

	2000W	2500W	3000W	4000W	6000W (100UM-M1.5)	8000W (100UM- M1.5)	
Material (mm)	Rýchlosť rezania Cutting Speed (m/min)	m/min	m/min	m/min	m/min	m/min	Plyn / Assistant Gas
Čierna oceľ - Black Steel							
1	7.0-12.0/20.0-25.0	7.0-12.0/25.0-30.0	7.0-12.0/30.0-40.0	8.0-12.0/35.0-45.0	8.0-12.0/45.0-60.0	8.0-12.0/45.0-60.0	Oxygen/Nitrogen
2	5.0-6.5/8.5.0-10.0	5.0-7.0/10.0-14.0	5.0-7.0/15.0-18.0	5.0-7.5/16.0-20.0	5.0-7.5/32.0-45.0	5.5-6.5/35.0-40.0	
3	3.0-4.6	3.2-4.8	3.5-5.0/6.0-9.0	3.8-5.0/10.0-14.0	3.8-5.0/20.0-25.0	4.0-5.0/25.0-30.0	
4	2.8-4.0	3.0-4.2	3.0-4.2	3.5-4.5/4.5-6.5	3.5-4.5/17.0-20.0	3.4-4.0/20.0-22.0	
5	2.2-3.2	2.4-3.4	2.5-3.6	3.0-3.8	3.0-3.8/7.0-8.0	3.0-3.5/12.0-15.0	
6	2.0-2.8	2.2-2.8	2.4-3.0	2.6-3.2	2.8-3.2/5.0-6.0	2.8-3.3/8.5-11.0	
8	1.4-2.0	1.4-2.0	1.8-2.4	2.0-2.5	2.3-2.6/3.0-4.0	2.5-2.8/5.5-7.0	Oxygen
10	1.1-1.4	1.2-1.7	1.2-1.8	1.8-2.1	2.1-2.5	2.3-2.6/3.5-4.0	
12	0.9-1.2	1.0-1.4	1.0-1.5	1.0-1.5	2.0-2.2	2.0-2.4	
14	0.75-0.85	0.8-0.9	0.85-0.9	0.9-1.0	1.7-2.0	1.8-2.2	
16	0.60-0.75	0.6-0.8	0.7-0.85	0.75-0.85	1.4-1.6	1.6-1.8	
18		0.6-0.75	0.6-0.75	0.7-0.8	0.75-0.95	0.8-1.5	
20		0.5-0.7	0.55-0.70	0.6-0.75	0.65-0.8	0.7-1.3	
25					** 0.55-0.65	** 0.55-0.65	
Rezanie 25 mm je určené materiálovou vlastnosťou / 25mm cutting is determined by material property							
Čísla označené červenou farbou sú len na malé rezanie / Figures marked in the red is for small scale cutting only							

	2000W	2500W	3000W	4000W	6000W (100UM-M1.5)	8000W (100UM- M1.5)	
Material (mm)	Rýchlosť rezania Cutting Speed (m/min)	m/min	m/min	m/min	m/min	m/min	Plyn / Assistant Gas
Nerezová oceľ - Stainless Steel							
1	20.0-28.0	30.0-42.0/30.0-45.0	35.0-50.0	45.0-55.0	40.0-60.0	40.0-60.0	Nitrogen
2	9.0-13.0	10.0-15.0	15.0-23.0	18.0-27.0	20.0-35.0	30.0-40.0	
3	4.0-6.5	5.0-7.5	7.0-11.0	10.0-15.0	16.0-22.0	20.0-25.0	
4	3.0-4.5	3.5-5.2	4.0-6.0	5.0-7.5	10.0-15.0	18-22.0	
5	1.8-2.5	2.0-3.0	2.5-4.0	4.0-5.0	8.0-10.0	10.0-15.0	
6	1.2-1.8	1.4-2.0	2.0-3.2	3.0-4.0	6.0-8.0	8.0-11.0	
8	0.7-0.9	0.8-1.1	1.2-1.8	1.5-2.6	3.2-4.0	5.0-7.0	
10			0.7-0.9	0.8-1.3	1.8-2.5	3.0-3.5	
12				0.65-0.8	1.2-1.5	2.0-2.5	
14					0.8-1.2	1.6-2.0	
16					0.6-0.9	1.2-1.5	
18					0.35-0.5	0.9-1.2	
20					0.2-0.3	0.70-0.85	
22						0.45-0.5	
25						0.25-0.35	
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	2000W	2500W	3000W	4000W	6000W (100UM-M1.5)	8000W (100UM- M1.5)	
Material (mm)	Rýchlosť rezania Cutting Speed (m/min)	m/min	m/min	m/min	m/min	m/min	Plyn / Assistant Gas
Hliník - Aluminium							
1	13.0-25.0/14.0-26.0	18.0-40.0/25.0-40.0	30.0-38.0/35.0-50.0	35.0-40.0/45.0-55.0	35.0-60.0	35.0-60.0	Nitrogen/Air
2	7.0-10.0/7.0-12.0	8.0-12.0/10.0-14.0	12.0-16.0/12.0-20.0	13.0-22.0/18.0-27.0	20.0-30.0	30.0-35.0	
3	4.0-6.0/4.5-6.0	4.0-7.0/5.0-7.0	6.5-8.0/6.5-9.0	7.0-13.0/9.0-14.0	13.0-18.0	16.0-20.0	
4	2.5-3.5/2.5-4.0	3.0-4.5/3.5-5.0	3.5-5.0/4.0-5.5	4.0-5.5/4.5-6.5	10.0-12.0	11.0-13.0	
5	1.4-1.8	2.0-3.0	2.5-3.5	3.0-4.0/3.5-5.0	5.0-8.0	6.5-7.5	
6	0.8-1.2	1.2-2.5	1.8-3.0	2.2-3.5/3.0-4.0	4.0-6.0	6.0-6.5	
8		0.6-0.9 (Small Scale)	0.9-1.3	0.9-1.6/1.5-2.0	2.0-3.0	3.5-4.0	
10			0.4-0.7 (Small Scale)	0.55-1.0	1.5-2.2	2.2-3.0	
12					1.2-1.6	2.0-2.5	
14					1.0-1.2	1.5-2.0	
16					0.8-1.0	1.3-1.5	
18					0.6-0.8	0.8-1.0	
20					0.3-0.4	0.6-0.8	
22						0.35-0.45	
25						0.2-0.3	

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	2000W	2500W	3000W	4000W	6000W (100UM-M1.5)	8000W (100UM- M1.5)	
Material (mm)	Rýchlosť rezania Cutting Speed (m/min)	m/min	m/min	m/min	m/min	m/min	Plyn / Assistant Gas
Mosadz - Brass							
1	10.0-16.0/13.0-22.0	12.0-18.0//25.0-35.0	20.0-32.0/25.0-36.0	25.0-30.0/18.0-35.0	30.0-55.0	35.0-55.0	Nitrogen
2	6.0-8.0/6.0-10.0	6.5-9.0/6.5-14.0	9.0-11.0/7.0-10.0	10.0-13.0/10.0-15.0	25.0-32.0	25.0-35.0	
3	2.5-4.0/2.5-5.0	3.0-4.5/3.0-8.0	4.0-6.0/5.0-6.0	5.0-6.5/6.0-7.5	12.0-15.0	16.0-20.0	
4	1.6-2.0	1.8-2.6	3.0-4.5	3.0-5.2	8.0-10.0	12.0-14.0	
5		1.2-1.6	1.5-2.0	2.0-3.0	5.0-6.5	8.0-10.0	
6			1.0-1.3	1.4-2.0	3.0-4.5	6.0-6.5	
8				0.7-0.8	1.2-2.0	3.5-4.0	
10					0.9-1.2	2.0-2.6	
12					0.6-0.85	1.3-1.6	

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