

# General Reference

## Contour Cutting Speeds & Feeds

	20 ga			16 ga			10 ga			3/16"			1/4"			3/8"			1/2"			3/4"			1"		
	MS	SS	AI	MS	SS	AI	MS	SS	AI	MS	SS	AI	MS	SS	AI	MS	SS	AI	MS	SS	AI	MS	SS	AI	MS	SS	AI
<b>L A S E R</b>																											
<b>2400W</b>																											
<b>O2</b>	400			260			160			*110			*90			*50			*36			*28					
<b>N2</b>	320	300	250	180	190	170	80	120	60	*50	*70	*30		*46	*14	*10											
<b>Air</b>	470	630		310	410																						
<b>3000W</b>																											
<b>O2</b>	400			260			160			*125			*105			*64			*48			*30					
<b>N2</b>	400	400	400	220	280	280	100	160	160	*60	*90	*45	*40	*64	*30		*18	*6		*16							
<b>Air</b>	590	780		390	520																						
<b>4000W</b>																											
<b>O2</b>	400			260			160			*125			*115			*77			*62			*38					
<b>N2</b>	440	500	500	330	360	360	145	200	200	*82	*105	72	*62	*90	*52		*30	*12		*25							
<b>Air</b>	750	1000		500	660																						
<b>P L A S M A</b>																											
<b>MAX100</b>	229	195	210	150	130	150							95	80	60				40	20	30	20	15	10	10	10	5
<b>HD3070</b>																											
<b>30A</b>	125	180		65	120		35						25														
<b>50A</b>	245			120	139		68	55		50	40		35														
<b>70A</b>				280	150	125	150	100	70	100	40		65	55	45		30				25						
<b>100A</b>								275					135	75		95	65		64	45							
<b>MAX200</b>													135	195	190	105	145	145	85	105	110	55	55	65	35	30	35
<b>HT2000</b>																											
<b>50A</b>				140																							
<b>100A</b>							240	140					120	80					60	35		30					
<b>200A</b>													160	195		100	145		80	105		55	55		35	30	
<b>W A T E R J E T</b>																											
<b>30 hp/60k</b>	204	212	629	113	118	349	44	46	137	30	32	94	22	23	67	14	15	42.0	10	10	30	7	7	19.0	4.5	5	14
<b>60 hp/60k</b>	297	310	914	165	172	508	65	68	200	44	46	136	32	33	98	20	21	61	14.4	15	44	9	9.4	28	6.5	6.7	20
<b>30 hp/60k</b>	66	69	204	37.0	38.5	113.0	15.0	15.2	44.6	10.0	10.3	30.5	7.0	7.5	22.0	4.5	4.6	13.7	3.2	3.3	10.0	2	2.1	6.2	1.5	1.5	4.5
<b>60 hp/60k</b>	96	100	295	53	56	164	21	22	65	14	15	44	10	10.8	31.7	6.5	6.8	20	4.6	5	14.3	2.9	3	9	2.1	2.2	6.5

} 1.5  
} 4

These numbers are for reference only and are subject to correction or clarification.