

1500W Sheet Cutting Parameter

Material	Thickness	Assisted Gas	Speed(m/min)
Carbon Steel	1.0	Nitrogen	15.0-25.0
	2.0		6.0-8.0
	1.0	Oxygen	6.0-11.0
	2.0		4.5-6.5
	3.0		2.3-3.5
	4.0		2.0-3.0
	5.0		1.5-2.2
	6.0		1.2-1.5
	8.0		0.9-1.3
	10.0		0.6-1.0
12.0	0.5-0.7		
Stainless steel	1.0	Nitrogen	18.0-28.0
	2.0		5.0-7.0
	3.0		2.0-3.0
	4.0		1.0-1.7
	5.0		0.5-0.8
	6.0		0.3-0.7
Brass	1.0	Nitrogen	10.0-13.0
	2.0		2.5-4.0
	3.0		2.0-3.0
Aluminum	1.0	Nitrogen	15.0-25.0
	2.0		3.0-6.5
	3.0		1.2-1.7
Copper	1.0	Oxygen	7.0-8.0
	2.0		0.8-1.2

(Above parameter is for reference only. The quality of materials, pressure during cutting, and profile designing, etc. will affect cutting speed.)



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Cost Analysis

Items	Cutting of stainless steel (1mm)	Cutting of carbon steel (5mm)
Electricity expenses	RMB12/h	RMB 12/h
Expenses of cutting auxiliary gas	RMB 16/h(N2)	RMB 10/h(O2)
Expenses of protective lens and nozzle	RMB 0.4/h	RMB 0.5/h
Total expenses	RMB 28.4/h	RMB 22.5/h

If the assisted cutting gas is the dried compressed air, expenses are the actual operation expenses of the air compressor plus expenses of electricity consumed by the machine tool and consumables like protective mirror and nozzle).

Notes:

- 1.The electricity expense and gas expense in the table above are based on the price in Foshan, China and prices in different areas will be various;
- 2.When the machine is cutting other thickness or different metal sheet, consumption of the assisted gas may be different.

