

Zhejiang GT Lasers Tech. Co., Ltd.

Cutting Speed Process Data Sheet of Laser Cutting Machine

Material	Thickness (mm)	CYL-1000/S	CYL-1500/S	CYL-2000/S	CYL-2000/S	CYL-2500/S	CYL-3000/S
		Fiber Diameter 20um	Fiber Diameter 50um	Fiber Diameter 50um	Fiber Diameter 100um	Fiber Diameter 100um	Fiber Diameter 100um
		Cutting Speed	Cutting Speed	Cutting Speed	Cutting Speed	Cutting Speed	Cutting Speed
		(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)
Carbon Steel (O ₂)	1	7.0-9.0	7.0-11.0	7.0-12.0	7.0-12.0	7.0-12.0	7.0-12.0
	2	5.0-6.0	5.0-6.5	5.0-6.5	5.0-6.5	5.0-7.0	5.0-7.0
	3	2.5-3.0	2.8-3.8	3.0-4.6	3.0-4.6	3.2-4.8	3.5-5.0
	4	2.0-2.4	2.5-3.2	2.8-4.0	2.8-4.0	3.0-4.2	3.0-4.2
	5	1.5-1.8	1.8-2.5	2.2-3.2	2.2-3.2	2.4-3.4	2.5-3.6
	6	1.4-1.6	1.6-2.2	2.0-2.8	2.0-2.8	2.2-2.8	2.4-3.0
	8	1.0-1.2	1.1-1.5	1.4-2.0	1.4-2.0	1.4-2.0	1.8-2.4
	10	0.75-0.85	1.0-1.2	1.1-1.4	1.1-1.4	1.2-1.7	1.2-1.8
Stainless Steel (N ₂)		CYL-1000/S(20UM)	CYL-1500/S(50um)	CYL-2000/S(50UM)	CYL-2000/S(100um)	CYL-2500/S(100um)	CYL-3000/S(100um)
	1	15-18	10.0-15.0	35.0-50.0	20.0-28.0	30.0-42.0	35.0-50.0
	2	4.5-6.0	5.0-7.0	10.0-15.0	9.0-13.0	10.0-15.0	15.0-23.0
	3	2.0-2.4	3.0-4.0	5.0-7.0	4.0-6.5	5.0-7.5	7.0-11.0
	4	1.0-1.5	2.0-2.8	3.5-4.5	3.0-4.5	3.5-5.2	4.0-6.0
	5	0.75-0.85	1.2-1.7	1.8-2.5	1.8-2.5	2.0-3.0	2.5-4.0
	6		0.7-1.0	0.7-0.8	1.2-1.8	1.4-2.0	2.0-3.2
	8		0.5-0.7	0.5-0.6	0.7-1.0	0.8-1.1	1.2-1.8
		10			0.5-0.6	0.5-0.7	0.7-0.9
	Aluminum (N ₂)		CYL-1500/S(50um)	CYL-2000/S(50UM)	CYL-2000/S(100um)	CYL-2500/S(100um)	CYL-3000/S(100um)
1		10.0-15.0	30.0-45.0	13.0-25.0	18.0-40.0	30.0-38.0	
2		5.0-6.0	10.0-15.0	7.0-10.0	8.0-12.0	12.0-16.0	
3		2.5-3.5	5.0-7.0	4.0-6.0	4.0-7.0	6.5-8.0	
4		1.4-2.0	3.5-5.0	2.5-3.5	3.0-4.5	3.5-5.0	
5		0.8-1.0	2.0-3.0	1.4-1.8	2.0-3.0	2.5-3.5	
6		0.5-0.6	1.5-2.0	0.8-1.2	1.2-2.5	1.8-3.0	
8			0.5-0.6	0.6-0.8	0.6-0.9	0.9-1.3	
	10			0.3-0.4	0.4-0.7		
Copper Steel (N ₂)		CYL-1500/S(50um)	CYL-2000/S(50UM)	CYL-2000/S(100um)	CYL-2500/S(100um)	CYL-3000/S(100um)	
	1	8.0-12.0	12.0-18.0	10.0-16.0	12.0-18.0	20.0-32.0	
	2	3.5-5.0	6.0-8.5	6.0-8.0	6.5-9.0	9.0-11.0	
	3	1.5-2.2	2.5-4.0	2.5-4.0	3.0-4.5	4.0-6.0	
	4	1.0-1.2	1.5-1.8	1.6-2.2	1.8-2.6	3.0-4.5	
	5	0.6-0.8	0.8-1.2	0.9-1.2	1.2-1.6	1.5-2.0	
	6		0.4-0.5	0.4-0.7	0.7-1.1	1.0-1.6	
Stainless Steel (AIR)		CYL-2000/S(50UM)	CYL-2000/S(100um)	CYL-2500/S(100um)	CYL-3000/S(100um)		
			输出纤径 50um	输出纤径 100um	输出纤径 100um	输出纤径 100um	
			切割速度	切割速度	切割速度	切割速度	
			(m/min)	(m/min)	(m/min)	(m/min)	
	1		35.0-50.0	20.0-28.0	30.0-45.0	35.0-50.0	
	2		10.0-15.0	9.0-12.0	10.0-15.0	15.0-23.0	
	3		5.0-7.0	4.0-6.0	5.0-6.5	7.0-11.0	
	4		3.5-4.5	3.5-4.0	3.5-5.5	4.0-6.5	
5		1.8-2.5	1.5-2.0	2.0-3.0	2.5-4.0		
6		0.7-0.8	1.0-1.2	1.4-2.0	2.0-3.2		
	8			0.8-1.1	1.2-1.8		
Aluminum (AIR)		CYL-2000/S(50UM)	CYL-2000/S(100um)	CYL-2500/S(100um)	CYL-3000/S(100um)		
	1		30.0-45.0	13.0-25.0	25.0-40.0	35.0-50.0	
	2		10.0-16.0	7.0-12.0	10.0-14.0	12.0-20.0	
	3		5.0-7.0	4.0-6.0	5.0-7.0	6.5-9.0	
	4		3.5-5.0	2.5-4.0	3.5-5.0	4.0-5.5	
	5		2.0-3.0	1.4-1.8	2.0-3.0	2.5-3.5	
	6		1.2-2.0	0.8-1.5	1.2-2.5	1.8-3.0	
Copper Steel (AIR)		CYL-2000/S(50UM)	CYL-2000/S(100um)	CYL-2500/S(100um)	CYL-3000/S(100um)		
	1		18-28.0	13.0-22.0	25.0-35.0	25.0-36.0	
	2		8-12.0	6.0-10.0	6.5-14.0	7.0-10.0	
	3		1.5-2.5	2.5-5.0	3.0-8	5.0-6.0	