

MetaQuip Fibercutter

Laserpower - Material - Speed - Thickness Table

Material	Thickness (mm)	Cutting speed for reference (m/min)													
		700/750W		1000W		1500W		2000W		3000W		4000W		6000W	
Stainless Steel Nitrogen (N ₂)	1	14.0-18.0		12.0-28.0		16.0-22.0		20.0-28.0		30.0-42.0		35.0-50.0		50.0-60.0	
	2	3.0-3.8		4.8-5.6		5.2-7.6		10.0-15.0		18.0-23.0		18.0-27.0		30.0-40.0	
	3	1.2-1.8		1.8-2.5		3.0-4.2		5.0-7.0		7.0-10.0		10.0-15.0		17.0-22.0	
	4	0.4-0.6		0.6-1.0		1.5-2.5		3.5-4.5		4.0-6.0		5.0-7.5		9.50-14.0	
	5					0.6-0.8		1.8-2.8		2.5-4.0		4.0-5.0		7.80-12.0	
	6							0.7-0.8		2.0-3.2		3.0-4.0		5.8-8.0	
	8							0.5-0.6		1.2-1.8		1.5-2.6		4.0-5.0	
	10									0.7-0.9		0.7-1.3		1.8-2.5	
	12											0.4-0.6		1.2-1.8	
	16													0.6-0.8	
20													0.3-0.4		
Aluminum Nitrogen (N ₂)	1	3.0-5.0		5.0-7.5		7.0-10.0		10.0-15.0		13.0-16.0		15.0-20.0		20.0-25.0	
	2			2.5-4.5		4.0-5.5		5.0-6.7		7.0-10.0		8.0-12.0		15.0-18.0	
	3			1.0-1.5		2.0-3.5		3.5-5.0		4.0-5.5		5.5-7.0		7.0-10.0	
	4					1.0-2.0*		2.0-3.5		3.0-5.0		3.5-5.0		5.0-5.5	
	6							0.8-1.5*		1.8-3.0		2.5-3.5		3.5-5.0	
	8									0.8-1.4		1.20-2.0		2.2-3.5	
	10									0.4-0.7*		0.7-1.1		1.0-2.0	
	12											0.4-0.6		0.8-1.2	
16													0.5-0.7		
Brass Nitrogen (N ₂)	1	1.5-2.0		2.5-4.0		4.0-6.0		5.0-7.0		8.0-12.0		10.0-15.0		15.0-18.0	
	2			1.5-2.0		2.5-4.0		3.5-5.0		4.5-6.0		5.5-7.0		6.0-10.0	
	3			0.8-1.5*		1.5-2.0		2.0-4.0		3.5-5.0		4.0-5.5		5.0-7.0	
	4					0.8-1.2*		1.5-1.8		2.5-4.0		3.0-4.5		4.5-6.0	
	5							0.8-1.2*		1.5-2.0		2.0-3.0		2.5-4.0	
	6									1.0-1.6		1.4-2.0		2.0-3.5	
	8									0.5-0.6*		0.7-0.8		1.0-1.5	
	10													0.6-0.9	
Carbon Steel Oxygen (O ₂) Use air or Nitrogen can speed up for cutting Carbon Steel thickness within 2mm	1	12.0-18.0		O ₂	AIR/N ₂	O ₂	AIR/N ₂	O ₂	AIR/N ₂	O ₂	AIR/N ₂	O ₂	AIR/N ₂	O ₂	AIR/N ₂
	2	4.6-6.0		9.0-12.0	15.0-18.0	9.0-13.0	16.0-21.0	8.0-12.0	18.0-28.0	10.0-15.0	28.0-38.0	12.0-18.0	35.0-45.0	13.0-18.0	50.0-60.0
	3	2.0-3.0		2.4-3.2		2.6-4.3		3.0-4.6		3.5-5.0	6.0-9.0	3.8-4.5	10.0-14.0	4.2-5.8	17.0-22.0
	4	1.8-2.2		2.0-2.6		2.5-3.6		2.8-4.0		3.0-4.5	4.0-5.5	3.5-4.8	4.5-6.5	3.9-5.2	5.5-8.5
	6	1.2-1.5		1.4-1.8		1.8-2.8		2.2-3.2		2.4-3.6		2.6-3.8		2.8-4.2	
	8	0.6-1.0		0.8-1.2		1.4-2.0		1.8-2.5		2.0-2.8		2.2-3.0		2.4-3.5	
	10	0.5-0.6*		0.6-0.8		1.0-1.4		1.2-1.8		1.4-2.0		1.8-2.4		2.2-2.8	
	12			0.5-0.6*		0.8-1.0		1.0-1.4		1.1-1.4		1.2-1.5		1.6-1.9	
	16							0.8-1.0		0.9-1.2		1.0-1.5		1.2-1.8	
	20							0.5-0.6*		0.6-0.8		0.7-1.0		0.8-1.4	
	22											0.5-0.6		0.55-0.65	
	25													0.4-0.6	