



█ Max. cutting thickness  
(do not suggest to cut for a long time)

## ■ Cutting thickness and velocity parameters

## Technical Parameters

Material	Thickness (mm)	IPG1000W	IPG1500W	IPG2000W	IPG3000W	IPG4000W	IPG6000W	IPG8000W	IPG10000W	IPG12000W
		Speed	Speed	Speed	Speed	Speed	Speed	Speed	Speed	Speed
		(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)	(m/min)
Carbon steel O <sub>2</sub>	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	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	5.0-7.0	5.0-7.0	5.0-7.0	5.0-7.0	5.0-7.0	5.0-7.0
	3	2.5-3.0	2.8-3.8	3.0-4.6	3.5-5.0	3.5-5.0	3.5-5.0	3.5-5.0	3.5-5.0	3.5-5.0
	4	2.0-2.4	2.5-3.2	2.8-4.0	3.0-4.2	3.0-4.2	3.0-4.2	3.0-4.2	3.0-4.2	3.0-4.2
	5	1.5-1.8	1.8-2.5	2.2-3.2	2.5-3.6	2.5-3.6	2.5-3.6	2.5-3.6	2.5-3.6	2.5-3.6
	6	1.4-1.6	1.6-2.2	2.0-2.8	2.4-3.0	2.4-3.0	2.4-3.0	2.4-3.0	2.4-3.0	2.4-3.0
	8	1.0-1.2	1.1-1.5	1.4-2.0	1.8-2.4	1.8-2.4	1.8-2.4	1.8-2.4	1.8-2.4	1.8-2.4
	10	0.75-0.85	1.0-1.2	1.1-1.4	1.2-1.8	1.2-1.8	1.2-1.8	1.2-1.8	1.2-1.8	1.2-1.8
	12	0.6-0.7	0.9-1.0	0.9-1.2	1.0-1.5	1.0-1.5	1.0-1.5	1.0-1.5	1.0-1.5	1.0-1.5
	16			0.60-0.75	0.7-0.85	0.7-0.85	0.7-0.85	0.7-0.85	0.7-0.85	0.7-0.85
	20				0.6-0.75	0.6-0.75	0.6-0.75	0.6-0.75	0.6-0.75	0.6-0.75
	22				0.50-0.65	0.50-0.65	0.50-0.65	0.50-0.65	0.50-0.65	0.50-0.65
	25				0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6	0.4-0.6
Stainless Steel N <sub>2</sub>	1	15-18	10.0-15.0	35.0-50.0	35.0-50.0	45.0-55.0	45.0-55.0	45.0-55.0	45.0-55.0	45.0-55.0
	2	4.5-6.0	5.0-7.0	10.0-15.0	15.0-23.0	18.0-27.0	20.0-35.0	23.0-37.0	26.0-40.0	28.0-43.0
	3	2.0-2.4	3.0-4.0	5.0-7.0	7.0-11.0	10.0-15.0	15.0-20.0	19.0-24.0	23.0-28.0	27.0-32.0
	4	1.0-1.5	2.0-2.8	3.5-4.5	4.0-6.0	5.0-7.5	10.0-14.0	14.0-17.0	18.0-22.0	22.0-26.0
	5	0.75-0.85	1.2-1.7	1.8-2.5	2.5-4.0	4.0-5.0	8.0-12.0	11.0-14.0	14.0-17.0	16.0-18.0
	6		0.7-1.0	0.7-0.8	2.0-3.2	3.0-4.0	6.0-8.0	8.0-9.5	9.5-11.0	10.5-12.0
	8		0.5-0.7	0.5-0.6	1.2-1.8	1.5-2.6	3.5-4.0	5.0-5.5	6.5-7.0	7.5-8.0
	10				0.7-0.9	0.7-1.3	1.8-2.2	2.5-3.0	3.4-3.9	4.0-4.5
	12				0.3-0.4	0.4-0.6	1.2-1.5	1.8-2.1	2.6-3.1	3.3-3.6
	16					0.3-0.5	0.8-1.2	1.5-1.8	2.2-2.5	2.7-3.0
	20					0.3-0.5	0.6-0.8	1.0-1.3	1.7-2.0	2.2-2.5
	22						0.3-0.4	0.6-0.75	1.0-1.2	1.4-1.6
	25							0.3-0.5	0.4-0.6	0.6-0.8
Aluminum N <sub>2</sub>	1	/	10.0-15.0	30.0-45.0	30.0-38.0	35.0-40.0	45.0-55.0	45.0-55.0	45.0-55.0	45.0-55.0
	2	/	5.0-6.0	10.0-15.0	12.0-16.0	13.0-22.0	20.0-30.0	27.0-35.0	33.0-40.0	36.0-43.0
	3	/	2.5-3.5	5.0-7.0	6.5-8.0	7.0-13.0	13.0-18.0	15.0-18.0	18.0-22.0	23.0-26.0
	4	/	1.4-2.0	3.5-5.0	3.5-5.0	4.0-5.5	10.0-12.0	12.0-13.5	15.0-18.0	19.0-22.0
	5	/	0.8-1.0	2.0-3.0	2.5-3.5	3.0-4.0	5.0-8.0	9.0-12.0	14.0-16.0	17.0-19.0
	6	/	0.5-0.6	1.5-2.0	1.8-3.0	2.2-3.5	4.0-6.0	7.5-9.5	10.0-12.5	13.0-15.0
	8	/		0.5-0.6	0.9-1.3	0.9-1.6	2.0-3.0	4.0-4.8	5.8-6.5	6.8-7.2
	10	/			0.4-0.7	0.55-1.0	1.0-1.9	1.5-2.7	3.0-3.8	3.7-4.2
	12	/			0.3-0.45	0.4-0.6	0.8-1.4	1.6-1.9	2.4-2.7	3.3-3.6
	14	/				0.3-0.4	0.6-0.9	1.0-1.2	1.4-1.6	1.7-1.8
	16	/					0.4-0.6	0.8-0.9	1.0-1.2	1.2-1.6
	20	/						0.7-0.85	0.9-1.0	1.1-1.2
	25	/						0.35-0.45	0.6-0.7	0.8-0.9
Brass N <sub>2</sub>	1	/	8.0-12.0	12.0-18.0	20.0-32.0	25.0-30.0	45.0-55.0	45.0-55.0	45.0-55.0	45.0-55.0
	2	/	3.5-5.0	6.0-8.5	9.0-11.0	10.0-13.0	25.0-35.0	27.0-35.0	33.0-40.0	36.0-43.0
	3	/	1.5-2.2	2.5-4.0	4.0-6.0	5.0-6.5	12.0-18.0	15.0-18.0	18.0-22.0	23.0-26.0
	4	/	1.0-1.2	1.5-1.8	3.0-4.5	3.0-5.2	8.0-10.0	12.0-13.5	15.0-18.0	19.0-22.0
	5	/	0.6-0.8	0.8-1.2	1.5-2.0	2.0-3.0	4.5-6.0	9.0-12.0	14.0-16.0	17.0-19.0
	6	/		0.4-0.5	1.0-1.6	1.4-2.0	3.0-4.0	7.5-9.5	10.0-12.5	13.0-15.0
	8	/			0.5-0.6	0.7-0.8	1.6-2.2	4.0-4.8	5.8-6.5	6.8-7.2
	10	/				0.2-0.3	0.8-1.2	1.5-2.7	3.0-3.8	3.7-4.2
	12	/						1.6-1.9	2.4-2.7	3.3-3.6

