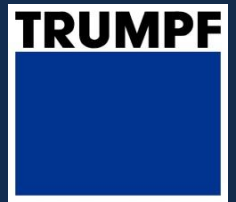
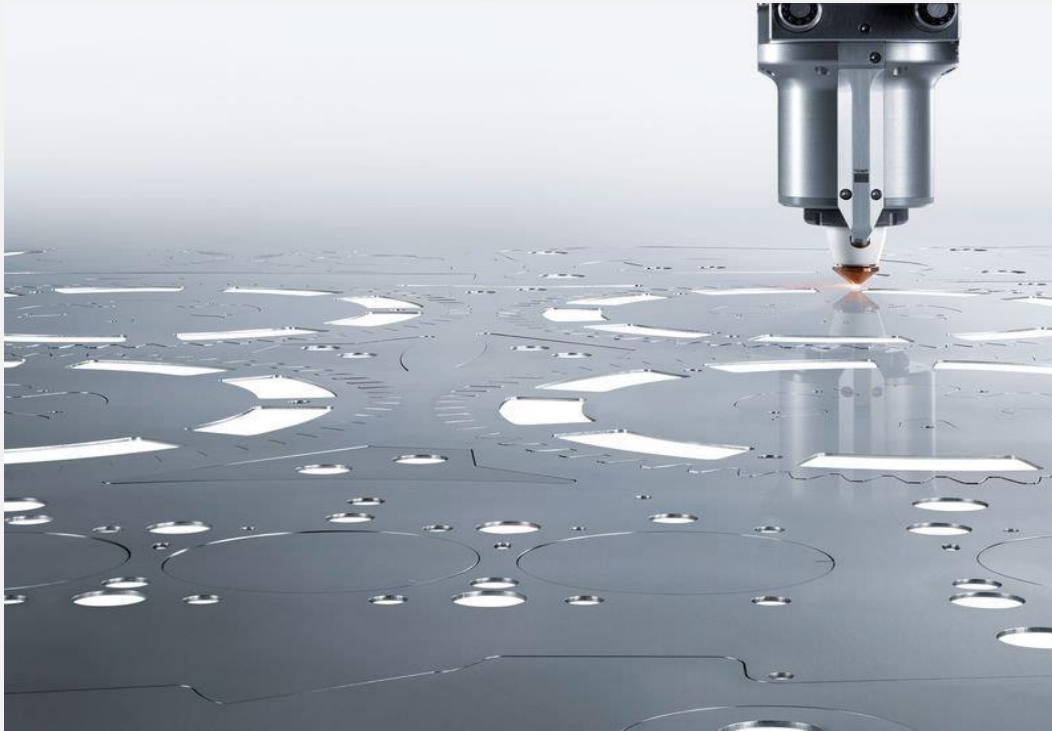


# TRUMPF Group



## Cutting Speeds for TruLaser Machines and Nozzle Charts

TRUMPF Inc.  
111 Hyde Rd.  
Farmington CT, 06032  
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Fax: (860) 255-6426  
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# Cutting Speeds: TruLaser 1030 / TruLaser 1030 fiber



**TRUMPF**

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Materials			TruCoax 2500						TruDisk 2001						TruDisk 3001					
	inch	mm	Cut Speed [in/min]	Pierce Time [s]	Lens [in]	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Lens [mm]	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Lens [mm]	Nozzle [mm]	PSI	Flow [CFH]
Steel	0.040	1.0	290-310	0.10	7.5	1.0	55	65	295-315	0.05	200	1.0	44	55	295-315	0.05	200	1.0	65	81
	0.060	1.5	240-275	0.10	7.5	1.0	50	65	216-236	0.10	200	1.0	44	55	216-236	0.10	200	1.0	65	81
	0.080	2.0	170-195	0.10	7.5	1.0	50	65	177-197	0.10	200	1.0	36	45	185-205	0.10	200	1.0	65	81
	0.120	3.0	140-150	0.10	7.5	1.0	35	45	140-150	0.15	200	1.0	9	10	123-138	0.15	200	1.0	65	81
	0.180	4.5	115-125	0.20	7.5	1.0	50	65	100-110	0.15	200	1.0	9	10	111-126	0.20	200	1.2	10	18
	0.250	6.4	85-95	0.30	7.5	1.0	55	68	77-87	0.50	200	1.2	9	25	88-98	0.40	200	1.2	9	16
O <sub>2</sub>	0.375	9.5	55-65	0.50	7.5	1.4	10	35	46-51	2.00	200	1.2	9	25	61-71	1.00	200	1.2	12	21
	0.500	12.7	35-40	1.00	7.5	1.4	10	35	30-35	3.00	200	1.4	9	25	37-47	6.00	200	1.4	9	24
	0.625	16	25-35	1.00	7.5	2.3	10	35	20-24	7.00	200	2.0	10	35	25-35	6.00	200	1.4	9	24
	0.750	20	-	-	-	-	-	-	-	-	-	-	-	-	18-24	15.00	200	4	9	128
	0.040	1.0	430-470	0.10	7.5	1.4	150	410	799-866	0.10	200	2.0	145	813	1062-1142	0.10	200	2.0	215	1156
	0.060	1.5	255-275	0.10	7.5	1.4	150	410	475-512	0.10	200	2.0	145	813	718-748	0.10	200	2.0	145	813
N <sub>2</sub>	0.080	2.0	225-235	0.10	7.5	1.4	150	410	374-394	0.10	200	2.3	232	1606	546-571	0.10	200	2.3	145	1046
	0.120	3.0	110-115	0.50	7.5	2.3	180	1233	137-157	0.10	200	2.3	290	1980	315-335	0.10	200	2.7	245	2443
	0.250	6.4	-	-	-	-	-	-	-	-	-	-	-	-	58-69	0.50	200	2.7	245	2443
	0.040	1.0	646-666	0.05	7.5	1.7	75	290	799-866	0.10	200	1.4	75	190	1101-1181	0.10	200	1.7	75	290
Air	0.060	1.5	370-390	0.10	7.5	2.3	75	570	531-551	0.10	200	1.7	75	290	757-787	0.10	200	2.0	75	470
	0.080	2.0	290-310	0.10	7.5	2.3	75	570	334-354	0.10	200	2.3	75	570	506-531	0.10	200	2.3	75	570
	0.120	3.0	-	-	-	-	-	-	-	-	-	-	-	-	315-335	0.10	200	2.3	75	570
Stainless	0.040	1.0	370-390	0.10	7.5	1.4	90	240	910-984	0.05	200	1.7	174	703	1160-1240	0.05	200	1.7	130	526
	0.060	1.5	255-275	0.10	7.5	1.4	140	380	630-669	0.15	200	1.7	174	703	806-846	0.15	200	1.7	160	644
	0.080	2.0	215-235	0.10	7.5	1.4	140	380	405-433	0.15	200	2.3	174	1233	472-492	0.15	200	2.3	175	1233
	0.120	3.0	125-135	0.30	7.5	2.3	180	1233	216-236	0.20	200	2.7	232	2313	275-295	0.20	200	2.7	205	2052
	0.180	4.5	60-65	0.60	7.5	2.3	225	1513	72-79	0.30	200	2.7	247	2443	103-118	0.30	200	2.7	260	2573
	0.250	6.4	34-39	0.80	7.5	2.3	240	1606	35-39	1.00	200	2.7	290	2833	69-79	1.00	200	2.7	260	2573
N <sub>2</sub>	0.310	7.8	20-24	0.80	7.5	2.3	240	1606	22-24	2.00	200	2.7	290	2833	32-39	2.00	200	2.7	260	2573
	0.625	16.0	-	-	-	-	-	-	-	-	-	-	-	-	9-12	15.00	200	2.7	290	2833
	0.040	1.0	690-745	0.05	7.5	2.3	75	570	799-866	0.03	200	2.0	145	813	1160-1240	0.03	200	1.4	75	190
	0.060	1.5	380-410	0.10	7.5	2.3	75	570	475-512	0.04	200	2.0	145	813	846-906	0.04	200	1.7	75	290
Air	0.080	2.0	265-285	0.10	7.5	2.3	75	570	374-394	0.05	200	2.3	232	1606	566-591	0.05	200	2.3	75	570
	0.120	3.0	-	-	-	-	-	-	-	-	-	-	-	-	197-217	0.06	200	2.3	75	570
Alumin.	0.040	1.0	450-470	0.05	7.5	1.4	105	270	802-827	0.05	200	2.0	145	813	806-846	0.05	200	2.0	60	402
	0.060	1.5	255-275	0.10	7.5	1.4	105	270	420-433	0.08	200	2.0	145	813	487-512	0.08	200	2.0	85	538
	0.080	2.0	195-215	0.10	7.5	1.7	135	526	260-276	0.08	200	2.0	145	813	334-354	0.08	200	2.0	115	675
	0.120	3.0	105-115	0.20	7.5	1.7	195	762	130-138	0.30	200	1.2	120	795	177-197	0.30	200	2.0	100	607
	0.180	4.5	45-50	0.80	7.5	2.3	195	1326	55-59	1.50	200	2.3	203	2105	84-94	1.50	200	2.3	205	1419
	0.250	6.4	26-31	1.50	7.5	2.3	195	1326	24-28	2.00	200	2.7	261	2573	61-71	1.00	200	2.3	260	1793
N <sub>2</sub>	0.500	12.7	-	-	-	-	-	-	-	-	-	-	-	-	15-20	4.00	200	2.7	290	2833
	0.040	1.0	645-665	0.05	7.5	2.7	75	882	757-787	0.05	200	2.7	75	882	1554-1654	0.05	200	2.7	75	882
	0.060	1.5	330-350	0.10	7.5	2.7	75	882	374-394	0.10	200	2.7	75	882	905-965	0.10	200	2.7	75	882
	0.080	2.0	215-235	0.10	7.5	2.7	75	882	295-315	0.10	200	2.7	75	882	546-571	0.10	200	2.7	75	882
Air	0.120	3.0	-	-	-	-	-	-	-	-	-	-	-	-	255-276	0.10	200	2.7	75	882
	0.040	1.0	-	-	-	-	-	-	498-512	0.05	200	1.2	73	120	718-748	0.05	200	1.2	75	130
	0.060	1.5	-	-	-	-	-	-	265-275	0.06	200	1.2	116	250	452-472	0.06	200	2.0	115	675
	0.080	2.0	-	-	-	-	-	-	150-157	0.20	200	1.2	116	250	295-315	0.10	200	2.0	115	675
O <sub>2</sub>	0.120	3.0	-	-	-	-	-	-	90-97	0.40	200	2.3	180	1233	107-122	0.30	200	2.3	175	1233
	0.160	4.0	-	-	-	-	-	-	-	-	-	-	-	-	73-83	0.40	200	2.3	175	1233
Brass	0.040	1.0	-	-	-	-	-	-	498-512	0.05	200	1.7	145	585	757-787	0.05	200	1.7	145	585
	0.060	1.5	-	-	-	-	-	-	300-315	0.07	200	1.7	145	585	452-472	0.07	200	1.7	145	585
	0.080	2.0	-	-	-	-	-	-	185-196	0.10	200	2.3	203	1419	315-335	0.10	200	2.3	205	1419
	0.120	3.0	-	-	-	-	-	-	70-78	0.10	200	2.3	232	1606	135-150	0.10	200	2.3	230	1606
	0.160	4.0	-	-	-	-	-	-	-	-	-	-	-	-	100-110	0.20	200	2.3	230	1606
	0.040	1.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

## NOTE:

This table displays maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, assist gas (O<sub>2</sub>, N<sub>2</sub>, Air) and gas pressure. Flow rates are estimated in CFH. Actual consumption rates may vary. Cutting speeds may be reduced if higher cutting quality is required or if lower material quality is used.

# Cutting Speeds: TruLaser 20X0 fiber

BrightLine fiber - Best Possible Edge Quality



TRUMPF

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Materials			TruDisk 2001					TruDisk 3001					TruDisk 4001				
	inch	mm	Cut Speed [in/min]	Pierce Time [s]	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Nozzle [mm]	PSI	Flow [CFH]
Steel	0.040	1.0	282-315	0.02	EAA10	65	100 CFH	295-315	0.02	EAA10	65	100 CFH	313-343	0.02	EAA10	73	109 CFH
	O <sub>2</sub>	0.060	220-244	0.02	EAA10	55	125 CFH	220-244	0.02	EAA10	55	125 CFH	220-244	0.02	EAA10	55	125 CFH
		0.080	185-205	0.02	EAA10	36	91 CFH	185-205	0.02	EAA10	94	195 CFH	185-205	0.02	EAA10	36	91 CFH
		0.120	130-145	0.03	EAA10	51	117 CFH	131-146	0.03	EAA10	51	117 CFH	137-157	0.04	EAA10	51	117 CFH
		0.180	74-82	0.05	EAA08	10	41 CFH	111-126	0.05	EAA12	10	41 CFH	111-126	0.05	EAA12	10	41 CFH
		0.250	64-71	0.09	EAA14	9	53 CFH	88-98	0.07	EAA12	9	53 CFH	104-114	0.07	EAA12	10	41 CFH
		0.375	35-39	0.33	EAA14	12	65 CFH	61-71	0.33	EAA12	12	65 CFH	69-79	0.33	EAA12	9	53 CFH
		0.500	25-30	2.00	EAA14	9	71 CFH	37-47	2.00	EAA14	9	71 CFH	49-59	2.00	EAA14	9	71 CFH
		0.625	20-24	6.00	EAA10	10	116 CFH	25-30	6.00	EAA14	9	105 CFH	37-47	4.40	EAA14	9	71 CFH
	0.750	20	-	-	-	-	-	23-28	11.80	EAK40	13	98 CFH	25-30	4.70	EAA14	7	92 CFH
	1.000	25	-	-	-	-	-	-	-	-	-	-	18-22	10.70	EAK40	8	179 CFH
Steel	0.040	1.0	600-669	0.01	EAA14	218	1218 CFH	1062-1142	0.01	EAA20	218	1218 CFH	1416-1516	0.01	EAA20	131	171 CFH
	N <sub>2</sub>	0.060	443-492	0.02	EAA14	145	837 CFH	718-748	0.02	EAA20	145	837 CFH	944-1024	0.02	EAA20	160	913 CFH
		0.080	286-318	0.02	EAA10	145	1104 CFH	546-571	0.02	EAA23	145	1104 CFH	757-787	0.02	EAA20	145	837 CFH
		0.120	152-169	0.03	EAA14	247	2481 CFH	269-299	0.03	EAA27	247	2481 CFH	364-394	0.03	EAA27	203	2067 CFH
		0.180	-	-	-	-	-	119-134	0.06	EAA27	247	2481 CFH	162-177	0.06	EAA27	261	2619 CFH
	0.250	6.4	-	-	-	-	-	49-59	0.20	EAA27	247	2481 CFH	79-91	0.18	EAA27	261	2619 CFH
Steel	0.040	1.0	692-768	0.01	EAA14	73	326 CFH	1101-1181	0.01	EAA17	73	326 CFH	1317-1417	0.01	EAA17	73	326 CFH
	Air	0.060	425-472	0.02	EAA14	73	449 CFH	757-787	0.02	EAA20	73	449 CFH	846-906	0.02	EAA20	73	449 CFH
		0.080	308-342	0.02	EAA10	73	592 CFH	506-531	0.02	EAA23	73	592 CFH	663-669	0.02	EAA23	73	592 CFH
		0.120	-	-	-	-	-	282-307	0.03	EAA23	73	589 CFH	393-433	0.03	EAA23	73	592 CFH
Stainless	0.040	1.0	787-827	0.01	EAA17	145	608 CFH	1160-1240	0.01	EAA17	131	552 CFH	1514-1614	0.01	EAA17	116	497 CFH
	N <sub>2</sub>	0.060	489-543	0.02	EAA17	145	608 CFH	806-846	0.02	EAA17	160	663 CFH	1101-1181	0.02	EAA17	131	552 CFH
		0.080	295-327	0.02	EAA23	189	1405 CFH	423-453	0.02	EAA23	189	1405 CFH	787-827	0.02	EAA23	160	1204 CFH
		0.120	142-157	0.03	EAA27	218	2205 CFH	275-295	0.03	EAA27	218	2205 CFH	319-339	0.03	EAA27	174	1792 CFH
		0.180	68-75	0.17	EAA27	261	2619 CFH	103-118	0.10	EAA27	261	2619 CFH	177-197	0.10	EAA27	261	2527 CFH
		0.250	46-51	0.30	EAA27	290	2894 CFH	69-79	0.20	EAA27	290	2894 CFH	105-120	0.20	EAA27	203	1995 CFH
		0.310	19-24	0.50	EAA27	261	2619 CFH	32-39	0.33	EAA27	261	2619 CFH	58-73	0.33	EAA27	232	2263 CFH
		0.625	-	-	-	-	-	9-12	11.85	EAA27	290	2894 CFH	10-14	8.00	EAA27	290	2894 CFH
	0.750	20.0	-	-	-	-	-	-	-	-	-	-	9-12	9.00	EAA27	290	2894 CFH
Stainless	0.040	1.0	886-984	0.01	EAA20	73	222 CFH	1160-1240	0.01	EAA14	73	222 CFH	1475-1575	0.01	EAA14	73	222 CFH
	Air	0.060	487-512	0.01	EAA20	73	326 CFH	846-906	0.01	EAA17	73	326 CFH	1101-1181	0.01	EAA17	73	326 CFH
		0.080	295-327	0.02	EAA23	73	592 CFH	566-591	0.02	EAA23	73	592 CFH	826-866	0.02	EAA23	73	592 CFH
		0.120	-	-	-	-	-	197-217	0.02	EAA23	73	592 CFH	452-472	0.02	EAA23	73	592 CFH
Aluminum	0.040	1.0	515-571	0.02	EAA20	87	533 CFH	806-846	0.02	EAA20	533	533 CFH	885-945	0.02	EAA20	58	381 CFH
	N <sub>2</sub>	0.060	300-331	0.02	EAA20	87	533 CFH	487-512	0.02	EAA20	533	533 CFH	506-531	0.02	EAA20	87	533 CFH
		0.080	188-208	0.02	EAA20	131	761 CFH	334-354	0.02	EAA20	761	761 CFH	352-382	0.02	EAA20	116	685 CFH
		0.120	96-106	0.03	EAA20	160	913 CFH	152-167	0.03	EAA20	723	723 CFH	177-197	0.03	EAA20	138	1054 CFH
		0.180	53-59	0.08	EAA23	203	1505 CFH	84-94	0.05	EAA23	1505	1505 CFH	123-138	0.05	EAA23	218	1605 CFH
		0.250	35-39	0.30	EAA23	232	1706 CFH	61-71	0.07	EAA23	1906	1906 CFH	88-98	0.07	EAA23	247	1806 CFH
		0.500	-	-	-	-	-	12-16	2.50	EAA27	2619	2619 CFH	22-26	2.00	EAA23	261	1906 CFH
		0.625	-	-	-	-	-	-	-	-	-	-	16-24	8.00	EAA23	261	1841 CFH
Aluminum	0.040	1.0	886-984	0.02	EAA27	73	813 CFH	1554-1654	0.02	EAA27	73	813 CFH	1750-1850	0.02	EAA23	73	592 CFH
	Air	0.060	530-587	0.02	EAA27	73	748 CFH	826-866	0.03	EAA27	73	813 CFH	1317-1417	0.02	EAA23	73	592 CFH
		0.080	320-354	0.03	EAA27	73	813 CFH	546-571	0.03	EAA27	73	813 CFH	244-584	0.03	EAA23	73	592 CFH
		0.120	-	-	-	-	-	255-276	0.03	EAA27	73	748 CFH	400-433	0.03	EAA27	73	748 CFH
Copper	0.040	1.0	487-512	0.03	EAA12	73	156 CFH	718-748	0.02	EAA12	73	156 CFH	826-866	0.02	EAA12	73	156 CFH
	O <sub>2</sub>	0.060	236-276	0.03	EAA20	116	640 CFH	452-472	0.02	EAA20	116	640 CFH	566-591	0.02	EAA20	116	640 CFH
		0.080	157-177	0.06	EAA20	116	640 CFH	253-283	0.03	EAA20	116	640 CFH	374-394	0.03	EAA20	116	640 CFH
		0.120	62-87	0.17	EAA23	174	1219 CFH	107-122	0.10	EAA23	174	1219 CFH	185-205	0.10	EAA23	174	1219 CFH
		0.180	-	-	-	-	-	49-59	0.13	EAA23	174	1219 CFH	92-102	0.13	EAA23	145	1032 CFH
		0.250	-	-	-	-	-	13-18	1.00	EAA27	174	1538 CFH	40-51	1.00	EAA27	174	1538 CFH
		0.310	-	-	-	-	-	-	-	-	-	-	13-20	1.00	EAA27	175	1539 CFH
Brass	0.040	1.0	487-512	0.02	EAA17	145	608 CFH	757-787	0.02	EAA17	145	608 CFH	1239-1339	0.02	EAA17	174	718 CFH
	N <sub>2</sub>	0.060	305-335	0.03	EAA17	145	608 CFH	452-472	0.02	EAA17	145	608 CFH	846-906	0.02	EAA17	174	718 CFH
		0.080	167-197	0.04	EAA23	203	1505 CFH	315-335	0.03	EAA23	203	1505 CFH	487-512	0.03	EAA20	174	982 CFH
		0.120	69-79	0.08	EAA23	232	1706 CFH	135-150	0.03	EAA23	232	1706 CFH	216-236	0.03	EAA20	261	1435 CFH
		0.180	-	-	-	-	-	69-79	0.07	EAA23	261	1906 CFH	91-106	0.07	EAA23	232	1646 CFH
		0.250	-	-	-	-	-	29-39	0.07	EAA23	290	2107 CFH	46-59	0.07	EAA23	290	2107 CFH
		0.310	-	-	-	-	-	-	-	-	-	-	28-39	0.33	EAA27	290	2894 CFH

## NOTE:

This table displays maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, assist gas (O<sub>2</sub>, N<sub>2</sub>, Air) and gas pressure.

Flow rates are estimated in CFH. Actual consumption rates may vary.

Cutting speeds may be reduced if higher cutting quality is required or if lower material quality is used.

# Cutting Speeds: TruLaser 30X0 fiber



**BrightLine fiber - Best possible edge quality**

**Performance Package - High quality edge with out sacrificing speed**

**High Speed Cutting - Absolute fastest cut speeds and reduced pierce times**

**Highspeed Eco Nozzle - Reducing the nitrogen consumption up to 70%**

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111 Hyde Rd.  
Farmington CT, 06032  
Phone: (860) 255-6153  
Fax: (860) 255-6426  
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Materials			TruDisk 3001					TruDisk 4001					TruDisk 6001				
	inch	mm	Cut Speed [in/min]	Pierce Time [s]	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Nozzle [mm]	PSI	Flow [CFH]	Inch/min	Pierce Time (s)	Nozzle	PSI	Flow
<b>Steel</b>	0.040	1.0	<b>334-354</b>	0.02	EAA10	65	100 CFH	<b>334-354</b>	0.02	EAA10	65	100 CFH	<b>334-354</b>	0.02	EAA12	58	130 CFH
<b>O<sub>2</sub></b>	0.060	1.5	<b>232-252</b>	0.02	EAA12	58	130 CFH	<b>232-252</b>	0.02	EAA12	58	130 CFH	<b>232-252</b>	0.02	EAA12	58	130 CFH
	0.080	2.0	<b>200-217</b>	0.02	EAA12	36	91 CFH	<b>200-217</b>	0.02	EAA12	36	91 CFH	<b>200-217</b>	0.02	EAA12	36	91 CFH
	0.120	3.0	<b>149-169</b>	0.03	EAA12	58	130 CFH	<b>149-169</b>	0.03	EAA12	41	99 CFH	<b>149-169</b>	0.02	EAA12	58	130 CFH
	0.180	4.5	<b>120-130</b>	0.05	EAA08	15	24 CFH	<b>126-136</b>	0.05	EAA08	15	24 CFH	<b>128-138</b>	0.05	EAA08	12	29 CFH
	0.250	6.4	<b>100-110</b>	0.05	EAA10	9	37 CFH	<b>104-114</b>	0.07	EAA10	10	41 CFH	<b>108-118</b>	0.06	EAA10	9	37 CFH
	0.375	9.5	<b>61-71</b>	0.33	EAA12	10	59 CFH	<b>69-79</b>	0.17	EAA12	10	59 CFH	<b>84-94</b>	0.17	EAA12	10	59 CFH
	0.500	12.7	<b>45-51</b>	1.65	EAA12	10	59 CFH	<b>52-59</b>	0.70	EAA12	10	59 CFH	<b>69-79</b>	0.39	EAA12	9	53 CFH
	0.625	16	<b>31-35</b>	3.25	EAA14	9	71 CFH	<b>41-47</b>	4.50	EAA14	9	71 CFH	<b>55-60</b>	1.15	EAA14	9	71 CFH
	0.750	20	<b>21-26</b>	5.00	EAA20	7	127 CFH	<b>28-33</b>	2.21	EAA20	7	127 CFH	<b>42-47</b>	2.15	EAA17	10	116 CFH
	1.000	25	-	-	-	-	-	<b>23-26</b>	13.35	EAA23	7	168 CFH	<b>32-36</b>	4.15	EAA20	10	160 CFH
<b>Steel</b>	0.040	1.0	<b>1278-1378</b>	0.01	EAA17	131	552 CFH	<b>1682-1732</b>	0.01	EAA17	131	552 CFH	<b>1908-2008</b>	0.01	EAA17	174	718 CFH
<b>N<sub>2</sub></b>	0.060	1.5	<b>885-945</b>	0.01	EAA20	145	831 CFH	<b>1186-1236</b>	0.01	EAU25	174	827 CFH	<b>1510-1610</b>	0.01	EAA17	145	608 CFH
	0.080	2.0	<b>653-693</b>	0.01	EAA23	174	1259 CFH	<b>910-945</b>	0.01	EAU25	203	954 CFH	<b>1101-1201</b>	0.01	EAA17	174	718 CFH
	0.120	3.0	<b>285-315</b>	0.01	EAA23	203	1453 CFH	<b>374-394</b>	0.01	EAU40	203	2144 CFH	<b>619-669</b>	0.01	EAU40	174	1797 CFH
	0.180	4.5	<b>135-150</b>	0.05	EAA27	247	2481 CFH	<b>231-256</b>	0.00	EAU100	87	1671 CFH	<b>336-386</b>	0.00	EAV30	87	1189 CFH
	0.250	6.4	<b>62-67</b>	0.33	EAA27	203	2067 CFH	<b>126-146</b>	0.00	EAU100	87	1683 CFH	<b>215-240</b>	0.00	EAV30	87	1189 CFH
<b>Stainless</b>	0.040	1.0	<b>1396-1496</b>	0.01	EAA14	131	377 CFH	<b>1682-1732</b>	0.01	EAA14	116	762	<b>2262-2362</b>	0.01	EAA17	203	828 CFH
<b>N<sub>2</sub></b>	0.060	1.5	<b>924-1024</b>	0.01	EAA20	189	1057 CFH	<b>1199-1299</b>	0.01	EAU30	145	1662	<b>1534-1634</b>	0.01	EAA20	174	989 CFH
	0.080	2.0	<b>655-669</b>	0.01	EAA23	218	1605 CFH	<b>895-965</b>	0.01	EAU30	174	1662	<b>1160-1260</b>	0.01	EAU30	145	1008 CFH
	0.120	3.0	<b>275-295</b>	0.02	EAA27	174	1792 CFH	<b>354-374</b>	0.02	EAU40	203	1777	<b>659-709</b>	0.02	EAU40	203	2144 CFH
	0.180	4.5	<b>145-157</b>	0.03	EAA23	261	1906 CFH	<b>282-307</b>	0.00	EAU100	87	2052	<b>403-433</b>	0.00	EAV30	73	1019 CFH
	0.250	6.4	<b>69-79</b>	0.07	EAA27	261	2619 CFH	<b>161-181</b>	0.05	EAU100	87	1896	<b>255-280</b>	0.00	EAV30	73	1019 CFH
	0.375	9.5	<b>23-26</b>	0.33	EAA27	290	2894 CFH	<b>45-55</b>	1.30	EAU100	87	2725	<b>88-98</b>	0.09	EAV30	58	849 CFH
	0.500	12.7	<b>10-14</b>	1.10	EAA27	290	2872 CFH	<b>26-31</b>	18.00	EAU100	116	3433	<b>49-59</b>	8.00	EAV30	73	1019 CFH
	0.625	16.0	-	-	-	-	-	<b>12-17</b>	22.50	EAU100	131	2833	<b>30-35</b>	9.00	EAV30	87	1189 CFH
	0.750	20.0	-	-	-	-	-	<b>9-12</b>	60.50	EAU100	174.0	2833	<b>18-22</b>	11.50	EAV30	116	1529 CFH
	1.000	25.0	-	-	-	-	-	-	-	-	-	-	<b>12-15</b>	16.00	EAV30	174	1274 CFH
<b>Alumin.</b>	0.040	1.0	<b>767-827</b>	0.01	EAA20	73	457 CFH	<b>845-945</b>	0.01	EAA17	73	331 CFH	<b>1050-1182</b>	0.01	EAA17	73	331 CFH
<b>N<sub>2</sub></b>	0.060	1.5	<b>481-531</b>	0.02	EAA20	94	571 CFH	<b>501-571</b>	0.02	EAA20	87	533 CFH	<b>688-748</b>	0.02	EAA20	73	457 CFH
	0.080	2.0	<b>314-354</b>	0.02	EAA20	116	685 CFH	<b>354-394</b>	0.02	EAA20	94	571 CFH	<b>475-512</b>	0.02	EAA20	131	761 CFH
	0.120	3.0	<b>127-142</b>	0.02	EAA20	131	761 CFH	<b>177-197</b>	0.02	EAA20	131	761 CFH	<b>400-430*)</b>	0.02	EAA23	116	903 CFH
	0.180	4.5	<b>88-98</b>	0.03	EAA23	160	1204 CFH	<b>132-142</b>	0.02	EAA23	160	1204 CFH	<b>334-354</b>	0.02	EAA27	174	1648 CFH
	0.250	6.4	<b>61-71</b>	0.05	EAA23	218	1605 CFH	<b>92-102</b>	0.04	EAA23	218	1605 CFH	<b>208-228</b>	0.07	EAU60	218	3274 CFH
	0.375	9.5	<b>30-35</b>	0.27	EAA23	232	1706 CFH	<b>50-55</b>	0.12	EAA23	232	1706 CFH	<b>88-98</b>	0.20	EAU60	174	2660 CFH
	0.500	12.7	<b>13-16</b>	1.25	EAA23	232	1706 CFH	<b>30-35</b>	0.50	EAA23	232	1706 CFH	<b>42-47</b>	0.35	EAA27	203	1363 CFH
	0.750	20.0	-	-	-	-	-	<b>11-14</b>	2.70	EAA23	232	1706 CFH	<b>16-20</b>	2.50	EAQ75	174	3731 CFH
	1.000	25.0	-	-	-	-	-	-	-	-	-	-	<b>8-10</b>	5.00	EAA27	319	3170 CFH
<b>Alumin.</b>	0.040	1.0	<b>2165-2362</b>	0.01	EAA14	116	317 CFH	<b>2165-2362</b>	0.01	EAA14	116	317 CFH	<b>2655-2755</b>	0.01	EAA14	131	352 CFH
<b>O<sub>2</sub></b>	0.060	1.5	<b>1219-1319</b>	0.01	EAA14	109	300 CFH	<b>1219-1319</b>	0.01	EAA14	109	300 CFH	<b>2655-2755</b>	0.01	EAA14	108	300 CFH
	0.080	2.0	<b>680-787</b>	0.02	EAA27	87	902 CFH	<b>680-787</b>	0.02	EAA27	87	902 CFH	<b>1869-1969</b>	0.02	EAA23	87	657 CFH
	0.120	3.0	-	-	-	-	-	-	-	-	-	-	<b>1120-1220</b>	0.02	EAA27	87	902 CFH
<b>Copper</b>	0.040	1.0	<b>765-787</b>	0.02	EAA12	73	156 CFH	<b>962-1062</b>	0.02	EAA12	73	156 CFH	<b>1475-1575</b>	0.01	EAA12	73	156 CFH
<b>O<sub>2</sub></b>	0.060	1.5	<b>472-492</b>	0.02	EAA20	116	636 CFH	<b>680-780</b>	0.02	EAA20	116	636 CFH	<b>1002-1102</b>	0.01	EAA20	131	706 CFH
	0.080	2.0	<b>315-323</b>	0.04	EAA20	131	706 CFH	<b>391-461</b>	0.04	EAA20	131	706 CFH	<b>852-902</b>	0.02	EAA20	145	777 CFH
	0.120	3.0	<b>115-130</b>	0.04	EAA23	160	1088 CFH	<b>224-264</b>	0.04	EAA23	160	1088 CFH	<b>313-343</b>	0.04	EAA23	131	906 CFH
	0.180	4.5	<b>45-51</b>	0.20	EAA27	160	1420 CFH	<b>77-87</b>	0.15	EAA27	160	1420 CFH	<b>106-126</b>	0.15	EAA27	159	1424 CFH
	0.250	6.4	<b>16-20</b>	0.67	EAA27	160	1546 CFH	<b>25-30</b>	0.29	EAA27	160	1546 CFH	<b>63-71</b>	0.22	EAA27	159	1424 CFH
	0.390	10.0	-	-	-	-	-	-	-	-	-	-	<b>24-26</b>	1.00	EAA27	159	1423 CFH
<b>Brass</b>	0.040	1.0	<b>787-815</b>	0.02	EAA17	145	608 CFH	<b>1109-1209</b>	0.02	EAA17	145	608 CFH	<b>1278-1378</b>	0.01	EAA20	145	837 CFH
<b>N<sub>2</sub></b>	0.060	1.5	<b>472-543</b>	0.03	EAA17	145	608 CFH	<b>690-740</b>	0.03	EAA17	145	608 CFH	<b>1160-1260</b>	0.01	EAA20	145	837 CFH
	0.080	2.0	<b>335-378</b>	0.03	EAA20	145	831 CFH	<b>486-516</b>	0.03	EAA20	145	831 CFH	<b>746-846</b>	0.01	EAA20	145	831 CFH
	0.120	3.0	<b>150-189</b>	0.04	EAA20	174	982 CFH	<b>228-248</b>	0.04	EAA20	174	982 CFH	<b>352-402</b>	0.01	EAA20	189	1058 CFH
	0.180	4.5	<b>80-85</b>	0.04	EAA27	218	2025 CFH	<b>123-138</b>	0.04	EAA27	218	2025 CFH	<b>197-217</b>	0.04	EAA27	218	2026 CFH
	0.250	6.4	<b>38-43</b>	0.04	EAA27	290	2658 CFH	<b>61-71</b>	0.04	EAA27	290	2658 CFH	<b>144-154</b>	0.04	EAA27	290	2659 CFH
	0.390	10.0	-	-	-	-	-	-	-	-	-	-	<b>35-39</b>	0.34	EAA27	290	2894 CFH

## NOTE:

\*)Preliminary

This table displays maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, assist gas (O<sub>2</sub>, N<sub>2</sub>, Air) and gas pressure.

Flow rates are estimated in CFH. Actual consumption rates may vary.

Cutting speeds may be reduced if higher cutting quality is required or if lower material quality is used.



# Cutting Speeds: TruLaser 50X0 fiber



**BrightLine fiber** - Best possible edge quality

**Performance Package** - High quality edge with out sacrificing speed

**High Speed Cutting** - Absolute fastest cut speeds and reduced pierce times

**Highspeed Eco Nozzle** - Reducing the nitrogen consumption up to 70%

**TRUMPF**



TRUMPF Inc.  
111 Hyde Rd.  
Farmington CT, 06032  
Phone: (860) 255-6153  
Fax: (860) 255-6426

Materials			TruDisk 6001 (6000 Watts)					TruDisk 8001 (8000 Watts)				
	inch	mm	Inch/min	Pierce Time (s)	Nozzle	PSI	Flow	Inch/min	Pierce Time (s)	Nozzle	PSI	Flow
<b>Steel</b> <b>O<sub>2</sub></b>	0.040	1.0	<b>334-354</b>	0.02	EAA12	58	130 CFH	<b>334-354</b>	0.02	EAA12	58	130 CFH
	0.060	1.5	<b>232-252</b>	0.02	EAA12	58	130 CFH	<b>232-252</b>	0.02	EAA12	58	130 CFH
	0.080	2.0	<b>200-217</b>	0.02	EAA12	36	91 CFH	<b>200-217</b>	0.02	EAA12	94	195 CFH
	0.120	3.0	<b>149-169</b>	0.02	EAA12	58	130 CFH	<b>149-169</b>	0.02	EAA12	58	130 CFH
	0.180	4.5	<b>128-138</b>	0.05	EAA08	12	29 CFH	<b>128-138</b>	0.05	EAA08	9	24 CFH
	0.250	6.4	<b>108-118</b>	0.06	EAA10	9	37 CFH	<b>108-118</b>	0.06	EAA10	9	37 CFH
	0.375	9.5	<b>84-94</b>	0.17	EAA12	10	59 CFH	<b>88-98</b>	0.17	EAA12	9	59 CFH
	0.500	12.7	<b>69-79</b>	0.39	EAA12	9	53 CFH	<b>80-87</b>	0.60	EAA14	10	71 CFH
	0.625	16	<b>55-60</b>	1.15	EAA14	9	71 CFH	<b>60-65</b>	2.50	EAA14	9	71 CFH
	0.750	20	<b>42-47</b>	2.15	EAA17	10	116 CFH	<b>49-53</b>	2.15	EAA17	10	116 CFH
	1.000	25	<b>32-36</b>	4.15	EAA20	10	160 CFH	<b>35-39</b>	4.15	EAA20	10	160 CFH
<b>Steel</b> <b>N<sub>2</sub></b>	0.040	1.0	<b>1908-2008</b>	0.01	EAA17	174	718 CFH	<b>2262-2362</b>	0.01	EAA17	145	608 CFH
	0.060	1.5	<b>1510-1610</b>	0.01	EAA17	145	608 CFH	<b>1868-1968</b>	0.01	EAA17	160	663 CFH
	0.080	2.0	<b>1101-1201</b>	0.01	EAA17	174	718 CFH	<b>1396-1496</b>	0.01	EAU25	218	1018 CFH
	0.120	3.0	<b>619-659</b>	0.01	EAU40	174	1797 CFH	<b>846-906</b>	0.01	EAU40	174	1797 CFH
	0.180	4.5	<b>361-386</b>	0.00	EAV30	87	1189 CFH	<b>444-484</b>	0.00	EAV30	73	1019 CFH
	0.250	6.4	<b>220-240</b>	0.00	EAV30	87	1189 CFH	<b>315-350</b>	0.00	EAV30	87	1189 CFH
	0.375	9.5	<b>79-89</b>	0.45	EAV30	73	1019 CFH	<b>117-130</b>	0.20	EAV30	87	1189 CFH
	0.500	12.7	-	-	-	-	-	<b>80-87</b>	0.60	EAV30	73	1019 CFH
<b>Stainless</b> <b>N<sub>2</sub></b>	0.040	1.0	<b>2262-2362</b>	0.01	EAA17	203	828 CFH	<b>2459-2559</b>	0.01	EAA20	232	1294 CFH
	0.060	1.5	<b>1534-1634</b>	0.01	EAA20	174	989 CFH	<b>1947-2047</b>	0.01	EAA23	217	1605 CFH
	0.080	2.0	<b>1160-1260</b>	0.01	EAU30	145	1008 CFH	<b>1474-1574</b>	0.01	EAU30	145	1008 CFH
	0.120	3.0	<b>659-709</b>	0.02	EAU40	203	2144 CFH	<b>944-1024</b>	0.02	EAU40	174	1858 CFH
	0.180	4.5	<b>403-433</b>	0.00	EAV30	73	1019 CFH	<b>537-567</b>	0.00	EAV30	73	1019 CFH
	0.250	6.4	<b>255-280</b>	0.00	EAV30	73	1019 CFH	<b>355-394</b>	0.00	EAV30	73	1019 CFH
	0.375	9.5	<b>82-102</b>	0.09	EAV30	58	849 CFH	<b>152-169</b>	0.09	EAV30	58	849 CFH
	0.500	12.7	<b>57-67</b>	1.50	EAV30	73	1019 CFH	<b>88-98</b>	1.50	EAV30	58	849 CFH
	0.625	16.0	<b>37-47</b>	1.00	EAV30	73	1019 CFH	<b>57-63</b>	1.00	EAV30	58	849 CFH
	0.750	20.0	<b>18-23</b>	9.00	EAV30	94	1274 CFH	<b>34-37</b>	9.00	EAV30	58	849 CFH
	1.000	25.0	<b>12-17</b>	13.00	EAV30	80	1104 CFH	<b>24-29</b>	13.00	EAV30	29	507 CFH
	1.570	40.0	-	-	-	-	-	<b>5-9</b>	160.00	EAQ95	174	2693 CFH
<b>Alumin.</b> <b>N<sub>2</sub></b>	0.040	1.0	<b>1050-1182</b>	0.01	EAA17	73	331 CFH	<b>1050-1182</b>	0.01	EAA17	73	331 CFH
	0.060	1.5	<b>688-748</b>	0.02	EAA20	73	457 CFH	<b>688-748</b>	0.02	EAA20	73	457 CFH
	0.080	2.0	<b>475-512</b>	0.02	EAA20	131	761 CFH	<b>475-512</b>	0.02	EAA20	131	761 CFH
	0.120	3.0	<b>400-430*)</b>	0.02	EAA23	116	903 CFH	<b>400-430*)</b>	0.02	EAA23	116	903 CFH
	0.180	4.5	<b>334-354</b>	0.02	EAA27	174	1648 CFH	<b>324-354</b>	0.02	EAA27	174	1648 CFH
	0.250	6.4	<b>208-228</b>	0.07	EAU60	218	3274 CFH	<b>273-283</b>	0.03	EAA27	189	1780 CFH
	0.375	9.5	<b>88-98</b>	0.20	EAU60	174	2660 CFH	<b>116-126</b>	0.20	EAK40	247	2163 CFH
	0.500	12.7	<b>45-55</b>	0.50	EAK40	203	1778 CFH	<b>66-71</b>	0.55	EAK40	283	2463 CFH
	0.750	20.0	<b>25-30</b>	1.05	EAK40	232	2018 CFH	<b>35-39</b>	5.00	EAK40	276	2340 CFH
	1.000	25.0	<b>9-10</b>	10.00	EAA27	319	3170 CFH	<b>11-12</b>	10.00	EAA27	319	3170 CFH
<b>Alumin.</b> <b>O<sub>2</sub></b>	0.040	1.0	<b>2655-2755</b>	0.01	EAA14	131	352 CFH	<b>2655-2755</b>	0.01	EAA17	116	465 CFH
	0.060	1.5	<b>2655-2755</b>	0.01	EAA14	108	300 CFH	<b>2655-2755</b>	0.01	EAA14	108	300 CFH
	0.080	2.0	<b>1869-1969</b>	0.02	EAA23	87	657 CFH	<b>2655-2755</b>	0.02	EAA23	87	657 CFH
	0.120	3.0	<b>1120-1220</b>	0.02	EAA27	87	902 CFH	<b>1616-1716</b>	0.02	EAA27	87	902 CFH
<b>Copper</b> <b>O<sub>2</sub></b>	0.040	1.0	<b>1475-1575</b>	0.01	EAA12	73	156 CFH	<b>1592-1692</b>	0.01	EAA12	101	208 CFH
	0.060	1.5	<b>1002-1102</b>	0.01	EAA20	131	706 CFH	<b>1160-1260</b>	0.01	EAA20	145	777 CFH
	0.080	2.0	<b>852-902</b>	0.02	EAA20	145	777 CFH	<b>958-1008</b>	0.01	EAA20	159	847 CFH
	0.120	3.0	<b>313-343</b>	0.04	EAA23	131	906 CFH	<b>328-378</b>	0.01	EAA23	159	1087 CFH
	0.180	4.5	<b>106-126</b>	0.15	EAA27	159	1424 CFH	<b>145-165</b>	0.15	EAA27	159	1426 CFH
	0.250	6.4	<b>63-71</b>	0.22	EAA27	159	1424 CFH	<b>84-94</b>	0.21	EAA27	159	1426 CFH
	0.390	10.0	<b>22-26</b>	1.00	EAA27	159	1423 CFH	<b>26-31</b>	1.00	EAA27	159	1425 CFH
<b>Brass</b> <b>N<sub>2</sub></b>	0.040	1.0	<b>1278-1378</b>	0.01	EAA20	145	837 CFH	<b>1278-1378</b>	0.01	EAA17	145	608 CFH
	0.060	1.5	<b>1160-1260</b>	0.01	EAA20	145	837 CFH	<b>1120-1220</b>	0.01	EAA17	145	608 CFH
	0.080	2.0	<b>746-846</b>	0.01	EAA20	145	831 CFH	<b>990-1039</b>	0.01	EAA20	145	831 CFH
	0.120	3.0	<b>352-402</b>	0.01	EAA20	189	1058 CFH	<b>530-555</b>	0.01	EAA20	174	982 CFH
	0.180	4.5	<b>197-217</b>	0.04	EAA27	217	2026 CFH	<b>326-346</b>	0.04	EAA27	217	2026 CFH
	0.250	6.4	<b>144-154</b>	0.04	EAA27	290	2659 CFH	<b>226-236</b>	0.04	EAA27	261	2407 CFH
	0.390	10.0	<b>35-39</b>	0.34	EAA27	290	2894 CFH	<b>39-44</b>	0.33	EAA27	261	2619 CFH

## NOTE:

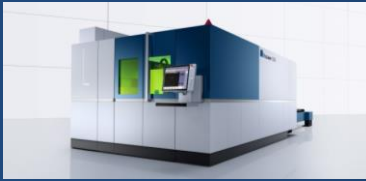
\*)Preliminary

This table displays maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, assist gas (O<sub>2</sub>, N<sub>2</sub>, Air) and gas pressure.

Flow rates are estimated in CFH. Actual consumption rates may vary.

Cutting speeds may be reduced if higher cutting quality is required or if lower material quality is used.

# Cutting Speeds: TruLaser 50X0 fiber



**BrightLine fiber** - Best possible edge quality

**Performance Package** - High quality edge with out sacrificing speed

**High Speed Cutting** - Absolute fastest cut speeds and reduced pierce times

**Highspeed Eco Nozzle** - Reducing the nitrogen consumption up to 70%

**TRUMPF**

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Phone: (860) 255-6153  
Fax: (860) 255-6426

Materials			TruDisk 10001 (10,000 Watts)				
	inch	mm	Inch/min	Pierce Time (s)	Nozzle	PSI	Flow
<b>Steel</b> <b>O<sub>2</sub></b>	0.040	1.0	324-354	0.02	EAA12	58	130 CFH
	0.060	1.5	222-252	0.02	EAA12	58	130 CFH
	0.080	2.0	197-217	0.02	EAA12	94	195 CFH
	0.120	3.0	149-169	0.03	EAA12	58	130 CFH
	0.180	4.5	118-138	0.05	EAA08	9	24 CFH
	0.250	6.4	103-118	0.06	EAA10	9	37 CFH
	0.375	9.5	88-98	0.17	EAA12	10	59 CFH
	0.500	12.7	77-87	0.60	EAA14	9	71 CFH
	0.625	16	55-65	0.50	EAA14	9	71 CFH
	0.750	20	49-59	0.85	EAA20	9	144 CFH
	1.000	25	35-45	2.35	EAA20	12	176 CFH
<b>Steel</b> <b>N<sub>2</sub></b>	0.040	1.0	2262-2362	0.01	EAA17	145	608 CFH
	0.060	1.5	1869-1969	0.01	EAA17	160	663 CFH
	0.080	2.0	1396-1496	0.01	EAU25	218	1018 CFH
	0.120	3.0	1052-1142	0.01	EAU40	174	1797 CFH
	0.180	4.5	600-650	0.00	EAV30	87	1189 CFH
	0.250	6.4	402-437	0.00	EAV30	87	1189 CFH
	0.375	9.5	155-185	0.00	EAV30	87	1189 CFH
	0.500	12.7	94-114	0.10	EAV30	32	543 CFH
<b>Stainless</b> <b>N<sub>2</sub></b>	0.040	1.0	1947-2047	0.01	EAA14	145	415 CFH
	0.060	1.5	1534-1634	0.01	EAA20	174	989 CFH
	0.080	2.0	1595-1575	0.01	EAU30	145	1008 CFH
	0.120	3.0	944-1024	0.01	EAU40	174	1858 CFH
	0.180	4.5	678-728	0.00	EAV30	73	1019 CFH
	0.250	6.4	450-500	0.00	EAV30	73	1019 CFH
	0.375	9.5	182-224	0.06	EAV30	44	679 CFH
	0.500	12.7	132-157	0.18	EAV30	58	849 CFH
	0.625	16.0	84-94	0.75	EAV30	73	1019 CFH
	0.750	20.0	45-55	9.75	EAV30	58	849 CFH
	1.000	25.0	34-39	13.00	EAV30	36	594 CFH
	1.570	40.0	5-6	165.00	EAQ95	174	2693 CFH
<b>Alumin.</b> <b>N<sub>2</sub></b>	0.040	1.0	1101-1181	0.01	EAA17	73	331 CFH
	0.060	1.5	684-748	0.01	EAA20	73	457 CFH
	0.080	2.0	472-512	0.01	EAA20	131	761 CFH
	0.120	3.0	400-430*)	0.01	EAA23	116	903 CFH
	0.180	4.5	324-354	0.02	EAA27	174	1648 CFH
	0.250	6.4	253-283	0.03	EAA27	189	1780 CFH
	0.375	9.5	134-154	0.00	EAU60	247	2704 CFH
	0.500	12.7	77-87	0.45	EAU60	261	2823 CFH
	0.750	20.0	42-47	0.80	EAU60	276	2813 CFH
	1.000	25.0	9-12	2.25	EAA27	319	3170 CFH
<b>Alumin.</b> <b>O<sub>2</sub></b>	0.040	1.0	2604-2756	0.01	EAA17	116	465 CFH
	0.060	1.5	2604-2756	0.01	EAA14	109	300 CFH
	0.080	2.0	2604-2756	0.00	EAA23	87	657 CFH
	0.120	3.0	1869-1969	0.00	EAA27	87	902 CFH
<b>Copper</b> <b>O<sub>2</sub></b>	0.040	1.0	1592-1692	0.01	EAA12	101	208 CFH
	0.060	1.5	1160-1260	0.01	EAA20	145	777 CFH
	0.080	2.0	958-1008	0.01	EAA20	159	847 CFH
	0.120	3.0	328-378	0.01	EAA23	159	1087 CFH
	0.180	4.5	145-165	0.15	EAA27	159	1426 CFH
	0.250	6.4	84-94	0.21	EAA27	159	1426 CFH
	0.390	10.0	26-31	1.00	EAA27	159	1425 CFH
<b>Brass</b> <b>N<sub>2</sub></b>	0.040	1.0	1278-1378	0.01	EAA17	145	608 CFH
	0.060	1.5	1120-1220	0.01	EAA17	145	608 CFH
	0.080	2.0	990-1039	0.01	EAA20	145	831 CFH
	0.120	3.0	530-555	0.01	EAA20	174	982 CFH
	0.180	4.5	326-346	0.04	EAA27	217	2026 CFH
	0.250	6.4	226-236	0.04	EAA27	261	2407 CFH
	0.390	10.0	39-44	0.33	EAA27	261	2619 CFH

## NOTE:

\*)Preliminary

This table displays maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, assist gas (O<sub>2</sub>, N<sub>2</sub>, Air) and gas pressure.

Flow rates are estimated in CFH. Actual consumption rates may vary.

Cutting speeds may be reduced if higher cutting quality is required or if lower material quality is used.

# Cutting Speeds: TruLaser Tube 5000 fiber



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Materials			TruDisk 2001						TruDisk 3001					
	inch	mm	Cut Speed [in/min]	Pierce Time [s]	Nozzle Name	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Nozzle Name	Nozzle [mm]	PSI	Flow [CFH]
Steel	0.040	1.0	266-295	0.00	EBD08	0.8	65	65	265-295	0.00	EBD08	0.8	65	65
	0.050	1.3	244-271	0.02	EBD08	0.8	65	65	244-271	0.02	EBD08	0.8	65	65
	0.060	1.5	227-251	0.03	EBD08	0.8	65	65	227-251	0.03	EBD10	1.0	65	100
	0.080	2.0	177-196	0.04	EBD08	0.8	58	59	177-196	0.04	EBD08	0.8	65	65
	0.100	2.5	149-165	0.05	EBD08	0.8	12	13	159-177	0.05	EBD08	0.8	12	13
	0.120	3.0	142-157	0.05	EBD08	0.8	12	13	142-157	0.05	EBD08	0.8	10	13
	0.140	3.5	128-141	0.10	EBD08	0.8	12	13	128-141	0.10	EBD08	0.8	15	24
	0.160	4.0	113-125	0.13	EBD10	1.0	12	21	113-125	0.13	EBD10	1.0	12	21
	0.180	4.5	106-118	0.60	EBD10	1.0	12	21	106-118	0.60	EBD10	1.0	65	21
	0.200	5.0	89-98	0.85	EBD10	1.0	9	18	99-110	0.85	EBD10	1.0	10	20
O <sub>2</sub>	0.240	6.0	74-82	3.40	EBD10	1.0	10	20	85-94	0.22	EBD10	1.0	10	20
	0.240	6.0	46-51	6.80	EBD14	1.4	6	31	57-63	6.80	EBD14	1.4	6	31
	0.280	7.0	39-43	7.00	EBD14	1.4	6	31	50-55	7.00	EBD14	1.4	6	31
	0.310	8.0	53-59	5.90	EBD10	1.0	12	21	71	5.90	EBD10	1.0	12	21
			-	-	-	-	-	-	-	-	-	-	-	-
Steel	0.040	1.0	602-669	0.00	EBD20	2.0	203	1141	886-984	0.00	EBD20	2.0	203	1141
	0.050	1.3	531-590	0.00	EBD20	2.0	203	1141	744-826	0.00	EBD20	2.0	203	1141
	0.060	1.5	496-551	0.00	EBD20	2.0	203	1141	709-787	0.00	EBD20	2.0	203	1141
	0.080	2.0	372-413	0.03	EBD20	2.0	218	1217	531-590	0.03	EBD20	2.0	218	1217
	0.100	2.5	248-275	0.03	EBD20	2.0	232	1293	354-393	0.03	EBD20	2.0	232	1293
	0.120	3.0	188-208	0.03	EBD20	2.0	232	1293	266-295	0.03	EBD20	2.0	232	1293
	0.140	3.5	145-161	0.03	EBD20	2.0	232	1293	209-232	0.03	EBD20	2.0	232	1293
	0.160	4.0	106-118	0.03	EBD23	2.3	232	1704	152-169	0.03	EBD23	2.3	232	1704
	0.180	4.5	-	-	-	-	-	-	106-118	0.05	EBD23	2.3	232	1704
	0.200	5.0	-	-	-	-	-	-	89-98	0.05	EBD23	2.3	261	1704
Stainless	0.040	1.0	602-669	0.00	EBD20	2.0	189	1065	886-984	0.00	EBD20	2.0	189	1065
	0.050	1.3	524-582	0.00	EBD20	2.0	203	1141	780-866	0.00	EBD20	2.0	203	1141
	0.060	1.5	471-523	0.00	EBD20	2.0	203	1141	709-787	0.00	EBD20	2.0	203	1141
	0.080	2.0	354-393	0.03	EBD20	2.0	203	1141	531-590	0.03	EBD20	2.0	203	1141
	0.100	2.5	255-283	0.04	EBD20	2.0	203	1141	354-393	0.04	EBD20	2.0	203	1141
	0.120	3.0	191-212	0.04	EBD20	2.0	203	1141	266-295	0.04	EBD20	2.0	203	1141
	0.140	3.5	142-157	0.04	EBD23	2.3	203	1141	191-212	0.04	EBD23	2.3	203	1504
	0.160	4.0	103-114	0.04	EBD23	2.3	203	1141	152-169	0.04	EBD23	2.3	203	1504
	0.180	4.5	-	-	-	-	-	-	99-110	0.04	EBD23	2.3	203	1504
	0.200	5.0	-	-	-	-	-	-	89-98	0.04	EBD23	2.3	203	1504
Alumin.	0.040	1.0	602-669	0.00	EBD17	1.7	145	828	886-984	0.00	EBD17	1.7	145	607
	0.050	1.3	425-472	0.00	EBD17	1.7	145	828	620-688	0.00	EBD17	1.7	145	607
	0.060	1.5	344-381	0.00	EBD17	1.7	145	828	514-570	0.00	EBD17	1.7	145	607
	0.080	2.0	237-263	0.00	EBD17	1.7	145	828	354-393	0.00	EBD17	1.7	232	1293
	0.100	2.5	184-204	0.10	EBD20	2.0	232	1293	266-295	0.10	EBD20	2.0	232	1293
	0.120	3.0	159-177	0.12	EBD20	2.0	232	1293	230-255	0.12	EBD20	2.0	232	1293
	0.140	3.5	-	-	-	-	-	-	191-212	0.20	EBD20	2.0	232	1293
	0.160	4.0	-	-	-	-	-	-	149-165	0.20	EBD20	2.0	232	1293
			-	-	-	-	-	-	-	-	-	-	-	-
			-	-	-	-	-	-	-	-	-	-	-	-
Alumin.	0.160	4.0	-	-	-	-	-	-	71-78	0.10	EBD20	2.0	181	961
			-	-	-	-	-	-	-	-	-	-	-	-
O <sub>2</sub>			-	-	-	-	-	-						
Copper	0.040	1.0	461-511	0.00	EBD12	1.2	116	234	602-669	0.00	EBD12	1.2	116	234
	0.050	1.3	330-366	0.04	EBD17	1.7	116	465	461-511	0.04	EBD17	1.7	116	465
	0.060	1.5	283-314	0.05	EBD17	1.7	116	465	425-472	0.05	EBD17	1.7	116	465
	0.080	2.0	170-188	0.09	EBD20	2.0	160	828	255-283	0.09	EBD20	2.0	160	854
	0.100	2.5	106-118	0.19	EBD23	2.3	145	1032	177-196	0.19	EBD23	2.3	145	1032
	0.120	3.0	71-78	0.27	EBD23	2.3	145	1032	124-137	0.27	EBD23	2.3	145	1032
	0.140	3.5	-	-	-	-	-	-	64-70	0.12	EBD23	2.3	87	657
	0.160	4.0	-	-	-	-	-	-	46-51	0.14	EBD23	2.3	87	657
Brass	0.040	1.0	531-590	0.00	EBD17	1.7	145	607	531-590	0.00	EBD17	1.7	145	607
	0.050	1.3	461-511	0.03	EBD17	1.7	145	607	461-511	0.03	EBD17	1.7	145	607
	0.060	1.5	407-452	0.03	EBD17	1.7	145	607	425-472	0.03	EBD17	1.7	145	607
	0.080	2.0	273-303	0.04	EBD20	2.0	145	837	354-393	0.04	EBD20	2.0	145	837
	0.100	2.5	213-236	0.04	EBD20	2.0	145	837	319-354	0.04	EBD20	2.0	145	837
	0.120	3.0	159-177	0.05	EBD20	2.0	174	989	266-295	0.05	EBD20	2.0	174	989
	0.140	3.5	-	-	-	-	-	-	213-236	0.1	EBD23	2.3	87	702
	0.160	4.0	-	-	-	-	-	-	177-196	0.05	EBD23	2.3	87	702

## NOTE:

This table displays maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, assist gas (O<sub>2</sub>, N<sub>2</sub>, Air) and gas pressure.

# Cutting Speeds: TruLaser Tube 5000 & 7000 CO<sub>2</sub>



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Materials			TruFlow 2000							TruFlow 2700							TruFlow 3200							TruFlow 3600						
			Cutting Speed [in/min]	Pierce Time [s]	Nozzle Name	Nozzle [mm]	PSI	Flow [CFH]	Cutting Speed [in/min]	Pierce Time [s]	Nozzle Name	Nozzle [mm]	PSI	Flow [CFH]	Cutting Speed [in/min]	Pierce Time [s]	Nozzle Name	Nozzle [mm]	PSI	Flow [CFH]	Cutting Speed [in/min]	Pierce Time [s]	Nozzle Name	Nozzle [mm]	PSI	Flow [CFH]				
Steel	0.040	1.0	265-295	0.00	EBD08	0.8	19	27	265-295	0.00	EBD08	0.8	19	27	265-295	0.04	EBD10	1.0	58	36	266-295	0.00	EBD08	0.8	19	27				
	0.050	1.3	244-271	0.04	EBD08	0.8	22	30	244-271	0.00	EBD08	0.8	22	30	244-271	0.04	EBD10	1.0	58	36	244-271	0.00	EBD08	0.8	22	30				
	0.060	1.5	226-251	0.05	EBD08	0.8	22	30	226-251	0.00	EBD08	0.8	22	30	226-251	0.04	EBD10	1.0	58	36	227-251	0.00	EBD08	0.8	22	30				
	0.080	2.0	177-196	0.05	EBD10	1.0	22	46	177-196	0.06	EBD08	0.8	22	30	177-196	0.04	EBD10	1.0	58	36	177-196	0.05	EBD08	0.8	22	30				
	0.100	2.5	145-161	0.05	EBD08	0.8	15	24	1445-161	0.08	EBD08	0.8	15	24	145-161	0.06	EBD10	1.0	58	36	145-161	0.06	EBD08	0.8	15	24				
	0.120	3.0	134-149	0.06	EBD08	0.8	15	24	134-149	0.09	EBD08	0.8	15	24	134-149	0.08	EBD10	1.0	58	36	135-149	0.07	EBD08	0.8	15	24				
	0.140	3.5	124-137	0.07	EBD08	0.8	15	24	116-129	0.10	EBD08	0.8	15	24	124-137	0.08	EBD10	1.0	7	17	124-137	0.10	EBD08	0.8	15	24				
	0.160	4.0	116-129	0.08	EBD08	0.8	15	24	109-122	0.11	EBD08	0.8	15	24	116-129	0.08	EBD10	1.0	7	17	117-129	0.11	EBD08	0.8	15	24				
	0.180	4.5	100-112	0.15	EBD10	1.0	12	21	102-114	0.25	EBD10	1.0	12	21	111-124	0.11	EBD10	1.0	12	21	110-122	0.15	EBD10	1.0	12	21				
	0.200	5.0	95-106	0.20	EBD10	1.0	12	21	67-74	0.40	EBD10	1.0	12	21	106-118	0.14	EBD10	1.0	12	21	106-118	0.20	EBD10	1.0	12	21				
O <sub>2</sub>	0.240	6.0	77-86	0.30	EBD08	0.8	10	13	92-102	0.40	EBD10	1.0	10	20	95-106	0.23	EBD12	1.2	9	26	96-106	0.30	EBD10	1.0	10	20				
	0.240	6.0	60-66	1.60	EBD14	1.4	6	31	60-66	1.60	EBD14	1.4	6	31	63-70	10.00	EBD14	1.4	6	31	78-96	1.60	EBD14	1.4	6	31				
	0.280	7.0	46-51	3.30	EBD14	1.4	6	31	63-70	3.30	EBD14	1.4	6	31	56-62	12.00	EBD14	1.4	6	31	64-70	3.30	EBD14	1.4	6	31				
	0.310	8.0	60-66	0.50	EBD10	1.0	15	36	67-74	2.70	EBD10	1.0	15	36	77-86	1.50	EBD12	1.2	9	26	78-96	2.70	EBD14	1.4	15	71				
	0.310	8.0	-	-	-	-	-	-	42-47	5.00	EBD14	1.4	6	31	-	-	-	-	-	-	53-59	5.00	EBD14	1.4	6	31				
	0.375	10.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	67-74	3.20	EBD10	1.0	15	36					
	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-				
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Steel	0.040	1.0	318-354	0.00	EBD14	1.4	174	490	318-354	0.00	EBD14	1.4	174	490	318-354	0.00	EBD14	1.4	174	490	319-354	0.00	EBD14	1.4	12	490				
	0.050	1.3	262-291	0.08	EBD14	1.4	189	527	283-314	0.05	EBD14	1.4	189	527	283-314	0.04	EBD14	1.4	189	527	283-314	0.05	EBD14	1.4	13	527				
	0.060	1.5	230-255	0.10	EBD14	1.4	203	565	255-283	0.05	EBD14	1.4	203	565	265-295	0.04	EBD14	1.4	203	565	266-295	0.05	EBD14	1.4	14	565				
	0.080	2.0	177-196	0.13	EBD14	1.4	218	603	212-236	0.05	EBD14	1.4	218	603	219-244	0.04	EBD14	1.4	218	603	220-244	0.05	EBD14	1.4	15	603				
	0.100	2.5	134-149	0.15	EBD14	1.4	218	603	155-173	0.05	EBD14	1.4	218	603	159-177	0.05	EBD14	1.4	218	603	159-177	0.05	EBD14	1.4	15	603				
	0.120	3.0	95-106	0.20	EBD14	1.4	232	640	106-118	0.06	EBD14	1.4	232	640	127-141	0.06	EBD14	1.4	232	640	128-141	0.06	EBD14	1.4	16	640				
	0.140	3.5	74-82	0.22	EBD17	1.7	232	938	85-94	0.07	EBD14	1.4	232	640	99-110	0.07	EBD14	1.4	232	640	106-118	0.07	EBD14	1.4	232	640				
	0.160	4.0	60-66	0.25	EBD17	1.7	232	938	67-74	0.10	EBD17	1.7	232	938	85-94	0.07	EBD17	1.7	232	938	89-98	0.10	EBD17	1.7	232	938				
	0.180	4.5	-	-	-	-	-	-	62-68	0.10	EBD17	1.7	232	938	77-86	0.09	EBD17	1.7	232	938	89-98	0.10	EBD17	1.7	232	938				
	0.200	5.0	-	-	-	-	-	-	58-64	0.15	EBD17	1.7	247	993	70-78	0.10	EBD17	1.7	247	993	78-86	0.13	EBD17	1.7	247	993				
N <sub>2</sub>	0.240	6.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-					
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Steel	0.040	1.0	372-413	0.00	EBD17	1.7	73	326	425-472	0.00	EBD17	1.7	73	326	425-472	0.00	EBD17	1.7	73	326										
	0.050	1.3	290-322	0.02	EBD17	1.7	73	326	336-374	0.04	EBD17	1.7	73	326	336-374	0.04	EBD17	1.7	73	326										
	0.060	1.5	255-283	0.02	EBD17	1.7	73	326	301-334	0.04	EBD17	1.7	73	326	301-334	0.04	EBD17	1.7	73	326										
	0.080	2.0	194-216	0.02	EBD23	2.3	73	592	226-251	0.04	EBD23	2.3	73	592	230-255	0.04	EBD23	2.3	73	592										
	0.100	2.5	-	-	-	-	-	-	155-173	0.05	EBD23	2.3	73	592	177-196	0.05	EBD23	2.3	73	592										
	0.120	3.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-											
	0.140	3.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-											
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Air	0.040	1.0	318-354	0.00	EBD14	1.4	174	490	318-354	0.00	EBD14	1.4	174	490	318-354	0.00	EBD14	1.4	174	490	319-354	0.00	EBD14	1.4	12	490				
	0.050	1.3	262-291	0.08	EBD14	1.4	189	527	283-314	0.05	EBD14	1.4	189	527	283-314	0.04	EBD14	1.4	189	527	283-314	0.05	EBD14	1.4	13	527				
	0.060	1.5	230-255	0.10	EBD14	1.4	203	565	255-283	0.05	EBD14	1.4	203	565	265-295	0.04	EBD14	1.4	203	565	266-295	0.05	EBD14	1.4	14	565				
	0.080	2.0	177-196	0.13	EBD14	1.4	218	603	212-236	0.05	EBD14	1.4	218	603	219-244	0.04	EBD14	1.4	218	603	220-244	0.05	EBD14	1.4	15	603				
	0.100	2.5	134-149	0.15	EBD14	1.4	218	603	155-173	0.05	EBD14	1.4	218	603	159-177	0.05	EBD14	1.4	218	603	159-177	0.05	EBD14	1.4	15	603				
	0.120	3.0	95-106	0.20	EBD14	1.4	232	640	106-118	0.06	EBD14																			



# Cutting Speeds: TruFlow Laser



Materials			TruFlow 3200						TruFlow 4000						TruFlow 5000						TruFlow 6000					
	inch	mm	Cut Speed [in/min]	Pierce Time [s]	Lens [in]	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Lens [in]	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Lens [in]	Nozzle [mm]	PSI	Flow [CFH]	Cut Speed [in/min]	Pierce Time [s]	Lens [in]	Nozzle [mm]	PSI	Flow [CFH]
Steel O <sub>2</sub>	0.040	1.0	302-322	0.00	5	0.8	19	15	302-322	0.00	5	0.8	51	41	302-322	0.00	5	0.8	51	41	302-322	0.00	5	0.8	19	15
	0.060	1.5	242-252	0.06	5	0.8	6	4	242-252	0.06	5	0.8	51	41	242-252	0.06	5	0.8	51	41	242-252	0.06	5	0.8	8	6
	0.080	2.0	203-213	0.07	10	0.8	8	6	203-213	0.07	10	0.8	8	6	203-213	0.07	10	0.8	8	6	203-213	0.07	10	0.8	8	6
	0.120	3.0	187-197	0.09	10	0.8	9	8	187-197	0.09	10	0.8	9	8	187-197	0.09	10	0.8	9	8	187-197	0.09	10	0.8	9	8
	0.180	4.5	112-122	0.30	10	0.8	12	10	136-146	0.15	10	0.8	12	10	151-161	0.12	10	0.8	12	10	171-181	0.12	10	0.8	12	10
	0.250	6.4	100-110	0.50	10	1.0	12	16	108-118	0.20	10	1.0	12	16	120-130	0.18	10	1.0	9	12	130-146	0.14	10	1.0	10	14
	0.375	9.5	61-71	1.80	10	1.2	10	25	69-79	0.50	10	1.2	10	25	81-91	0.48	10	1.2	10	25	84-94	0.22	10	1.2	10	25
	0.500	12.7	45-55	2.80	10	1.4	9	26	49-59	1.20	10	1.4	9	26	60-67	0.83	10	1.4	10	30	65-75	0.55	10	1.4	10	30
	0.625	16	34-39	4.40	10	1.4	10	30	42-47	2.60	10	1.4	10	30	50-55	1.50	10	1.4	10	30	50-55	1.50	10	1.4	10	30
	0.750	20	28-33	5.00	10	2.0	9	50	30-35	5.00	10	2.0	9	50	38-43	3.16	10	2.0	9	50	38-43	3.16	10	2.0	9	50
1.000	25	-	-	-	-	-	-	-	-	-	-	-	-	26-31	9.36	10	2.3	8	70	26-31	9.36	10	2.3	9	75	
Steel N <sub>2</sub>	0.040	1.0	757-787	0.05	5	1.7	102	408	944-984	0.05	5	1.7	100	408	1004-1024	0.04	5	1.7	100	408	1240-1260	0.04	5	1.7	100	408
	0.060	1.5	433-453	0.05	5	2.0	123	609	452-472	0.05	5	1.7	100	408	650-669	0.04	5	1.7	100	408	787-807	0.04	5	1.7	100	408
	0.080	2.0	179-189	0.13	10	1.4	150	430	226-236	0.05	10	1.7	100	408	344-354	0.08	5	1.7	100	408	541-551	0.05	5	1.7	100	408
	0.120	3.0	108-118	0.19	10	1.7	225	880	136-146	0.06	10	1.7	235	945	183-193	0.09	10	2.3	235	1615	300-315	0.06	5	2.3	235	1615
	0.180	4.5	57-67	0.28	10	1.7	225	880	81-91	0.15	10	2.3	250	1750	100-110	0.14	10	2.3	250	1750	136-146	0.12	10	2.3	250	1750
	0.250	6.4							69-79	0.17	10	2.3	220	1550	86-96	0.17	10	2.3	280	1960	100-110	0.17	10	2.3	280	1960
	0.310	8.0												60-65	0.25	10	2.3	294	1995	66-71	0.20	10	2.3	290	1980	
	0.375	9.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	41-51	0.23	10	2.7	348	3425
Steel Air	0.040	1.0	366-386	0.05	5	1.7	45	110	728-748	0.05	10	1.4	73	195	767-787	0.05	10	1.4	74	195	901-921	0.05	5	1.4	73	195
	0.060	1.5	248-268	0.06	5	1.7	45	110	531-551	0.06	10	1.7	66	270	610-630	0.06	10	1.7	74	300	649-669	0.06	5	1.7	73	300
	0.080	2.0	180-197	0.07	5	2.3	45	200	384-394	0.07	10	2.3	59	530	452-472	0.07	10	2.3	74	570	456-476	0.07	5	2.3	73	570
	0.120	3.0	116-126	0.12	5	2.3	73	570	202-217	0.12	10	2.3	73	570	225-240	0.12	10	2.3	74	570	229-244	0.12	5	2.3	73	571
Stainless N <sub>2</sub>	0.040	1.0	807-827	0.06	5	1.7	105	408	929-949	0.06	5	1.7	100	408	964-984	0.06	5	1.7	100	408	1004-1024	0.05	5	1.7	100	408
	0.060	1.5	433-453	0.10	5	1.7	105	408	496-516	0.10	5	1.7	100	408	689-709	0.10	5	1.7	100	408	846-866	0.05	5	1.7	100	408
	0.080	2.0	221-236	0.14	10	1.4	225	590	248-263	0.10	5	1.7	200	820	492-512	0.10	5	1.7	100	408	610-630	0.05	5	1.7	100	408
	0.120	3.0	147-157	0.20	10	1.7	240	939	151-161	0.10	10	2.0	220	1170	175-185	0.10	10	1.7	235	945	195-205	0.06	5	1.7	235	945
	0.180	4.5	73-83	0.37	10	2.3	240	1606	88-98	0.21	10	2.3	220	1530	122-132	0.10	10	2.3	220	1530	132-142	0.08	10	2.3	206	1425
	0.250	6.4	57-67	0.60	10	2.3	240	1606	77-87	0.23	10	2.3	235	1615	84-94	0.23	10	2.3	206	1425	106-116	0.12	10	2.3	206	1425
	0.375	9.5	11-16	1.50	10	2.7	300	2833	27-33	0.35	10	2.7	250	2460	39-49	0.25	10	2.7	250	2460	49-59	0.25	10	2.7	250	2460
	0.500	12.7	5-8	2.10	10	2.7	315	3100	20-25	4.00	10	6.0	218	3200	28-33	0.60	10	2.7	325	3200	36-41	0.60	10	2.7	290	2875
	0.625	16.0							10-12	8.00	10	7.5	218	3231	17-22	6.00	10	2.7	290	2875	21-26	1.35	10	2.7	325	3200
	0.750	20.0													11-16	10.00	10	2.7	290	2875	16-20	2.66	10	2.7	290	2875
1.000	25.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	8-10	6.67	10	2.7	325	3200	
Stainless Air	0.040	1.0	354-374	0.05	5	1.7	73	290	767-787	0.05	5	1.7	73	300	925-945	0.05	5	1.7	73	300	964-984	0.05	10	1.7	74	300
	0.060	1.5	305-315	0.05	5	1.7	73	290	560-590	0.05	5	1.7	73	300	571-591	0.05	5	1.7	73	300	610-630	0.05	10	1.7	74	300
	0.080	2.0	261-276	0.06	5	1.7	73	290	374-394	0.06	5	1.7	73	300	381-394	0.06	5	1.7	73	300	452-472	0.06	10	1.7	74	300
	0.120	3.0	147-157	0.60	5	2.3	73	570	262-276	0.35	5	2.7	73	366	265-285	0.32	5	2.3	73	580	275-295	0.06	10	1.7	74	300
Aluminum N <sub>2</sub>	0.040	1.0	1082-1102	0.00	5	1.7	90	349	1358-1378	0.00	5	1.7	100	408	1476-1496	0.00	5	1.7	100	408	1555-1575	0.00	5	1.7	100	408
	0.060	1.5	748-768	0.06	5	1.7	105	408	886-906	0.06	5	1.7	100	408	1043-1063	0.05	5	1.7	100	408	1161-1181	0.00	5	1.7	100	408
	0.080	2.0	212-232	0.09	10	1.7	145	585	271-291	0.08	10	1.7	145	585	767-787	0.07	5	1.7	100	408	905-925	0.00	5	1.7	100	408
	0.120	3.0	136-146	0.15	10	2	180	950	183-193	0.13	10	2.0	145	820	354-374	0.09	5	2.0	235	1235	492-512	0.06	5	2.0	235	1235
	0.180	4.5	53-63	0.24	10	2	210	1088	100-110	0.16	10	2.0	160	885	116-126	0.11	10	2.3	220	1530	151-161	0.10	10	2.3	206	1425
	0.250	6.4	35-39	0.45	10	2.3	225	1513	65-71	0.40	10	2.3	132	960	81-91	0.14	10	2.7	206	2070	96-106	0.14	10	2.7	206	2070
	0.375	9.5							23-28	4.00	10	2.3	235	1615	25-31	2.00	10	2.0	250	1320	32-37	0.56	10	2.0	250	1320
	0.500	12.7													13-18	2.20	10	2.3	325	2250	17-22	1.60	10	2.3	295	2000
	0.625	16.0																			10-14	4.00	10	2.3	325	2250
	Alumin. Air	0.040	1.0	571-591	0.09	5	2.3	73	570	689-709	0.09	5	2.0	73	480	1092-1102	0.09	5	2.0	73	480	1220-1240	0.05	5	2.0	73
0.060		1.5	334-354	0.12	5	2.3	73	570	492-512	0.12	5	2.3	73	570	649-669	0.12	5	2.3	73	570	886-906	0.05	5	2.3	73	580
0.080		2.0	187-197	0.15	5	2.3	73	570	344-354	0.15	5	2.3	73	570	452-472	0.15	5	2.3	59	540	610-630	0.06				

## NOTE:

This table displays maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, assist gas (O<sub>2</sub>, N<sub>2</sub>, Air) and gas pressure.

Flow rates are estimated in CFH. Actual consumption rates may vary.

Cutting speeds may be reduced if higher cutting quality is required or if lower material quality is used.

# Cutting Speeds: TruFlow Classic Laser



TRUMPF Inc.  
111 Hyde Rd.  
Farmington CT, 06032  
Phone: (860) 255-6153  
Fax: (860) 255-6426  
www.us.trumpf.com

Materials			TruFlow 2700						TruFlow 3200						TruFlow 4000						TruFlow 5000						TruFlow 6000					
	inch	mm	in/min	Lens	Nozzle	PSI	Flow	in/min	Lens	Nozzle	PSI	Flow	in/min	Lens	Nozzle	PSI	Flow	in/min	Lens	Nozzle	PSI	Flow	in/min	Lens	Nozzle	PSI	Flow	in/min	Lens	Nozzle	PSI	Flow
Steel O <sub>2</sub>	0.040	1.0	280-350	5"	0.8	55	40 CFH	280-350	5"	0.8	55	40 CFH	280-350	5"	0.8	55	40 CFH	280-350	5"	0.8	55	40 CFH	280-350	5"	0.8	55	40 CFH	210-270	5"	1.0	50	60 CFH
	0.060	1.5	210-270	5"	1.0	50	60 CFH	210-270	5"	1.0	50	60 CFH	210-270	5"	1.0	50	60 CFH	210-270	5"	1.0	50	60 CFH	210-270	5"	1.0	50	60 CFH	170-230	5"	1.0	50	60 CFH
	0.080	2.0	170-230	5"	1.0	50	60 CFH	170-230	5"	1.0	50	60 CFH	170-230	5"	1.0	50	60 CFH	170-230	5"	1.0	50	60 CFH	170-230	5"	1.0	50	60 CFH	130-190	5"	1.0	50	60 CFH
	0.100	2.5	130-190	5"	1.0	50	60 CFH	130-190	5"	1.0	50	60 CFH	130-190	5"	1.0	50	60 CFH	130-190	5"	1.0	50	60 CFH	130-190	5"	1.0	50	60 CFH	100-130	5"	1.0	15	15 CFH
	0.120	3.0	120-180	5"	0.8	35	30 CFH	120-180	5"	0.8	35	30 CFH	120-180	5"	1.0	35	42 CFH	120-180	5"	1.0	35	42 CFH	120-180	5"	1.0	35	42 CFH	90-120	7.5"	1.0	10	15 CFH
	0.180	4.5	90-120	7.5"	1.0	10	15 CFH	100-130	7.5"	1.0	10	15 CFH	110-140	7.5"	1.0	10	15 CFH	140-160	7.5"	1.0	10	15 CFH	140-160	7.5"	1.0	10	15 CFH	130-140	7.5"	1.0	10	15 CFH
	0.250	6.4	70-90	7.5"	1.0	10	15 CFH	90-110	7.5"	1.0	10	15 CFH	100-120	7.5"	1.0	10	15 CFH	120-130	7.5"	1.0	10	15 CFH	120-130	7.5"	1.0	10	15 CFH	105-115	7.5"	1.0	10	15 CFH
	0.375	9.5	40-50	7.5"	1.4	10	30 CFH	56-66	7.5"	1.4	8	28 CFH	70-80	7.5"	1.4	8	28 CFH	85-90	7.5"	1.4	8	28 CFH	85-90	7.5"	1.4	8	28 CFH	75-85	7.5"	1.4	8	28 CFH
	0.500	12.7	32-40	7.5"	1.4	10	30 CFH	40-48	7.5"	1.4	8	28 CFH	56-64	7.5"	1.4	8	28 CFH	70-80	7.5"	1.4	8	28 CFH	70-80	7.5"	1.4	8	28 CFH	65-70	7.5"	1.4	8	28 CFH
	0.625	16	24-28	7.5"	1.7	8	35 CFH	30-34	7.5"	1.4	8	28 CFH	38-46	7.5"	1.4	8	28 CFH	55-60	7.5"	1.4	8	28 CFH	55-60	7.5"	1.4	8	28 CFH	42-46	7.5"	1.7	8	35 CFH
0.750	20						28-32	7.5"	1.7	8	35 CFH	32-36	7.5"	1.7	8	35 CFH	38-42	7.5"	1.7	8	35 CFH	38-42	7.5"	1.7	8	35 CFH	32	7.5"	2.3	8	70 CFH	
1.000	25	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	32	7.5"	2.3	8	70 CFH	32	7.5"	2.3	8	70 CFH	35	7.5"	2.3	8	70 CFH
Steel N <sub>2</sub>	0.040	1.0	260-320	5"	1.4	150	400 CFH	320-380	5"	1.4	150	400 CFH	360-420	5"	1.4	150	400 CFH	1000	3.75"	2.3	140	1030 CFH	1200	3.75"	2.3	140	1030 CFH	600-750	3.75"	2.3	140	1030 CFH
	0.060	1.5	190-250	5"	1.4	180	480 CFH	250-310	5"	1.4	180	480 CFH	260-350	5"	1.4	180	480 CFH	500-650	3.75"	2.3	140	1030 CFH	600-750	3.75"	2.3	140	1030 CFH	320-340	5"	1.7	300	1190 CFH
	0.080	2.0	150-180	5"	1.4	200	550 CFH	190-230	5"	1.4	170	465 CFH	200-260	5"	1.4	170	465 CFH	260-280	5"	1.7	300	1190 CFH	600-750	3.75"	2.3	140	1030 CFH	200-220	7.5"	1.7	210	850 CFH
	0.120	3.0	60-80	5"	1.7	210	850 CFH	120-140	5"	1.7	210	850 CFH	140-170	5"	1.7	210	850 CFH	180-200	7.5"	1.7	210	850 CFH	600-750	3.75"	2.3	140	1030 CFH	130-140	7.5"	1.7	210	850 CFH
	0.160	4.0	40-50	7.5"	2.3	240	1650 CFH	70-90	7.5"	2.3	240	1650 CFH	80-100	7.5"	2.3	240	1650 CFH	120-130	7.5"	2.3	240	1650 CFH	600-750	3.75"	2.3	140	1030 CFH	105-115	7.5"	2.3	280	1960 CFH
	0.250	6.4	-	-	-	-	-	30-40	7.5"	2.3	280	1960 CFH	50-60	7.5"	2.3	280	1960 CFH	90-100	7.5"	2.3	280	1960 CFH	600-750	3.75"	2.3	140	1030 CFH	-	-	-	-	-
Steel Air	0.040	1.0	420-480	5"	2.3	75	600 CFH	530-590	5"	2.3	75	600 CFH	720-780	5"	2.3	75	600 CFH	1200	3.75"	2.3	90	680 CFH	1200	3.75"	2.3	90	680 CFH	750-800	7.5"	2.3	90	680 CFH
	0.060	1.5	270-330	5"	2.3	75	600 CFH	350-410	5"	2.3	75	600 CFH	470-530	5"	2.3	75	600 CFH	650-700	5"	2.3	90	680 CFH	750-800	7.5"	2.3	90	680 CFH	540-600	7.5"	2.3	90	680 CFH
	0.080	2.0	200-260	5"	2.3	75	600 CFH	250-310	5"	2.3	75	600 CFH	350-410	5"	2.3	75	600 CFH	440-500	5"	2.3	90	680 CFH	750-800	7.5"	2.3	90	680 CFH	300	7.5"	2.3	90	680 CFH
	0.120	3.0																210	5"	2.3	90	680 CFH	750-800	7.5"	2.3	90	680 CFH	180	7.5"	2.3	90	680 CFH
	0.180	4.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	
Stainless N <sub>2</sub>	0.040	1.0	280-360	5"	1.4	160	430 CFH	360-420	5"	1.4	170	465 CFH	400-460	5"	1.4	170	465 CFH	1200	3.75"	1.7	100	405 CFH	1200	3.75"	1.7	100	405 CFH	550-650	5"	1.7	170	700 CFH
	0.060	1.5	220-280	5"	1.4	200	550 CFH	280-340	5"	1.4	170	465 CFH	290-350	5"	1.4	170	465 CFH	450-500	5"	1.7	170	700 CFH	550-650	5"	1.7	170	700 CFH	280-340	5"	1.4	170	470 CFH
	0.080	2.0	170-200	5"	1.4	200	550 CFH	220-250	5"	1.4	170	465 CFH	230-260	5"	1.4	170	465 CFH	250-300	5"	1.4	170	470 CFH	550-650	5"	1.7	170	700 CFH	250-280	5"	1.4	220	610 CFH
	0.120	3.0	80-100	5"	1.4	200	550 CFH	120-160	5"	1.4	170	465 CFH	160-190	5"	1.4	220	610 CFH	220-240	5"	1.4	220	610 CFH	550-650	5"	1.7	170	700 CFH	145-155	7.5"	1.7	220	900 CFH
	0.180	4.5	70-78	7.5"	2.3	250	1750 CFH	80-100	7.5"	2.3	170	1225 CFH	100-120	7.5"	1.7	220	900 CFH	130-140	7.5"	1.7	220	900 CFH	550-650	5"	1.7	170	700 CFH	115-125	7.5"	2.3	240	1650 CFH
	0.250	6.4	42-50	7.5"	2.3	260	1793 CFH	56-64	7.5"	2.3	200	1415 CFH	80-100	7.5"	2.3	240	1650 CFH	100-110	7.5"	2.3	240	1650 CFH	550-650	5"	1.7	170	700 CFH	90-100	7.5"	2.3	240	1650 CFH
	0.375	9.5						10-18	7.5"	2.3	270	1850 CFH	28-36	7.5"	2.3	290	1980 CFH	45-50	9.0"	2.3	290	1980 CFH	550-650	5"	1.7	170	700 CFH	85-90	7.5"	2.3	290	1980 CFH
	0.500	12.7						14-18	7.5"	2.3	280	1920 CFH	16-20	7.5"	2.3	290	1980 CFH	35-40	9.0"	2.3	290	1980 CFH	550-650	5"	1.7	170	700 CFH	75-85	7.5"	2.3	290	1980 CFH
	0.625	16.0						8-12	7.5"	2.3	280	1920 CFH	14-18	7.5"	2.3	290	1980 CFH	22-25	9.0"	2.3	290	1980 CFH	550-650	5"	1.7	170	700 CFH	65-70	7.5"	2.3	290	1980 CFH
	0.750	19.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	18-20	9.0"	2.7	320	3100 CFH	550-650	5"	1.7	170	700 CFH	22-24	10"	2.7	320	3100 CFH
Stainless Air	0.040	1.0	420-480	5"	2.3	75	600 CFH	530-590	5"	2.3	75	600 CFH	720-780	5"	2.3	75	600 CFH	1200	3.75"	2.3	75	600 CFH	1200	3.75"	2.3	75	600 CFH	750-800	7.5"	2.3	75	600 CFH
	0.060	1.5	270-330	5"	2.3	75	600 CFH	350-410	5"	2.3	75	600 CFH	470-530	5"	2.3	75	600 CFH	650-700	5"	2.3	75	600 CFH	750-800	7.5"	2.3	75	600 CFH	540-600	7.5"	2.3	75	600 CFH
	0.080	2.0	200-260	5"	2.3	75	600 CFH	250-310	5"	2.3	75	600 CFH	350-410	5"	2.3	75	600 CFH	420-480	5"	2.3	75	600 CFH	750-800	7.5"	2.3	75	600 CFH	500-550	5"	2.3	75	600 CFH
Aluminum N <sub>2</sub>	0.040	1.0	320-380	5"	1.4	120	320 CFH	400-460	5"	1.4	120	320 CFH	420-480	5"	1.4	120	320 CFH	1000	3.75"	1.7	100	405 CFH	1000	3.75"	1.7	100	405 CFH	500-550	5"	1.7	200	820 CFH
	0.060	1.5	220-280	5"	1.4	180	480 CFH	270-330	5"	1.4	200	550 CFH	320-380	5"	1.4	200	550 CFH	420-480	5"	1.7	200	820 CFH	500-550	5"	1.7	200	820 CFH	380-420	5"	1.7	200	820 CFH
	0.080	2.0	130-190	5"	1.4	180	480 CFH	180-240	5"	1.4	200	550 CFH	2																			










# TruLaser Nozzle Prices



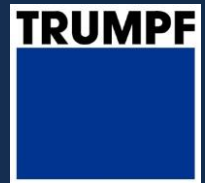
TRUMPF Inc.  
111 Hyde Rd.  
Farmington CT, 06032  
Phone: (860) 255-6153  
Fax: (860) 255-6426  
www.us.trumpf.com

## Cutting Nozzles

## Auxiliary Nozzle




Standard Nozzle	Slim Nozzle	CoolLine Nozzle	Shower Nozzle	Brightline	Performance Package	High Speed Cutting	High Speed Eco Nozzle	Cross-Jet
EAA	EAB	EGL	EAQ	EAK	EAU	EAU	EAV	Small Nozzle
								
Price [USD]								
\$49.50/pack of 5	\$60/pack of 5	\$59/piece	\$79/piece	\$79/piece	\$201/pack of 5	\$201/pack of 5	<ul style="list-style-type: none"> <li>• Nozzle \$101/piece</li> <li>• Inner \$101/pack</li> <li>• Sleeve \$220/pack</li> </ul>	\$45/pack of 5
Diameter [mm]								
0.8 1 1.2 1.4	1.7 2 2.3 2.7	0.8 1 1.2 1.4	1.7 2 2.3 2.7	1.4 1.7 2 2.3	6 7.5 9 9.5	2.5 3	2.5 3 4 6	10 3 2
Application								
<ul style="list-style-type: none"> <li>• All TRUMPF laser machines and BrightLine cutting.</li> <li>• Increasing assist gas widens the nozzle diameter.</li> </ul>	<ul style="list-style-type: none"> <li>• Narrow nozzle used in place of standard nozzle to avoid sheet metal tip ups.</li> </ul>	<ul style="list-style-type: none"> <li>• CoolLine cutting ranging from 0.63" to 1.0"</li> <li>• Sprays water mist over thicker material</li> <li>• Allows more complex geometries and thinner webs</li> </ul>	<ul style="list-style-type: none"> <li>• BrightLine cutting.</li> <li>• Nozzle produces smoother edges and reduces burrs.</li> </ul>	<ul style="list-style-type: none"> <li>• BrightLine &amp; thick Aluminum cutting.</li> </ul>	<ul style="list-style-type: none"> <li>• Smoother, homogeneous parts</li> <li>• Fewer burrs and discoloration</li> <li>• Improved process stability</li> <li>• Quality cuts at increased speed</li> </ul>	<ul style="list-style-type: none"> <li>• Significantly increases cut speeds in mild and stainless steel with N2</li> <li>• 40% lower gas consumption</li> </ul>	<ul style="list-style-type: none"> <li>• 70% lower gas consumption</li> <li>• Touchdown nozzle on the metal sheet prevents lateral gas loss with high speed cutting</li> </ul>	<ul style="list-style-type: none"> <li>• Creates lateral air blast while piercing through material.</li> </ul>

# TruLaser Tube Nozzles



TRUMPF Inc.  
111 Hyde Rd.  
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Phone: (860) 255-6153  
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## Cutting Nozzles

Standard TL Tube		Slim TL Tube		Slim TL Tube	
EBD		EBG		EBF	
					
Diameter [mm]					
0.8	1.7	0.8		1.7	
1	2	1.0		2.0	
1.2	2.3	1.2		2.3	
1.4	2.7	1.4			
Price [USD]					
\$44.50 / pack fo 5		\$44.50 / packof 5		\$44.50 / pack of 5	
Application					
• Standard nozzle for both CO <sub>2</sub> and Fiber machines		• For Bevel cutting			