Cutting Process Parameters

Material	Cutting Thickness(mm)	Punch Diameter (mm)	Cutting Max Speed (mm/min)	Inclination Angle	Minimum Line Width（mm）	Gas	Notes
Stainless Steel	0.5	0.2	8000	Negligible	0.15	Oxygen (Request smooth: using nitrogen)	Speed reduce 20% when using nitrogen
	1	0.25	3600	Negligible	0.15		
	2	0.3	1500	1.5 degree	0.25		
	3	0.4	1100	1.5 degree	0.3		
	4	0.6	700	1.5 degree	0.4		
	5	0.7	500	1.5 degree	0.45		
	6	0.8	400	1.5 degree	0.5		
Mid Steel	1	0.2	3600	Negligible	0.15	Oxygen (Request smooth: using nitrogen)	Speed reduce 20% when using nitrogen
	2	0.3	1500	1.5 degree	0.25		
	3	0.4	1100	1.5 degree	0.3		
	4	0.6	700	1.5 degree	0.4		
	5	0.8	500	1.5 degree	0.45		
	6	1.0	400	1.5 degree	0.5		
	7	1.2	300	1.5 degree	0.55		
	8	1.5	180	1.5 degree	0.6		
Brass	0.5	0.2	1500	Negligible	0.15	Oxygen (Request smooth: using nitrogen)	Speed reduce 20% when using nitrogen
	1	0.3	1000	Negligible	0.25		
	2	0.4	480	1.5 degree	0.4		
	3	0.5	180	1.5 degree	0.5		
Aluminum	0.5	0.2	2000	Negligible	0.2	Oxygen (Request smooth: using nitrogen)	Speed reduce 20% when using nitrogen
	1	0.3	1200	Negligible	0.2		
	2	0.4	600	1.5 degree	0.25		
	3	0.5	300	1.5 degree	0.35		
	4	0.6	180	1.5 degree	0.5		
	5	0.8	120	1.5 degree	0.8		