Layer Parameter Settings

Global Parameter | layer 1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

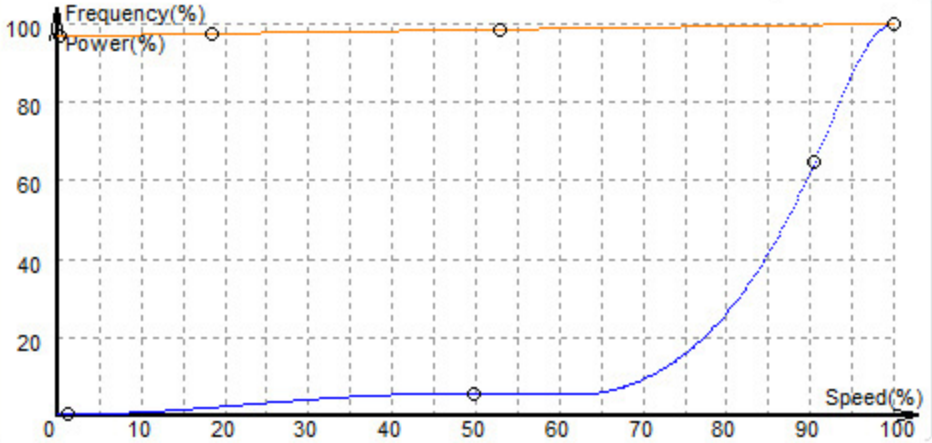
Cut | Pierce

Cut Speed:	1	m/min
Lift Height:	3	mm
Cut Height:	3	mm
Cut Gas:	Oxygen	
Cut Pressure:	0.1	BAR
Cut Cur:	70	%
	700	W
Cut Pwr:	10	%
Cut Freq:	1000	Hz
Beam Size:	0	x
Cut Focus:	0	mm
Delay Time:	0	ms
Laser off delay	0	ms

Slow Lead Length: 2 mm Speed: 0.18 m/min

Slow Stop Length: 2 mm Speed: 0.18 m/min

Dymc Pwr Adj | Dymc Freq Adj | Show in Abs | Curve edit



User Notes GRAVIROVKA

焦点3.5
双1.0

Гравировка

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

No Pierce | 1 Stage | 2 Stages | 3 Stages

Step Time:	600	ms	Step Time:	1020	ms	Step Time:	1000	ms
Piercing Height	10	mm	Piercing Height	15	mm	Piercing Height	15	mm
Piercing Gas:	Oxygen		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	0.1	BAR	Piercing Pres:	0.5	BAR	Piercing Pres:	5	BAR
Piercing Cur:	100	%	Piercing Cur:	100	%	Piercing Cur:	100	%
	1,000	W		1,000	W		1,000	W
Piercing Pwr:	60	%	Piercing Pwr:	70	%	Piercing Pwr:	50	%
Piercing Freq:	400	Hz	Piercing Freq:	400	Hz	Piercing Freq:	5000	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	0	ms	Piercing Time:	1500	ms	Piercing Time:	200	ms
Extra Puffing:	500	ms	Extra Puffing:	500	ms	Extra Puffing	500	ms

User Notes GRAVIROVKA

焦点3.5
双1.0

Гравировка

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

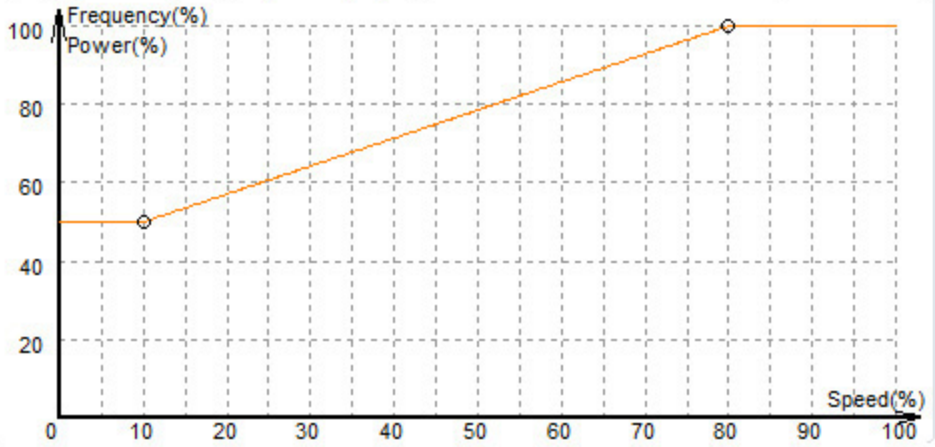
Cut | Pierce

Cut Speed:	1.6	m/min
Lift Height:	35	mm
Cut Height:	0.5	mm
Cut Gas:	Oxygen	
Cut Pressure:	0.5	BAR
Cut Cur:	100	%
	1,000	W
Cut Pwr:	100	%
Cut Freq:	5000	Hz
Beam Size:	0	x
Cut Focus:	0	mm
Delay Time:	0	ms
Laser off delay	0	ms

Slow Lead Length: 2 mm Speed: 0.18 m/min

Slow Stop Length: 2 mm Speed: 0.18 m/min

Dymc Pwr Adj | Dymc Freq Adj | Show in Abs | Curve edit



User Notes **3 mm good quality nozzle 1.5 focus +3.5 GQ**

焦点3.5
双1.0

Ст3, 09Г2С

t=3 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

No Pierce | 1 Stage | 2 Stages | 3 Stages

Step Time:	600	ms	Step Time:	1020	ms	Step Time:	1000	ms
Piercing Height	10	mm	Piercing Height	15	mm	Piercing Height	15	mm
Piercing Gas:	Oxygen		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	0.1	BAR	Piercing Pres:	0.5	BAR	Piercing Pres:	5	BAR
Piercing Cur:	100	%	Piercing Cur:	100	%	Piercing Cur:	100	%
	1,000	W		1,000	W		1,000	W
Piercing Pwr:	30	%	Piercing Pwr:	70	%	Piercing Pwr:	50	%
Piercing Freq:	400	Hz	Piercing Freq:	400	Hz	Piercing Freq:	5000	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	0	ms	Piercing Time:	1500	ms	Piercing Time:	200	ms
Extra Puffing:	500	ms	Extra Puffing:	500	ms	Extra Puffing	500	ms

User Notes **3 mm good quality nozzle 1.5 focus +3.5 GQ**

焦点3.5
双1.0

Ст3, 09Г2С t=3 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

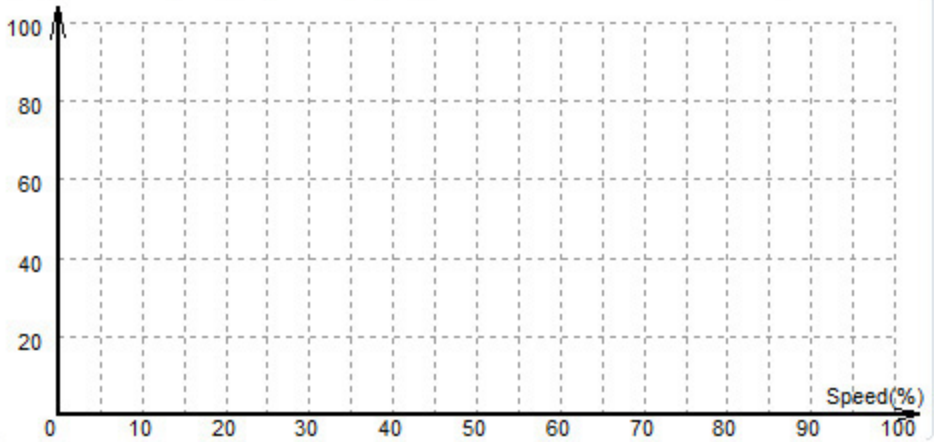
Cut | Pierce

Cut Speed:	1.2	m/min
Lift Height:	25	mm
Cut Height:	0.5	mm
Cut Gas:	Oxygen	
Cut Pressure:	0.6	BAR
Cut Cur:	100	%
	1,000	W
Cut Pwr:	100	%
Cut Freq:	5000	Hz
Beam Size:	0	x
Cut Focus:	0.01	mm
Delay Time:	0	ms
Laser off delay	150	ms

Slow Lead Length: 4 mm Speed: 0.4 m/min

Slow Stop Length: 4 mm Speed: 0.4 m/min

Dymc Pwr Adj | Dymc Freq Adj | Show in Abs | Curve edit



User Notes 4 mm good quality nozzle 1.5 focus +2.5

Ст3, 09Г2С

t=4 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

No Pierce | 1 Stage | 2 Stages | 3 Stages

Step Time:	2000	ms	Step Time:	1000	ms	Step Time:	1000	ms
Piercing Height	5	mm	Piercing Height	5	mm	Piercing Height	15	mm
Piercing Gas:	Oxygen		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	0.1	BAR	Piercing Pres:	0.3	BAR	Piercing Pres:	5	BAR
Piercing Cur:	100	%	Piercing Cur:	60	%	Piercing Cur:	100	%
	1,000	W		600	W		1,000	W
Piercing Pwr:	20	%	Piercing Pwr:	30	%	Piercing Pwr:	50	%
Piercing Freq:	400	Hz	Piercing Freq:	1000	Hz	Piercing Freq:	5000	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	700	ms	Piercing Time:	2000	ms	Piercing Time:	200	ms
Extra Puffing:	1000	ms	Extra Puffing:	500	ms	Extra Puffing	500	ms

User Notes **4 mm good quality nozzle 1.5 focus +2.5**

Ст3, 09Г2С t=4 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

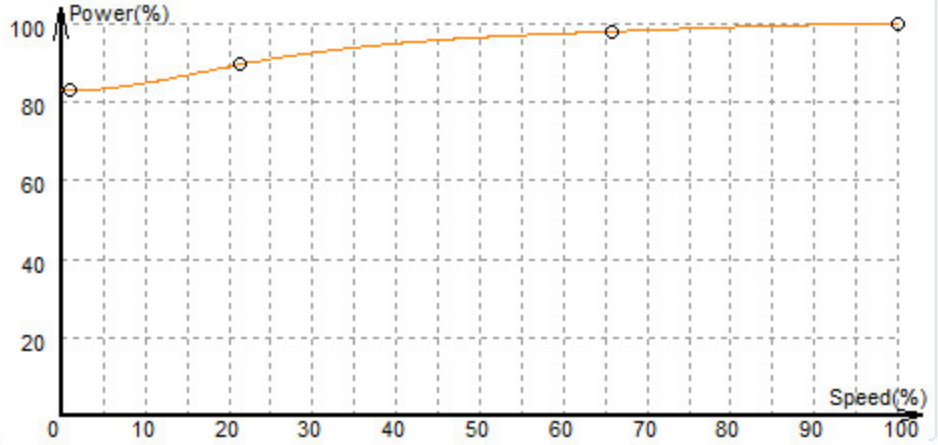
Cut | Pierce

Cut Speed:	1.4	m/min
Lift Height:	18	mm
Cut Height:	0.8	mm
Cut Gas:	Oxygen	
Cut Pressure:	0.55	BAR
Cut Cur:	100	%
	1,000	W
Cut Pwr:	100	%
Cut Freq:	5000	Hz
Beam Size:	0	x
Cut Focus:	0	mm
Delay Time:	0	ms
Laser off delay	100	ms

Slow Lead Length: 2 mm Speed: 0.1 m/min

Slow Stop Length: 2 mm Speed: 0.18 m/min

Dymc Pwr Adj | Dymc Freq Adj | Show in Abs | Curve edit



User Notes 5 mm good quality nozzle 1.5 focus +2.5

Ст3, 09Г2С t=5 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

No Pierce | 1 Stage | 2 Stages | 3 Stages

Step Time:	700	ms	Step Time:	1100	ms	Step Time:	1000	ms
Piercing Height	6	mm	Piercing Height	6	mm	Piercing Height	15	mm
Piercing Gas:	Oxygen		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	0.1	BAR	Piercing Pres:	0.3	BAR	Piercing Pres:	5	BAR
Piercing Cur:	100	%	Piercing Cur:	60	%	Piercing Cur:	100	%
	1,000	W		600	W		1,000	W
Piercing Pwr:	40	%	Piercing Pwr:	30	%	Piercing Pwr:	50	%
Piercing Freq:	1000	Hz	Piercing Freq:	1000	Hz	Piercing Freq:	5000	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	500	ms	Piercing Time:	2000	ms	Piercing Time:	200	ms
Extra Puffing:	1000	ms	Extra Puffing:	500	ms	Extra Puffing	500	ms

User Notes **5 mm good quality nozzle 1.5 focus +2.5**

Ст3, 09Г2С t=5 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

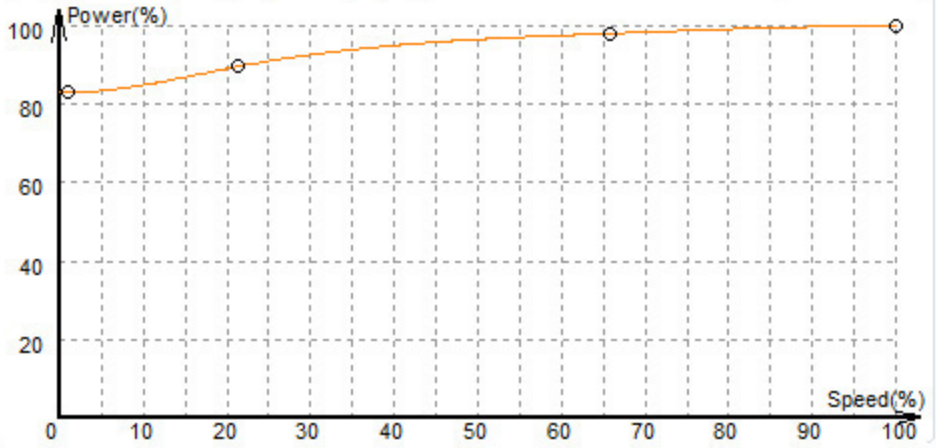
Cut | Pierce

Cut Speed:	1	m/min
Lift Height:	35	mm
Cut Height:	0.8	mm
Cut Gas:	Oxygen	
Cut Pressure:	0.5	BAR
Cut Cur:	100	%
	1,000	W
Cut Pwr:	100	%
Cut Freq:	5000	Hz
Beam Size:	0	x
Cut Focus:	0	mm
Delay Time:	0	ms
Laser off delay	100	ms

Slow Lead Length: 2 mm Speed: 0.1 m/min

Slow Stop Length: 2 mm Speed: 0.18 m/min

Dymc Pwr Adj | Dymc Freq Adj | Show in Abs | Curve edit



User Notes 6 mm good quality nozzle 1.5 focus +3

Ст3, 09Г2С t=6 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

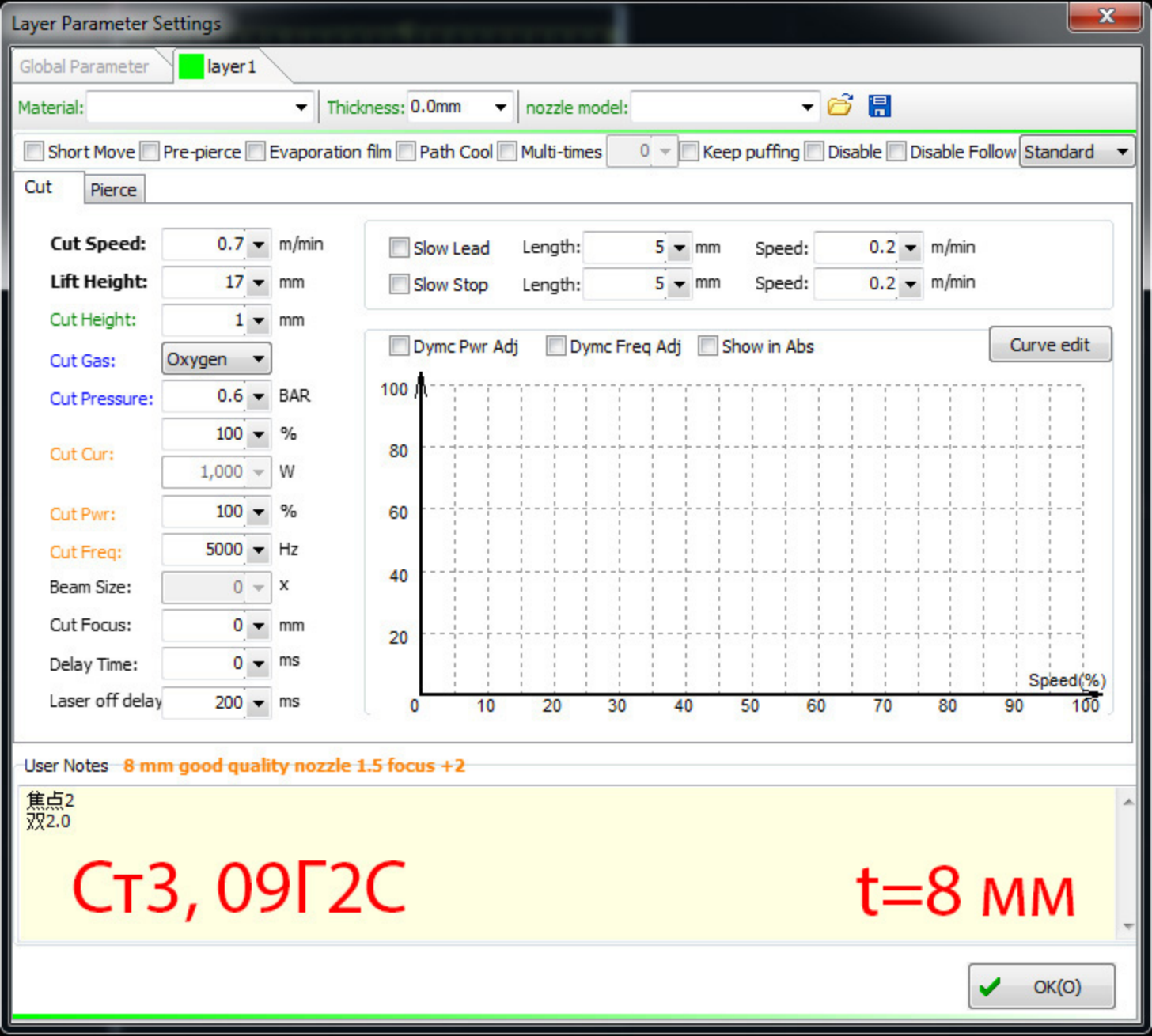
No Pierce | 1 Stage | 2 Stages | 3 Stages

Step Time:	5000	ms	Step Time:	1100	ms	Step Time:	1000	ms
Piercing Height	6	mm	Piercing Height	4	mm	Piercing Height	15	mm
Piercing Gas:	Oxygen		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	0.1	BAR	Piercing Pres:	0.3	BAR	Piercing Pres:	5	BAR
Piercing Cur:	100	%	Piercing Cur:	90	%	Piercing Cur:	100	%
	1,000	W		900	W		1,000	W
Piercing Pwr:	35	%	Piercing Pwr:	30	%	Piercing Pwr:	50	%
Piercing Freq:	600	Hz	Piercing Freq:	800	Hz	Piercing Freq:	5000	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	0	ms	Piercing Time:	2000	ms	Piercing Time:	200	ms
Extra Puffing:	1000	ms	Extra Puffing:	500	ms	Extra Puffing	500	ms

User Notes 6 mm good quality nozzle 1.5 focus +3

Ст3, 09Г2С t=6 мм

OK(O)


Layer Parameter Settings
Global Parameter
layer1
Material:
Thickness: 0.0mm
nozzle model:
Short Move
Pre-pierce
Evaporation film
Path Cool
Multi-times
0
Keep puffing
Disable
Disable Follow
Standard
Cut
Pierce
Cut Speed: 0.7 m/min
Lift Height: 17 mm
Cut Height: 1 mm
Cut Gas: Oxygen
Cut Pressure: 0.6 BAR
Cut Cur: 100 %
1,000 W
Cut Pwr: 100 %
Cut Freq: 5000 Hz
Beam Size: 0 x
Cut Focus: 0 mm
Delay Time: 0 ms
Laser off delay 200 ms
Slow Lead Length: 5 mm Speed: 0.2 m/min
Slow Stop Length: 5 mm Speed: 0.2 m/min
Dymc Pwr Adj
Dymc Freq Adj
Show in Abs
Curve edit
100
80
60
40
20
0
10
20
30
40
50
60
70
80
90
100
Speed(%)
User Notes
8 mm good quality nozzle 1.5 focus +2
焦点2
双2.0
Ст3, 09Г2С
t=8 мм
OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

No Pierce | 1 Stage | 2 Stages | 3 Stages

Step Time:	3000	ms	Step Time:	300	ms	Step Time:	1000	ms
Piercing Height	5	mm	Piercing Height	10	mm	Piercing Height	15	mm
Piercing Gas:	Oxygen		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	0.1	BAR	Piercing Pres:	0.2	BAR	Piercing Pres:	5	BAR
Piercing Cur:	100	%	Piercing Cur:	100	%	Piercing Cur:	100	%
	1,000	W		1,000	W		1,000	W
Piercing Pwr:	50	%	Piercing Pwr:	45	%	Piercing Pwr:	50	%
Piercing Freq:	400	Hz	Piercing Freq:	400	Hz	Piercing Freq:	5000	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	700	ms	Piercing Time:	2000	ms	Piercing Time:	200	ms
Extra Puffing:	500	ms	Extra Puffing:	500	ms	Extra Puffing	500	ms

User Notes **8 mm good quality nozzle 1.5 focus +2**

焦点2
双2.0

Ст3, 09Г2С t=8 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

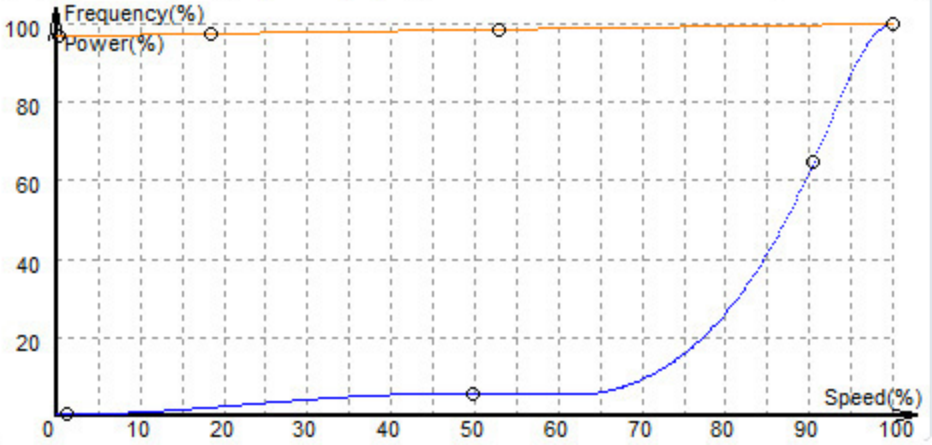
Cut | Pierce

Cut Speed:	0.6	m/min
Lift Height:	14	mm
Cut Height:	0.8	mm
Cut Gas:	Oxygen	
Cut Pressure:	0.6	BAR
Cut Cur:	100	%
	1,000	W
Cut Pwr:	100	%
Cut Freq:	5000	Hz
Beam Size:	0	x
Cut Focus:	0	mm
Delay Time:	400	ms
Laser off delay	100	ms

Slow Lead Length: 2 mm Speed: 0.1 m/min

Slow Stop Length: 2 mm Speed: 0.18 m/min

Dymc Pwr Adj | Dymc Freq Adj | Show in Abs | Curve edit



User Notes 10 mm good quality nozzle 2 focus +2.5(max edt)

Ст3, 09Г2С t=10 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

No Pierce | 1 Stage | 2 Stages | 3 Stages

Step Time:	4000	ms	Step Time:	4000	ms	Step Time:	1000	ms
Piercing Height	7	mm	Piercing Height	8	mm	Piercing Height	15	mm
Piercing Gas:	Oxygen		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	0.4	BAR	Piercing Pres:	0.4	BAR	Piercing Pres:	5	BAR
Piercing Cur:	100	%	Piercing Cur:	100	%	Piercing Cur:	100	%
	1,000	W		1,000	W		1,000	W
Piercing Pwr:	40	%	Piercing Pwr:	55	%	Piercing Pwr:	50	%
Piercing Freq:	600	Hz	Piercing Freq:	800	Hz	Piercing Freq:	5000	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	550	ms	Piercing Time:	800	ms	Piercing Time:	200	ms
Extra Puffing:	500	ms	Extra Puffing:	500	ms	Extra Puffing	500	ms

User Notes 10 mm good quality nozzle 2 focus +2.5(max edt)

Ст3, 09Г2С Вариант №1 t=10 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: | Thickness: 0.0mm | nozzle model:

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

No Pierce | 1 Stage | 2 Stages | 3 Stages

	1 Stage	2 Stages	3 Stages
Step Time:	12000 ms	4000 ms	1000 ms
Piercing Height	7 mm	8 mm	15 mm
Piercing Gas:	Oxygen	Oxygen	Oxygen
Piercing Pres:	0.4 BAR	0.4 BAR	5 BAR
Piercing Cur:	100 % / 1,000 W	100 % / 1,000 W	100 % / 1,000 W
Piercing Pwr:	40 %	55 %	50 %
Piercing Freq:	600 Hz	800 Hz	5000 Hz
Beam Size:	0 x	0 x	0 x
Piercing Focus:	0 mm	0 mm	0 mm
Piercing Time:	0 ms	800 ms	200 ms
Extra Puffing:	500 ms	500 ms	500 ms

User Notes **10 mm good quality nozzle 2 focus +2.5(max edt)**

Ст3, 09Г2С Вариант №2 t=10 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: 不锈钢 | Thickness: 12.0mm | nozzle model: d1.5

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

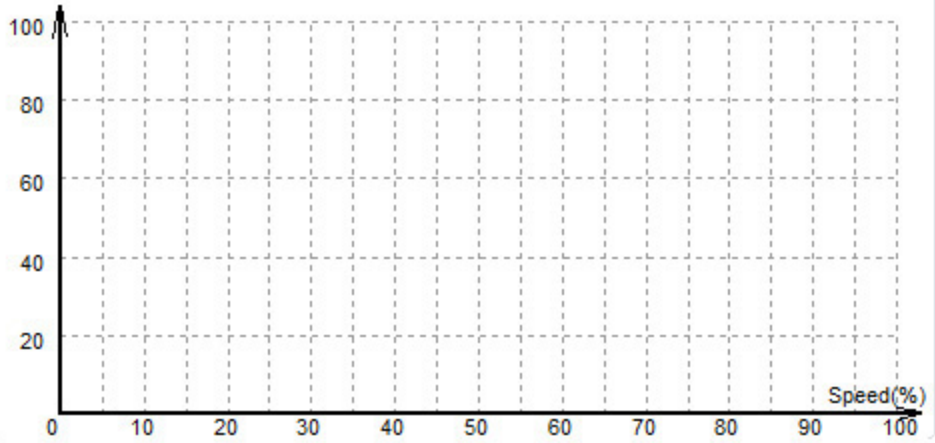
Cut | Pierce

Cut Speed:	3.2	m/min
Lift Height:	8	mm
Cut Height:	0.5	mm
Cut Gas:	NitrogenH	
Cut Pressure:	0.45	BAR
Cut Cur:	100	%
	1,000	W
Cut Pwr:	100	%
Cut Freq:	5000	Hz
Beam Size:	0	x
Cut Focus:	0	mm
Delay Time:	400	ms
Laser off delay	0	ms

Slow Lead Length: 3 mm Speed: 0.12 m/min

Slow Stop Length: 0 mm Speed: 0.12 m/min

Dymc Pwr Adj | Dymc Freq Adj | Show in Abs | Curve edit



User Notes 3mm 340 st

MPa 0.78 fokus -2.85

08X18H10 (AISI 304) t=3 мм

OK(O)

Layer Parameter Settings

Global Parameter | layer1

Material: 不锈钢 | Thickness: 12.0mm | nozzle model: d1.5

Short Move | Pre-pierce | Evaporation film | Path Cool | Multi-times 0 | Keep puffing | Disable | Disable Follow | Standard

Cut | Pierce

No Pierce | 1 Stage | 2 Stages | 3 Stages

Step Time:	200	ms	Step Time:	1000	ms	Step Time:	1000	ms
Piercing Height	2	mm	Piercing Height	11	mm	Piercing Height	15	mm
Piercing Gas:	NitrogenH		Piercing Gas:	Oxygen		Piercing Gas:	Oxygen	
Piercing Pres:	1.1	BAR	Piercing Pres:	1.2	BAR	Piercing Pres:	1	BAR
Piercing Cur:	100	%	Piercing Cur:	100	%	Piercing Cur:	100	%
	1,000	W		1,000	W		1,000	W
Piercing Pwr:	100	%	Piercing Pwr:	100	%	Piercing Pwr:	50	%
Piercing Freq:	100	Hz	Piercing Freq:	100	Hz	Piercing Freq:	50	Hz
Beam Size:	0	x	Beam Size:	0	x	Beam Size:	0	x
Piercing Focus:	0	mm	Piercing Focus:	0	mm	Piercing Focus:	0	mm
Piercing Time:	500	ms	Piercing Time:	1000	ms	Piercing Time:	200	ms
Extra Puffing:	500	ms	Extra Puffing:	500	ms	Extra Puffing	500	ms

User Notes 3mm 340 st

MPa 0.78 fokus -2.85

08X18H10 (AISI 304) t=3 мм

OK(O)