

Metal sheet cutting Technical Parameters

| Material | (mm) Thickness | 1500W | 2000W | 3000W | 4000W | 6000W | 8000W | 12000W | 15000W | 20000W | 30000W |
|--------------------------------|-------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|------------------|
| | | Speed (m/min) | Speed (m/min) | Speed (m/min) | Speed (m/min) | Speed (m/min) | Speed (m/min) | Speed (m/min) | Speed (m/min) | Speed (m/min) | Speed (m/min) |
| 炭素鋼 Carbon steel Q2 | 1 | 18.0-25.0 | 22.0-30.0 | 30.0-38.0 | 30.0-44.0 | 35.0-48.0 | 60.0-70.0 | 66.0-80.0 | 70.0-90.0 | 80.0-95.0 | 95.0-100.0 |
| | 2 | 3.8-5.0 | 5.0-6.0 | 5.5-7.0 | 5.5-7.7 | 6.0-8.25 | 6.8-7.2 | 7.2-7.8 | 7.5-8.2 | 7.8-8.5 | 8.0-10.0 |
| | 3 | 2.8-3.8 | 3.5-4.3 | 3.6-5.0 | 3.7-5.5 | 4.0-5.5 | 4.8-5.5 | 5.2-5.8 | 5.5-6.0 | 5.8-6.3 | 6.0-7.0 |
| | 4 | 2.3-3.5 | 2.8-4.0 | 3.0-4.5 | 3.5-4.6 | 3.5-5.0 | 3.8-4.3 | 4.2-4.6 | 4.5-5.2 | 4.8-5.5 | 5.0-6.5 |
| | 5 | 1.6-2.5 | 2.5-3.0 | 2.5-3.3 | 2.5-4.0 | 3.0-4.2 | 3.3-4.3 | 3.8-4.7 | 4.0-5.0 | 4.3-4.8 | 4.5-5.0 |
| | 6 | 1.4-1.8 | 2.2-2.5 | 2.3-2.8 | 2.5-3.5 | 2.6-3.5 | 3.0-3.4 | 3.5-4.0 | 3.8-4.3 | 4.0-4.5 | 4.2-4.8 |
| | 8 | 0.9-1.3 | 1.3-1.8 | 1.8-2.2 | 2.0-2.8 | 2.0-2.8 | 2.3-3.0 | 2.6-3.3 | 2.8-3.5 | 3.0-3.6 | 3.5-4.0 |
| | 10 | 0.8-1.2 | 1.2-1.5 | 1.2-1.6 | 1.2-2.2 | 1.8-2.3 | 2.0-2.5 | 2.5-3.0 | 2.6-3.0 | 2.8-3.2 | 3.0-3.5 |
| | 12 | 0.7-1.0 | 0.8-1.0 | 1.0-1.3 | 1.0-1.7 | 1.6-2.1 | 1.7-2.2 | 2.0-2.3 | 2.5-3.0 | 2.7-3.2 | 2.8-3.4 |
| | 16-2000W | 0.5-0.7 | 0.6-0.8 | 0.6-0.9 | 0.7-1.0 | 0.7-1.0 | 1.2-1.4 | 1.4-1.6 | 1.7-2.0 | 1.9-2.3 | 2.0-2.5 |
| | 20-3000W | | | 0.5-0.8 | 0.6-0.9 | 0.5-0.9 | 1.0-1.1 | 1.2-1.5(快速2.1) | 1.3-1.6 | 1.5-1.8 | 1.6-2.0 |
| | 22-4000W | | | | 0.5-0.8 | 0.5-0.7 | 0.9-1.0 | 0.9-1.2 | 1.1-1.3 | 1.3-1.6 | 1.5-1.8 |
| | 25-6000W | | | | | 0.4-0.6 | 0.6-0.7 | 0.6-0.9 | 0.9-1.2 | 1.0-1.4 | 1.3-1.5 |
| | 30-8000W | | | | | | 0.3-0.6 | 0.5-0.8 | 0.6-0.8 | 0.8-1.2 | 1.2-1.4 |
| | 40 | | | | | | | 0.25-0.33 | 0.4-0.7 | 0.7-0.9 | 0.9-1.1 |
| | 50-12000W | | | | | | | 0.18-0.2 | 0.2-0.25 | 0.3-0.5 | 0.6-0.8 |
| | 60-15000W | | | | | | | | 0.18-0.2 | 0.2-0.25 | 0.22-0.28 |
| 70-20000W | | | | | | | | | 0.18-0.2 | 0.19-0.22 | |
| 80-30000W | | | | | | | | | | 0.12-0.15 | |
| ステンレス Stainless Steel N2 | 1 | 20.0-28.0 | 27.5-33.0 | 31.0-38.5 | 33.0-45.0 | 50.0-65.0 | 63.0-66.0 | 70.0-80.0 | 75.0-90.0 | 80.0-100.0 | 82.0-100.0 |
| | 2 | 7.0-10.0 | 9.0-11.0 | 12.0-16.5 | 15.0-20.0 | 30.0-40.0 | 40.0-44.0 | 44.0-48.0 | 46.0-50.0 | 50.0-60.0 | 63.0-75.0 |
| | 3 | 4.5-5.5 | 5.0-6.5 | 7.0-10.0 | 7.5-12.0 | 18.0-25.0 | 25.0-28.0 | 28.0-35.0 | 30.0-38.0 | 35.0-45.0 | 52.0-58.0 |
| | 4 | 2.0-2.5 | 2.2-2.8 | 5.0-7.2 | 5.5-9.0 | 10.0-15.5 | 15.0-18.0 | 20.0-26.0 | 22.0-28.0 | 30.0-32.0 | 35.0-43.0 |
| | 5 | 1.5-2.0 | 1.5-2.0 | 1.8-2.4 | 4.0-5.5 | 8.0-13.5 | 12.0-14.0 | 15.0-20.0 | 16.0-20.0 | 24.0-28.0 | 25.0-30.0 |
| | 6 | 0.6-0.9 | 0.7-1.3 | 1.0-1.6 | 2.6-4.5 | 6.0-9.0 | 9.0-9.5 | 11.0-13.0 | 12.0-15.0 | 20.0-25.0 | 22.0-25.0 |
| | 8-2000W | | 0.3-0.6 | 1.2-2.0 | 1.6-2.8 | 4.0-5.5 | 5.0-5.3 | 7.0-7.5 | 7.5-8.5 | 14.0-17.0 | 18.0-22.0 |
| | 10-3000W | | | 0.7-1.0 | 0.7-1.6 | 1.8-2.8 | 3.8-4.0 | 5.0-5.5 | 5.5-6.5 | 10.0-13.0 | 14.0-18.0 |
| | 12-4000W | | | | 0.5-0.9 | 1.2-1.6 | 2.5-2.7 | 3.0-3.5 | 3.3-4.0 | 9.0-10.0 | 12.0-14.0 |
| | 14-6000W | | | | | 0.8-1.2 | 1.8-1.9 | 2.3-2.8 | 2.5-3.0 | 7.0-8.5 | 8.0-10.0 |
| | 16-6000W | | | | | 0.6-0.9 | 1.3-1.5 | 2.1-2.5 | 2.3-2.8 | 5.0-6.0 | 7.0-8.0 |
| | 20-8000W | | | | | | 0.7-0.8 | 1.4-1.7 | 1.5-1.9 | 2.5-3.0 | 4.0-5.0 |
| | 25-8000W | | | | | | 0.5-0.6 | 0.7-1.0 | 0.9-1.2 | 1.4-1.8 | 2.0-2.5 |
| | 30-12000W | | | | | | | 0.5-0.7 | 0.6-0.8 | 0.9-1.2 | 1.2-2.0 |
| | 35-12000W | | | | | | | 0.4-0.5 | 0.5 | 0.55-0.8 | 0.7-1.0 |
| | 40-12000W | | | | | | | 0.3 | 0.4 | 0.4-0.5 | 0.6-0.8 |
| | 50-15000W | | | | | | | 0.2 | 0.25 | 0.3-0.35 | 0.3-0.4 |
| 60-1500W | | | | | | | | 0.15 | 0.15-0.2 | 0.15-0.25 | |
| 70-20000W | | | | | | | | | 0.1-0.13 | 0.12-0.15 | |
| 80-20000W | | | | | | | | | 0.06-0.08 | 0.08-0.1 | |
| 90-20000W | | | | | | | | | 0.05-0.06 | 0.5-0.08 | |
| 100-30000W | | | | | | | | | 0.03-0.04 | 0.04-0.05 | |
| アルミニウム Aluminum N2 | 1 | 15.0-27.5 | 22.0-31.0 | 25.0-30.0 | 28.0-32.0 | 35.0-45.0 | 40.0-50.0 | 45.0-55.0 | 50.0-60.0 | 55.0-65.0 | 60.0-70.0 |
| | 2 | 7.0-8.6 | 10.0-13.2 | 15.0-18.0 | 16.0-20.0 | 20.0-25.0 | 25.0-30.0 | 30.0-35.0 | 35.0-38.0 | 40.0-45.0 | 45.0-50.0 |
| | 3 | 2.5-4.0 | 5.0-6.6 | 7.0-8.0 | 10.0-12.0 | 14.0-16.0 | 15.0-23.0 | 20.0-25.0 | 25.0-30.0 | 30.0-35.0 | 38.0-45.0 |
| | 4 | 1.0-1.6 | 1.5-2.2 | 5.0-6.0 | 6.0-7.0 | 8.0-10.0 | 12.0-16.0 | 18.0-20.0 | 20.0-23.0 | 25.0-30.0 | 28.0-35.0 |
| | 5 | 0.6-0.9 | 1.0-1.3 | 2.5-3.0 | 4.0-5.0 | 5.0-7.0 | 7.0-10 | 14.0-16.0 | 15.0-18.0 | 18.0-20.0 | 20.0-25.0 |
| | 6 | | 0.6-0.9 | 1.5-2.0 | 2.5-3.0 | 3.5-4.0 | 5.0-7.0 | 10.0-12.0 | 12.0-14.0 | 16.0-18.0 | 18.0-22.0 |
| | 8 | | 0.4-0.7 | 0.5-0.8 | 1.0-1.3 | 1.5-2.0 | 2.5-4.0 | 6.0-8.0 | 8.0-10.0 | 10.0-13.0 | 14.0-18.0 |
| | 10 | | | 0.3-0.4 | 0.8-1.0 | 1.0-1.2 | 2.0-2.5 | 4.0-6.0 | 5.0-7.0 | 9.5-10.0 | 12.0-15.0 |
| | 12 | | | | 0.6-0.8 | 0.6-0.7 | 1.6-2.0 | 2.0-3.0 | 2.5-3.5 | 5.0-6.0 | 10.0-12.0 |
| | 14 | | | | 0.3-0.5 | 0.4-0.6 | 0.8-1.2 | 1.5-2.5 | 2.0-3.0 | 4.5-5.0 | 8.0-10.0 |
| | 16 | | | | | 0.3-0.4 | 0.8-1.0 | 1.3-2.0 | 1.5-2.5 | 3.0-4.0 | 6.0-8.0 |
| | 20 | | | | | | 0.5-0.7 | 0.8-1.2 | 0.8-1.2 | 1.6-2.0 | 2.0-3.0 |
| | 25 | | | | | | 0.4-0.5 | 0.5-0.7 | 0.5-0.7 | 1.0-1.2 | 1.5-2.0 |
| | 30 | | | | | | | 0.4-0.5 | 0.45-0.6 | 0.8-1.0 | 1.0-1.2 |
| | 35 | | | | | | | 0.3-0.35 | 0.45-0.55 | 0.7-0.9 | 0.8-1.0 |
| | 40 | | | | | | | 0.25-0.3 | 0.28-0.33 | 0.4-0.7 | 0.5-0.8 |
| | 50 | | | | | | | 0.15-0.2 | 0.2-0.25 | 0.3-0.5 | 0.4-0.6 |
| 60 | | | | | | | | 0.2 | 0.2-0.3 | 0.25-0.35 | |
| 70 | | | | | | | | | 0.08-0.13 | 0.12-0.15 | |
| 80 | | | | | | | | | | 0.08-0.1 | |
| 真鍮 Brass N2 | 1 | 15.0-22.0 | 20.0-27.0 | 20.0-28.0 | 25.0-30.0 | 30.0-40.0 | 35.0-45.0 | 38.0-50.0 | 40.0-55.0 | 45.0-60.0 | 55.0-65.0 |
| | 2 | 4.0-7.2 | 7.7-8.8 | 7.0-13.2 | 12.0-15.0 | 15.0-18.0 | 25.0-27.0 | 30.0-35.0 | 32.0-37.0 | 35.0-40.0 | 38.0-45.0 |
| | 3 | 1.1-1.5 | 3.0-4.5 | 5.0-7.2 | 5.5-7.7 | 12.0-14.0 | 15.0-18.0 | 18.0-22.0 | 20.0-24.0 | 25.0-28.0 | 28.0-33.0 |
| | 4 | 1.0-1.2 | 1.3-1.8 | 2.5-3.0 | 3.5-5.5 | 8.0-10.0 | 10.0-12.0 | 15.0-18.0 | 16.0-19.0 | 19.0-22.0 | 22.0-26.0 |
| | 5 | 0.6-0.9 | 0.8-0.9 | 1.6-2.0 | 2.0-3.5 | 5.0-5.5 | 7.0-9.0 | 12.0-15.0 | 13.0-16.0 | 17.0-19.0 | 18.5-22.0 |
| | 6 | | 0.4-0.6 | 0.8-1.2 | 1.4-2.2 | 3.2-3.8 | 6.0-6.5 | 7.0-10.0 | 9.0-11.0 | 12.0-15.0 | 15.0-18.0 |
| | 8 | | | 0.3-0.4 | 0.8-1.0 | 1.5-1.8 | 2.5-3.0 | 5.5-6.5 | 6.0-8.0 | 8.0-10.0 | 10.0-15.0 |
| | 10 | | | | 0.4-0.6 | 0.8-1.0 | 1.0-1.5 | 3.5-4.7 | 5.0-6.0 | 7.0-8.0 | 8.0-10.0 |
| | 12 | | | | | 0.6-0.7 | 0.8-1.2 | 1.8-2.0 | 2.0-2.2 | 2.5-3.5 | 5.0-8.0 |
| | 15 | | | | | | 0.6-0.7 | 1.0-1.2 | 1.3-1.4 | 1.8-2.0 | 2.5-4.5 |
| | 18 | | | | | | | 0.5-0.7 | 0.8-1.2 | 0.8-1.3 | 1.3-1.8 |
| | 20 | | | | | | | 0.3-0.5 | 0.6-0.7 | 0.8-1.0 | 1.0-1.2 |
| | 25 | | | | | | | | 0.4-0.6 | 0.7-0.9 | 0.8-1.0 |
| | 30 | | | | | | | | 0.3-0.5 | 0.5-0.7 | 0.6-0.8 |
| | 40 | | | | | | | | | 0.4-0.5 | 0.5-0.65 |
| | 50 | | | | | | | | | | 0.4-0.5 |
| | 銅 Copper Q2 | 1 | 6 | 15 | | | 25-30 | 25-30 | 25-30 | 25-30 | 25-30 |
| 2 | | 1.8 | 2.4 | | | 15-18 | 16-20 | 20-25 | 20-25 | 25-30 | 25-30 |
| 3 | | | 1 | | | 8-10 | 12-14 | 16-18 | 18-20 | 20-25 | 20-25 |
| 4 | | | | | | 5-6 | 7-8 | 10-12 | 12-14 | 16-18 | 18-20 |
| 5 | | | | | | 3-4 | 4-5 | 6-8 | 8-9 | 10-12 | 15-18 |
| 6 | | | | | | 1.5-2 | 2.5-3 | 4-5 | 6-7 | 8-10 | 10-15 |
| 8 | | | | | | 1-1.5 | 2-2.5 | 2.5-3.5 | 4-6 | 6-10 | 6-10 |
| 10 | | | | | | 0.5-0.7 | 1-1.2 | 1.5-2 | 2-3.5 | 2-3.5 | 2-3.5 |
| 12 | | | | | | | | 2-2.5 | 2-2.5 | 2-2.5 | 2-2.5 |
| 15 | | | | | | | | | | 1-1.5 | 1-1.5 |

The above parameters are for reference only