

RFL-C1000 Cutting Data

Single module RFL-C1000 core 25µm cutting data (collimation 100mm/focus 125mm)

RFL-C1000 CW Fiber Laser (25µm)								
material	thickness (mm)	speed (m/min)	power (W)	gas	Air pressure	nozzle (mm)	focus position	cutting height (mm)
carbon steel	0.8	18	1000	N ₂ /	10	1.5S	0	1
	1	10		Air	10	1.5S	0	1
	2	4	1000	O ₂	2	1.2D	+3	0.8
	3	3			0.6	1.2D	+3	0.8
	4	2.3			0.6	1.2D	+3	0.8
	5	1.8			0.6	1.2D	+3	0.8
	6	1.5			0.6	1.5D	+3	0.8
	8	1.1			0.6	1.5D	+3	0.8
	10	0.8			0.6	2.5D	+3	0.8
stainless steel	0.8	20	1000	N ₂	12	1.5S	0	0.8
	1	13			12	1.5S	0	0.5
	2	6			12	2.0S	-1	0.5
	3	3			12	3.0S	-1.5	0.5
	4	1			14	3.0S	-2	0.5
	5	0.6			16	3.5S	-2.5	0.5
aluminum alloy	0.8	18	1000	N ₂	12	1.5S	0	0.8
	1	10			12	1.5S	0	0.5
	2	5			14	2.0S	-1	0.5
	3	1.5			16	3.0S	-1.5	0.5
brass	1	9	1000	N ₂	12	2.0S	0	0.5
	2	2			14	2.0S	-1	0.5
	3	0.8			16	3.0S	-1.5	0.5