

C-SS0.375**Material Information**

Material Name C-SS0.375 **Material Type** SS **Pierce Number** 101
Material Thickness 0.375 **Head Number** 1
Material Process STD **WACS** No

Cuttina

Cut Number	Feed Rate [F]	Power [S]	Frequency	Duty Cycle	Gas Pressure	Gas Kind	Gas Time	Nozzle Gap	Cutter Offset	Edge Number	Approach Number	Focal Position	Pulse Type
1	15.7	4000	400	50	1.40	7	1.0	0.015	0.0047	0	0	-0.260	0
2	34.0	4000	2000	100	1.40	7	1.0	0.015	0.0047	0	0	-0.260	0
3	34.0	4000	2000	100	1.40	7	1.0	0.015	0.0043	0	0	-0.260	0
4	34.0	4000	2000	100	1.40	7	1.0	0.015	0.0043	0	0	-0.260	0
5	15.7	4000	400	50	1.40	7	1.0	0.015	0.0043	0	0	-0.260	0
6	34.0	4000	2000	100	1.40	7	1.0	0.015	0.0043	0	0	-0.260	0
7	34.0	4000	2000	100	1.40	7	1.0	0.015	0.0043	0	0	-0.260	0
8	34.0	4000	2000	100	1.40	7	1.0	0.015	0.0043	0	0	-0.260	0
9	34.0	4000	2000	100	1.40	7	1.0	0.015	0.0043	0	0	-0.260	0
10	118.1	370	1000	80	0.10	4	0.0	0.059	0.0000	0	0	-0.059	0

Piercing

Piercing Number	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	4000	100	100	0	0	0.0	0	1.0	0.20	4	1.5	0.200	0.000	38
102	4000	100	100	0	0	0.0	0	1.0	0.20	4	1.5	0.200	0.000	38
103	4000	100	100	0	0	0.0	0	1.0	0.20	4	1.5	0.200	0.000	38

Edae

Edge Number	Work Angle	Pierce Power	Pierce Frequency	Pierce Duty	Pierce Time	Gas Pressure	Gas Kind	Distance	Feed Rate	Recover Frequency	Recover Duty	Recover Cycle
201	0.00	4000	0	0	0.0	0.80	4	0.2000	5.0	0	100	
202	0.00	4000	0	0	0.0	0.80	4	0.1181	7.9	0	100	
203	175.00	4000	0	0	1.0	0.60	4	0.1000	2.0	100	65	
204	0.00	4000	0	0	0.0	0.80	4	0.1181	7.9	0	100	
205	0.00	4000	0	0	0.0	0.40	4	0.1969	10.0	2000	100	