CARBON STEEL

Thickness (in)	Gauge	Speed (IPM)	Focal Position (mm)	Focal Position (in)	Cutting Height (in)	Gas	Nozzle Type	Air Pressure (PSI)	Laser Power (W)	Cutting Frequency (Hz)	Duty Cycle (%)
0.039”	20	1319	0	0	0.02	N2	Single 1.0	203	1500	5000	100
0.079”	14	374	-0.25	-0.010	0.02	N2	Single 1.5	203	1500	5000	100
0.157”	8	98	5.0	0.197	0.031	O2	Double 1.0	11	1500	5000	100
0.197”	6	75	2.5	0.098	0.059	O2	Double 3.0	11	1500	5000	100
0.236”	3	67	2.5	0.098	0.059	O2	Double 3.0	11	1500	5000	100
0.315”	—	47	2.5	0.098	0.059	O2	Double 3.0	11	1500	5000	100
0.394”	—	37	2.5	0.098	0.059	O2	Double 3.0	11	1500	5000	100
0.472”	—	33	2.5	0.098	0.059	O2	Double 3.0	11	1500	5000	100
0.551”	—	26	2.5	0.098	0.059	O2	Double 4.0	11	1500	5000	100

STAINLESS STEEL

Thickness (in)	Gauge	Speed (IPM)	Focal Position (mm)	Focal Position (in)	Cutting Height (in)	Gas	Nozzle Type	Air Pressure (PSI)	Laser Power (W)	Cutting Frequency (Hz)	Duty Cycle (%)
0.039”	20	1319	0	0	0.02	N2	Single 1.0	203	1500	5000	100
0.079”	14	374	-0.25	-0.010	0.02	N2	Single 1.5	203	1500	5000	100
0.118”	11	171	-1.25	-0.049	0.02	N2	Single 2.0	203	1500	5000	100
0.157”	8	87	-2.25	-0.089	0.02	N2	Single 3.0	203	1500	5000	100
0.197”	6	67	-3.25	-0.128	0.02	N2	Single 3.5	203	1500	5000	100
0.236”	3	43	-4.75	-0.187	0.02	N2	Single 3.5	203	1500	5000	100

ALUMINUM

Thickness (in)	Gauge	Speed (IPM)	Focal Position (mm)	Focal Position (in)	Cutting Height (in)	Gas	Nozzle Type	Air Pressure (PSI)	Laser Power (W)	Cutting Frequency (Hz)	Duty Cycle (%)
0.039”	20	1024	0	0	0.02	Air	Single 1.0	203	1500	5000	100
0.079”	14	335	-0.25	-0.010	0.02	Air	Single 1.5	203	1500	5000	100
0.118”	11	157	-0.25	-0.010	0.02	Air	Single 2.0	203	1500	5000	100
0.157”	8	83	-1.25	-0.049	0.02	Air	Single 3.0	203	1500	5000	100
0.197”	6	35	-1.5	-0.059	0.02	Air	Single 3.5	203	1500	5000	100

BRASS

Thickness (in)	Gauge	Speed (IPM)	Focal Position (mm)	Focal Position (in)	Cutting Height (in)	Gas	Nozzle Type	Air Pressure (PSI)	Laser Power (W)	Cutting Frequency (Hz)	Duty Cycle (%)
0.039”	20	965	0	0	0.02	Air	Single 1.0	203	1500	5000	100
0.079”	14	295	-0.25	-0.010	0.02	Air	Single 1.5	203	1500	5000	100
0.118”	11	112	-0.25	-0.010	0.02	Air	Single 2.0	203	1500	5000	100
0.157”	8	63	-1.25	-0.049	0.02	Air	Single 3.0	203	1500	5000	100