.7	O2	0.5
	2	20~30	0.6~0.8	O2	0.5
	2.5	7~10	0.3~0.5	O2	0.5

Raycus 300W Cutting Parameters

Material	Thickness(mm)	Speed(mm/s)	Gas Pressure(MPa)	Gas	Cutting Height
Stainless Steel	0.5	>200	1	N2	0.6
	1	90~120	>1.1	N2	0.6
	2	16~20	>1.5	N2	0.6
Carbon Steel	1	120~150	1	O2	1
	2	35~45	0.6~0.8	O2	1
	3	15~18	0.3~0.5	O2	1

Raycus 500W Cutting Parameters

Material	Thickness(mm)	Speed(mm/s)	Gas Pressure(MPa)	Gas	Cutting Height
Stainless Steel	0.5	>300	1	N2	0.6
	1	140~200	>1.1	N2	0.6
	2	30~40	>1.8	N2	0.6
	3	14~20	>2.0	N3	0.6
Carbon Steel	1	140~200	1	O2	1
	2	50~60	0.6~0.8	O2	1
	3	25~35	0.25~0.4	O2	1
	4	20~25	0.15~0.2	O2	1
	5	15~20	0.15~0.2	O2	1
	6	12~16	0.1~0.2	O2	1

Raycus 750W Cutting Parameters

Material	Thickness(mm)	Speed(mm/s)	Gas Pressure(MPa)	Gas	Cutting Height
Stainless Steel	0.5	>350	1	N2	0.6
	1	200~300	>1.1	N2	0.6
	2	60~70	>1.5	N2	0.6
	3	20~30	>1.8	N2	0.6
	4	13~20	>2.0	N2	0.6
Carbon Steel	1	200~300	1	O2	1
	2	70~90	0.6~0.8	O2	1
	3	50~65	0.25~0.4	O2	1
	4	30~40	0.15~0.2	O2	1
	5	20~30	0.15~0.2	O2	1
	6	15~20	0.10~0.15	O2	1
	8	12~14	0.10~0.15	O2	1
	10	10	0.10~0.15	O2	1

Raycus 1000W Cutting Parameters

Material	Thickness(mm)	Speed(mm/s)	Gas Pressure(MPa)	Gas	Cutting Height
Stainless Steel	0.5	>400	1	N2	0.6
	1	280~350	>1.1	N2	0.6
	2	90~120	>1.5	N2	0.6
	3	35~50	>2.0	N2	0.6
	4	15~25	>2.0	N2	0.6
	5	10~15	>2.0	N2	0.6
Carbon Steel	1	250~300	1	O2	1
	2	85~100	0.5~0.8	O2	1
	3	58~70	0.25~0.4	O2	1
	4	38~45	0.15~0.2	O2	1
	5	28~35	0.15~0.2	O2	1
	6	20~30	0.10~0.15	O2	1
	8	15~18	0.10~0.15	O2	1
	10	10~12	0.10~0.15	O2	1

Raycus 2000W Cutting Parameters

Material	Thickness(mm)	Speed(mm/s)	Gas Pressure(MPa)	Gas	Cutting Height
Stainless Steel	0.5	>500	1	N2	0.6
	1	400~450	>1.1	N2	0.6
	2	150~180	>1.5	N2	0.6
	3	85~100	>2.0	N2	0.6
	4	50~60	>2.0	N2	0.6
	5	25~35	>2.0	N2	0.6
	6	15~20	>2.0	N2	1
	8	9~12	>2.0	N2	1
Carbon Steel	3	70~80	1	O2	1
	5	50~55	0.5~0.8	O2	1
	6	35~45	0.25~0.4	O2	1
	8	20~30	0.15~0.2	O2	1
	10	18~25	0.15~0.2	O2	1
	12	16~20	0.10~0.15	O2	1
	14	15~18	0.10~0.15	O2	1
	16	13~15	0.10~0.15	O2	1
	20	10~12	0.10~0.15	O2	1

Note：

1 Above data is calculated under clean mirrors

2 Above date just for reference