
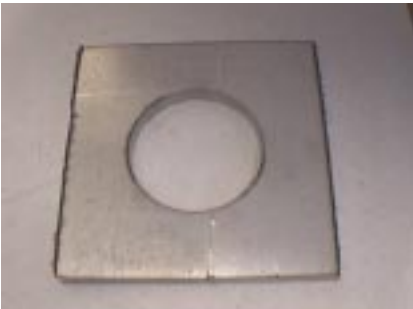








Stainless steel-N₂ technology:

All the following solutions are reliable only if the following conditions are verified:

- Nitrogen purity at least 99,99% (or 4.0).
- Lens and nozzle not damaged.
- Good quality material (certified, without oxydation, calamin or paint).
- Laser mode without distortion (air free of acid or solvent).

<u>Problem</u>	<u>Possible reasons</u>	<u>Possible solutions</u>
<i>Loss of cut.</i> 	<ul style="list-style-type: none">- Speed too high.- Focal too low.- Power too low.	<ul style="list-style-type: none">-Decrease speed.-Increase power.
<i>Burr on opposite sides.</i> 	<ul style="list-style-type: none">- Lens not centered.- Nozzle hole not free or not circular.- Optical chain alignment not perfect.	<ul style="list-style-type: none">- Check lens centering.- Check nozzle conditions.- Check optical chain alignment.
<i>Black burr only on the outside.</i> 	<ul style="list-style-type: none">- Focal point too low.	<ul style="list-style-type: none">- Move up focal point by step of 0.1-0.2 mm

<u>Problem</u>	<u>Possible reasons</u>	<u>Possible solutions</u>
<p><i>Long white burr.</i></p> 	<p>-Nitrogen pressure too low</p>	<p>-Increase nitrogen pressure.</p>
<p><i>Black burr all around the piece.</i></p> 	<p>- Focal point too high.</p>	<p>-Move down focal point by step of 0.1-0.2 mm.</p>
<p><i>Snatched cut</i></p> 	<p>- Cutting speed too high.</p>	<p>-Reduce cutting speed by step of 150-200 mm/min.</p>
<p><i>Very light burr.</i></p> 	<p>- Focal too low.</p>	<p>- Move up focal point by step of 0.1-0.2 mm</p>

<u>Problem</u>	<u>Possible reasons</u>	<u>Possible solutions</u>
<p><i>Yellow colored cutting side.</i></p> 	<ul style="list-style-type: none"> -Nitrogen not pure. -Presence of oxygen or air in the gas pipe. 	<ul style="list-style-type: none"> -Check nitrogen purity. -Insert a delay after gas call in order to clean the pipe. -Check gas circuit conditions (no leaks).