

Amada Laser Cutting Condition Table

Material Name

File Name : C:\My Documents\English2k.mdb

A-1050AL0.040

Material Information

| | | | | | |
|--------------------|---------------|---------------|-----|---------------|-----|
| Material Name | A-1050AL0.040 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | | | Head Number | 2 |
| Material Process | STD | | | WACS | No |

Cutting

| 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 | 19.7 | 1500 | 500 | 45 | 0.80 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 2 | 47.2 | 1500 | 500 | 65 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 118.1 | 2000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 157.5 | 2200 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 236.2 | 2700 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 236.2 | 2700 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 236.2 | 2700 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 236.2 | 2700 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 236.2 | 2700 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |

Edge

| Edge Number | Work Angle | Pierce Power | Pierce Frequency | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty Cycle |
|-------------|------------|--------------|------------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-1050AL0.060****Material Information**

| | | | | | |
|---------------------------|---------------|----------------------|-----|----------------------|-----|
| Material Name | A-1050AL0.060 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | 2 | |
| Material Process | STD | WACS | | No | |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 1500 | 500 | 60 | 0.80 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 2 | 39.4 | 1500 | 500 | 80 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 118.1 | 2200 | 1500 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 157.5 | 2700 | 1500 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 196.9 | 3200 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 196.9 | 3200 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 196.9 | 3200 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 196.9 | 3200 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 196.9 | 3200 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-1050AL0.080****Material Information**

Material Name A-1050AL0.080 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 1500 | 500 | 70 | 0.80 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 2 | 39.4 | 2000 | 1500 | 75 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 98.4 | 2200 | 1500 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 118.1 | 2500 | 1500 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 137.8 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 137.8 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 137.8 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 137.8 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 137.8 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0787 | 11.8 | 0 | 100 | |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 0 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-1050AL0.120****Material Information**

Material Name A-1050AL0.120 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 3000 | 500 | 35 | 0.70 | 5 | 0.0 | 0.028 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 2 | 39.4 | 2000 | 1000 | 100 | 0.70 | 5 | 0.0 | 0.020 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 3 | 78.7 | 2700 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 4 | 98.4 | 3200 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 5 | 98.4 | 3200 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 6 | 98.4 | 3200 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 7 | 98.4 | 3200 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 8 | 98.4 | 3200 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 9 | 98.4 | 3200 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 0.10 | 1 | 0.0 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 100 | 100 | |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 100 | 100 | |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 11.8 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-5052AL0.040****Material Information**

Material Name A-5052AL0.040 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 1500 | 500 | 40 | 0.80 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 2 | 47.2 | 1500 | 500 | 50 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 118.1 | 1800 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 157.5 | 2000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 236.2 | 2500 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 236.2 | 2500 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 236.2 | 2500 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 236.2 | 2500 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 236.2 | 2500 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-5052AL0.060****Material Information**

Material Name A-5052AL0.060 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 1500 | 500 | 55 | 0.80 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 2 | 39.4 | 1500 | 500 | 70 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 118.1 | 2000 | 1500 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 157.5 | 2500 | 1500 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 196.9 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 196.9 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 196.9 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 196.9 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 196.9 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-5052AL0.080****Material Information**

Material Name A-5052AL0.080 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 1500 | 500 | 60 | 0.80 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 2 | 39.4 | 1500 | 1500 | 80 | 0.80 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 98.4 | 2000 | 1500 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 118.1 | 2300 | 1500 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 157.5 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 157.5 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 157.5 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 157.5 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 157.5 | 3000 | 2000 | 100 | 0.80 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0787 | 11.8 | 0 | 100 | |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.80 | 5 | 0.0394 | 11.8 | 0 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-5052AL0.120****Material Information**

| | | | | | |
|---------------------------|---------------|----------------------|-----|----------------------|-----|
| Material Name | A-5052AL0.120 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | 2 | |
| Material Process | STD | WACS | | No | |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 1500 | 500 | 70 | 0.70 | 5 | 0.0 | 0.020 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 2 | 39.4 | 2000 | 1500 | 70 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 3 | 78.7 | 2000 | 1500 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 4 | 98.4 | 2500 | 1500 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 5 | 118.1 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 6 | 118.1 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 7 | 118.1 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 8 | 118.1 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 9 | 118.1 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 0.10 | 1 | 0.0 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 100 | 100 | |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 100 | 100 | |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 11.8 | 100 | 100 | |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 11.8 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-5052AL0.160****Material Information**

Material Name A-5052AL0.160 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 3000 | 200 | 40 | 0.70 | 5 | 0.0 | 0.028 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 2 | 23.6 | 3000 | 500 | 60 | 0.70 | 5 | 0.0 | 0.020 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 3 | 59.1 | 2200 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 4 | 78.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 5 | 78.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 6 | 78.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 7 | 78.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 8 | 78.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 9 | 78.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 50 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 50 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 50 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 90 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 90 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 100 | | 100 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 100 | | 100 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 100 | | 100 |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-5052AL0.200****Material Information**

| | | | | | |
|---------------------------|---------------|----------------------|-----|----------------------|-----|
| Material Name | A-5052AL0.200 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | | 2 |
| Material Process | STD | WACS | | | No |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 7.9 | 3000 | 200 | 55 | 0.70 | 5 | 0.0 | 0.028 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 2 | 19.7 | 3000 | 300 | 70 | 0.70 | 5 | 0.0 | 0.020 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 3 | 39.4 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 4 | 39.4 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 5 | 39.4 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 6 | 39.4 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 7 | 39.4 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 8 | 39.4 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 9 | 39.4 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 50 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 50 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 50 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 90 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 90 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 100 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 100 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 100 |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-5052AL0.250****Material Information**

Material Name A-5052AL0.250 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 7.9 | 3000 | 200 | 60 | 0.70 | 5 | 0.0 | 0.028 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 2 | 15.7 | 3000 | 300 | 80 | 0.70 | 5 | 0.0 | 0.020 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 3 | 31.5 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 4 | 31.5 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 5 | 31.5 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 6 | 31.5 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 7 | 31.5 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 8 | 31.5 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 9 | 31.5 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 50 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 50 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 50 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 90 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 90 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 2000 | | 100 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 2000 | | 100 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 2000 | | 100 |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-5052AL0.312****Material Information**

Material Name A-5052AL0.312 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 2 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 3 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 4 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 5 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 6 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 7 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 8 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 203 | 201 | -0.039 | 0 |
| 9 | 19.7 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 0.0 | 0 | 0 | 0 | 0.00 | 0 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 60 | 0 | 0 | 0.0 | 0 | 4.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 60 | 0 | 0 | 0.0 | 0 | 4.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 60 | 0 | 0 | 0.0 | 0 | 4.0 | 0.10 | 1 | 0.5 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 90 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.1181 | 3.9 | 2000 | | 90 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 2000 | | 100 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 2000 | | 100 |
| 205 | 120.00 | 4000 | 100 | 100 | 0.0 | 0.70 | 5 | 0.0394 | 3.9 | 2000 | | 100 |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-SS0.040****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 200 | 12 | 0.60 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.020 | 0 |
| 2 | 39.4 | 2000 | 500 | 25 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.020 | 0 |
| 3 | 196.9 | 2000 | 1500 | 100 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.020 | 0 |
| 4 | 315.0 | 3000 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.020 | 0 |
| 5 | 393.7 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.020 | 0 |
| 6 | 393.7 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.020 | 0 |
| 7 | 393.7 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.020 | 0 |
| 8 | 393.7 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.020 | 0 |
| 9 | 393.7 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.020 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 5 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.020 | 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 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.020 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.020 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | 0.020 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-SS0.060****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 200 | 13 | 0.60 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 2 | 39.4 | 2000 | 500 | 25 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 157.5 | 2200 | 1500 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 236.2 | 3000 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 275.6 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 275.6 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 275.6 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 275.6 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 275.6 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 5 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.1 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.10 | 5 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-SS0.080****Material Information**

Material Name A-SS0.080 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 200 | 15 | 0.70 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 2 | 39.4 | 2000 | 500 | 45 | 0.70 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 3 | 137.8 | 2500 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 4 | 196.9 | 3000 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 5 | 236.2 | 3500 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 6 | 236.2 | 3500 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 7 | 236.2 | 3500 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 8 | 236.2 | 3500 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 9 | 236.2 | 3500 | 2000 | 100 | 0.70 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.020 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 5 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.020 | 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 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | -0.020 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | -0.020 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | -0.020 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 5 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**A-SS0.120****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 2000 | 200 | 30 | 0.60 | 5 | 0.0 | 0.028 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 2 | 39.4 | 2500 | 1000 | 40 | 0.60 | 5 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 3 | 98.4 | 2500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 4 | 137.8 | 3000 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 5 | 157.5 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 6 | 157.5 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 7 | 157.5 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 8 | 157.5 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 9 | 157.5 | 3500 | 2000 | 100 | 0.60 | 5 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.020 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 5 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.020 | 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 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | -0.020 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | -0.020 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 5 | 0.0 | 0.005 | -0.020 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0394 | 11.8 | 300 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0394 | 11.8 | 300 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0394 | 11.8 | 300 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0394 | 11.8 | 300 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 5 | 0.0394 | 11.8 | 300 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-GALV0.031****Material Information**

Material Name C-GALV0.031 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 20 | 0.80 | 4 | 0.3 | 0.028 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 78.7 | 2000 | 1200 | 45 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 196.9 | 1800 | 1500 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 315.0 | 2800 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 393.7 | 3300 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 393.7 | 3300 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 787.4 | 4000 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.028 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 393.7 | 3300 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 393.7 | 3300 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-GALV0.035****Material Information**

Material Name C-GALV0.035 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 25 | 0.80 | 4 | 0.3 | 0.028 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 78.7 | 2000 | 1200 | 50 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 196.9 | 2000 | 1500 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 315.0 | 3000 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 315.0 | 3000 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 315.0 | 3000 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 315.0 | 3000 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 315.0 | 3000 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 315.0 | 3000 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-GALV0.048****Material Information**

Material Name C-GALV0.048 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 25 | 0.80 | 4 | 0.3 | 0.028 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 78.7 | 2000 | 1200 | 50 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 196.9 | 2200 | 1500 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 315.0 | 3200 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 315.0 | 3200 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 315.0 | 3200 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 315.0 | 3200 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 315.0 | 3200 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 315.0 | 3200 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-GALV0.060****Material Information**

Material Name C-GALV0.060 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 30 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.020 | 0 |
| 2 | 78.7 | 2000 | 1200 | 55 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 3 | 157.5 | 3000 | 2000 | 65 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 4 | 236.2 | 3000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 5 | 275.6 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 6 | 275.6 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 7 | 275.6 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 8 | 275.6 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 9 | 275.6 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.020 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.020 | 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 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.020 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.020 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.020 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-GALV0.090****Material Information**

Material Name C-GALV0.090 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 35 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 2 | 78.7 | 3000 | 1200 | 50 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 3 | 137.8 | 2600 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 4 | 196.9 | 3200 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 5 | 196.9 | 3200 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 6 | 196.9 | 3200 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 7 | 196.9 | 3200 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 8 | 196.9 | 3200 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 9 | 196.9 | 3200 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-GALV0.125****Material Information**

Material Name C-GALV0.125 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 35 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 2 | 59.1 | 3000 | 1000 | 45 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 3 | 98.4 | 2500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 4 | 137.8 | 3000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 5 | 157.5 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 6 | 157.5 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 7 | 157.5 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 8 | 157.5 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 9 | 157.5 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-SS0.040****Material Information**

| | | | | | |
|---------------------------|-----------|----------------------|-----|----------------------|-----|
| Material Name | C-SS0.040 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | | 2 |
| Material Process | STD | WACS | | | No |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 25 | 0.80 | 4 | 0.3 | 0.028 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 78.7 | 2000 | 1200 | 50 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 3 | 196.9 | 2000 | 1500 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 4 | 315.0 | 3000 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 5 | 393.7 | 3500 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 6 | 393.7 | 3500 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 7 | 393.7 | 3500 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 8 | 393.7 | 3500 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 201 | 0.000 | 0 |
| 9 | 393.7 | 3500 | 2000 | 100 | 0.80 | 4 | 0.3 | 0.020 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.20 | 4 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-SS0.060****Material Information**

Material Name C-SS0.060 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 30 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.020 | 0 |
| 2 | 78.7 | 2000 | 1200 | 55 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 3 | 157.5 | 3000 | 2000 | 65 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 4 | 236.2 | 3000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 5 | 275.6 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 6 | 315.0 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 7 | 315.0 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 8 | 315.0 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.020 | 0 |
| 9 | 315.0 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.020 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.020 | 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 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.020 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.020 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.020 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-SS0.080****Material Information**

Material Name C-SS0.080 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 35 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 2 | 78.7 | 3000 | 1200 | 50 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 3 | 137.8 | 2500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 4 | 196.9 | 3000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 5 | 236.2 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 6 | 275.6 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 7 | 275.6 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 8 | 275.6 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 9 | 275.6 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-SS0.120****Material Information**

Material Name
Material Type
Pierce Number

Material Thickness
Head Number

Material Process
WACS

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 2000 | 500 | 35 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 2 | 59.1 | 3000 | 1000 | 45 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 3 | 98.4 | 2500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 4 | 137.8 | 3000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 5 | 157.5 | 3500 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 6 | 177.2 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 7 | 177.2 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 8 | 177.2 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 201 | -0.039 | 0 |
| 9 | 177.2 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.020 | 0.0039 | 0 | 0 | -0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.039 | 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 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.20 | 4 | 0.0 | 0.005 | -0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0197 | 11.8 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-SS0.160****Material Information**

Material Name C-SS0.160 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 3000 | 100 | 40 | 0.80 | 4 | 0.0 | 0.028 | 0.0059 | 0 | 201 | -0.059 | 0 |
| 2 | 31.5 | 3000 | 500 | 45 | 0.80 | 4 | 0.0 | 0.020 | 0.0059 | 0 | 201 | -0.059 | 0 |
| 3 | 59.1 | 4000 | 1200 | 65 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.059 | 0 |
| 4 | 98.4 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.059 | 0 |
| 5 | 98.4 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.059 | 0 |
| 6 | 98.4 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.059 | 0 |
| 7 | 98.4 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.059 | 0 |
| 8 | 98.4 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.059 | 0 |
| 9 | 98.4 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 0 | -0.059 | 0 |
| 10 | 118.1 | 300 | 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 | 0.0 | 0.006 | -0.059 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.20 | 4 | 0.0 | 0.006 | -0.059 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.20 | 4 | 0.0 | 0.006 | -0.059 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-SS0.200****Material Information**

Material Name C-SS0.200 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 7.9 | 3000 | 100 | 35 | 0.80 | 4 | 0.0 | 0.028 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 2 | 31.5 | 3000 | 500 | 60 | 0.80 | 4 | 0.0 | 0.020 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 3 | 59.1 | 4000 | 1000 | 70 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 4 | 78.7 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 5 | 78.7 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 6 | 78.7 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 7 | 78.7 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 8 | 78.7 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 9 | 78.7 | 4000 | 2000 | 100 | 0.80 | 4 | 0.0 | 0.012 | 0.0059 | 0 | 0 | -0.098 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.098 | 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 | 0.0 | 0.006 | -0.098 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.20 | 4 | 0.0 | 0.006 | -0.098 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.20 | 4 | 0.0 | 0.006 | -0.098 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 7.9 | 100 | 100 |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-SS0.250****Material Information**

Material Name C-SS0.250 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 7.9 | 3000 | 100 | 35 | 0.80 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 2 | 23.6 | 3000 | 300 | 65 | 1.10 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 3 | 47.2 | 4000 | 1000 | 60 | 1.10 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 4 | 70.9 | 4000 | 2000 | 100 | 1.10 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 5 | 70.9 | 4000 | 2000 | 100 | 1.10 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 6 | 70.9 | 4000 | 2000 | 100 | 1.10 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 7 | 70.9 | 4000 | 2000 | 100 | 1.10 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 8 | 70.9 | 4000 | 2000 | 100 | 1.10 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 201 | -0.098 | 0 |
| 9 | 70.9 | 4000 | 2000 | 100 | 1.10 | 7 | 0.0 | 0.012 | 0.0059 | 0 | 0 | -0.098 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.138 | 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 | 0.0 | 0.006 | -0.138 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.20 | 4 | 0.0 | 0.006 | -0.138 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.20 | 4 | 0.0 | 0.006 | -0.138 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 3.9 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 3.9 | 100 | 100 | |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 3.9 | 100 | 100 | |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 3.9 | 100 | 100 | |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.80 | 4 | 0.0787 | 3.9 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**C-SS0.375****Material Information**

Material Name C-SS0.375 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cutting

| 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 | 7.9 | 4000 | 200 | 40 | 1.30 | 7 | 0.5 | 0.028 | 0.0059 | 0 | 201 | -0.177 | 0 |
| 2 | 23.6 | 4000 | 700 | 65 | 1.30 | 7 | 0.5 | 0.020 | 0.0059 | 0 | 201 | -0.177 | 0 |
| 3 | 39.4 | 4000 | 1200 | 85 | 1.30 | 7 | 0.5 | 0.012 | 0.0059 | 0 | 201 | -0.177 | 0 |
| 4 | 47.2 | 4000 | 2000 | 100 | 1.30 | 7 | 0.5 | 0.012 | 0.0059 | 0 | 201 | -0.177 | 0 |
| 5 | 39.4 | 4000 | 2000 | 100 | 1.30 | 7 | 0.5 | 0.012 | 0.0059 | 0 | 201 | -0.177 | 0 |
| 6 | 47.2 | 4000 | 2000 | 100 | 1.30 | 7 | 0.5 | 0.012 | 0.0059 | 0 | 201 | -0.177 | 0 |
| 7 | 47.2 | 4000 | 2000 | 100 | 1.30 | 7 | 0.5 | 0.012 | 0.0059 | 0 | 201 | -0.177 | 0 |
| 8 | 47.2 | 4000 | 2000 | 100 | 1.30 | 7 | 0.5 | 0.012 | 0.0059 | 0 | 201 | -0.177 | 0 |
| 9 | 47.2 | 4000 | 2000 | 100 | 1.30 | 7 | 0.5 | 0.012 | 0.0059 | 0 | 0 | -0.177 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 4 | 0.0 | 0.059 | 0.0000 | 0 | 0 | -0.177 | 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 | 2.0 | 0.006 | -0.177 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.20 | 4 | 2.0 | 0.006 | -0.177 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.20 | 4 | 2.0 | 0.006 | -0.177 | 0 |

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 | 0 | 0 | 0 | 0.0 | 1.30 | 7 | 0.0787 | 3.9 | 100 | 100 | |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 1.30 | 7 | 0.0787 | 3.9 | 100 | 100 | |
| 203 | 120.00 | 4000 | 100 | 100 | 0.0 | 1.30 | 7 | 0.0787 | 3.9 | 100 | 100 | |
| 204 | 120.00 | 4000 | 100 | 100 | 0.0 | 1.30 | 7 | 0.0787 | 3.9 | 100 | 100 | |
| 205 | 120.00 | 4000 | 100 | 100 | 0.0 | 0.80 | 4 | 0.0787 | 19.7 | 100 | 100 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**HRS0.500S****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 3000 | 20 | 25 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 0 | 0 | 0.079 | 0 |
| 2 | 63.0 | 4000 | 700 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 3 | 63.0 | 4000 | 700 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 4 | 63.0 | 4000 | 700 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 5 | 63.0 | 4000 | 700 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 6 | 63.0 | 4000 | 700 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 7 | 63.0 | 4000 | 700 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 8 | 63.0 | 4000 | 700 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 9 | 63.0 | 4000 | 700 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 0 | 0.079 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.079 | 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 | 10 | 5 | 5 | 1 | 0.8 | 12 | 12.0 | 0.07 | 1 | 0.0 | 0.005 | 0.079 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 12.0 | 0.07 | 1 | 0.0 | 0.009 | 0.079 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 12.0 | 0.07 | 1 | 0.0 | 0.009 | 0.079 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 25 |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 25 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-CRS0.048****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 1500 | 100 | 20 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 118.1 | 2000 | 1500 | 30 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 157.5 | 800 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 196.9 | 900 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 236.2 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 236.2 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 236.2 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 236.2 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 236.2 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.1 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.1 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.1 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-CRS0.048S****Material Information**

Material Name O-CRS0.048S **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 1500 | 100 | 20 | 0.15 | 1 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 2 | 236.2 | 1000 | 1000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 3 | 236.2 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 4 | 236.2 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 5 | 236.2 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 6 | 236.2 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 7 | 236.2 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 8 | 236.2 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 9 | 236.2 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.15 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.039 | 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 | 2000 | 80 | 10 | 0 | 0 | 0.0 | 0 | 0.1 | 0.15 | 1 | 0.0 | 0.005 | 0.039 | 0 |
| 102 | 1000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.15 | 1 | 0.0 | 0.005 | 0.039 | 0 |
| 103 | 1000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.1 | 0.15 | 1 | 0.0 | 0.005 | 0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | | 0 |
| 203 | 120.00 | 0 | 0 | 0 | 0.2 | 0.15 | 1 | 0.0079 | 39.4 | 100 | | 10 |
| 204 | 120.00 | 0 | 0 | 0 | 0.2 | 0.15 | 1 | 0.0079 | 39.4 | 100 | | 10 |
| 205 | 120.00 | 0 | 0 | 0 | 0.2 | 0.15 | 1 | 0.0079 | 39.4 | 100 | | 10 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-CRS0.060****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 15.7 | 1500 | 100 | 20 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 78.7 | 2000 | 1200 | 30 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 157.5 | 900 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 196.9 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 196.9 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 196.9 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 196.9 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 196.9 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 196.9 | 1000 | 2000 | 100 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-CRS0.060S****Material Information**

Material Name O-CRS0.060S **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 15.7 | 1500 | 100 | 20 | 0.12 | 1 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 2 | 196.9 | 1000 | 2000 | 100 | 0.12 | 1 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 3 | 196.9 | 1000 | 2000 | 100 | 0.12 | 1 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 4 | 196.9 | 1000 | 2000 | 100 | 0.12 | 1 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 5 | 196.9 | 1000 | 2000 | 100 | 0.12 | 1 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 6 | 196.9 | 1000 | 2000 | 100 | 0.12 | 1 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 7 | 196.9 | 1000 | 2000 | 100 | 0.12 | 1 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 8 | 196.9 | 1000 | 2000 | 100 | 0.12 | 1 | 0.0 | 0.028 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 9 | 196.9 | 1000 | 2000 | 100 | 0.12 | 1 | 0.0 | 0.028 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.12 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.118 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.12 | 1 | 0.0 | 0.005 | 0.039 | 0 |
| 102 | 1000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.12 | 1 | 0.0 | 0.005 | 0.039 | 0 |
| 103 | 1000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.12 | 1 | 0.0 | 0.005 | 0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.20 | 2 | 0.0197 | 19.7 | 100 | | 15 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-CRS0.090S****Material Information**

| | | | | | |
|---------------------------|-------------|----------------------|-----|----------------------|-----|
| Material Name | O-CRS0.090S | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | | 2 |
| Material Process | STD | WACS | | | No |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 1500 | 100 | 20 | 0.15 | 1 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 2 | 137.8 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 3 | 137.8 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 4 | 137.8 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 5 | 137.8 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 6 | 137.8 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 7 | 137.8 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 8 | 137.8 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.039 | 0 |
| 9 | 137.8 | 1000 | 2000 | 100 | 0.15 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.15 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.118 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.15 | 1 | 0.0 | 0.005 | 0.118 | 0 |
| 102 | 1200 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.15 | 1 | 0.0 | 0.005 | 0.118 | 0 |
| 103 | 1200 | 100 | 100 | 0 | 0 | 0.0 | 0 | 0.5 | 0.15 | 1 | 0.0 | 0.005 | 0.118 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 2000 | 100 | 30 | 0.0 | 0.20 | 2 | 0.0197 | 7.9 | 100 | | 15 |
| 202 | 0.00 | 2000 | 100 | 30 | 0.0 | 0.20 | 2 | 0.0197 | 7.9 | 100 | | 15 |
| 203 | 120.00 | 2000 | 100 | 30 | 0.0 | 0.20 | 2 | 0.0394 | 7.9 | 100 | | 15 |
| 204 | 120.00 | 2000 | 100 | 30 | 0.0 | 0.20 | 2 | 0.0394 | 7.9 | 100 | | 15 |
| 205 | 120.00 | 2000 | 100 | 30 | 0.0 | 0.20 | 2 | 0.0394 | 7.9 | 100 | | 15 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-CRS0.125****Material Information**

Material Name O-CRS0.125 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 7.9 | 1500 | 100 | 20 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 39.4 | 2000 | 500 | 25 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 98.4 | 2000 | 2000 | 45 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 118.1 | 2000 | 2000 | 50 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 118.1 | 2000 | 2000 | 50 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 118.1 | 2000 | 2000 | 50 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 118.1 | 2000 | 2000 | 50 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 118.1 | 2000 | 2000 | 50 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 118.1 | 2000 | 2000 | 50 | 0.20 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 2000 | 150 | 20 | 0.0 | 0.20 | 2 | 0.0197 | 3.9 | 50 | 15 | |
| 202 | 0.00 | 2000 | 150 | 20 | 0.0 | 0.20 | 2 | 0.0197 | 3.9 | 50 | 15 | |
| 203 | 120.00 | 2000 | 150 | 20 | 0.0 | 0.20 | 2 | 0.0394 | 3.9 | 50 | 15 | |
| 204 | 120.00 | 2000 | 150 | 20 | 0.0 | 0.20 | 2 | 0.0394 | 3.9 | 50 | 15 | |
| 205 | 120.00 | 2000 | 150 | 20 | 0.0 | 0.20 | 2 | 0.0394 | 3.9 | 50 | 15 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-CRS0.125S****Material Information**

Material Name O-CRS0.125S **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cutting

| 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 | 7.9 | 1500 | 100 | 20 | 0.05 | 1 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.118 | 0 |
| 2 | 137.8 | 1800 | 2000 | 100 | 0.05 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.118 | 0 |
| 3 | 137.8 | 1800 | 2000 | 100 | 0.05 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.118 | 0 |
| 4 | 137.8 | 1800 | 2000 | 100 | 0.05 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.118 | 0 |
| 5 | 137.8 | 1800 | 2000 | 100 | 0.05 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.118 | 0 |
| 6 | 137.8 | 1800 | 2000 | 100 | 0.05 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.118 | 0 |
| 7 | 137.8 | 1800 | 2000 | 100 | 0.05 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.118 | 0 |
| 8 | 137.8 | 1800 | 2000 | 100 | 0.05 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 201 | 0.118 | 0 |
| 9 | 137.8 | 1800 | 2000 | 100 | 0.05 | 1 | 0.0 | 0.020 | 0.0039 | 0 | 0 | 0.118 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 2 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.118 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.05 | 1 | 0.0 | 0.005 | 0.118 | 0 |
| 102 | 2000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.05 | 1 | 0.0 | 0.009 | 0.118 | 0 |
| 103 | 2000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 1.0 | 0.05 | 1 | 0.0 | 0.009 | 0.118 | 0 |

Edage

| 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 | 2000 | 150 | 20 | 0.0 | 0.05 | 1 | 0.0197 | 3.9 | 50 | 15 | |
| 202 | 0.00 | 2000 | 150 | 20 | 0.0 | 0.05 | 1 | 0.0197 | 3.9 | 50 | 15 | |
| 203 | 120.00 | 2000 | 150 | 20 | 0.0 | 0.05 | 1 | 0.0394 | 3.9 | 50 | 15 | |
| 204 | 120.00 | 2000 | 150 | 20 | 0.0 | 0.05 | 1 | 0.0394 | 3.9 | 50 | 15 | |
| 205 | 120.00 | 2000 | 150 | 20 | 0.0 | 0.05 | 1 | 0.0394 | 3.9 | 50 | 15 | |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-GALV0.030****Material Information**

Material Name O-GALV0.030 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 1500 | 300 | 10 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 1500 | 1000 | 25 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 3 | 118.1 | 1500 | 2000 | 45 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 137.8 | 1500 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 157.5 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 157.5 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 157.5 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 157.5 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 157.5 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-GALV0.040****Material Information**

Material Name O-GALV0.040 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cutting

| 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 | 19.7 | 1500 | 300 | 15 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 1500 | 1000 | 30 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 3 | 118.1 | 1500 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edge

| 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 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-GALV0.050****Material Information**

| | | | | | |
|---------------------------|-------------|----------------------|-----|----------------------|-----|
| Material Name | O-GALV0.050 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | | 2 |
| Material Process | STD | WACS | | | No |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 1500 | 300 | 15 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 1500 | 1000 | 30 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 3 | 118.1 | 1500 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 137.8 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-GALV0.060****Material Information**

| | | | | | |
|---------------------------|-------------|----------------------|-----|----------------------|-----|
| Material Name | O-GALV0.060 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | | 2 |
| Material Process | STD | WACS | | | No |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 1500 | 300 | 20 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 1500 | 1000 | 35 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 3 | 98.4 | 1500 | 2000 | 55 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 118.1 | 1500 | 2000 | 60 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 118.1 | 1500 | 2000 | 60 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 118.1 | 1500 | 2000 | 60 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 118.1 | 1500 | 2000 | 60 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 118.1 | 1500 | 2000 | 60 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 118.1 | 1500 | 2000 | 60 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-GALV0.090****Material Information**

| | | | | | |
|---------------------------|-------------|----------------------|-----|----------------------|-----|
| Material Name | O-GALV0.090 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | | 2 |
| Material Process | STD | WACS | | | No |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 19.7 | 1500 | 300 | 25 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 1500 | 1200 | 60 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 3 | 78.7 | 1500 | 2000 | 65 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 98.4 | 1500 | 2000 | 70 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 98.4 | 1500 | 2000 | 70 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 98.4 | 1500 | 2000 | 70 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 98.4 | 1500 | 2000 | 70 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 98.4 | 1500 | 2000 | 70 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 98.4 | 1500 | 2000 | 70 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 25 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0197 | 7.9 | 100 | | 25 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0394 | 7.9 | 100 | | 25 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0394 | 7.9 | 100 | | 25 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0394 | 7.9 | 100 | | 25 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-GALV0.125****Material Information**

Material Name O-GALV0.125 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 2000 | 100 | 15 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 39.4 | 2000 | 1000 | 30 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 3 | 59.1 | 2000 | 1500 | 40 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 4 | 78.7 | 2000 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 5 | 78.7 | 2000 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 6 | 78.7 | 2000 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 7 | 78.7 | 2000 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 8 | 78.7 | 2000 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.000 | 0 |
| 9 | 78.7 | 2000 | 2000 | 50 | 0.30 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0394 | 3.9 | 50 | 20 |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0394 | 3.9 | 50 | 20 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0394 | 3.9 | 50 | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0394 | 3.9 | 50 | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.30 | 3 | 0.0394 | 3.9 | 50 | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-HRS0.187****Material Information**

Material Name O-HRS0.187 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 7.9 | 2000 | 100 | 15 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.020 | 0 |
| 2 | 39.4 | 2000 | 1200 | 35 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 3 | 59.1 | 2000 | 1500 | 50 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 4 | 78.7 | 2000 | 2000 | 55 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 5 | 78.7 | 2000 | 2000 | 55 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 6 | 78.7 | 2000 | 2000 | 55 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 7 | 78.7 | 2000 | 2000 | 55 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 8 | 78.7 | 2000 | 2000 | 55 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 9 | 78.7 | 2000 | 2000 | 55 | 0.10 | 1 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.020 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.020 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.5 | 0.10 | 1 | 0.5 | 0.005 | 0.020 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.5 | 0.10 | 1 | 0.5 | 0.005 | 0.020 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.5 | 0.10 | 1 | 0.5 | 0.005 | 0.020 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.10 | 1 | 0.0394 | 3.9 | 20 | | 15 |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.10 | 1 | 0.0394 | 3.9 | 20 | | 15 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.10 | 1 | 0.0394 | 3.9 | 20 | | 15 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.10 | 1 | 0.0394 | 3.9 | 20 | | 15 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.10 | 1 | 0.0394 | 3.9 | 20 | | 15 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-HRS0.187S****Material Information**

Material Name O-HRS0.187S **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 2000 | 20 | 15 | 0.05 | 1 | 0.5 | 0.059 | 0.0059 | 0 | 0 | 0.079 | 0 |
| 2 | 137.8 | 4000 | 2000 | 100 | 0.05 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 3 | 137.8 | 4000 | 2000 | 100 | 0.05 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 4 | 137.8 | 4000 | 2000 | 100 | 0.05 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 5 | 137.8 | 4000 | 2000 | 100 | 0.05 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 6 | 137.8 | 4000 | 2000 | 100 | 0.05 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 7 | 137.8 | 4000 | 2000 | 100 | 0.05 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 8 | 137.8 | 4000 | 2000 | 100 | 0.05 | 1 | 0.5 | 0.028 | 0.0000 | 0 | 0 | 0.079 | 0 |
| 9 | 137.8 | 4000 | 2000 | 100 | 0.05 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 0 | 0.079 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.079 | 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 | 2000 | 80 | 20 | 0 | 0 | 0.0 | 0 | 4.0 | 0.05 | 1 | 0.0 | 0.005 | 0.079 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 4.0 | 0.05 | 1 | 0.0 | 0.009 | 0.079 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 4.0 | 0.05 | 1 | 0.0 | 0.009 | 0.079 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |
| 202 | 0.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |
| 203 | 120.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |
| 204 | 120.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |
| 205 | 120.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-HRS0.250****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 7.9 | 2000 | 100 | 30 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.020 | 0 |
| 2 | 39.4 | 2000 | 1200 | 45 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 3 | 59.1 | 2000 | 1500 | 60 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 4 | 70.9 | 2000 | 2000 | 65 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 5 | 70.9 | 2000 | 2000 | 60 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 6 | 70.9 | 2000 | 2000 | 60 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 7 | 70.9 | 2000 | 2000 | 60 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 8 | 70.9 | 2000 | 2000 | 60 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 203 | 201 | 0.020 | 0 |
| 9 | 70.9 | 2000 | 2000 | 60 | 0.08 | 1 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.020 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.08 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.020 | 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 | 2000 | 80 | 20 | 0 | 0 | 0.0 | 0 | 2.0 | 0.08 | 1 | 0.5 | 0.005 | 0.020 | 0 |
| 102 | 2000 | 80 | 20 | 0 | 0 | 0.0 | 0 | 2.0 | 0.08 | 1 | 0.5 | 0.005 | 0.020 | 0 |
| 103 | 2000 | 80 | 20 | 0 | 0 | 0.0 | 0 | 2.0 | 0.08 | 1 | 0.5 | 0.005 | 0.020 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0394 | 3.9 | 20 | | 20 |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0394 | 3.9 | 20 | | 20 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0394 | 3.9 | 20 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0394 | 3.9 | 20 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0394 | 3.9 | 20 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-HRS0.250S****Material Information**

Material Name O-HRS0.250S **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 2000 | 20 | 20 | 0.08 | 1 | 0.5 | 0.059 | 0.0059 | 0 | 0 | 0.079 | 0 |
| 2 | 118.1 | 4000 | 2000 | 100 | 0.08 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 3 | 118.1 | 4000 | 2000 | 100 | 0.08 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 4 | 118.1 | 4000 | 2000 | 100 | 0.08 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 5 | 118.1 | 4000 | 2000 | 100 | 0.08 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 6 | 118.1 | 4000 | 2000 | 100 | 0.08 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 7 | 118.1 | 4000 | 2000 | 100 | 0.08 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 8 | 118.1 | 4000 | 2000 | 100 | 0.08 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 201 | 0.079 | 0 |
| 9 | 118.1 | 4000 | 2000 | 100 | 0.08 | 1 | 0.5 | 0.028 | 0.0059 | 0 | 0 | 0.079 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.079 | 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 | 2000 | 80 | 20 | 0 | 0 | 0.0 | 0 | 4.0 | 0.08 | 1 | 0.0 | 0.005 | 0.079 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 4.0 | 0.08 | 1 | 0.0 | 0.009 | 0.079 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 4.0 | 0.08 | 1 | 0.0 | 0.009 | 0.079 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |
| 202 | 0.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |
| 203 | 120.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |
| 204 | 120.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |
| 205 | 120.00 | 2000 | 0 | 0 | 0.0 | 0.08 | 1 | 0.0787 | 7.9 | 50 | | 30 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-HRS0.375****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 3000 | 20 | 25 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 0 | 0 | 0.079 | 0 |
| 2 | 39.4 | 3000 | 1000 | 40 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 3 | 51.2 | 3000 | 1000 | 60 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 4 | 59.1 | 3000 | 1000 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 5 | 59.1 | 3000 | 1000 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 6 | 59.1 | 3000 | 1000 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 7 | 59.1 | 3000 | 1000 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 8 | 59.1 | 3000 | 1000 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 9 | 59.1 | 3000 | 1000 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 0 | 0 | 0.079 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.079 | 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 | 3000 | 10 | 7 | 5 | 1 | 0.5 | 12 | 7.0 | 0.07 | 1 | 0.0 | 0.005 | 0.079 | 0 |
| 102 | 3000 | 10 | 7 | 5 | 1 | 0.5 | 12 | 7.0 | 0.07 | 1 | 0.0 | 0.005 | 0.079 | 0 |
| 103 | 3000 | 10 | 7 | 5 | 1 | 0.5 | 12 | 7.0 | 0.07 | 1 | 0.0 | 0.005 | 0.079 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 25 |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 25 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-HRS0.375S****Material Information**

Material Name O-HRS0.375S **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 3000 | 20 | 25 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 0 | 0 | 0.079 | 0 |
| 2 | 78.7 | 4000 | 1000 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 3 | 78.7 | 4000 | 1000 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 4 | 78.7 | 4000 | 1000 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 5 | 78.7 | 4000 | 1000 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 6 | 78.7 | 4000 | 1000 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 7 | 78.7 | 4000 | 1000 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 8 | 78.7 | 4000 | 1000 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 201 | 0.079 | 0 |
| 9 | 78.7 | 4000 | 1000 | 100 | 0.07 | 1 | 0.5 | 0.028 | 0.0079 | 0 | 0 | 0.079 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.079 | 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 | 3000 | 10 | 7 | 10 | 1 | 0.7 | 12 | 6.0 | 0.07 | 1 | 0.0 | 0.005 | 0.079 | 0 |
| 102 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 6.0 | 0.07 | 1 | 0.0 | 0.009 | 0.079 | 0 |
| 103 | 4000 | 100 | 100 | 0 | 0 | 0.0 | 0 | 6.0 | 0.07 | 1 | 0.0 | 0.009 | 0.079 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 25 |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 25 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-HRS0.500****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.5 | 2000 | 20 | 35 | 0.05 | 1 | 0.5 | 0.059 | 0.0100 | 0 | 0 | 0.079 | 0 |
| 2 | 25.0 | 1800 | 800 | 60 | 0.05 | 1 | 1.0 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 0 |
| 3 | 35.0 | 1800 | 800 | 85 | 0.05 | 1 | 0.5 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 0 |
| 4 | 45.0 | 1800 | 1000 | 95 | 0.05 | 1 | 0.5 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 0 |
| 5 | 45.0 | 1800 | 1000 | 95 | 0.05 | 1 | 0.5 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 0 |
| 6 | 45.0 | 1800 | 1000 | 95 | 0.05 | 1 | 0.5 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 0 |
| 7 | 45.0 | 1800 | 1000 | 100 | 0.05 | 1 | 0.5 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 0 |
| 8 | 45.0 | 1800 | 1000 | 100 | 0.05 | 1 | 0.5 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 0 |
| 9 | 45.0 | 1800 | 1000 | 100 | 0.05 | 1 | 0.5 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 0 |
| 10 | 110.0 | 1500 | 1000 | 10 | 0.05 | 1 | 1.0 | 0.059 | 0.0100 | 201 | 201 | 0.000 | 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 | 2700 | 10 | 20 | 10 | 1 | 0.5 | 15 | 10.0 | 0.05 | 1 | 1.5 | 0.059 | 0.000 | 0 |
| 102 | 3000 | 10 | 15 | 10 | 1 | 0.5 | 15 | 8.0 | 0.05 | 1 | 1.5 | 0.059 | 0.000 | 0 |
| 103 | 4000 | 10 | 10 | 5 | 1 | 1.0 | 15 | 8.0 | 0.05 | 1 | 1.5 | 0.059 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 1200.00 | 0 | 0 | 0 | 0.0 | 1.00 | 1 | 1.0000 | 100.0 | 10 | | 35 |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 1.00 | 1 | 1.0000 | 100.0 | 10 | | 35 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.05 | 1 | 0.0590 | 3.5 | 10 | | 35 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.05 | 1 | 0.0590 | 3.5 | 10 | | 35 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.05 | 1 | 0.0590 | 3.5 | 10 | | 35 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-HRS0.500S****Material Information**

| | | | | | |
|---------------------------|-------------|----------------------|-----|----------------------|-----|
| Material Name | O-HRS0.500S | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | | 2 |
| Material Process | STD | WACS | | | No |

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 3000 | 20 | 25 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 0 | 0 | 0.079 | 0 |
| 2 | 31.5 | 3000 | 700 | 45 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 3 | 39.4 | 3000 | 700 | 50 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 4 | 47.2 | 3000 | 700 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 5 | 47.2 | 3000 | 700 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 6 | 47.2 | 3000 | 700 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 7 | 47.2 | 3000 | 700 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 8 | 47.2 | 3000 | 700 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 203 | 201 | 0.079 | 0 |
| 9 | 47.2 | 3000 | 700 | 65 | 0.07 | 1 | 0.5 | 0.059 | 0.0079 | 0 | 0 | 0.079 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.079 | 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 | 10 | 5 | 5 | 1 | 0.8 | 12 | 8.0 | 0.07 | 1 | 0.0 | 0.005 | 0.079 | 0 |
| 102 | 4000 | 10 | 5 | 5 | 1 | 0.8 | 12 | 8.0 | 0.07 | 1 | 0.0 | 0.005 | 0.079 | 0 |
| 103 | 4000 | 10 | 5 | 5 | 1 | 0.8 | 12 | 8.0 | 0.07 | 1 | 0.0 | 0.005 | 0.079 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 25 |
| 202 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 25 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.07 | 1 | 0.0394 | 3.9 | 10 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.060****Material Information**

Material Name **Material Type** **Pierce Number**
Material Thickness **Head Number**
Material Process **WACS**

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 2000 | 200 | 7 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 2000 | 1000 | 35 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 157.5 | 2000 | 1500 | 50 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 236.2 | 2000 | 1500 | 60 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 315.0 | 3000 | 2000 | 80 | 0.50 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 315.0 | 3000 | 2000 | 80 | 0.50 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 315.0 | 3000 | 2000 | 80 | 0.50 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 315.0 | 3000 | 2000 | 80 | 0.50 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 315.0 | 3000 | 2000 | 80 | 0.50 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.080****Material Information**

| | | | | | |
|---------------------------|-----------|----------------------|-----|----------------------|-----|
| Material Name | O-SS0.080 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | | | Head Number | 2 |
| Material Process | STD | | | WACS | No |

| | | | | | |
|---------------------------|-----------|----------------------|-----|----------------------|-----|
| Material Name | O-SS0.080 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | | | Head Number | 2 |
| Material Process | STD | | | WACS | No |

| Cut Number | Feed Rate [F] | Power [S] | Frequ ncy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|---------------|------------------|--------------|--------------|---------------|-----------------|-------------|-------------|---------------|------------------|----------------|--------------------|-------------------|---------------|
| 1 | 11.8 | 2000 | 200 | 10 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 1 | 11.8 | 2000 | 200 | 10 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 2000 | 1000 | 40 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 2000 | 1000 | 40 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 157.5 | 1500 | 1500 | 80 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 157.5 | 1500 | 1500 | 80 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 236.2 | 2000 | 2000 | 80 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 236.2 | 2000 | 2000 | 80 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 |
|--------------------|-------|----------------------|-----------------|-------------------|--------------|--------------|---------------|----------------|-----------------|-------------|---------------|---------------|-------------------|---------------|
|--------------------|-------|----------------------|-----------------|-------------------|--------------|--------------|---------------|----------------|-----------------|-------------|---------------|---------------|-------------------|---------------|

Material Name**File Name :** C:\My Documents\English2k.mdb

| | | | | | | | | | | | | | | |
|-----|------|----|----|---|---|-----|---|-----|------|---|-----|-------|-------|---|
| 101 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 101 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| <u>Edge Numbe</u> | <u>Work Angle</u> | <u>Pierce Power</u> | <u>Pierce Frequenc</u> | <u>Pierce Duty</u> | <u>Pierce Time</u> | <u>Gas Pressure</u> | <u>Gas Kind</u> | <u>Distance</u> | <u>Feed Rate</u> | <u>Recover Frequency</u> | <u>Recover Duty Cycle</u> |
|-----------------------|-----------------------|-------------------------|----------------------------|------------------------|------------------------|-------------------------|---------------------|-----------------|------------------|------------------------------|-------------------------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.080****Material Information**

| | | | | | |
|---------------------------|-----------|----------------------|-----|----------------------|-----|
| Material Name | O-SS0.080 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | 2 | |
| Material Process | STD | WACS | | No | |

| | | | | | |
|---------------------------|-----------|----------------------|-----|----------------------|-----|
| Material Name | O-SS0.080 | Material Type | SPH | Pierce Number | 101 |
| Material Thickness | 0.177 | Head Number | | 2 | |
| Material Process | STD | WACS | | No | |

| Cut Number | Feed Rate [F] | Power [S] | Frequ ncy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|---------------|------------------|--------------|--------------|---------------|-----------------|-------------|-------------|---------------|------------------|----------------|--------------------|-------------------|---------------|
| 1 | 11.8 | 2000 | 200 | 10 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 1 | 11.8 | 2000 | 200 | 10 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 2000 | 1000 | 40 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 2000 | 1000 | 40 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 157.5 | 1500 | 1500 | 80 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 157.5 | 1500 | 1500 | 80 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 236.2 | 2000 | 2000 | 80 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 236.2 | 2000 | 2000 | 80 | 0.40 | 2 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 315.0 | 3000 | 2000 | 90 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 |
|--------------------|-------|----------------------|-----------------|-------------------|--------------|--------------|---------------|----------------|-----------------|-------------|---------------|---------------|-------------------|---------------|
|--------------------|-------|----------------------|-----------------|-------------------|--------------|--------------|---------------|----------------|-----------------|-------------|---------------|---------------|-------------------|---------------|

Material Name**File Name :** C:\My Documents\English2k.mdb

| | | | | | | | | | | | | | | |
|-----|------|----|----|---|---|-----|---|-----|------|---|-----|-------|-------|---|
| 101 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 101 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 0.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| <u>Edge</u> <u>Numbe</u> | <u>Work</u> <u>Angle</u> | <u>Pierce</u> <u>Power</u> | <u>Pierce</u> <u>Frequenc</u> | <u>Pierce</u> <u>Duty</u> | <u>Pierce</u> <u>Time</u> | <u>Gas</u> <u>Pressure</u> | <u>Gas</u> <u>Kind</u> | <u>Distance</u> | <u>Feed Rate</u> | <u>Recover</u> <u>Frequency</u> | <u>Recover</u> <u>Duty Cycle</u> |
|-----------------------------|-----------------------------|-------------------------------|----------------------------------|------------------------------|------------------------------|-------------------------------|---------------------------|-----------------|------------------|------------------------------------|-------------------------------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.120****Material Information**

Material Name O-SS0.120 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 11.8 | 2000 | 100 | 15 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 59.1 | 2000 | 1000 | 50 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 118.1 | 2000 | 2000 | 65 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 157.5 | 2000 | 2000 | 95 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 216.5 | 3000 | 2000 | 95 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 216.5 | 3000 | 2000 | 95 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 216.5 | 3000 | 2000 | 95 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 216.5 | 3000 | 2000 | 95 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 216.5 | 3000 | 2000 | 95 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 1.5 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.160****Material Information**

Material Name O-SS0.160 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| <i>Cut Number</i> | <i>Feed Rate [F]</i> | <i>Power [S]</i> | <i>Freque ncy</i> | <i>Duty Cycle</i> | <i>Gas Pressure</i> | <i>Gas Kind</i> | <i>Gas Time</i> | <i>Nozzle Gap</i> | <i>Cutter Offset</i> | <i>Edge Number</i> | <i>Approach Number</i> | <i>Focal Position</i> | <i>Pulse Type</i> |
|-----------------------|--------------------------|----------------------|-----------------------|-----------------------|-------------------------|---------------------|---------------------|-----------------------|--------------------------|------------------------|----------------------------|---------------------------|-----------------------|
| 1 | 11.8 | 2000 | 100 | 10 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 19.7 | 2000 | 500 | 15 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 39.4 | 2000 | 2000 | 25 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 51.2 | 2000 | 2000 | 30 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 59.1 | 2000 | 2000 | 45 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 59.1 | 2000 | 2000 | 45 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 59.1 | 2000 | 2000 | 45 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 59.1 | 2000 | 2000 | 45 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 59.1 | 2000 | 2000 | 45 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 0 |

Piercing

| <i>Piercing Number</i> | <i>Power</i> | <i>Initial Frequency</i> | <i>Initial Duty</i> | <i>Inc. Frequency</i> | <i>Inc. Duty</i> | <i>Step Time</i> | <i>Step Count</i> | <i>Pierce Time</i> | <i>Gas Pressure</i> | <i>Gas Kind</i> | <i>Purge Time</i> | <i>Nozzle Gap</i> | <i>Focal Position</i> | <i>Pulse Type</i> |
|----------------------------|--------------|------------------------------|-------------------------|---------------------------|----------------------|----------------------|-----------------------|------------------------|-------------------------|---------------------|-----------------------|-----------------------|---------------------------|-----------------------|
| 101 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 2.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| <i>Edge Numbe</i> | <i>Work Angle</i> | <i>Pierce Power</i> | <i>Pierce Frequenc</i> | <i>Pierce Duty</i> | <i>Pierce Time</i> | <i>Gas Pressure</i> | <i>Gas Kind</i> | <i>Distance</i> | <i>Feed Rate</i> | <i>Recover Frequency</i> | <i>Recover Duty Cycle</i> |
|-----------------------|-----------------------|-------------------------|----------------------------|------------------------|------------------------|-------------------------|---------------------|-----------------|------------------|------------------------------|-------------------------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.200****Material Information**

Material Name O-SS0.200 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 2000 | 50 | 10 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 11.8 | 2000 | 300 | 15 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 19.7 | 2000 | 500 | 20 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 27.6 | 2000 | 1000 | 25 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 27.6 | 2000 | 1000 | 25 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 27.6 | 2000 | 1000 | 25 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 27.6 | 2000 | 1000 | 25 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 27.6 | 2000 | 1000 | 25 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 27.6 | 2000 | 1000 | 25 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 3.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 3.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 3.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.250****Material Information**

Material Name O-SS0.250 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 2000 | 50 | 12 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 2 | 11.8 | 2000 | 300 | 15 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 3 | 23.6 | 2000 | 1000 | 26 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 4 | 23.6 | 2000 | 1000 | 26 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 5 | 23.6 | 2000 | 1000 | 26 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 6 | 23.6 | 2000 | 1000 | 26 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 7 | 23.6 | 2000 | 1000 | 26 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 8 | 23.6 | 2000 | 1000 | 26 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 9 | 23.6 | 2000 | 1000 | 26 | 0.60 | 3 | 0.0 | 0.059 | 0.0039 | 0 | 0 | 0.000 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.000 | 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 | 2000 | 80 | 20 | 0 | 0 | 0.0 | 0 | 4.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 102 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 4.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |
| 103 | 2000 | 80 | 15 | 0 | 0 | 0.0 | 0 | 4.0 | 0.10 | 1 | 0.0 | 0.005 | 0.000 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 203 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 204 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |
| 205 | 0.00 | 0 | 0 | 0 | 0.0 | 0.00 | 0 | 0.0000 | 0.0 | 0 | 0 | 0 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.375****Material Information**

Material Name O-SS0.375 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cuttina

| Cut Number | Feed Rate [F] | Power [S] | Frequen cy | Duty Cycle | Gas Pressure | Gas Kind | Gas Time | Nozzle Gap | Cutter Offset | Edge Number | Approach Number | Focal Position | Pulse Type |
|------------|---------------|-----------|------------|------------|--------------|----------|----------|------------|---------------|-------------|-----------------|----------------|------------|
| 1 | 3.9 | 2000 | 50 | 20 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 0 | 0 | 0.039 | 0 |
| 2 | 7.9 | 2000 | 50 | 22 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 203 | 201 | 0.039 | 0 |
| 3 | 11.8 | 2000 | 100 | 30 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 203 | 201 | 0.039 | 0 |
| 4 | 15.7 | 2000 | 300 | 35 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 203 | 201 | 0.039 | 0 |
| 5 | 15.7 | 2000 | 300 | 35 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 203 | 201 | 0.039 | 0 |
| 6 | 15.7 | 2000 | 300 | 35 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 203 | 201 | 0.039 | 0 |
| 7 | 15.7 | 2000 | 300 | 35 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 203 | 201 | 0.039 | 0 |
| 8 | 15.7 | 2000 | 300 | 35 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 203 | 201 | 0.039 | 0 |
| 9 | 15.7 | 2000 | 300 | 35 | 0.60 | 3 | 0.0 | 0.059 | 0.0059 | 0 | 0 | 0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.20 | 5 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.039 | 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 | 3000 | 10 | 7 | 10 | 1 | 0.5 | 12 | 7.0 | 0.07 | 1 | 0.0 | 0.005 | 0.039 | 0 |
| 102 | 3000 | 10 | 7 | 10 | 1 | 0.5 | 12 | 7.0 | 0.07 | 1 | 0.0 | 0.005 | 0.039 | 0 |
| 103 | 3000 | 10 | 7 | 10 | 1 | 0.5 | 12 | 7.0 | 0.07 | 1 | 0.0 | 0.005 | 0.039 | 0 |

Edae

| Edge Numbe | Work Angle | Pierce Power | Pierce Frequenc | Pierce Duty | Pierce Time | Gas Pressure | Gas Kind | Distance | Feed Rate | Recover Frequency | Recover Duty | Recover Cycle |
|------------|------------|--------------|-----------------|-------------|-------------|--------------|----------|----------|-----------|-------------------|--------------|---------------|
| 201 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 3 | 0.0394 | 3.9 | 50 | | 15 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.60 | 3 | 0.0394 | 3.9 | 50 | | 15 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.60 | 3 | 0.0394 | 3.9 | 50 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.60 | 3 | 0.0394 | 3.9 | 50 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.60 | 3 | 0.0394 | 3.9 | 50 | | 20 |

Material Name**File Name :** C:\My Documents\English2k.mdb**O-SS0.500****Material Information**

Material Name O-SS0.500 **Material Type** SPH **Pierce Number** 101
Material Thickness 0.177 **Head Number** 2
Material Process STD **WACS** No

Cutting

| 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 | 3.9 | 3000 | 50 | 20 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 0 | 201 | 0.039 | 0 |
| 2 | 7.9 | 3000 | 250 | 17 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 203 | 201 | 0.039 | 0 |
| 3 | 7.9 | 3000 | 250 | 17 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 203 | 201 | 0.039 | 0 |
| 4 | 7.9 | 3000 | 250 | 17 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 203 | 201 | 0.039 | 0 |
| 5 | 7.9 | 3000 | 250 | 17 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 203 | 201 | 0.039 | 0 |
| 6 | 7.9 | 3000 | 250 | 17 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 203 | 201 | 0.039 | 0 |
| 7 | 7.9 | 3000 | 250 | 17 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 203 | 201 | 0.039 | 0 |
| 8 | 7.9 | 3000 | 250 | 17 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 203 | 201 | 0.039 | 0 |
| 9 | 7.9 | 3000 | 250 | 17 | 0.70 | 3 | 1.0 | 0.059 | 0.0079 | 0 | 0 | 0.039 | 0 |
| 10 | 118.1 | 300 | 1000 | 80 | 0.10 | 1 | 0.0 | 0.059 | 0.0000 | 0 | 0 | 0.039 | 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 | 3000 | 10 | 7 | 10 | 1 | 0.5 | 12 | 10.0 | 0.07 | 1 | 0.0 | 0.005 | 0.039 | 0 |
| 102 | 3000 | 10 | 7 | 10 | 1 | 0.5 | 12 | 10.0 | 0.07 | 1 | 0.0 | 0.005 | 0.039 | 0 |
| 103 | 3000 | 10 | 7 | 10 | 1 | 0.5 | 12 | 10.0 | 0.07 | 1 | 0.0 | 0.005 | 0.039 | 0 |

Edge

| 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 | 0 | 0 | 0 | 0.0 | 0.70 | 3 | 0.0787 | 3.9 | 25 | | 30 |
| 202 | 0.00 | 0 | 0 | 0 | 0.0 | 0.70 | 3 | 0.0787 | 3.9 | 25 | | 30 |
| 203 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 3 | 0.0787 | 3.9 | 25 | | 20 |
| 204 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 3 | 0.0787 | 3.9 | 25 | | 20 |
| 205 | 120.00 | 0 | 0 | 0 | 0.0 | 0.70 | 3 | 0.0787 | 3.9 | 25 | | 20 |