

Amada Laser Cutting Condition Tab

Material Name

File Name P:\emachine 2nd back up\jon's laser stuff

O-HRS0.375

Material Information

<u>Material Name</u>	O-HRS0.375	<u>Material Type</u>	AL5052	<u>Pierce Number</u>	101
<u>Material Thickness</u>	0.060	<u>Head Number</u>			2
<u>Material Process</u>	STD	<u>WACS</u>			No

Cutting

Cut Number	Feed Rate	Power [S]	Frequency	Duty Cycle	Gas Pressure	Gas	Gas Time	Nozzle Gap	Cutter Offset	Edge Number	Approach	Focal Position	Pulse Type
1	3.1	2000	20	25	0.05	1	0.0	0.059	0.0059	0	0	0.039	0
2	11.8	2000	30	35	0.05	1	0.0	0.059	0.0059	203	201	0.039	0
3	39.4	2000	500	70	0.05	1	0.0	0.059	0.0059	203	201	0.039	0
4	51.2	2000	1500	85	0.05	1	0.0	0.059	0.0059	203	201	0.039	0
5	59.1	2000	1500	100	0.05	1	0.0	0.059	0.0059	203	201	0.039	0
6	59.1	2000	1500	100	0.05	1	0.0	0.059	0.0059	203	201	0.039	0
7	59.1	2000	1500	100	0.05	1	0.0	0.059	0.0059	203	201	0.039	0
8	59.1	2000	1500	100	0.05	1	0.0	0.059	0.0059	203	201	0.039	0
9	59.1	2000	1500	100	0.05	1	0.0	0.059	0.0059	0	0	0.039	0
10	118.1	1500	1300	25	0.10	5	0.0	0.059	0.0000	0	0	0.039	0

Piercing

Piercing	Power	Initial Frequency	Initial Duty	Inc. Frequency	Inc. Duty	Step Time	Step Count	Pierce Time	Gas Pressure	Gas Kind	Purge Time	Nozzle Gap	Focal Position	Pulse Type
101	2000	10	20	10	1	0.5	10	5.0	0.05	1	0.0	0.059	0.039	0
102	2000	10	20	10	1	0.5	10	5.0	0.05	1	0.0	0.059	0.039	0
103	2000	10	20	10	1	0.5	10	5.0	0.05	1	0.0	0.059	0.039	0

Edge

Edge	Work Angle	Pierce Power	Pierce Frequency	Pierce Duty	Pierce Time	Gas Pressure	Gas	Distance	Feed Rate	Recover Frequency	Recover Duty
201	120.00	2000	0	0	0.0	0.05	1	0.0394	3.9	20	25
202	120.00	2000	0	0	0.0	0.05	1	0.0394	3.9	20	25
203	120.00	2000	0	0	0.0	0.05	1	0.0591	3.9	20	25
204	120.00	2000	0	0	0.0	0.05	1	0.0591	3.9	20	25
205	120.00	2000	0	0	0.0	0.05	1	0.0591	3.9	20	25