Amada Laser Cutting Condition Tab

Material Nam **File Name** P:\emachine 2nd back up\jon's laser stuf

HRS0.500WS

Material Informati

Material Name	HRS0.500WS	Material Typ	HRS	Pierce Number	101
Material Thickne	0.500			Head Number	1
				WACS	Yes
Material Proce	STD				

Cutting

Cut Numbe	Feed Rate	Power [S]	Frequency	Duty Cycle	Gas Pressur	Gas	Gas Time	Nozzle Gap	Cutter Offset	Edge Numbe	Approach	Focal Position	Pulse Type
1	2.0	4000	10	25	0.06	1	1.0	0.050	0.0091	0	0	0.000	0
2	11.8	3600	200	35	0.06	1	1.0	0.050	0.0091	203	201	0.000	0
3	40.0	4000	700	50	0.06	1	1.0	0.050	0.0091	203	201	0.000	0
4	50.0	4000	1000	80	0.06	1	1.0	0.050	0.0091	203	201	0.000	0
5	2.0	4000	10	25	0.06	1	1.0	0.050	0.0091	0	0	0.000	0
6	11.8	3600	200	35	0.06	1	1.0	0.050	0.0091	203	201	0.000	0
7	40.0	4000	700	50	0.06	1	1.0	0.050	0.0091	203	201	0.000	0
8	50.0	4000	1000	80	0.06	1	1.0	0.050	0.0091	203	201	0.000	0
9	50.0	4000	1000	80	0.06	1	1.0	0.050	0.0091	203	201	0.000	0
10	39.4	800	500	50	0.15	5	0.0	0.059	0.0000	0	0	0.000	0

Piercing

Piercing	Power	Initial Frequenc	Initial Duty	Inc. Frequenc	Inc. Duty	Step Time	Step Cou	Pierce Time	Gas Pressure	Gas Kind	Purge Time	Nozzle Gap	Focal Position	Pulse Type
101	4000	10	7	5	1	1.0	12	10.0	0.06	1	0.0	0.050	0.000	85
102	4000	10	12	5	1	1.0	12	10.0	0.06	1	0.0	0.050	0.000	85
103	4000	100	100	0	0	0.0	0	0.5	0.10	1	0.0	0.200	0.000	85

Edge

Edge	Work Angle	Pierce Power	Pierce Frequen	Pierce Duty	Pierce Time	Gas Pressure	Gas	Distance	Feed Rate	Recover Frequenc	Recover Duty
201	0.00	4000	10	25	0.5	0.06	1	0.0591	11.8	0	100
202	0.00	4000	10	25	0.5	0.06	1	0.0591	2.0	10	30
203	120.00	4000	10	20	0.5	0.06	1	0.0600	2.0	10	25
204	170.00	4000	10	25	0.5	0.06	1	0.0591	2.0	10	25
205	170.00	4000	10	25	0.5	0.06	1	0.0591	2.0	10	25

Amada Laser Cutting Condition Tab

Material Nam **File Name** P:\emachine 2nd back up\jon's laser stuf

HRS0.500

Material Informati

Material Name	HRS0.500	Material Typ	HRS	Pierce Number	101
Material Thickne	0.500			Head Number	1
				WACS	No
Material Proce	STD				

Cutting

Cut Numbe	Feed Rate	Power [S]	Frequency	Duty Cycle	Gas Pressur	Gas	Gas Time	Nozzle Gap	Cutter Offset	Edge Numbe	Approach	Focal Position	Pulse Type
1	2.0	3600	10	25	0.15	1	2.0	0.030	0.0091	0	0	-0.079	0
2	40.0	4000	800	50	0.09	1	2.0	0.030	0.0091	0	0	-0.079	0
3	40.0	4000	2000	100	0.09	1	3.0	0.030	0.0091	0	0	-0.079	0
4	55.0	4000	2000	100	0.09	1	0.0	0.030	0.0091	0	0	-0.079	0
5	2.0	3600	10	25	0.15	1	3.0	0.030	0.0091	0	0	-0.079	0
6	40.0	4000	800	50	0.09	1	3.0	0.030	0.0091	0	0	-0.079	0
7	40.0	4000	2000	100	0.09	1	3.0	0.030	0.0091	0	0	-0.079	0
8	55.0	4000	2000	100	0.09	1	3.0	0.030	0.0091	0	0	-0.079	0
9	55.0	4000	2000	100	0.09	1	3.0	0.030	0.0091	0	0	-0.079	0
10	39.4	800	500	50	0.15	1	0.0	0.080	0.0000	0	0	0.059	0

Piercing

Piercing	Power	Initial Frequenc	Initial Duty	Inc. Frequenc	Inc. Duty	Step Time	Step Cou	Pierce Time	Gas Pressure	Gas Kind	Purge Time	Nozzle Gap	Focal Position	Pulse Type
101	4000	10	6	10	1	0.5	12	10.0	0.10	1	0.0	0.060	0.000	85
102	4000	10	12	10	1	0.5	12	10.0	0.10	1	0.0	0.060	0.000	85
103	4000	100	100	0	0	0.0	0	0.5	0.10	1	0.0	0.200	0.000	85

Edge

Edge	Work Angle	Pierce Power	Pierce Frequen	Pierce Duty	Pierce Time	Gas Pressure	Gas	Distance	Feed Rate	Recover Frequenc	Recover Duty
201	0.00	3600	10	25	0.5	0.06	1	0.0591	11.8	0	100
202	0.00	3600	10	25	0.5	0.06	1	0.0591	2.0	10	30
203	120.00	2000	10	100	0.5	0.06	1	0.0000	2.0	10	25
204	170.00	3600	10	25	0.5	0.06	1	0.0591	2.0	10	25
205	170.00	3600	10	25	0.5	0.06	1	0.0591	2.0	10	25