

# LASER CUTTING MACHINE

## **LCG** SERIES

(FS 31i-LB)

(AMNC-3i)

**AF3500I-C**

## PROCESSING CONDITIONS

**X41391A**

AMADA Europe  
BP 41040 – 95912 ROISSY AÉROPORT CDG CEDEX  
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*Original instructions*



<b>Rev</b>	<b>Date</b>	<b>Details</b>
A	22/04/2015	First version for Amada Europe

It is recommended that the instructions for this machine should be read carefully until you are thoroughly familiar with it.

Scrupulously follow installation, usage and maintenance operations as described in this manual to avoid any risk of accident to the operator.

Keep this documentation close by and refer to it whenever necessary.

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## IMPORTANT

**RECEPTION:** Your machine was loaded onto the carrier's truck and the carrier recognises that he received it in perfect condition.

However, if an incident occurs during transport (which is always possible) or if you observe any visible damage (traces of shocks or dents, etc.) on your machine, please make your reserves as follows:

- A – On the delivery form presented to you for acceptance by the carrier.
- B – By notifying them to the carrier and to ourselves (for information) by registered letter within not more than 48 hours.
- C – It is strictly prohibited to use your machine with protective covers removed or modified. Should maintenance operations be required, only qualified staff authorized by AMADA is entitled to do so.

**FOR ANY PROBLEMS THAT OCCUR  
DURING INSTALLATION OF THE MACHINE**

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# PREFACE

This book describes the processing condition files already registered in the NC.

- These data are standard data.
- The data of processing conditions Nos. 5 to 9 are reference data.
- The pre-registered processing condition files are named according to the JIS material name, thickness (in millimeters), and processing method of the worksheet for which the cutting conditions are set. When the material name ends in a number, it is connected by a hyphen to the thickness.

SPC: Cold-rolled steel SPCC

SPH: Hot-rolled steel SPHC

SS400: Structural steel SS400

SUS: Stainless steel SUS304-2B

A1050: Pure aluminum A1050

A5052: Aluminum alloy A5052

SECC: Electrogalvanized steel SECC with zinc coating amount of 10 g/m<sup>2</sup> per side

SGC: Galvanized steel SGC

- The last letter of the material name has the following meaning:

S: Use of lens with focal length of 7.5"

E: ECO Cut

H: Over 1.0 MPa high-pressure assist gas

- The D4.0AL nozzle set for cutting medium- and heavy-gauge aluminum sheets is a double nozzle exclusive for high-reflectivity materials. Do not use the other  $\phi$ 4.0 nozzle types (D4.0, D4.0C, D4.0W) for these materials.
- Do not use the D\*.C nozzles when piercing and cutting a worksheet with oxygen gas.
- Check that the shield ring is installed into the plug before installing the nozzle unit. Unless the shield ring is installed, the plug may burn out.

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The processing conditions are sorted in alphabetical and numerical order. The processing conditions are listed as described below on the [LIST] view (the [LASER] tab in Common Tools -> the [LIST] button).

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C-A1050-1.0HS	63
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SPC1.2E-2-----	244
SPC1.2S-----	245
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SPC1.5S-----	251
SPC1.5SE-----	252
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# A-A1050-0.5

[Material] A-A1050-0.5 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3000	9000	100	0.60	5	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	14000	3000	14000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	40	70	0
902	3000	1500	50	70	0
903	3000	2000	60	70	0
904	3000	2000	70	70	0
905	0	2000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	5	4.00	1000	4.000

Laser Gain Recv. Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A1050-0.5S**

[Material] A-A1050-0.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	10000	3000	10000	85	0.60	5	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
6	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	40	60	0
902	3000	1500	50	60	0
903	3000	2000	60	60	0
904	3000	2000	70	60	0
905	0	2000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	5	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-0.8

[Material] A-A1050-0.8 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3000	9000	100	0.60	5	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	12000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	13000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	12000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	12000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	12000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	12000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	40	70	0
902	3000	1500	50	70	0
903	3000	2000	60	70	0
904	3000	2000	70	70	0
905	0	2000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A1050-0.8S**

[Material] A-A1050-0.8S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	10000	3000	10000	85	0.60	5	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	13000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	13000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
6	13000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	13000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	13000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	13000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	40	60	0
902	3000	1500	50	60	0
903	3000	2000	60	60	0
904	3000	2000	70	60	0
905	0	2000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	5	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-1.0

[Material] A-A1050-1.0 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3000	9000	90	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
4	11000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
5	12000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	11000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
7	11000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
8	11000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
9	11000	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	20	30	0
902	3000	1500	30	30	0
903	3000	2000	40	30	0
904	3000	2000	50	30	0
905	0	2000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**A-A1050-1.0S**

[Material] A-A1050-1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3000	9000	85	0.60	5	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	40	60	0
902	3000	1500	50	60	0
903	3000	2000	60	60	0
904	3000	2000	70	60	0
905	0	2000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-1.2

[Material] A-A1050-1.2 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 1.20 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	8000	3000	9000	90	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
4	8500	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
5	8500	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	8500	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
7	8500	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
8	8500	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
9	8500	3000	10000	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	20	30	0
902	3000	1500	30	30	0
903	3000	2000	40	30	0
904	3000	2000	50	30	0
905	0	2000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A1050-1.2S**

[Material] A-A1050-1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 1.20 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3200	1000	45	0.60	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3200	9000	85	0.60	5	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	9500	3200	9500	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	9500	3200	9500	100	0.60	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	9500	3200	9500	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	9500	3200	9500	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	9500	3200	9500	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	9500	3200	9500	100	0.60	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	40	60	0
902	3200	1500	50	60	0
903	3200	2000	60	60	0
904	3200	2000	70	60	0
905	0	2000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-1.5

[Material] A-A1050-1.5 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 1.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	25	0.70	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	60	0.70	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	5000	3200	5000	85	0.70	5	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	5500	3200	5500	100	0.70	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	5500	3200	5500	100	0.70	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	5500	3200	5500	100	0.70	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
7	5500	3200	5500	100	0.70	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
8	5500	3200	5500	100	0.70	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
9	5500	3200	5500	100	0.70	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	40	30	0
902	3200	1000	50	30	0
903	3200	1000	60	30	0
904	3200	1000	70	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.70	0	1.000	300	200	35	0.700	0
202	0	3200	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	5500	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	5500	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	5500	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	5500	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	5500	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	5500	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	5500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A1050-1.5S**

[Material] A-A1050-1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 1.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	25	0.60	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3200	1500	50	0.60	5	0.0	0.500	0.120	0	201	0	102	0.00	Standard	No
3	5800	3200	5800	85	0.60	5	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
4	6300	3200	6300	100	0.60	5	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
5	6300	3200	6300	100	0.60	5	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
6	6300	3200	6300	100	0.60	5	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
7	6300	3200	6300	100	0.60	5	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
8	6300	3200	6300	100	0.60	5	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
9	6300	3200	6300	100	0.60	5	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	50	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-3.00	OFF
102	3500	100	50	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
103	3500	100	50	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
104	3500	100	50	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
105	3500	100	50	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	40	70	0
902	3200	1000	50	70	0
903	3200	1000	60	70	0
904	3200	1000	70	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.60	5	4.00	1000	4.000

Laser Gain Recv. Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	150	33	0.000	0.60	0	1.000	300	150	33	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.60	0	3.000	4000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.60	0	3.000	4500	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.60	0	3.000	4500	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.60	0	3.000	4500	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.60	0	3.000	4500	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.60	0	3.000	4500	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.60	0	3.000	4500	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.60	0	3.000	4500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-2.0

[Material] A-A1050-2.0 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 2.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	30	0.90	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	60	0.90	5	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	3500	3200	3500	90	0.90	5	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
4	4000	3200	4000	100	0.90	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
5	4000	3200	4000	100	0.90	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	4000	3200	4000	100	0.90	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
7	4000	3200	4000	100	0.90	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
8	4000	3200	4000	100	0.90	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
9	4000	3200	4000	100	0.90	5	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	50	30	0
902	3200	1000	60	30	0
903	3200	1000	70	30	0
904	3200	1000	80	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.90	5	4.00	1000	4.000

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3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	40	0.000	0.90	0	1.000	300	200	40	0.700	0
202	0	3000	2000	100	0.000	0.90	0	1.000	500	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.90	0	3.000	3500	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A1050-2.0S**

[Material] A-A1050-2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 2.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	40	0.70	5	0.3	0.700	0.120	0	201	0	101	-0.50	Standard	No
2	2000	3500	1500	80	0.70	5	0.0	0.500	0.120	0	201	901	102	0.00	Standard	No
3	3000	3500	3000	90	0.70	5	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
4	3500	3500	3500	100	0.70	5	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
5	3500	3500	3500	100	0.70	5	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
6	3500	3500	3500	100	0.70	5	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
7	3500	3500	3500	100	0.70	5	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
8	3500	3500	3000	100	0.70	5	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
9	3500	3500	3500	100	0.70	5	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	50	0	0	0.000	0	0.400	0.25	5	0.3	5.000	-3.00	OFF
102	3500	100	50	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-3.00	OFF
103	3500	100	50	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-3.00	OFF
104	3500	100	50	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-3.00	OFF
105	3500	100	50	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	40	70	0
902	3500	1000	50	70	0
903	3500	1000	60	70	0
904	3500	1000	70	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.70	5	4.00	1000	4.000

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 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	40	0.000	0.70	0	1.000	200	100	40	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
			Pie.	Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-2.5

[Material] A-A1050-2.5 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 2.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	200	40	0.95	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1000	3000	1200	65	0.95	5	0.0	0.300	0.120	0	201	0	102	0.00	Standard	No
3	2500	3500	2500	100	0.95	5	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
4	3000	3500	3000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
5	3000	3500	3000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
6	3000	3500	3000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
7	3000	3500	3000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
8	3000	3500	3000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
9	3000	3500	3000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	50	30	0
902	3500	200	60	30	0
903	3500	200	70	30	0
904	3500	200	80	30	0
905	0	200	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3300	2000	100	0.80	5	4.00	700	4.000

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3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	45	0.000	0.80	5	1.500	100	200	45	1.500	0
202	0	3500	2000	100	0.000	0.95	0	2.000	200	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**A-A1050-2.5S**

[Material] A-A1050-2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 2.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	200	35	0.70	5	0.3	0.700	0.130	0	201	0	101	-0.50	Standard	No
2	1000	3500	1500	60	0.70	5	0.0	0.500	0.130	0	201	0	101	0.00	Standard	No
3	2500	3500	2500	90	0.70	5	0.0	0.500	0.130	0	202	902	102	0.00	Standard	No
4	3000	3500	3000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
5	3000	3500	3000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
6	3000	3500	3000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
7	3000	3500	3000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
8	3000	3500	3000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
9	3000	3500	3000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	50	0	0	0.000	0	0.500	0.25	5	0.3	5.000	-2.00	OFF
102	3500	100	50	0	0	0.000	0	0.500	0.35	5	0.0	5.000	-2.00	OFF
103	3500	100	50	0	0	0.000	0	0.500	0.35	5	0.0	5.000	-2.00	OFF
104	3500	100	50	0	0	0.000	0	0.500	0.35	5	0.0	5.000	-2.00	OFF
105	3500	100	50	0	0	0.000	0	0.500	0.35	5	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	50	70	0
902	3500	1000	60	70	0
903	3500	1000	70	70	0
904	3500	1000	80	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.80	5	4.00	700	4.000

Laser Gain Recv.  
 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	40	0.000	0.70	0	1.500	100	100	40	1.500	0
202	0	3500	2000	100	0.000	0.70	0	3.000	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-3.0

[Material] A-A1050-3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 3.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	200	40	0.95	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1000	3000	1200	65	0.95	5	0.0	0.300	0.120	0	201	0	102	0.00	Standard	No
3	1700	3500	2000	100	0.95	5	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
4	2000	3500	2000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
5	2000	3500	2000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
6	2000	3500	2000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
7	2000	3500	2000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
8	2000	3500	2000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
9	2000	3500	2000	100	0.95	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	50	30	0
902	3500	200	60	30	0
903	3500	200	70	30	0
904	3500	200	80	30	0
905	0	200	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3300	2000	100	0.95	5	4.00	700	4.000

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3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	45	0.000	0.80	5	1.500	100	200	45	1.500	0
202	0	3500	2000	100	0.000	0.95	0	2.000	200	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A1050-3.0S**

[Material] A-A1050-3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 3.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	200	35	0.70	5	0.3	0.700	0.130	0	201	0	101	-0.50	Standard	No
2	1000	3500	1500	60	0.70	5	0.0	0.500	0.130	0	201	0	101	0.00	Standard	No
3	2000	3500	1500	90	0.70	5	0.0	0.500	0.130	0	202	902	102	0.00	Standard	No
4	2500	3500	2000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
5	2500	3500	2000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
6	2500	3500	2000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
7	2500	3500	2000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
8	2500	3500	2000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
9	2500	3500	2000	100	0.70	5	0.0	0.500	0.130	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	50	0	0	0.000	0	0.500	0.25	5	0.3	5.000	-2.50	OFF
102	3500	100	50	0	0	0.000	0	0.500	0.35	5	0.0	5.000	-2.50	OFF
103	3500	100	50	0	0	0.000	0	0.500	0.35	5	0.0	5.000	-2.50	OFF
104	3500	100	50	0	0	0.000	0	0.500	0.35	5	0.0	5.000	-2.50	OFF
105	3500	100	50	0	0	0.000	0	0.500	0.35	5	0.0	5.000	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	50	70	0
902	3500	1000	60	70	0
903	3500	1000	70	70	0
904	3500	1000	80	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.70	5	4.00	700	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	40	0.000	0.70	0	1.500	100	100	40	1.500	0
202	0	3500	2000	100	0.000	0.70	0	3.000	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	2500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-4.0S

[Material] A-A1050-4.0S [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 4.00 [CutWay] Aluminium [NzlType] D\*:\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	200	45	0.70	5	0.0	1.500	0.140	0	201	0	101	-1.00	Standard	No
2	1000	3500	700	65	0.70	5	0.0	0.500	0.140	0	201	902	101	0.00	Standard	No
3	1500	3500	2000	90	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
4	2000	3500	2000	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
5	2000	3500	2000	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
6	2000	3500	2000	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
7	2000	3500	2000	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
8	2000	3500	2000	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
9	2000	3500	2000	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	70	0	0	0.000	0	1.000	0.20	5	0.5	5.000	-1.50	OFF
102	3500	100	70	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF
103	3500	100	70	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF
104	3500	100	70	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF
105	3500	100	70	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	40	60	0
902	3500	1000	50	60	0
903	3500	1000	60	60	0
904	3500	1000	70	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	60	0.000	0.50	5	1.500	100	300	60	2.000	0
202	0	3500	100	100	0.000	0.70	0	3.000	500	100	100	0.700	0
203	120	3500	1500	90	0.000	0.70	0	3.000	1500	1500	90	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A1050-5.0S**

[Material] A-A1050-5.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 5.00 [CutWay] Aluminium [NzlType] D\*:AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	200	60	0.70	5	0.0	1.000	0.140	0	201	0	101	-1.00	Standard	No
2	800	3500	1000	80	0.70	5	0.0	0.700	0.140	0	201	903	101	0.00	Standard	No
3	1100	3500	1500	100	0.70	5	0.0	0.500	0.140	203	202	903	102	0.00	Standard	No
4	1300	3500	1500	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
5	1300	3500	1500	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
6	1300	3500	1500	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
7	1300	3500	1500	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
8	1300	3500	1500	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
9	1300	3500	1500	100	0.70	5	0.0	0.500	0.140	204	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	80	0	0	0.000	0	1.500	0.20	5	0.5	5.000	-1.50	OFF
102	3500	100	80	0	0	0.000	0	1.500	0.20	5	0.5	5.000	-1.50	OFF
103	3500	100	80	0	0	0.000	0	1.500	0.20	5	0.5	5.000	-1.50	OFF
104	3500	100	80	0	0	0.000	0	1.500	0.20	5	0.5	5.000	-1.50	OFF
105	3500	100	80	0	0	0.000	0	1.500	0.20	5	0.5	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	40	60	0
902	3500	1000	50	60	0
903	3500	1000	60	60	0
904	3500	1000	70	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	400	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	200	80	0.000	0.60	5	2.000	50	200	80	1.500	0
202	0	3500	1500	100	0.000	0.60	5	3.000	200	1500	100	0.700	0
203	120	3500	1500	90	0.000	0.70	0	3.000	800	1500	90	0.000	0
204	120	3500	1500	90	0.000	0.70	0	3.000	800	1500	90	0.000	0
205	120	3500	1500	90	0.000	0.70	0	3.000	800	1500	90	0.000	0
206	120	3500	1500	90	0.000	0.70	0	3.000	800	1500	90	0.000	0
207	120	3500	1500	90	0.000	0.70	0	3.000	800	1500	90	0.000	0
208	120	3500	1500	90	0.000	0.70	0	3.000	800	1500	90	0.000	0
209	120	3500	1500	90	0.000	0.70	0	3.000	800	1500	90	0.000	0
210	120	3500	1500	90	0.000	0.70	0	3.000	800	1500	90	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A1050-6.0S

[Material] A-A1050-6.0S [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 6.00 [CutWay] Aluminium [NzlType] D\*:\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	200	75	0.80	5	0.0	1.500	0.140	0	201	0	101	-1.00	Standard	No
2	500	3500	500	85	0.90	5	0.0	0.500	0.140	204	202	0	102	0.00	Standard	No
3	600	3500	600	100	0.90	5	0.0	0.500	0.140	204	202	0	102	0.00	Standard	No
4	800	3500	800	100	0.90	5	0.0	0.500	0.140	205	202	0	102	0.00	Standard	No
5	800	3500	800	100	0.90	5	0.0	0.500	0.140	205	202	0	102	0.00	Standard	No
6	800	3500	800	100	0.90	5	0.0	0.500	0.140	205	202	0	102	0.00	Standard	No
7	800	3500	800	100	0.90	5	0.0	0.500	0.140	205	202	0	102	0.00	Standard	No
8	800	3500	800	100	0.90	5	0.0	0.500	0.140	205	202	0	102	0.00	Standard	No
9	800	3500	800	100	0.90	5	0.0	0.500	0.140	205	202	0	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	90	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF
102	3500	100	90	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF
103	3500	100	90	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF
104	3500	100	90	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF
105	3500	100	90	0	0	0.000	0	2.000	0.20	5	0.5	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	40	40	0
902	3500	1000	50	40	0
903	3500	1000	60	40	0
904	3500	1000	70	40	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.90	5	4.00	200	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	200	95	0.000	0.90	5	2.000	50	200	95	1.500	0
202	0	3500	800	100	0.000	0.90	5	3.000	200	800	100	0.700	0
203	120	3500	500	90	0.000	0.90	0	3.000	600	500	90	0.000	0
204	120	3500	500	90	0.000	0.90	0	3.000	600	500	90	0.000	0
205	120	3500	500	90	0.000	0.90	0	3.000	600	500	90	0.000	0
206	120	3500	500	90	0.000	0.90	0	3.000	600	500	90	0.000	0
207	120	3500	500	90	0.000	0.90	0	3.000	600	500	90	0.000	0
208	120	3500	500	90	0.000	0.90	0	3.000	600	500	90	0.000	0
209	120	3500	500	90	0.000	0.90	0	3.000	600	500	90	0.000	0
210	120	3500	500	90	0.000	0.90	0	3.000	600	500	90	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A5052-0.5**

[Material] A-A5052-0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	15000	3000	15000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	15000	3000	15000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	15000	3000	15000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	15000	3000	15000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	15000	3000	15000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	15000	3000	15000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	3000	40	50	0
902	3000	3000	50	50	0
903	3000	3000	60	50	0
904	3000	3000	70	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-0.5S

[Material] A-A5052-0.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	13000	3500	13000	100	0.60	5	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	14000	3500	14000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	15000	3500	15000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	14000	3500	14000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	14000	3500	14000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	14000	3500	14000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	14000	3500	14000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	40	50	0
902	3500	3000	50	50	0
903	3500	3000	60	50	0
904	3500	3000	70	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**A-A5052-0.8**

[Material] A-A5052-0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	11000	3000	11000	100	0.60	5	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	13000	3000	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	12000	3000	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	3000	40	50	0
902	3000	3000	50	50	0
903	3000	3000	60	50	0
904	3000	3000	70	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-0.8S

[Material] A-A5052-0.8S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	11000	3500	11000	100	0.60	5	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	13000	3500	13000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-2.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	5	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	40	50	0
902	3500	3000	50	50	0
903	3500	3000	60	50	0
904	3500	3000	70	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A5052-1.0**

[Material] A-A5052-1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	9000	3200	9000	90	0.60	5	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	10000	3200	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	11000	3200	11000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	10000	3200	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	10000	3200	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	10000	3200	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	10000	3200	10000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	3000	30	30	0
902	3200	3000	40	30	0
903	3200	3000	50	30	0
904	3200	3000	60	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	5	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-1.0S

[Material] A-A5052-1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	9000	3500	9000	100	0.60	5	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	12000	3500	12000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	10	50	0
902	3500	3000	20	50	0
903	3500	3000	30	50	0
904	3500	3000	40	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-1.2

[Material] A-A5052-1.2 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.20 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	8000	3200	8000	90	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
4	9000	3200	9000	100	0.60	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
5	9000	3200	9000	100	0.60	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
6	9000	3200	9000	100	0.60	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
7	9000	3200	9000	100	0.60	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
8	9000	3200	9000	100	0.60	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
9	9000	3200	9000	100	0.60	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	3000	20	30	0
902	3200	3000	30	30	0
903	3200	3000	40	30	0
904	3200	3000	50	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-1.2S

[Material] A-A5052-1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.20 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	300	15	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	40	0.60	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	8500	3500	8500	100	0.60	5	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	9000	3500	9000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	9000	3500	9000	100	0.60	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
6	9000	3500	9000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	9000	3500	9000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	9000	3500	9000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	9000	3500	9000	100	0.60	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	30	50	0
902	3500	3000	30	50	0
903	3500	3000	40	50	0
904	3500	3000	40	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A5052-1.5**

[Material] A-A5052-1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.70	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.70	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	7200	3200	7200	90	0.70	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
4	8000	3200	8000	100	0.70	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
5	8000	3200	8000	100	0.70	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
6	8000	3200	8000	100	0.70	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
7	8000	3200	8000	100	0.70	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
8	8000	3200	8000	100	0.70	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
9	8000	3200	8000	100	0.70	5	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	30	30	0
902	3200	1000	40	30	0
903	3200	1000	50	30	0
904	3200	1000	60	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3200	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.60	0	3.000	5000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A5052-1.5S**

[Material] A-A5052-1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	5	0.0	0.300	0.110	0	201	0	105	0.00	Medium	No
3	7800	3500	7800	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
4	8500	3500	8500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
5	8500	3500	8500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
6	8500	3500	8500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
7	8500	3500	8500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
8	8500	3500	8500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
9	8500	3500	8500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	30	30	0
902	3500	1000	40	30	0
903	3500	1000	50	30	0
904	3500	1000	60	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3500	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**A-A5052-2.0**

[Material] A-A5052-2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 2.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	25	0.70	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	65	0.70	5	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	5400	3500	5400	100	0.70	5	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	6000	3500	6000	100	0.70	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	6000	3500	6000	100	0.70	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	6000	3500	6000	100	0.70	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	6000	3500	6000	100	0.70	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	6000	3500	6000	100	0.70	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	6000	3500	6000	100	0.70	5	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	30	50	0
902	3500	1000	40	50	0
903	3500	1000	50	50	0
904	3500	1000	70	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.60	0	1.000	300	200	35	0.700	0
202	0	3500	2000	100	0.000	0.60	0	1.000	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-2.0S

[Material] A-A5052-2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 2.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	25	0.60	5	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	65	0.60	5	0.0	0.300	0.110	0	201	0	105	0.00	Medium	No
3	6500	3200	6500	90	0.60	5	0.0	0.300	0.110	0	202	903	105	0.00	Medium	No
4	7000	3200	7500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
5	7000	3200	7500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
6	7000	3200	7500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
7	7000	3200	7500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
8	7000	3200	7500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
9	7000	3200	7500	100	0.60	5	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	30	20	0
902	3200	1000	40	20	0
903	3200	1000	50	20	0
904	3200	1000	60	20	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.60	0	1.000	300	200	35	0.700	0
202	0	3200	2000	100	0.000	0.60	0	1.000	500	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.60	0	3.000	4000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-2.5

[Material] A-A5052-2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 2.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	200	30	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1000	3000	1200	65	0.70	5	0.0	0.300	0.120	0	201	0	105	0.00	Medium	No
3	3000	3500	3000	90	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
4	3500	3500	3500	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
5	3500	3500	3500	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
6	3500	3500	3500	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
7	3500	3500	3500	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
8	3500	3500	3500	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
9	3500	3500	3500	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	200	50	60	0
904	3500	200	70	60	0
905	0	200	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3300	2000	100	0.80	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	35	0.000	0.70	0	1.000	100	200	35	1.500	0
202	0	2800	2000	100	0.000	0.70	0	1.500	300	2000	100	0.700	0
203	120	3500	2000	100	0.500	0.70	0	1.500	1500	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-2.5S

[Material] A-A5052-2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 2.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	25	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3500	800	45	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	4000	3500	4000	90	0.70	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	4500	3500	4500	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	4500	3500	4500	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	4500	3500	4500	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	4500	3500	4500	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	4500	3500	4500	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	4500	3500	4500	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-2.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	200	50	60	0
904	3500	200	60	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.70	0	1.000	300	200	35	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	400	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-3.0

[Material] A-A5052-3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 3.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	200	30	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1000	3000	1200	65	0.70	5	0.0	0.300	0.120	0	201	0	105	0.00	Medium	No
3	2500	3500	2500	90	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
4	3000	3500	3000	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
5	3000	3500	3000	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
6	3000	3500	3000	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
7	3000	3500	3000	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
8	3000	3500	3000	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
9	3000	3500	3000	100	0.70	5	0.0	0.300	0.120	0	202	0	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	200	50	60	0
904	3500	200	70	60	0
905	0	200	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3300	2000	100	0.70	5	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	35	0.000	0.70	0	1.000	100	200	35	1.500	0
202	0	2800	2000	100	0.000	0.70	0	1.500	300	2000	100	0.700	0
203	120	3500	2000	100	0.500	0.70	0	1.500	1500	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-3.0S

[Material] A-A5052-3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 3.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	25	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3500	800	45	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	3500	3500	3500	90	0.70	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	4000	3500	4000	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	4000	3500	4000	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	4000	3500	4000	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	4000	3500	4000	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	4000	3500	4000	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-2.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	200	50	60	0
904	3500	200	60	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.70	0	1.000	300	200	35	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	400	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-A5052-4.0S**

[Material] A-A5052-4.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 4.00 [CutWay] Aluminium [NzlType] D\*\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	200	30	0.60	5	0.0	1.500	0.140	0	201	0	101	-0.50	Standard	No
2	1000	3500	600	50	0.60	5	0.0	0.500	0.140	0	201	901	102	0.00	Standard	No
3	2000	3500	1500	90	0.60	5	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
4	2500	3500	2000	100	0.60	5	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
5	2500	3500	2000	100	0.60	5	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
6	2500	3500	2000	100	0.60	5	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
7	2500	3500	2000	100	0.60	5	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
8	2000	3500	1500	90	0.60	5	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
9	2500	3500	2000	100	0.60	5	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	60	0	0	0.000	0	1.000	0.20	5	0.5	5.000	-1.50	OFF
102	3500	100	60	0	0	0.000	0	1.000	0.25	5	0.3	5.000	-1.50	OFF
103	3500	100	60	0	0	0.000	0	1.000	0.25	5	0.3	5.000	-1.50	OFF
104	3500	100	60	0	0	0.000	0	1.000	0.25	5	0.3	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.100	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	500	40	60	0
902	3500	500	50	60	0
903	3500	500	70	60	0
904	3500	500	80	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.60	5	4.00	500	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	150	51	0.000	0.60	5	1.300	150	150	51	1.500	0
202	0	3500	100	100	0.000	0.60	0	2.000	800	100	100	0.700	0
203	120	3500	1500	90	0.000	0.60	0	3.000	1200	1500	90	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-A5052-5.0S

[Material] A-A5052-5.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 5.00 [CutWay] Aluminium [NzlType] D\*:\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	40	0.70	5	0.0	1.000	0.140	0	201	0	101	-1.00	Standard	No
2	1000	3500	600	60	0.70	5	0.0	0.700	0.140	0	201	0	101	0.00	Standard	No
3	1500	3500	2000	90	0.70	5	0.0	0.300	0.140	0	202	903	102	0.00	Standard	No
4	2000	3500	2500	100	0.70	5	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
5	2000	3500	2500	100	0.70	5	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
6	2000	3500	2500	100	0.70	5	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
7	2000	3500	2500	100	0.70	5	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
8	2000	3500	2500	100	0.70	5	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
9	2000	3500	2500	100	0.70	5	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	60	0	0	0.000	0	1.000	0.20	5	0.5	5.000	-1.50	OFF
102	3500	100	60	0	0	0.000	0	1.000	0.25	5	0.3	5.000	-1.50	OFF
103	3500	100	60	0	0	0.000	0	1.000	0.25	5	0.3	5.000	-1.50	OFF
104	3500	100	60	0	0	0.000	0	1.000	0.25	5	0.3	5.000	-1.50	OFF
105	3500	100	60	0	0	0.000	0	1.000	0.25	5	0.3	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	500	40	60	0
902	3500	500	50	60	0
903	3500	500	60	60	0
904	3500	500	70	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	100	0.70	5	4.00	400	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	200	60	0.000	0.60	5	1.500	100	200	60	1.500	0
202	0	3500	1500	100	0.000	0.70	0	2.500	500	1500	100	0.700	0
203	120	3500	1500	90	0.000	0.70	0	3.000	1000	1500	90	0.000	0
204	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
206	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
207	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
208	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
209	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
210	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**A-A5052-6.0S**

[Material] A-A5052-6.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 6.00 [CutWay] Aluminium [NzlType] D\*:AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	55	0.70	5	0.0	1.000	0.140	0	201	0	101	-1.00	Standard	No
2	700	3500	700	65	0.70	5	0.0	0.700	0.140	0	201	0	101	0.00	Standard	No
3	1000	3500	2000	90	0.70	5	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
4	1200	3500	2000	100	0.70	5	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
5	1200	3500	2000	100	0.70	5	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
6	1200	3500	2000	100	0.70	5	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
7	1200	3500	2000	100	0.70	5	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
8	1200	3500	2000	100	0.70	5	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
9	1200	3500	2000	100	0.70	5	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	1.500	0.20	5	0.5	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	1.500	0.25	5	0.3	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	1.500	0.25	5	0.3	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	1.500	0.25	5	0.3	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	1.500	0.25	5	0.3	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	500	40	70	0
902	3500	500	50	70	0
903	3500	500	60	70	0
904	3500	500	70	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	100	0.70	5	4.00	300	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	65	0.000	0.50	5	2.000	100	100	65	2.000	0
202	0	3500	1500	100	0.000	0.70	0	3.000	300	1500	100	0.700	0
203	120	3500	1500	90	0.000	0.70	0	4.000	400	1500	90	0.000	0
204	120	3500	1500	100	0.000	0.70	0	4.000	400	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.70	0	4.000	400	1500	100	0.000	0
206	120	3500	1500	100	0.000	0.70	0	4.000	400	1500	100	0.000	0
207	120	3500	1500	100	0.000	0.70	0	4.000	400	1500	100	0.000	0
208	120	3500	1500	100	0.000	0.70	0	4.000	400	1500	100	0.000	0
209	120	3500	1500	100	0.000	0.70	0	4.000	400	1500	100	0.000	0
210	120	3500	1500	100	0.000	0.70	0	4.000	400	1500	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS0.5

[Material] A-SUS0.5 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	10000	3500	11000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	15	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS0.5HS

[Material] A-SUS0.5HS [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.70	5	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	5	0.0	1.500	0.120	0	201	902	105	0.00	Medium	No
3	27000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	30000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	30000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	30000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	30000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	30000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	30000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	15	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS0.8

[Material] A-SUS0.8 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8000	3500	8000	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	15	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS0.8HS

[Material] A-SUS0.8HS [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.70	5	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	5	0.0	1.500	0.120	0	201	902	105	0.00	Medium	No
3	25000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	27000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	27000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	27000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	27000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	27000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	27000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	15	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS1.0

[Material] A-SUS1.0 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	7500	3500	7500	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	8000	3500	8000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	8000	3500	8000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	8000	3500	8000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	8000	3500	8000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	8000	3500	8000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	8000	3500	8000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	20	0
902	3500	200	15	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS1.0HS

[Material] A-SUS1.0HS [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.70	5	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	5	0.0	1.500	0.120	0	201	902	105	0.00	Medium	No
3	23000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	25000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
5	25000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
6	25000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
7	25000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
8	25000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
9	25000	3500	20000	100	0.70	5	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	15	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS1.0S

[Material] A-SUS1.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.60	5	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	35	0.60	5	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	6500	3500	6500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	7000	3500	7000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	7500	3500	7500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
6	7000	3500	7000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	7000	3500	7000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	7000	3500	7000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	7000	3500	7000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-4.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	5	0.0	5.000	-4.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	20	0
902	3500	200	20	20	0
903	3500	300	30	20	0
904	3500	300	40	20	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.60	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



# A-SUS1.2

[Material] A-SUS1.2 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	6500	3500	6500	90	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	7000	3500	7000	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
5	7000	3500	7000	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
6	7000	3500	7000	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
7	7000	3500	7000	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
8	7000	3500	7000	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
9	7000	3500	7000	100	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	2000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	20	0
902	3500	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS1.2S

[Material] A-SUS1.2S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	5	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.70	5	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	5000	3500	5000	85	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	5500	3500	5500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	5500	3500	5500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
6	5500	3500	5500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	5500	3500	5500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	5500	3500	5500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	5500	3500	5500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-4.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-4.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	20	20	0
904	3500	300	30	20	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS1.5

[Material] A-SUS1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	12	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	5000	3500	5000	90	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	5500	3500	5500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	5500	3500	5500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	5500	3500	5500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	5500	3500	5500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	5500	3500	5500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	5500	3500	5500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	22	0.000	0.70	0	1.000	300	200	22	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	800	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS1.5S

[Material] A-SUS1.5S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.60	5	0.0	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	4500	3500	4500	90	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	5000	3500	5000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	5500	3500	5500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
6	5000	3500	5000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	5000	3500	5000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	5000	3500	5000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	5000	3500	5000	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-4.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-4.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	10	20	0
904	3500	300	20	20	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.60	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS2.0

[Material] A-SUS2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	14	0.70	5	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.70	5	0.0	0.300	0.140	0	201	902	105	0.00	Medium	No
3	3600	3500	3600	90	0.70	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
5	4000	3500	4000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
6	4000	3500	4000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
7	4000	3500	4000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
8	4000	3500	4000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
9	4000	3500	4000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	40	0
902	3000	200	20	40	0
903	3500	200	20	40	0
904	3500	200	30	40	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.70	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS2.0S

[Material] A-SUS2.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	5	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	50	0.70	5	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	3500	3500	3500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.70	5	0.0	0.500	0.200	0	202	904	105	0.00	Medium	No
5	4000	3500	4000	100	0.70	5	0.0	0.500	0.200	0	202	904	105	0.00	Medium	No
6	4000	3500	4000	100	0.70	5	0.0	0.500	0.200	0	202	904	105	0.00	Medium	No
7	4000	3500	4000	100	0.70	5	0.0	0.500	0.200	0	202	904	105	0.00	Medium	No
8	4000	3500	4000	100	0.70	5	0.0	0.500	0.200	0	202	904	105	0.00	Medium	No
9	4000	3500	4000	100	0.70	5	0.0	0.500	0.200	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-4.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.50	5	0.0	5.000	-4.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	50	0
902	3000	200	20	50	0
903	3500	300	20	50	0
904	3500	300	30	50	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**A-SUS2.5**

[Material] A-SUS2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	14	0.70	5	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.70	5	0.0	0.300	0.140	0	201	902	105	0.00	Medium	No
3	3000	3500	3000	90	0.70	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	3500	3500	3500	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
5	3500	3500	3500	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
6	3500	3500	3500	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
7	3500	3500	3500	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
8	3500	3500	3500	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
9	3500	3500	3500	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	40	0
902	3000	200	20	40	0
903	3500	200	20	40	0
904	3500	200	30	40	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.70	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS2.5S

[Material] A-SUS2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.70	5	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	55	0.70	5	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	3000	3500	3000	90	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	3500	3500	3500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	3500	3500	3500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
6	3500	3500	3500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	3500	3500	3500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	3500	3500	3500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	3500	3500	3500	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.300	0.25	5	0.3	5.000	-4.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-4.00	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-4.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	60	0
902	3500	200	40	60	0
903	3500	300	50	60	0
904	3500	300	60	60	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



# A-SUS3.0

[Material] A-SUS3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 0 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.70	5	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	1000	3000	800	65	0.70	5	0.0	0.500	0.140	0	201	902	105	0.00	Medium	No
3	2500	3500	2500	90	0.70	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	3000	3500	3000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
5	3000	3500	3000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
6	3000	3500	3000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
7	3000	3500	3000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
8	3000	3500	3000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
9	3000	3500	3000	100	0.70	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1300	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	60	0
902	3000	200	40	60	0
903	3500	200	30	60	0
904	3500	200	40	60	0
905	1300	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.70	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# A-SUS3.0S

[Material] A-SUS3.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.70	5	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	55	0.70	5	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	2700	3500	2700	90	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	3000	3500	3000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	3000	3500	3000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
6	3000	3500	3000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	3000	3500	3000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	3000	3500	3000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	3000	3500	3000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-4.00	OFF
102	3500	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-4.00	OFF
103	3500	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-4.00	OFF
104	3500	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-4.00	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-4.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	20	60	0
902	3500	200	30	60	0
903	3500	300	40	60	0
904	3500	300	50	60	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-0.5

[Material] C-A1050-0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3000	9000	100	0.60	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	13000	3000	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	14000	3000	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
6	13000	3000	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	13000	3000	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	13000	3000	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	13000	3000	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	30	70	0
902	3000	1000	40	70	0
903	3000	1000	50	70	0
904	3000	1000	60	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A1050-0.5HS**

[Material] C-A1050-0.5HS [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	300	15	0.80	4	0.3	1.500	0.110	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	40	0.80	4	0.0	1.500	0.110	0	201	0	102	0.00	Standard	No
3	30000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
4	32000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
5	34000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
6	32000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
7	32000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
8	32000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
9	32000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	20	30	0
902	3500	1000	25	30	0
903	3500	1000	30	30	0
904	3500	1000	35	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.80	0	1.000	300	200	25	0.000	0
202	0	3000	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A1050-0.5S**

[Material] C-A1050-0.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.70	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3200	1000	45	0.70	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	10000	3200	10000	85	0.70	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	13000	3300	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
6	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	40	70	0
902	3200	1000	50	70	0
903	3200	1000	60	70	0
904	3200	1000	70	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.70	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.70	0	1.000	300	200	30	0.700	0
202	0	3200	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-0.8

[Material] C-A1050-0.8 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3000	9000	100	0.60	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	12000	3000	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	13000	3000	13000	100	0.60	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	12000	3000	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	12000	3000	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	12000	3000	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	12000	3000	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	30	70	0
902	3000	1000	40	70	0
903	3000	1000	60	70	0
904	3000	1000	70	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	4	4.00	1000	4.000

Laser Gain Recv. Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-0.8HS

[Material] C-A1050-0.8HS [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	300	15	0.80	4	0.3	1.500	0.110	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	40	0.80	4	0.0	1.500	0.110	0	201	0	102	0.00	Standard	No
3	28000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
4	30000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
5	32000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
6	30000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
7	30000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
8	30000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
9	30000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	25	30	0
902	3000	1000	30	30	0
903	3500	1000	35	30	0
904	3500	1000	40	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.80	0	1.000	300	200	25	0.000	0
202	0	3000	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-0.8S

[Material] C-A1050-0.8S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.70	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3200	1000	45	0.70	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	10000	3200	10000	85	0.70	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	13000	3300	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
6	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	13000	3200	13000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	30	70	0
902	3200	1000	40	70	0
903	3200	1000	50	70	0
904	3200	1000	60	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.70	4	4.00	1000	4.000

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3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.70	0	1.000	300	200	30	0.700	0
202	0	3200	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-A1050-1.0**

[Material] C-A1050-1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3000	9000	100	0.60	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	11000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	12000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	11000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	11000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	11000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	11000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	30	70	0
902	3000	1000	40	70	0
903	3000	1000	50	70	0
904	3000	1000	60	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.60	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3000	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3000	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-1.0HS

[Material] C-A1050-1.0HS [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	300	15	0.80	4	0.3	1.500	0.110	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	40	0.80	4	0.0	1.500	0.110	0	201	0	102	0.00	Standard	No
3	25000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
4	28000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
5	30000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
6	28000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
7	28000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
8	28000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
9	28000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	25	30	0
902	3500	1000	30	30	0
903	3500	1000	35	30	0
904	3500	1000	40	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.80	0	1.000	300	200	25	0.000	0
202	0	3000	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A1050-1.0S**

[Material] C-A1050-1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.70	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3200	1000	45	0.70	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	9000	3200	9000	85	0.70	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	12000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	13000	3300	13000	100	0.70	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	12000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	12000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	12000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	12000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	30	70	0
902	3200	1000	40	70	0
903	3200	1000	50	70	0
904	3200	1000	60	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.70	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.70	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A1050-1.2**

[Material] C-A1050-1.2 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 1.20 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	8500	3000	9000	100	0.60	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	9000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	9000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	9000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	9000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	9000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	9000	3000	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	30	70	0
902	3000	1000	40	70	0
903	3000	1000	50	70	0
904	3000	1000	60	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-1.2S

[Material] C-A1050-1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 1.20 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.70	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3200	1000	45	0.70	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	8500	3200	9000	85	0.70	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	9000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	9000	3300	13000	100	0.70	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	9000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	9000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	9000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	9000	3200	12000	100	0.70	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.5	5.000	-3.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	30	70	0
902	3200	1000	40	70	0
903	3200	1000	50	70	0
904	3200	1000	60	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	2000	100	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.70	0	1.000	300	200	30	0.700	0
202	0	3000	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A1050-1.5**

[Material] C-A1050-1.5 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 1.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	25	0.80	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	60	0.80	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	5400	3200	5400	85	0.80	4	0.0	0.500	0.110	0	202	902	102	0.00	Standard	No
4	6000	3200	6000	100	0.80	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
5	6000	3200	6000	100	0.80	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
6	6000	3200	6000	100	0.80	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
7	6000	3200	6000	100	0.80	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
8	6000	3200	6000	100	0.80	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
9	6000	3200	6000	100	0.80	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	30	60	0
902	3200	1000	40	60	0
903	3200	1000	50	60	0
904	3200	1000	60	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2700	2000	100	0.80	4	4.00	1000	4.000

Laser Mont.	Gain	Recv.
	3	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.80	0	1.000	300	200	35	0.700	0
202	0	3200	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-1.5S

[Material] C-A1050-1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 1.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	25	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3200	1500	50	0.80	4	0.0	0.500	0.120	0	201	0	102	0.00	Standard	No
3	5800	3200	5800	85	0.80	4	0.0	0.500	0.120	0	202	903	102	0.00	Standard	No
4	6300	3200	6300	100	0.80	4	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
5	6300	3200	6300	100	0.80	4	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
6	6300	3200	6300	100	0.80	4	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
7	6300	3200	6300	100	0.80	4	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
8	6300	3200	6300	100	0.80	4	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
9	6300	3200	6300	100	0.80	4	0.0	0.500	0.120	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	50	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-3.50	OFF
102	3500	100	50	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.50	OFF
103	3500	100	50	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.50	OFF
104	3500	100	50	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.50	OFF
105	3500	100	50	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	40	70	0
902	3200	1000	50	70	0
903	3200	1000	60	70	0
904	3200	1000	70	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	150	33	0.000	0.80	0	1.000	300	150	33	0.700	0
202	0	3000	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A1050-2.0**

[Material] C-A1050-2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 2.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	30	0.80	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	60	0.80	4	0.0	0.500	0.110	0	201	0	102	0.00	Standard	No
3	3500	3200	3500	90	0.80	4	0.0	0.500	0.110	0	202	903	102	0.00	Standard	No
4	4000	3200	4000	100	0.80	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
5	4000	3200	4000	100	0.80	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
6	4000	3200	4000	100	0.80	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
7	4000	3200	4000	100	0.80	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
8	4000	3200	4000	100	0.80	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
9	4000	3200	4000	100	0.80	4	0.0	0.500	0.110	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	1000	50	30	0
902	3200	1000	60	30	0
903	3200	1000	70	30	0
904	3200	1000	80	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

Laser Gain Recv. Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	40	0.000	0.80	0	1.000	300	200	40	0.700	0
202	0	3000	2000	100	0.000	0.80	0	1.000	500	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.80	0	3.000	3500	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-A1050-2.0S**

[Material] C-A1050-2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 2.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	40	0.80	4	0.3	0.700	0.120	0	201	0	101	0.20	Standard	No
2	2000	3500	1500	80	0.80	4	0.0	0.500	0.120	0	201	902	102	0.00	Standard	No
3	3000	3500	3000	90	0.80	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
4	3500	3500	3500	100	0.80	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
5	3500	3500	3500	100	0.80	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
6	3500	3500	3500	100	0.80	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
7	3500	3500	3500	100	0.80	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
8	3500	3500	3500	100	0.80	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
9	3500	3500	3500	100	0.80	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	50	0	0	0.000	0	0.400	0.25	4	0.3	5.000	-3.00	OFF
102	3500	100	50	0	0	0.000	0	0.300	0.35	4	0.0	5.000	-3.00	OFF
103	3500	100	50	0	0	0.000	0	0.300	0.35	4	0.0	5.000	-3.00	OFF
104	3500	100	50	0	0	0.000	0	0.300	0.35	4	0.0	5.000	-3.00	OFF
105	3500	100	50	0	0	0.000	0	0.300	0.35	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	40	70	0
902	3500	1000	50	70	0
903	3500	1000	60	70	0
904	3500	1000	70	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	40	0.000	0.80	0	1.000	200	100	40	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	3500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	3500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	3500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	3500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	3500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	3500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	3500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
			Pie.	Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-2.5

[Material] C-A1050-2.5 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 2.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	200	40	0.85	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1000	3000	1200	65	0.85	4	0.0	0.300	0.120	0	201	0	102	0.00	Standard	No
3	3000	3500	3000	100	0.85	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
4	3500	3500	3500	100	0.85	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
5	3500	3500	3500	100	0.85	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
6	3500	3500	3500	100	0.85	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
7	3500	3500	3500	100	0.85	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
8	3500	3500	3500	100	0.85	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
9	3500	3500	3500	100	0.85	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	40	70	0
902	3500	200	50	70	0
903	3500	200	60	70	0
904	3500	200	70	70	0
905	0	200	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3300	2000	100	0.80	4	4.00	700	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	45	0.000	0.80	4	1.500	100	200	45	1.500	0
202	0	3500	2000	100	0.000	0.85	4	2.000	200	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.85	0	3.000	2300	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.85	0	3.000	2300	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.85	0	3.000	2300	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.85	0	3.000	2300	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.85	0	3.000	2300	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.85	0	3.000	2300	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.85	0	3.000	2300	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.85	0	3.000	2300	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A1050-2.5S**

[Material] C-A1050-2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 2.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	200	35	0.85	4	0.3	0.700	0.130	0	201	0	101	-0.70	Standard	No
2	1000	3500	1500	60	0.85	4	0.0	0.300	0.130	0	201	0	101	0.00	Standard	No
3	2500	3500	2000	90	0.85	4	0.0	0.300	0.130	0	202	902	102	0.00	Standard	No
4	3000	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
5	3000	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
6	3000	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
7	3000	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
8	3000	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
9	3000	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	50	0	0	0.000	0	0.500	0.25	4	0.3	5.000	-2.00	OFF
102	3500	100	50	0	0	0.000	0	0.500	0.25	4	0.3	5.000	-2.00	OFF
103	3500	100	30	0	0	0.000	0	0.500	0.20	1	0.5	5.000	-2.00	OFF
104	3500	100	30	0	0	0.000	0	0.500	0.20	1	0.5	5.000	-2.00	OFF
105	3500	100	30	0	0	0.000	0	0.500	0.20	1	0.5	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	50	70	0
902	3500	1000	60	70	0
903	3500	1000	70	70	0
904	3500	1000	80	70	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.80	4	4.00	700	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	40	0.000	0.80	4	1.500	100	100	40	1.500	0
202	0	3500	2000	100	0.000	0.85	0	3.000	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.85	0	3.000	2000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

### C-A1050-3.0

[Material] C-A1050-3.0 [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 3.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	200	40	0.95	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1000	3000	1200	65	0.95	4	0.0	0.300	0.120	0	201	0	102	0.00	Standard	No
3	2300	3500	2300	100	0.95	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
4	2500	3500	2500	100	0.95	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
5	2500	3500	2500	100	0.95	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
6	2500	3500	2500	100	0.95	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
7	2500	3500	2500	100	0.95	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
8	2500	3500	2500	100	0.95	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
9	2500	3500	2500	100	0.95	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	40	70	0
902	3500	200	50	70	0
903	3500	200	60	70	0
904	3500	200	70	70	0
905	0	200	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3300	2000	100	0.95	4	4.00	700	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	45	0.000	0.80	4	1.500	100	200	45	1.500	0
202	0	3500	2000	100	0.000	0.95	4	2.000	200	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	2300	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-3.0S

[Material] C-A1050-3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 3.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	200	35	0.85	4	0.3	0.700	0.130	0	201	0	101	-0.70	Standard	No
2	1000	3500	1500	60	0.85	4	0.0	0.300	0.130	0	201	0	101	0.00	Standard	No
3	2000	3500	2000	90	0.85	4	0.0	0.300	0.130	0	202	902	102	0.00	Standard	No
4	2500	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
5	2500	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
6	2500	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
7	2500	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
8	2500	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
9	2500	3500	2500	100	0.85	4	0.0	0.300	0.130	0	202	903	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	50	0	0	0.000	0	0.500	0.25	4	0.3	5.000	-2.00	OFF
102	3500	100	50	0	0	0.000	0	0.500	0.25	4	0.3	5.000	-2.00	OFF
103	3500	100	30	0	0	0.000	0	0.500	0.20	1	0.5	5.000	-2.00	OFF
104	3500	100	30	0	0	0.000	0	0.500	0.20	1	0.5	5.000	-2.00	OFF
105	3500	100	30	0	0	0.000	0	0.500	0.20	1	0.5	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	50	60	0
902	3500	1000	60	60	0
903	3500	1000	70	60	0
904	3500	1000	80	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.85	4	4.00	700	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	40	0.000	0.80	4	1.500	100	100	40	1.500	0
202	0	3500	2000	100	0.000	0.85	0	3.000	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.85	0	3.000	2000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.85	0	3.000	2500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-4.0S

[Material] C-A1050-4.0S [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 4.00 [CutWay] Aluminium [NzlType] D\*:\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	200	45	0.70	4	0.0	1.500	0.140	0	201	0	101	-1.00	Standard	No
2	1000	3500	1500	65	0.70	4	0.0	0.300	0.140	0	201	901	101	0.00	Standard	No
3	1500	3500	1500	90	0.70	4	0.0	0.300	0.140	0	202	903	102	0.00	Standard	No
4	2000	3500	2000	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
5	2300	3500	2300	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
6	2000	3500	2000	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
7	2000	3500	2000	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
8	2000	3500	2000	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
9	2000	3500	2000	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	70	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	70	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-1.50	OFF
103	3500	100	30	0	0	0.000	0	2.000	0.20	1	0.5	5.000	-1.50	OFF
104	3500	100	30	0	0	0.000	0	2.000	0.20	1	0.5	5.000	-1.50	OFF
105	3500	100	30	0	0	0.000	0	2.000	0.20	1	0.5	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	40	60	0
902	3500	1000	50	60	0
903	3500	1000	60	60	0
904	3500	1000	70	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	4	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	60	0.000	0.50	4	1.500	100	300	60	2.000	0
202	0	3500	100	100	0.000	0.70	0	3.000	500	100	100	0.700	0
203	120	3500	1500	90	0.000	0.70	0	3.000	1500	1500	90	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	2000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A1050-5.0S**

[Material] C-A1050-5.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A1050 [Thic] 5.00 [CutWay] Aluminium [NzlType] D\*:AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	200	60	0.80	4	0.0	1.000	0.140	0	201	0	101	-1.00	Standard	No
2	1000	3500	1000	80	0.80	4	0.0	0.700	0.140	0	201	0	101	0.00	Standard	No
3	1200	3500	1500	100	0.80	4	0.0	0.300	0.140	0	202	903	102	0.00	Standard	No
4	1500	3500	1500	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
5	1500	3500	1500	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
6	1500	3500	1500	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
7	1500	3500	1500	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
8	1500	3500	1500	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
9	1500	3500	1500	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	80	0	0	0.000	0	1.500	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	80	0	0	0.000	0	1.500	0.25	4	0.3	5.000	-1.50	OFF
103	3500	100	50	0	0	0.000	0	1.500	0.20	1	0.5	5.000	-1.50	OFF
104	3500	100	50	0	0	0.000	0	1.500	0.20	1	0.5	5.000	-1.50	OFF
105	3500	100	50	0	0	0.000	0	1.500	0.20	1	0.5	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	30	60	0
902	3500	1000	40	60	0
903	3500	1000	50	60	0
904	3500	1000	60	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	400	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	200	80	0.000	0.60	4	2.000	50	200	80	1.500	0
202	0	3500	1500	100	0.000	0.60	4	3.000	200	1500	100	0.700	0
203	120	3500	1500	100	0.000	0.80	0	3.000	1000	1500	100	0.000	0
204	120	3500	1500	100	0.000	0.80	0	3.000	1000	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.80	0	3.000	1000	1500	100	0.000	0
206	120	3500	1500	100	0.000	0.80	0	3.000	1000	1500	100	0.000	0
207	120	3500	1500	100	0.000	0.80	0	3.000	1000	1500	100	0.000	0
208	120	3500	1500	100	0.000	0.80	0	3.000	1000	1500	100	0.000	0
209	120	3500	1500	100	0.000	0.80	0	3.000	1000	1500	100	0.000	0
210	120	3500	1500	100	0.000	0.80	0	3.000	1000	1500	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-A1050-6.0S

[Material] C-A1050-6.0S [Oscillator] AF35LCG0EU-001  
 [Quality] A1050 [Thic] 6.00 [CutWay] Aluminium [NzlType] D\*:\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	200	75	0.80	4	0.3	1.500	0.140	0	201	0	101	-1.00	Standard	No
2	600	3500	1000	85	0.90	4	0.0	0.300	0.140	0	202	0	102	0.00	Standard	No
3	800	3500	1000	100	0.90	4	0.0	0.300	0.140	0	202	903	102	0.00	Standard	No
4	1000	3500	1500	100	0.90	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
5	1000	3500	1500	100	0.90	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
6	1000	3500	1500	100	0.90	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
7	1000	3500	1500	100	0.90	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
8	1000	3500	1500	100	0.90	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
9	1000	3500	1500	100	0.90	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	60	0	0	0.000	0	2.000	0.20	1	0.5	5.000	-1.50	OFF
102	3500	100	60	0	0	0.000	0	2.000	0.20	1	0.5	5.000	-1.50	OFF
103	3500	100	60	0	0	0.000	0	2.000	0.20	1	0.5	5.000	-1.50	OFF
104	3500	100	60	0	0	0.000	0	2.000	0.20	1	0.5	5.000	-1.50	OFF
105	3500	100	60	0	0	0.000	0	2.000	0.20	1	0.5	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	40	60	0
902	3500	1000	50	60	0
903	3500	1000	60	60	0
904	3500	1000	70	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	200	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	200	95	0.000	0.60	4	2.000	50	200	95	1.500	0
202	0	3500	1500	100	0.000	0.60	4	3.000	200	1500	100	0.700	0
203	120	3500	1500	100	0.000	0.90	0	3.000	1000	1500	100	0.000	0
204	120	3500	1500	100	0.000	0.90	0	3.000	1000	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.90	0	3.000	1000	1500	100	0.000	0
206	120	3500	1500	100	0.000	0.90	0	3.000	1000	1500	100	0.000	0
207	120	3500	1500	100	0.000	0.90	0	3.000	1000	1500	100	0.000	0
208	120	3500	1500	100	0.000	0.90	0	3.000	1000	1500	100	0.000	0
209	120	3500	1500	100	0.000	0.90	0	3.000	1000	1500	100	0.000	0
210	120	3500	1500	100	0.000	0.90	0	3.000	1000	1500	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-A5052-0.5**

[Material] C-A5052-0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	15000	3500	15000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	15000	3500	15000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	15000	3500	15000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	15000	3500	15000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	15000	3500	15000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	15000	3500	15000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	40	30	0
902	3500	3000	50	30	0
903	3500	3000	60	30	0
904	3500	3000	70	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-0.5HS**

[Material] C-A5052-0.5HS [Oscillator] AF35LCG0EU-001  
 [Quality] A5052 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.80	4	0.3	1.500	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.80	4	0.0	1.500	0.110	0	201	0	105	0.00	Medium	No
3	32000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
4	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
5	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
6	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
7	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
8	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
9	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	10	30	0
902	3500	1000	20	30	0
903	3500	1000	25	30	0
904	3500	1000	30	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.80	0	1.000	300	200	25	0.000	0
202	0	3000	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-0.5S**

[Material] C-A5052-0.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	15000	3500	15000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-4.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-4.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-4.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-4.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	4	0.0	5.000	-4.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	20	50	0
902	3500	3000	30	50	0
903	3500	3000	40	50	0
904	3500	3000	50	50	0
905	0	3000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-0.8**

[Material] C-A5052-0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	12000	3500	12000	100	0.60	4	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	15000	3500	15000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	40	30	0
902	3500	3000	50	30	0
903	3500	3000	60	30	0
904	3500	3000	70	30	0
905	0	3000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-0.8HS**

[Material] C-A5052-0.8HS [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.80	4	0.3	1.500	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.80	4	0.0	1.500	0.110	0	201	0	105	0.00	Medium	No
3	22000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	902	105	0.00	Medium	No
4	25000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
5	25000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	904	105	0.00	Medium	No
6	25000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
7	25000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
8	25000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
9	25000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	10	30	0
902	3500	1000	20	30	0
903	3500	1000	25	30	0
904	3500	1000	30	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.80	0	1.000	300	200	25	0.000	0
202	0	3000	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-0.8S**

[Material] C-A5052-0.8S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 0.80 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	12000	3500	12000	100	0.60	4	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	4	0.0	5.000	-3.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	20	50	0
902	3500	3000	30	50	0
903	3500	3000	40	50	0
904	3500	3000	50	50	0
905	0	3000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-1.0**

[Material] C-A5052-1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	9000	3500	9000	100	0.60	4	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	14000	3500	14000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	40	30	0
902	3500	3000	50	30	0
903	3500	3000	60	30	0
904	3500	3000	70	30	0
905	0	3000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-1.0HS**

[Material] C-A5052-1.0HS [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.80	4	0.3	1.500	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.80	4	0.0	1.500	0.110	0	201	0	105	0.00	Medium	No
3	32000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
4	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
5	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
6	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
7	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
8	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
9	35000	3500	20000	100	0.80	4	0.0	1.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	1000	10	30	0
902	3000	1000	20	30	0
903	3500	1000	25	30	0
904	3500	1000	30	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.80	0	1.000	300	200	25	0.000	0
202	0	3000	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-A5052-1.0S**

[Material] C-A5052-1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	9000	3500	9000	100	0.60	4	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	12000	3500	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	13000	3500	13000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	12000	3500	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	12000	3500	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	12000	3500	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	12000	3500	12000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.60	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	20	50	0
902	3500	3000	30	50	0
903	3500	3000	40	50	0
904	3500	3000	50	50	0
905	0	3000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.60	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-1.2**

[Material] C-A5052-1.2 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.20 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	300	15	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	40	0.60	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	9000	3500	9000	100	0.60	4	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	10000	3500	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	10000	3500	10000	100	0.60	4	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
6	10000	3500	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	10000	3500	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	10000	3500	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	10000	3500	10000	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	20	30	0
902	3500	3000	30	30	0
903	3500	3000	40	30	0
904	3500	3000	50	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-1.2S**

[Material] C-A5052-1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.20 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	300	15	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	40	0.60	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	8500	3500	8500	100	0.60	4	0.0	0.500	0.110	0	202	902	105	0.00	Medium	No
4	9500	3500	9500	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	9500	3500	9500	100	0.60	4	0.0	0.500	0.110	0	202	904	105	0.00	Medium	No
6	9500	3500	9500	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	9500	3500	9500	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	9500	3500	9500	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	9500	3500	9500	100	0.60	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	3000	20	50	0
902	3500	3000	30	50	0
903	3500	3000	40	50	0
904	3500	3000	50	50	0
905	0	3000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2800	2000	100	0.80	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.60	0	1.000	300	200	25	0.700	0
202	0	3000	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	9000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-1.5**

[Material] C-A5052-1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.65	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.65	4	0.0	0.500	0.110	0	201	0	105	0.00	Medium	No
3	8000	3500	8000	90	0.65	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
4	9000	3500	9000	100	0.65	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
5	9000	3500	9000	100	0.65	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
6	9000	3500	9000	100	0.65	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
7	9000	3500	9000	100	0.65	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
8	9000	3500	9000	100	0.65	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
9	9000	3500	9000	100	0.65	4	0.0	0.500	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	30	30	0
902	3500	1000	40	30	0
903	3500	1000	50	30	0
904	3500	1000	60	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.65	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.65	0	1.000	300	200	30	0.700	0
202	0	3500	2000	100	0.000	0.65	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.65	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.65	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.65	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.65	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.65	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.65	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.65	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.65	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-1.5S**

[Material] C-A5052-1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 1.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	20	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.60	4	0.0	0.300	0.110	0	201	0	105	0.00	Medium	No
3	8000	3500	8000	100	0.60	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
4	9000	3500	9000	100	0.60	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
5	9000	3500	9000	100	0.60	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
6	9000	3500	9000	100	0.60	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
7	9000	3500	9000	100	0.60	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
8	9000	3500	9000	100	0.60	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
9	9000	3500	9000	100	0.60	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	30	30	0
902	3500	1000	40	30	0
903	3500	1000	50	30	0
904	3500	1000	60	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.60	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.60	0	1.000	300	200	30	0.700	0
202	0	3500	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-2.0**

[Material] C-A5052-2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 2.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	25	0.80	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	65	0.80	4	0.0	0.300	0.110	0	201	0	105	0.00	Medium	No
3	7000	3500	7000	100	0.80	4	0.0	0.300	0.110	0	202	903	105	0.00	Medium	No
4	7500	3500	7500	100	0.80	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
5	7500	3500	7500	100	0.80	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
6	7500	3500	7500	100	0.80	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
7	7500	3500	7500	100	0.80	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
8	7500	3500	7500	100	0.80	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
9	7500	3500	7500	100	0.80	4	0.0	0.300	0.110	0	202	904	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	30	40	0
902	3500	1000	40	40	0
903	3500	1000	50	40	0
904	3500	1000	70	40	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

Laser Gain Recv. Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.80	0	1.000	300	200	35	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	4700	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	4700	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	4700	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	4700	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	4700	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	4700	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	4700	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-2.0S**

[Material] C-A5052-2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 2.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	300	25	0.60	4	0.3	0.700	0.110	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	65	0.60	4	0.0	0.300	0.110	0	201	0	105	0.00	Medium	No
3	6500	3500	6500	90	0.60	4	0.0	0.300	0.110	0	202	902	105	0.00	Medium	No
4	7500	3500	7500	100	0.60	4	0.0	0.300	0.110	0	202	903	105	0.00	Medium	No
5	7500	3500	7500	100	0.60	4	0.0	0.300	0.110	0	202	903	105	0.00	Medium	No
6	7500	3500	7500	100	0.60	4	0.0	0.300	0.110	0	202	903	105	0.00	Medium	No
7	7500	3500	7500	100	0.60	4	0.0	0.300	0.110	0	202	903	105	0.00	Medium	No
8	7500	3500	7500	100	0.60	4	0.0	0.300	0.110	0	202	903	105	0.00	Medium	No
9	7500	3500	7500	100	0.60	4	0.0	0.300	0.110	0	202	903	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	1000	30	30	0
902	3500	1000	40	30	0
903	3500	1000	50	30	0
904	3500	1000	60	30	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.60	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.60	0	1.000	300	200	35	0.700	0
202	0	3500	2000	100	0.000	0.60	0	1.000	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	4700	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

### C-A5052-2.5

[Material] C-A5052-2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 2.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	200	30	0.90	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1000	3000	1200	65	0.90	4	0.0	0.300	0.120	0	201	0	105	0.00	Medium	No
3	3500	3500	3500	90	0.90	4	0.0	0.300	0.120	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
5	4000	3500	4000	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
6	4000	3500	4000	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
7	4000	3500	4000	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
8	4000	3500	4000	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
9	4000	3500	4000	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	200	50	60	0
904	3500	200	60	60	0
905	0	200	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3300	2000	100	0.80	4	4.00	1000	4.000

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3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	35	0.000	0.90	0	1.000	100	200	35	1.500	0
202	0	3300	2000	100	0.000	0.90	0	1.500	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.90	0	3.000	2700	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-A5052-2.5S**

[Material] C-A5052-2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 2.50 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	25	0.80	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3500	800	40	0.80	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	4500	3500	4000	90	0.80	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	5000	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	5000	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	5000	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	5000	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	5000	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	5000	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-2.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	4	0.0	5.000	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	200	50	60	0
904	3500	200	60	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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 Mont.

7 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.80	0	1.000	300	200	35	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.500	400	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-3.0**

[Material] C-A5052-3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 3.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] ON [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	200	30	0.90	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1000	3000	1200	65	0.90	4	0.0	0.300	0.120	0	201	0	105	0.00	Medium	No
3	3000	3500	3000	90	0.90	4	0.0	0.300	0.120	0	202	903	105	0.00	Medium	No
4	3500	3500	3500	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
5	3500	3500	3500	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
6	3500	3500	3500	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
7	3500	3500	3500	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
8	3500	3500	3000	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
9	3500	3500	3500	100	0.90	4	0.0	0.300	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	200	50	60	0
904	3500	200	60	60	0
905	0	200	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3300	2000	100	0.90	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	35	0.000	0.90	0	1.000	100	200	35	1.500	0
202	0	2800	2000	100	0.000	0.90	0	1.500	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.90	0	3.000	2700	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-3.0S**

[Material] C-A5052-3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 3.00 [CutWay] Aluminium [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] ON [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	25	0.80	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3500	800	40	0.80	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	4000	3500	4000	90	0.80	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	4500	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	4500	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	4500	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	4500	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	4500	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	4500	3500	4000	100	0.80	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-2.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	4	0.0	5.000	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	200	50	60	0
904	3500	200	60	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	35	0.000	0.80	0	1.000	300	200	35	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.500	400	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-4.0S**

[Material] C-A5052-4.0S [Oscillator] AF35LCG0EU-001  
 [Quality] A5052 [Thic] 4.00 [CutWay] Aluminium [NzlType] D\*:\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	200	30	0.60	4	0.0	1.500	0.140	0	201	0	101	-0.70	Standard	No
2	1000	3500	600	50	0.60	4	0.0	0.500	0.140	0	201	901	102	0.00	Standard	No
3	3000	3500	1500	90	0.60	4	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
4	3500	3500	2000	100	0.60	4	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
5	3500	3500	2000	100	0.60	4	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
6	3500	3500	2000	100	0.60	4	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
7	3500	3500	2000	100	0.60	4	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
8	3000	3500	1500	90	0.60	4	0.0	0.500	0.140	0	202	903	102	0.00	Standard	No
9	3500	3500	2000	100	0.60	4	0.0	0.500	0.140	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	60	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	60	0	0	0.000	0	1.000	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	60	0	0	0.000	0	1.000	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	60	0	0	0.000	0	1.000	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.100	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	500	40	60	0
902	3500	500	50	60	0
903	3500	500	70	60	0
904	3500	500	70	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.60	4	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	150	51	0.000	0.60	4	1.300	150	150	51	1.500	0
202	0	3500	100	100	0.000	0.60	0	2.000	800	100	100	0.700	0
203	120	3500	1500	90	0.000	0.60	0	3.000	1200	1500	90	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	1200	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-5.0S**

[Material] C-A5052-5.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 5.00 [CutWay] Aluminium [NzlType] D\*\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	40	0.70	4	0.0	1.000	0.140	0	201	0	101	-1.00	Standard	No
2	1000	3500	600	60	0.70	4	0.0	0.700	0.140	0	201	0	101	0.00	Standard	No
3	1800	3500	2000	90	0.70	4	0.0	0.300	0.140	0	202	903	102	0.00	Standard	No
4	2500	3500	2500	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
5	2500	3500	2500	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
6	2500	3500	2500	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
7	2500	3500	2500	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
8	2500	3500	2500	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
9	2500	3500	2500	100	0.70	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	60	0	0	0.000	0	1.000	0.20	4	0.5	5.000	-1.50	OFF
102	3500	100	60	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-1.50	OFF
103	3500	100	60	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-1.50	OFF
104	3500	100	60	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-1.50	OFF
105	3500	100	60	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	500	40	60	0
902	3500	500	50	60	0
903	3500	500	60	60	0
904	3500	500	70	60	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	100	0.70	4	4.00	400	4.000

Laser Gain Recv.  
 Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	200	60	0.000	0.60	4	1.500	100	200	60	1.500	0
202	0	3500	1500	100	0.000	0.70	0	2.500	500	1500	100	0.700	0
203	120	3500	1500	90	0.000	0.70	0	3.000	1000	1500	90	0.000	0
204	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
206	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
207	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
208	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
209	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0
210	120	3500	1500	100	0.000	0.70	0	3.000	1000	1500	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-6.0S**

[Material] C-A5052-6.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 6.00 [CutWay] Aluminium [NzlType] D\*:\*AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	55	0.80	4	0.0	1.000	0.140	0	201	0	101	-1.00	Standard	No
2	700	3500	700	65	0.80	4	0.0	0.700	0.140	0	201	0	101	0.00	Standard	No
3	1700	3500	2000	90	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
4	2000	3500	2000	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
5	2000	3500	2000	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
6	2000	3500	2000	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
7	2000	3500	2000	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
8	2000	3500	2000	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
9	2000	3500	2000	100	0.80	4	0.0	0.300	0.140	0	202	904	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	1.500	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	1.500	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	1.500	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	1.500	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	1.500	0.35	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	500	40	50	0
902	3500	500	50	50	0
903	3500	500	60	50	0
904	3500	500	80	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	100	0.80	4	4.00	300	4.000

Laser Gain Recv. Mont.

3 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	65	0.000	0.50	4	2.000	100	100	65	2.000	0
202	0	3500	1500	100	0.000	0.80	0	3.000	300	1500	100	0.700	0
203	120	3500	1500	90	0.000	0.80	0	3.000	800	1500	90	0.000	0
204	120	3500	1500	100	0.000	0.80	0	3.000	800	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.80	0	3.000	800	1500	100	0.000	0
206	120	3500	1500	100	0.000	0.80	0	3.000	800	1500	100	0.000	0
207	120	3500	1500	100	0.000	0.80	0	3.000	800	1500	100	0.000	0
208	120	3500	1500	100	0.000	0.80	0	3.000	800	1500	100	0.000	0
209	120	3500	1500	100	0.000	0.80	0	3.000	800	1500	100	0.000	0
210	120	3500	1500	100	0.000	0.80	0	3.000	800	1500	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-A5052-8.0S**

[Material] C-A5052-8.0S [Oscillator] AF35LGG0EU-001  
 [Quality] A5052 [Thic] 8.00 [CutWay] Aluminium [NzlType] D\*:AL [Head] Standard  
 [Foc] -2.0 [Reflect.] ON [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 7 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	100	3500	200	70	0.90	4	0.0	1.500	0.150	0	201	0	101	0.00	Standard	No
2	700	3500	500	85	0.90	4	0.0	0.300	0.150	0	202	0	102	0.00	Standard	No
3	800	3500	500	90	0.90	4	0.0	0.300	0.150	0	202	0	102	0.00	Standard	No
4	1200	3500	1200	100	0.90	4	0.0	0.300	0.150	0	202	0	102	0.00	Standard	No
5	1200	3500	1200	100	0.90	4	0.0	0.300	0.150	0	202	0	102	0.00	Standard	No
6	1200	3500	1200	100	0.90	4	0.0	0.300	0.150	0	202	0	102	0.00	Standard	No
7	1200	3500	1200	100	0.90	4	0.0	0.300	0.150	0	202	0	102	0.00	Standard	No
8	1200	3500	1200	100	0.90	4	0.0	0.300	0.150	0	202	0	102	0.00	Standard	No
9	1200	3500	1200	100	0.90	4	0.0	0.300	0.150	0	202	0	102	0.00	Standard	No
(Etch)																
10	20000	0	1000	0	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	80	0	0	0.000	0	3.000	0.20	1	0.5	5.000	-1.50	OFF
102	3500	100	80	0	0	0.000	0	3.000	0.20	1	0.5	5.000	-1.50	OFF
103	3500	100	80	0	0	0.000	0	3.000	0.20	1	0.5	5.000	-1.50	OFF
104	3500	100	80	0	0	0.000	0	3.000	0.20	1	0.5	5.000	-1.50	OFF
105	3500	100	80	0	0	0.000	0	3.000	0.20	1	0.5	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	5.0	0	Trace	No	0
OFF	OFF	5.0	0	Trace	No	0
OFF	OFF	5.0	0	Trace	No	0
OFF	OFF	5.0	0	Trace	No	0
OFF	OFF	5.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	500	40	50	0
902	3500	500	50	50	0
903	3500	500	60	50	0
904	3500	500	70	50	0
905	0	1000	0	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	500	100	0.90	4	4.00	100	4.000

Laser Gain Recv.  
 Mont.

3 0

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	200	90	0.000	0.50	4	2.000	70	200	90	2.000	0
202	0	3500	750	85	0.000	0.70	4	4.000	200	750	85	2.000	0
203	120	3500	750	85	0.000	0.90	0	4.000	200	750	85	0.000	0
204	120	3500	750	85	0.000	0.90	0	4.000	200	750	85	0.000	0
205	120	3500	750	85	0.000	0.90	0	4.000	200	750	85	0.000	0
206	120	3500	750	85	0.000	0.90	0	4.000	200	750	85	0.000	0
207	120	3500	750	85	0.000	0.90	0	4.000	200	750	85	0.000	0
208	120	3500	750	85	0.000	0.90	0	4.000	200	750	85	0.000	0
209	120	3500	750	85	0.000	0.90	0	4.000	200	750	85	0.000	0
210	120	3500	750	85	0.000	0.90	0	4.000	200	750	85	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC0.5**

[Material] C-SECC0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	10000	3300	10000	90	0.70	4	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	11000	3300	11000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	12000	3300	12000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	11000	3300	11000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	11000	3300	11000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	11000	3300	11000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	11000	3300	11000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	4	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	20	30	0
902	3000	200	30	30	0
903	3300	200	30	30	0
904	3300	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3300	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3300	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3300	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3300	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3300	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3300	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3300	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3300	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3300	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-SECC0.5HS**

[Material] C-SECC0.5HS [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	200	10	0.70	4	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3500	800	35	0.70	4	0.0	1.500	0.120	0	201	903	105	0.00	Medium	No
3	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	33000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.10	4	0.0	1.000	0.000	0	0	0	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	3500	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC0.8**

[Material] C-SECC0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	9000	3300	9000	90	0.70	4	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	10500	3300	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	11000	3500	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	10500	3300	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	10500	3300	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	10500	3300	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	10500	3300	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	30	0
902	3000	200	30	30	0
903	3500	200	30	30	0
904	3500	200	30	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC0.8HS**

[Material] C-SECC0.8HS [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	200	10	0.70	4	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3500	800	35	0.70	4	0.0	1.500	0.120	0	201	903	105	0.00	Medium	No
3	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.10	4	0.0	1.000	0.000	0	0	0	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC1.0**

[Material] C-SECC1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	9000	3500	9000	90	0.70	4	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	10000	3500	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	10500	3500	10500	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	10000	3500	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	10000	3500	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	10000	3500	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	10000	3500	10000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC1.0HS**

[Material] C-SECC1.0HS [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	200	10	0.70	4	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3500	800	35	0.70	4	0.0	1.500	0.120	0	201	903	105	0.00	Medium	No
3	23000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.10	4	0.0	1.000	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC1.0S**

[Material] C-SECC1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	4	0.3	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	35	0.80	4	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	7500	3500	7500	90	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	8000	3500	8000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
5	8500	3500	8500	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	8000	3500	8000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	8000	3500	8000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	8000	3500	8000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	8000	3500	8000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	4	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-4.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-4.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-4.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-4.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-4.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	300	20	30	0
904	3500	300	30	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC1.2**

[Material] C-SECC1.2 [Oscillator] AF35LOG0EU-001  
 [Quality] SECC [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3200	800	35	0.70	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	8000	3200	8000	85	0.70	4	0.0	0.500	0.130	0	202	902	105	0.00	Medium	No
4	8500	3200	8500	100	0.70	4	0.0	0.500	0.130	0	202	902	105	0.00	Medium	No
5	9000	3500	9000	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	8500	3200	8500	100	0.70	4	0.0	0.500	0.130	0	202	902	105	0.00	Medium	No
7	8500	3200	8500	100	0.70	4	0.0	0.500	0.130	0	202	902	105	0.00	Medium	No
8	8500	3200	8500	100	0.70	4	0.0	0.500	0.130	0	202	902	105	0.00	Medium	No
9	8500	3200	8500	100	0.70	4	0.0	0.500	0.130	0	202	902	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	200	10	30	0
902	3200	200	20	30	0
903	3200	200	30	30	0
904	3500	200	30	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC1.2S**

[Material] C-SECC1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	4	0.3	0.500	0.160	0	201	0	101	0.20	Standard	No
2	2000	3500	1000	40	0.80	4	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	6700	3500	6700	90	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	7200	3500	7200	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
5	7500	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	7200	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	7200	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	7200	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	7200	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.80	0	1.000	300	300	25	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-SECC1.5**

[Material] C-SECC1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	12	0.70	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	6000	3500	6000	85	0.70	4	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	6800	3500	6800	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	6800	3500	6800	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	6800	3500	6800	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	6800	3500	6800	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	6800	3500	6800	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	6800	3500	6800	100	0.70	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	15	30	0
902	3000	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	22	0.000	0.70	0	1.000	300	200	22	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	700	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC1.5S**

[Material] C-SECC1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	16	0.80	4	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1500	35	0.80	4	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	5500	3500	5500	90	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
4	6000	3500	6000	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
5	6300	3500	6300	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
6	6000	3500	6000	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
7	6000	3500	6000	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
8	6000	3500	6000	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
9	6000	3500	6000	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	35	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	26	0.000	0.80	0	1.000	300	200	26	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	88	0.000	0.80	0	3.000	4500	2000	88	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC2.0**

[Material] C-SECC2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	25	0.95	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.95	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	5200	3500	5200	90	0.95	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	5700	3500	5700	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	6000	3500	6000	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	5700	3500	5700	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	5700	3500	5700	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	5700	3500	5700	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	5700	3500	5700	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	30	0.000	0.95	0	1.000	250	200	30	0.700	0
202	0	3500	2000	100	0.000	0.95	0	1.500	450	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC2.0S**

[Material] C-SECC2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	4	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	35	0.80	4	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	5200	3500	5200	90	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
4	5700	3500	5700	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
5	6000	3500	6000	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
6	5700	3500	5700	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
7	5700	3500	5700	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
8	5700	3500	5700	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
9	5700	3500	5700	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	40	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1500	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	4	4.00	1000	4.000

Laser Gain Recv. Mont.

6 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	30	0.000	0.80	0	1.000	200	200	30	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	800	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.80	0	3.000	4000	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC2.5**

[Material] C-SECC2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	100	25	0.95	4	0.3	0.500	0.130	0	201	0	101	-0.30	Standard	No
2	2000	3500	800	55	0.95	4	0.0	0.300	0.130	0	201	902	105	0.00	Medium	No
3	3600	4000	3600	70	0.95	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	4000	4000	4000	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	4200	4000	4000	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	4000	4000	4000	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	4000	4000	4000	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	4000	4000	4000	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	4000	4000	4000	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	4	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	20	30	0
902	3500	200	30	30	0
903	4000	200	20	30	0
904	4000	200	30	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	4	4.00	1000	2.000

Laser Gain Recv.  
 Mont.

8 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.80	4	1.000	100	200	30	0.500	0
202	0	3500	2000	100	0.000	0.80	4	1.500	300	2000	100	0.500	0
203	120	3500	2000	80	0.000	0.95	0	3.000	2800	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC2.5S**

[Material] C-SECC2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	100	25	0.90	4	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	65	0.90	4	0.0	0.300	0.170	0	202	902	105	0.00	Medium	No
3	3500	4000	3500	70	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
4	4200	4000	4000	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
5	4500	4000	4000	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
6	4200	4000	4000	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
7	4200	4000	4000	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
8	4200	4000	4000	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
9	4200	4000	4000	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	4	0.0	1.500	0.000	0	0	905	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	20	20	0
902	3500	200	30	20	0
903	4000	200	20	20	0
904	4000	200	30	20	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.90	4	4.00	1000	4.000

Laser Mont.	Gain	Recv.
	6	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	35	0.000	0.90	0	1.000	100	100	35	0.700	0
202	0	3500	1200	85	0.000	0.90	0	1.000	500	1200	85	0.700	0
203	120	3500	2000	90	0.000	0.90	0	3.000	2800	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC3.0**

[Material] C-SECC3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3500	100	25	1.50	4	0.3	0.500	0.130	0	201	0	101	-0.30	Standard	No
2	2000	3500	800	50	1.50	4	0.0	0.300	0.130	0	201	902	105	0.00	Medium	No
3	3000	4000	3000	70	1.50	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	40	60	0
902	3500	200	50	60	0
903	4000	200	50	60	0
904	4000	200	60	60	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	4	4.00	1000	2.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.80	4	1.000	100	200	30	0.500	0
202	0	3500	2000	100	0.000	0.80	4	1.500	300	2000	100	0.500	0
203	120	3500	2000	80	0.000	1.50	0	3.000	2800	2000	80	0.000	0
204	120	3500	2000	100	0.000	1.50	0	3.000	3300	2000	100	0.000	0
205	120	3500	2000	100	0.000	1.50	0	3.000	3300	2000	100	0.000	0
206	120	3500	2000	100	0.000	1.50	0	3.000	3300	2000	100	0.000	0
207	120	3500	2000	100	0.000	1.50	0	3.000	3300	2000	100	0.000	0
208	120	3500	2000	100	0.000	1.50	0	3.000	3300	2000	100	0.000	0
209	120	3500	2000	100	0.000	1.50	0	3.000	3300	2000	100	0.000	0
210	120	3500	2000	100	0.000	1.50	0	3.000	3300	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SECC3.0-2**

[Material] C-SECC3.0-2 [Oscillator] AF35LCG0EU-001  
 [Quality] SECC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	100	25	0.95	4	0.3	0.500	0.130	0	201	0	101	-0.30	Standard	No
2	2000	3500	800	65	0.95	4	0.0	0.300	0.130	0	201	902	105	0.00	Medium	No
3	3000	4000	3000	75	0.95	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	3500	4000	3500	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	3500	4000	3500	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	3500	4000	3500	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	3500	4000	3500	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	3500	4000	3500	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	3500	4000	3500	75	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.10	4	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	40	60	0
902	3500	200	50	60	0
903	4000	200	50	60	0
904	4000	200	60	60	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	4	4.00	1000	2.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.80	4	1.000	100	200	30	0.500	0
202	0	3500	2000	100	0.000	0.80	4	1.500	300	2000	100	0.500	0
203	120	3500	2000	80	0.000	0.95	0	3.000	2800	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-SECC3.0S**

[Material] C-SECC3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -2.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	100	25	0.90	4	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	65	0.90	4	0.0	0.300	0.170	0	202	902	105	0.00	Medium	No
3	3300	4000	3300	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
4	3800	4000	3800	75	0.90	4	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
5	4000	4000	4000	75	0.90	4	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
6	3800	4000	3800	75	0.90	4	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
7	3800	4000	3800	75	0.90	4	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
8	3800	4000	3800	75	0.90	4	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
9	3800	4000	3800	75	0.90	4	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	4	0.0	1.500	0.000	0	0	905	0	2.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-1.00	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.00	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.00	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-1.00	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	4000	200	50	60	0
904	4000	200	60	60	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	35	0.000	0.90	0	1.000	100	100	35	0.700	0
202	0	3500	1200	85	0.000	0.90	0	1.000	500	1200	85	0.700	0
203	120	3500	2000	90	0.000	0.90	0	3.000	2800	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC0.5**

[Material] C-SPC0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.70	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	4	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8500	3500	8500	85	0.70	4	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	12000	3500	10000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	13000	3500	10000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	12000	3500	10000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	12000	3500	10000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	12000	3500	10000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	12000	3500	10000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC0.5HS**

[Material] C-SPC0.5HS [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.80	4	0.0	1.500	0.120	0	201	902	105	0.00	Medium	No
3	27000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	30000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	30000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	30000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	30000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	30000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	30000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-SPC0.8

[Material] C-SPC0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.70	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	4	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8500	3500	8500	85	0.70	4	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	11000	3500	11000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	12000	3500	12000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	11000	3500	11000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	11000	3500	11000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	11000	3500	11000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	11000	3500	11000	100	0.70	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC0.8HS**

[Material] C-SPC0.8HS [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.80	4	0.0	1.500	0.120	0	201	902	105	0.00	Medium	No
3	24000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	27000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	30000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	27000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	27000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	27000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	27000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC1.0**

[Material] C-SPC1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.80	4	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8500	3500	8500	85	0.80	4	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC1.0HS**

[Material] C-SPC1.0HS [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.80	4	0.0	1.500	0.120	0	201	902	105	0.00	Medium	No
3	22000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	25000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	25000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	25000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	25000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	25000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	25000	3500	20000	100	0.80	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	100	0.000	0.80	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-SPC1.0S

[Material] C-SPC1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.80	4	0.3	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	50	0.80	4	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	8000	3500	8000	85	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	9000	3500	9000	100	0.80	4	0.0	0.500	0.160	0	202	904	105	0.00	Medium	No
5	9000	3500	9000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	9000	3500	9000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	9000	3500	9000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	9000	3500	9000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	9000	3500	9000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1250	1000	22	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	300	20	30	0
904	3500	300	30	30	0
905	1250	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6200	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



C-SPC1.2

[Material] C-SPC1.2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.90	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	35	0.90	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	7200	3500	7200	85	0.90	4	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	8000	3500	8000	100	0.90	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	8000	3500	8000	100	0.90	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	8000	3500	8000	100	0.90	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	8000	3500	8000	100	0.90	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	8000	3500	8000	100	0.90	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	8000	3500	8000	100	0.90	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.90	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.90	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.90	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC1.2S**

[Material] C-SPC1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	12	0.80	4	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	50	0.80	4	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	6800	3500	6800	90	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	7500	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	904	105	0.00	Medium	No
5	7500	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	904	105	0.00	Medium	No
6	7500	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	904	105	0.00	Medium	No
7	7500	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	904	105	0.00	Medium	No
8	7500	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	904	105	0.00	Medium	No
9	7500	3500	7500	100	0.80	4	0.0	0.500	0.160	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1250	1000	22	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	25	30	0
904	3500	200	30	30	0
905	1250	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	22	0.000	0.80	0	1.000	300	300	22	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC1.5**

[Material] C-SPC1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	12	0.90	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.90	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	6300	3500	6300	90	0.90	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	7200	3500	7200	100	0.90	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	7500	3500	7500	100	0.90	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	7200	3500	7200	100	0.90	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	7200	3500	7200	100	0.90	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	7200	3500	7200	100	0.90	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	7200	3500	7200	100	0.90	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1200	1000	15	30	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.90	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	22	0.000	0.90	0	1.000	300	200	22	0.700	0
202	0	3500	2000	100	0.000	0.90	0	1.500	700	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.90	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-SPC1.5S

[Material] C-SPC1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	16	0.80	4	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	50	0.80	4	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	5400	3500	5400	85	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	6000	3500	6000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
5	6300	3500	6000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	6000	3500	6000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	6000	3500	6000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	6000	3500	6000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	6000	3500	6000	100	0.80	4	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1250	1000	22	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
105	3500	100	100	0	0	0.000	0	0.020	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1250	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	26	0.000	0.80	0	1.000	300	200	26	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.80	0	3.000	4500	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC2.0**

[Material] C-SPC2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	14	1.00	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	1.00	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	5000	3500	5000	90	1.00	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	5500	3500	5500	100	1.00	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	5500	3500	5500	100	1.00	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	5500	3500	5500	100	1.00	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	5500	3500	5500	100	1.00	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	5500	3500	5500	100	1.00	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	5500	3500	5500	100	1.00	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	1.00	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	1.00	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	1.00	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	1.00	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	1.00	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	1.00	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	1.00	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	1.00	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	1.00	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	1.00	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	1.00	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC2.0-2**

[Material] C-SPC2.0-2 [Oscillator] AF35LCG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.70	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.70	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	5000	3500	5000	90	0.70	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	5500	3500	5500	100	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	6000	3500	5500	100	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	5500	3500	5500	100	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	5500	3500	5500	100	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	5500	3500	5500	100	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	5500	3500	5500	100	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	13	50	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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6 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.70	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC2.0S**

[Material] C-SPC2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	4	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	40	0.80	4	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	5000	3500	5000	90	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
4	5500	3500	5500	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
5	5500	3500	5500	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
6	5500	3500	5500	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
7	5500	3500	5500	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
8	5500	3500	5500	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
9	5500	3500	5500	100	0.80	4	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
105	3500	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	20	0
902	3500	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	30	0.000	0.80	0	1.000	200	200	30	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	800	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.80	0	3.000	4000	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC2.5**

[Material] C-SPC2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	1.40	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3500	800	45	1.40	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	4300	3500	4300	90	1.40	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	4800	3500	4800	100	1.40	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	5000	3500	5000	100	1.40	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	4800	3500	4800	100	1.40	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	4800	3500	4800	100	1.40	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	4800	3500	4800	100	1.40	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	4800	3500	4800	100	1.40	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	15	30	0
902	3500	200	25	30	0
903	3500	200	30	30	0
904	3500	200	35	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	27	0.000	1.40	0	1.000	300	200	27	0.700	0
202	0	3500	2000	100	0.000	1.40	0	1.500	300	2000	100	0.500	0
203	120	3500	2000	100	0.000	1.40	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	1.40	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	1.40	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	1.40	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	1.40	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	1.40	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	1.40	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	1.40	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-SPC2.5-2**

[Material] C-SPC2.5-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.95	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3500	800	45	0.95	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	3600	3500	3600	90	0.95	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	4200	3500	4200	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	4000	3500	4000	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	4000	3500	4000	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	4000	3500	4000	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	4000	3500	4000	100	0.95	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	27	0.000	0.95	0	1.000	300	200	27	0.700	0
202	0	3500	2000	100	0.000	0.95	0	1.500	300	2000	100	0.500	0
203	120	3500	2000	100	0.000	0.95	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	3000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC2.5S**

[Material] C-SPC2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	23	0.90	4	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	40	0.90	4	0.0	0.500	0.170	0	201	902	105	0.00	Medium	No
3	4000	3500	4000	90	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
4	4300	3500	4300	100	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
5	4500	3500	4500	100	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
6	4300	3500	4300	100	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
7	4300	3500	4300	100	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
8	4300	3500	4300	100	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
9	4300	3500	4300	100	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	35	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.200	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.90	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	33	0.000	0.90	0	1.000	200	200	33	0.700	0
202	0	3500	2000	100	0.000	0.90	0	1.000	800	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.90	0	3.000	3600	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC3.0**

[Material] C-SPC3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 13 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	250	3500	100	25	1.60	4	0.3	0.500	0.130	0	201	0	101	0.00	Standard	No
2	1500	3500	800	65	1.60	4	0.0	0.300	0.130	0	201	902	105	0.00	Medium	No
3	3000	4000	3000	70	1.60	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	3500	4000	3500	75	1.60	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	3500	4000	3500	75	1.60	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	3500	4000	3500	75	1.60	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	3500	4000	3500	75	1.60	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	3500	4000	3500	75	1.60	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	3500	4000	3500	75	1.60	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3200	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	20	30	0
902	3500	200	30	30	0
903	4000	200	30	30	0
904	4000	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	80	0.95	4	4.00	1000	2.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	60	0.000	1.00	4	1.000	100	200	60	0.500	0
202	0	3500	2000	100	0.000	1.00	4	1.500	200	2000	100	0.500	0
203	120	3500	2000	100	0.000	1.60	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	1.60	0	3.000	3500	2000	100	0.000	0
205	120	3500	2000	100	0.000	1.60	0	3.000	3500	2000	100	0.000	0
206	120	3500	2000	100	0.000	1.60	0	3.000	3500	2000	100	0.000	0
207	120	3500	2000	100	0.000	1.60	0	3.000	3500	2000	100	0.000	0
208	120	3500	2000	100	0.000	1.60	0	3.000	3500	2000	100	0.000	0
209	120	3500	2000	100	0.000	1.60	0	3.000	3500	2000	100	0.000	0
210	120	3500	2000	100	0.000	1.60	0	3.000	3500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC3.0-2**

[Material] C-SPC3.0-2 [Oscillator] AF35LCG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 13 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	250	3500	100	25	1.50	4	0.3	0.500	0.130	0	201	0	101	0.00	Standard	No
2	1500	3500	800	65	1.50	4	0.0	0.300	0.130	0	201	902	105	0.00	Medium	No
3	3000	4000	3000	70	1.50	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	3500	4000	3500	75	1.50	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3200	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	20	30	0
902	3500	200	30	30	0
903	4000	200	30	30	0
904	4000	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	80	0.95	4	4.00	1000	2.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	60	0.000	1.00	4	1.000	100	200	60	0.500	0
202	0	3500	2000	100	0.000	1.00	4	1.500	200	2000	100	0.500	0
203	120	3500	2000	100	0.000	1.50	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	1.50	0	3.000	3500	2000	100	0.000	0
205	120	3500	2000	100	0.000	1.50	0	3.000	3500	2000	100	0.000	0
206	120	3500	2000	100	0.000	1.50	0	3.000	3500	2000	100	0.000	0
207	120	3500	2000	100	0.000	1.50	0	3.000	3500	2000	100	0.000	0
208	120	3500	2000	100	0.000	1.50	0	3.000	3500	2000	100	0.000	0
209	120	3500	2000	100	0.000	1.50	0	3.000	3500	2000	100	0.000	0
210	120	3500	2000	100	0.000	1.50	0	3.000	3500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC3.0-3**

[Material] C-SPC3.0-3 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 3.00 [Lens] 5"  
 [AC] 13 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	250	3500	100	25	0.70	4	0.3	0.500	0.130	0	201	0	101	0.00	Standard	No
2	1500	3500	800	65	0.70	4	0.0	0.300	0.130	0	201	902	105	0.00	Medium	No
3	3000	4000	3000	70	0.70	4	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	3500	4000	3500	75	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	3500	4000	3500	75	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	3500	4000	3500	75	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	3500	4000	3500	75	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	3500	4000	3500	75	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	3500	4000	3500	75	0.70	4	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	22	0.10	4	0.0	1.500	0.000	0	0	905	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3200	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	20	30	0
902	3500	200	30	30	0
903	4000	200	35	30	0
904	4000	200	45	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	80	0.70	4	4.00	1000	2.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	60	0.000	0.70	4	1.000	100	200	60	0.500	0
202	0	3500	2000	100	0.000	0.70	4	1.500	200	2000	100	0.500	0
203	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC3.0S**

[Material] C-SPC3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	100	30	0.90	4	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	65	0.90	4	0.0	0.300	0.170	0	202	902	105	0.00	Medium	No
3	3000	4000	3000	70	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
4	3500	4000	3500	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
5	3500	4000	3500	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
6	3500	4000	3500	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
7	3500	4000	3500	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
8	3500	4000	3500	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
9	3500	4000	3500	75	0.90	4	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	40	0	0	0.000	0	0.300	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.300	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.300	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.300	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	20	60	0
902	3500	200	30	60	0
903	4000	200	60	60	0
904	4000	200	70	60	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.90	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	45	0.000	0.90	0	1.000	100	100	45	0.700	0
202	0	3500	1500	90	0.000	0.90	0	1.500	300	1500	90	0.700	0
203	120	3500	2000	90	0.000	0.90	0	3.000	2800	2000	90	0.000	0
204	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
205	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
206	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
207	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
208	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
209	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
210	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC4.0S**

[Material] C-SPC4.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 4.00 [CutWay] Clean [NzlType] D\*:C [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	150	35	0.80	4	0.3	0.700	0.170	0	201	0	101	-0.70	Standard	No
2	1000	3500	700	50	0.80	4	0.3	0.500	0.170	0	201	0	102	0.00	Standard	No
3	2400	4000	2000	70	0.80	4	0.0	0.300	0.170	0	202	903	102	0.00	Standard	No
4	2700	4000	2000	75	0.80	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
5	3000	4000	2000	75	0.80	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
6	2700	4000	2000	75	0.80	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
7	2700	4000	2000	75	0.80	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
8	2700	4000	2000	75	0.80	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
9	2700	4000	2000	75	0.80	4	0.0	0.300	0.170	0	202	904	105	0.00	Standard	No
(Etch)																
10	8000	1200	1000	25	0.10	4	0.0	1.500	0.000	0	0	905	0	1.50	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	400	30	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	0.500	0.35	4	0.0	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	0.500	0.35	4	0.0	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	0.500	0.35	4	0.0	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	0.080	0.40	4	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	300	40	60	0
902	3500	300	50	60	0
903	4000	300	50	60	0
904	4000	300	60	60	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.80	4	4.00	700	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	42	0.000	0.80	4	1.300	100	100	42	1.000	0
202	0	3500	1500	90	0.000	0.80	4	2.000	200	1500	100	0.700	0
203	120	3500	1500	90	0.000	0.80	0	3.000	1800	1500	90	0.000	0
204	120	3500	1500	90	0.000	0.80	0	3.000	1800	1500	90	0.000	0
205	120	3500	1500	90	0.000	0.80	0	3.000	1800	1500	90	0.000	0
206	120	3500	1500	90	0.000	0.80	0	3.000	1800	1500	90	0.000	0
207	120	3500	1500	90	0.000	0.80	0	3.000	1800	1500	90	0.000	0
208	120	3500	1500	90	0.000	0.80	0	3.000	1800	1500	90	0.000	0
209	120	3500	1500	90	0.000	0.80	0	3.000	1800	1500	90	0.000	0
210	120	3500	1500	90	0.000	0.80	0	3.000	1800	1500	90	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC5.0S**

[Material] C-SPC5.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 5.00 [CutWay] Clean [NzlType] D\*:\*C [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	150	35	0.90	4	0.3	0.700	0.170	0	201	0	101	-0.70	Standard	No
2	1000	3500	700	50	0.90	4	0.3	0.500	0.170	0	201	0	102	0.00	Standard	No
3	1900	4000	2000	70	0.90	4	0.0	0.300	0.170	0	202	903	102	0.00	Standard	No
4	2200	4000	2000	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
5	2200	4000	2000	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
6	2200	4000	2000	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
7	2200	4000	2000	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
8	2200	4000	2000	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
9	2200	4000	2000	75	0.90	4	0.0	0.300	0.170	0	202	904	105	0.00	Standard	No
(Etch)																
10	8000	1200	1000	25	0.10	4	0.0	1.500	0.000	0	0	905	0	2.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	400	30	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.500	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.500	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.500	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.080	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	300	40	60	0
902	3500	300	50	60	0
903	4000	300	50	60	0
904	4000	300	60	60	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.80	4	4.00	700	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	42	0.000	0.90	4	1.300	100	100	42	1.000	0
202	0	3500	1500	90	0.000	0.90	4	2.000	200	1500	100	0.700	0
203	120	3500	1500	90	0.000	0.90	0	3.000	1800	1500	90	0.000	0
204	120	3500	1500	90	0.000	0.90	0	3.000	1800	1500	90	0.000	0
205	120	3500	1500	90	0.000	0.90	0	3.000	1800	1500	90	0.000	0
206	120	3500	1500	90	0.000	0.90	0	3.000	1800	1500	90	0.000	0
207	120	3500	1500	90	0.000	0.90	0	3.000	1800	1500	90	0.000	0
208	120	3500	1500	90	0.000	0.90	0	3.000	1800	1500	90	0.000	0
209	120	3500	1500	90	0.000	0.90	0	3.000	1800	1500	90	0.000	0
210	120	3500	1500	90	0.000	0.90	0	3.000	1800	1500	90	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-SPC6.0S**

[Material] C-SPC6.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 6.00 [CutWay] Clean [NzlType] D\*:C [Head] Standard  
 [Foc] -2.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	35	0.90	4	0.3	0.700	0.170	0	201	0	101	-0.70	Standard	No
2	800	3500	1000	45	0.90	4	0.0	0.500	0.170	0	201	0	102	0.00	Standard	No
3	1600	4000	1200	70	0.90	4	0.0	0.300	0.170	0	202	903	102	0.00	Standard	No
4	2000	4000	1500	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
5	2100	4000	1500	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
6	2000	4000	1500	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
7	2000	4000	1500	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
8	2000	4000	1500	75	0.90	4	0.0	0.300	0.170	0	202	904	102	0.00	Standard	No
9	2000	4000	1500	75	0.90	4	0.0	0.300	0.170	0	202	904	105	0.00	Standard	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	2.50	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	500	45	0	0	0.000	0	1.500	0.25	4	0.3	5.000	-1.00	OFF
102	3500	100	100	0	0	0.000	0	0.700	0.35	4	0.0	5.000	-1.00	OFF
103	3500	100	100	0	0	0.000	0	0.700	0.35	4	0.0	5.000	-1.00	OFF
104	3500	100	100	0	0	0.000	0	0.700	0.35	4	0.0	5.000	-1.00	OFF
105	3500	100	100	0	0	0.000	0	0.120	0.40	4	0.0	5.000	-1.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	300	30	60	0
902	3500	300	40	60	0
903	4000	300	50	60	0
904	4000	300	60	60	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1200	90	0.90	4	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	45	0.000	0.60	4	2.000	100	100	45	0.700	0
202	0	3500	1200	100	0.000	0.80	4	3.000	700	1200	100	0.500	0
203	120	3500	1200	90	0.000	0.90	0	3.000	1600	1200	90	0.000	0
204	120	3500	1500	100	0.000	0.90	0	3.000	1800	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.90	0	3.000	1800	1500	100	0.000	0
206	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
207	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
208	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
209	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
210	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SPC8.0S**

[Material] C-SPC8.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 8.00 [CutWay] Clean [NzlType] D\*:\*C [Head] Standard  
 [Foc] -3.0 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 7 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	50	1.20	4	0.0	0.700	0.170	0	201	0	101	-1.00	Standard	No
2	800	3500	700	85	1.50	4	0.0	0.300	0.170	203	202	902	102	0.00	Standard	No
3	1000	4000	1000	70	1.50	4	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
4	1100	4000	1000	75	1.50	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
5	1100	4000	1000	75	1.50	4	0.0	0.300	0.170	204	202	904	102	0.00	Standard	No
6	1100	4000	1000	75	1.50	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
7	1100	4000	1000	75	1.50	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
8	1100	4000	1000	75	1.50	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
9	1100	4000	1000	75	1.50	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
(Etch)																
10	6000	1250	1000	25	0.10	4	0.0	1.500	0.000	0	0	905	0	3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	300	35	0	0	0.000	0	2.500	0.20	4	0.5	5.000	-0.50	OFF
102	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
103	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
104	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
105	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	1.0	0	Trace	No	0
OFF	OFF	3.5	0	Trace	No	0
OFF	OFF	3.5	0	Trace	No	0
OFF	OFF	3.5	0	Trace	No	0
OFF	OFF	3.5	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	20	60	0
902	3500	100	25	60	0
903	4000	100	50	60	0
904	4000	100	60	60	0
905	1250	1000	20	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	700	80	0.80	4	4.00	300	5.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	40	0.000	0.60	4	2.000	100	100	40	1.000	0
202	0	3500	700	80	0.000	0.80	4	4.000	500	700	80	0.700	0
203	120	3500	1000	95	0.000	1.50	0	6.000	700	1000	95	0.000	0
204	120	3500	1000	100	0.000	1.50	0	6.000	900	1000	100	0.000	0
205	120	3500	1000	100	0.000	1.50	0	6.000	900	1000	100	0.000	0
206	120	3500	1000	100	0.000	1.50	0	6.000	900	1000	100	0.000	0
207	120	3500	1000	100	0.000	1.50	0	6.000	900	1000	100	0.000	0
208	120	3500	1000	100	0.000	1.50	0	6.000	900	1000	100	0.000	0
209	120	3500	1000	100	0.000	1.50	0	6.000	900	1000	100	0.000	0
210	120	3500	1000	100	0.000	1.50	0	6.000	900	1000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

C-SUS0.5

[Material] C-SUS0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.80	4	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	9000	3500	9000	90	0.80	4	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	12000	3500	12000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	13000	3500	13000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	12000	3500	12000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	12000	3500	12000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	12000	3500	12000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	12000	3500	12000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.000	0.000	0	0	0	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	2500	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS0.5HS**

[Material] C-SUS0.5HS [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	200	10	0.70	4	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3500	800	35	0.70	4	0.0	1.500	0.120	0	201	903	105	0.00	Medium	No
3	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	30000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	2500	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS0.8**

[Material] C-SUS0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.80	4	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	9000	3500	9000	90	0.80	4	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	10500	3500	10500	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	11000	3500	11000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	10500	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	10500	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	10500	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	10500	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.000	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	2500	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS0.8HS**

[Material] C-SUS0.8HS [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	200	10	0.70	4	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3500	800	35	0.70	4	0.0	1.500	0.120	0	201	903	105	0.00	Medium	No
3	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
5	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
6	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
7	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
8	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
9	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	2500	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS1.0**

[Material] C-SUS1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.80	4	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8500	3500	8500	90	0.80	4	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	10500	3500	10500	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	10000	3500	10000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.000	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	2500	100	100	0	0	0.000	0	0.010	0.80	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS1.0HS**

[Material] C-SUS1.0HS [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	200	10	0.70	4	0.3	1.500	0.120	0	201	0	101	0.00	Standard	No
2	2000	3500	800	35	0.70	4	0.0	1.500	0.120	0	201	903	105	0.00	Medium	No
3	23000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	903	105	0.00	Medium	No
4	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
5	27000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
6	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
7	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
8	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
9	25000	3500	20000	100	0.70	4	0.0	1.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	2500	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.000	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.000	0
203	120	3500	2000	80	0.000	0.70	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-SUS1.0S**

[Material] C-SUS1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	4	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.70	4	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	7200	3500	7200	85	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	8000	3500	8000	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	8500	3500	8500	100	0.70	4	0.0	0.500	0.200	0	202	904	105	0.00	Medium	No
6	8000	3500	8000	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	8000	3500	8000	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	8000	3500	8000	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	8000	3500	8000	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	20	20	0
904	3500	300	30	20	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-SUS1.2

[Material] C-SUS1.2 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	200	10	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3500	800	35	0.80	4	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8000	3500	8000	90	0.80	4	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	8500	3500	8500	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	9000	3500	9000	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	8500	3500	8500	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	8500	3500	8500	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	8500	3500	8500	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	8500	3500	8500	100	0.80	4	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.000	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	2500	100	100	0	0	0.000	0	0.010	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	20	0
902	3500	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS1.2S**

[Material] C-SUS1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	4	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.70	4	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	7000	3500	7000	85	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	7500	3500	7500	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	7500	3500	7500	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
6	7500	3500	7500	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	7500	3500	7500	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	7500	3500	7500	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	7500	3500	7500	100	0.70	4	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	30	20	0
904	3500	300	40	20	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# C-SUS1.5

[Material] C-SUS1.5 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	20	0.95	4	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.95	4	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	6800	3500	6800	90	0.95	4	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	7200	3500	7200	100	0.95	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	7500	3500	7200	100	0.95	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	7200	3500	7200	100	0.95	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	7200	3500	7200	100	0.95	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	7200	3500	7200	100	0.95	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	7200	3500	7200	100	0.95	4	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.95	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	30	0.000	0.95	0	1.000	300	200	30	0.700	0
202	0	3500	2000	100	0.000	0.95	0	1.500	800	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS1.5S**

[Material] C-SUS1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.80	4	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.80	4	0.0	0.300	0.200	0	201	902	105	0.00	Medium	No
3	6500	3500	6500	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
4	7000	3500	7000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
5	7300	3500	7500	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
6	7000	3500	7000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
7	7000	3500	7000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
8	7000	3500	7000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
9	7000	3500	7000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	20	20	0
904	3500	300	30	20	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS10.0S**

[Material] C-SUS10.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 10.00 [CutWay] Clean [NzlType] D\*:\*C [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 7 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	45	1.50	4	0.3	0.700	0.170	0	201	0	101	0.00	Standard	No
2	500	3500	500	60	1.50	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
3	800	3500	800	90	1.50	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
4	1000	3500	1000	100	1.50	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
5	1100	3500	1000	100	1.50	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
6	1000	3500	1000	100	1.50	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
7	1000	3500	1000	100	1.50	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
8	1000	3500	1000	100	1.50	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
9	1000	3500	1000	100	1.50	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
(Etch)																
10	6000	1200	1000	18	0.10	4	0.0	1.500	0.000	0	0	0	0	2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	2.000	0.20	4	0.5	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.3	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.3	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.3	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.3	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	1.5	0	Trace	No	0
OFF	OFF	4.0	0	Trace	No	0
OFF	OFF	4.0	0	Trace	No	0
OFF	OFF	4.0	0	Trace	No	0
OFF	OFF	4.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	30	0
902	3500	100	30	30	0
903	3500	100	30	30	0
904	3500	100	30	30	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	100	100	0.80	4	4.00	200	4.000

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11 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	55	0.000	0.60	4	2.000	100	100	55	1.000	0
202	0	3500	700	100	0.000	1.20	4	5.000	200	700	100	0.500	0
203	150	3500	100	40	0.000	1.50	0	7.000	100	100	40	0.000	0
204	150	3500	700	85	0.000	1.50	0	7.000	400	700	85	0.000	0
205	175	3500	700	90	0.000	1.50	0	7.000	500	700	90	0.000	0
206	175	3500	700	90	0.000	1.50	0	7.000	500	700	90	0.000	0
207	175	3500	700	90	0.000	1.50	0	7.000	500	700	90	0.000	0
208	175	3500	700	90	0.000	1.50	0	7.000	500	700	90	0.000	0
209	175	3500	700	90	0.000	1.50	0	7.000	500	700	90	0.000	0
210	175	3500	700	90	0.000	1.50	0	7.000	500	700	90	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS12.0S-RF**

[Material] C-SUS12.0S-RF [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 12.00 [CutWay] Clean [NzlType] D\*:C [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 7.00 [Lens] 7.5"  
 [AC] 7 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	45	1.30	4	0.3	0.700	0.170	0	201	0	101	0.00	Standard	No
2	250	3500	250	60	1.30	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
3	450	3500	450	85	1.30	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
4	600	3500	600	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
5	600	3500	600	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
6	600	3500	600	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
7	600	3500	600	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
8	600	3500	600	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
9	600	3500	600	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
(Etch)																
10	8000	1200	1000	18	0.10	4	0.0	1.500	0.000	0	0	0	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	2.000	0.20	4	0.5	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.3	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.3	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.3	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.3	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	1.5	0	Trace	No	0
OFF	OFF	6.0	0	Trace	No	0
OFF	OFF	6.0	0	Trace	No	0
OFF	OFF	6.0	0	Trace	No	0
OFF	OFF	6.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	40	30	0
902	3500	100	40	30	0
903	3500	100	40	30	0
904	3500	100	40	30	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	100	100	0.80	4	4.00	200	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	55	0.000	0.60	4	2.000	100	55	1.000	0	
202	0	3500	700	100	0.000	1.00	4	5.000	150	700	100	0.500	0
203	150	3500	100	40	0.000	1.30	0	7.000	100	100	40	0.000	0
204	150	3500	700	85	0.000	1.30	0	7.000	500	700	85	0.000	0
205	175	3500	700	100	0.000	1.30	0	7.000	600	700	100	0.000	0
206	175	3500	700	100	0.000	1.30	0	7.000	600	700	100	0.000	0
207	175	3500	700	100	0.000	1.30	0	7.000	600	700	100	0.000	0
208	175	3500	700	100	0.000	1.30	0	7.000	600	700	100	0.000	0
209	175	3500	700	100	0.000	1.30	0	7.000	600	700	100	0.000	0
210	175	3500	700	100	0.000	1.30	0	7.000	600	700	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS2.0**

[Material] C-SUS2.0 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.95	4	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.95	4	0.0	0.300	0.140	0	201	902	105	0.00	Medium	No
3	5400	3500	5400	90	0.95	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	6000	3500	6000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
5	6300	3500	6300	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
6	6000	3500	6000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
7	6000	3500	6000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
8	6000	3500	6000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
9	6000	3500	6000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.95	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.95	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**C-SUS2.0S**

[Material] C-SUS2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.80	4	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.80	4	0.0	0.300	0.200	0	201	902	105	0.00	Medium	No
3	5400	3500	5400	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
4	6000	3500	6000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
5	6300	3500	6300	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
6	6000	3500	6000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
7	6000	3500	6000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
8	6000	3500	6000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
9	6000	3500	6000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-3.00	OFF
105	3500	100	100	0	0	0.000	0	0.030	0.50	4	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	300	20	30	0
904	3500	300	30	30	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS2.5**

[Material] C-SUS2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	14	0.95	4	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.95	4	0.0	0.300	0.140	0	201	902	105	0.00	Medium	No
3	4500	3500	4500	85	0.95	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	5000	3500	5000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
5	5000	3500	5000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
6	5000	3500	5000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
7	5000	3500	5000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
8	5000	3500	5000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
9	5000	3500	5000	100	0.95	4	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	4	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.200	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.95	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.95	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS2.5S**

[Material] C-SUS2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.80	4	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.80	4	0.0	0.300	0.200	0	201	902	105	0.00	Medium	No
3	4500	3500	4500	85	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
4	5000	3500	5000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
5	5500	3500	5000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
6	5000	3500	5000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
7	5000	3500	5000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
8	5000	3500	5000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
9	5000	3500	5000	100	0.80	4	0.0	0.300	0.200	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	0.100	0.40	4	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	10	0
902	3000	200	20	10	0
903	3500	300	25	10	0
904	3500	300	30	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS3.0**

[Material] C-SUS3.0 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 13 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	1.40	4	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	2000	3000	800	55	1.40	4	0.0	0.500	0.140	0	201	902	105	0.00	Medium	No
3	3500	3500	3500	85	1.40	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	1.40	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
5	4200	3500	4200	100	1.40	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
6	4000	3500	4000	100	1.40	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
7	4000	3500	4000	100	1.40	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
8	4000	3500	4000	100	1.40	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
9	4000	3500	4000	100	1.40	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1300	1000	18	0.10	4	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.300	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.030	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	60	0
902	3000	200	40	60	0
903	3500	200	50	60	0
904	3500	200	60	60	0
905	1300	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	4	4.00	1000	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.90	4	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.90	4	1.500	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	1.40	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	1.40	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	1.40	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	1.40	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	1.40	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	1.40	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	1.40	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	1.40	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS3.0-2**

[Material] C-SUS3.0-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.90	4	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	1500	3000	800	55	0.90	4	0.0	0.500	0.140	0	201	902	105	0.00	Medium	No
3	3000	3500	3000	85	0.90	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	3500	3500	3500	100	0.90	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
5	3700	3500	3700	100	0.90	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
6	3500	3500	3500	100	0.90	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
7	3500	3500	3500	100	0.90	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
8	3500	3500	3500	100	0.90	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
9	3500	3500	3500	100	0.90	4	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1300	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.300	0.25	4	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	40	60	0
902	3000	200	50	60	0
903	3500	200	60	60	0
904	3500	200	60	60	0
905	1300	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.90	4	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.90	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.90	0	1.500	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.90	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS3.0S**

[Material] C-SUS3.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	4	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	60	0.80	4	0.0	0.300	0.200	0	201	902	105	0.00	Medium	No
3	3600	3500	3600	90	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
5	4200	3500	4000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
6	4000	3500	4000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
7	4000	3500	4000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
8	4000	3500	4000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
9	4000	3500	4000	100	0.80	4	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.300	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	30	0
902	3300	200	40	30	0
903	3500	300	50	30	0
904	3500	300	50	30	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS4.0S**

[Material] C-SUS4.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 4.00 [CutWay] Clean [NzlType] D\*:C [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	250	35	0.80	4	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1300	3000	1300	60	0.80	4	0.0	0.300	0.120	0	201	902	102	0.00	Standard	No
3	2600	3500	2600	85	0.80	4	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
4	3000	3500	3000	100	0.80	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
5	3000	3500	3000	100	0.80	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
6	3000	3500	3000	100	0.80	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
7	3000	3500	3000	100	0.80	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
8	3000	3500	3000	100	0.80	4	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
9	3000	3500	3000	100	0.80	4	0.0	0.300	0.120	0	202	904	105	0.00	Standard	No
(Etch)																
10	8000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	1.50	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	4	0.3	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	4	0.0	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	0.010	0.40	4	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	10	0
902	3500	200	20	10	0
903	3500	200	30	10	0
904	3500	200	40	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	4	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	200	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**C-SUS5.0S**

[Material] C-SUS5.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 5.00 [CutWay] Clean [NzlType] D\*:\*C [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3000	100	40	0.80	4	0.3	0.700	0.170	0	201	0	101	0.00	Standard	No
2	1000	3000	1000	70	0.80	4	0.0	0.500	0.170	0	201	0	102	0.00	Standard	No
3	2000	3500	2000	85	0.80	4	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
4	2500	3500	2500	100	0.80	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
5	2500	3500	2500	100	0.80	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
6	2500	3500	2500	100	0.80	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
7	2500	3500	2500	100	0.80	4	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
8	2500	3500	2500	100	0.80	4	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
9	2500	3500	2500	100	0.80	4	0.0	0.300	0.170	204	202	903	105	0.00	Standard	No
(Etch)																
10	8000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	2.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	500	20	0	0	0.000	0	3.000	0.25	4	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.700	0.35	4	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.100	0	0.700	0.35	4	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.100	0	0.700	0.35	4	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.100	0	0.120	0.40	4	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	300	10	10	0
902	3500	300	20	10	0
903	3500	300	25	10	0
904	3500	300	30	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1200	100	0.80	4	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	28	0.000	0.60	4	1.500	100	100	28	1.000	0
202	0	3500	1200	90	0.000	0.80	0	2.500	800	1200	90	0.700	0
203	120	3500	1200	90	0.000	0.80	0	3.000	1600	2500	90	0.000	0
204	120	3500	3000	100	0.000	0.80	0	3.000	1800	3000	100	0.000	0
205	120	3500	3000	100	0.000	0.80	0	3.000	1800	3000	100	0.000	0
206	120	3500	3000	100	0.000	0.80	0	3.000	1800	3000	100	0.000	0
207	120	3500	3000	100	0.000	0.80	0	3.000	1800	3000	100	0.000	0
208	120	3500	3000	100	0.000	0.80	0	3.000	1800	3000	100	0.000	0
209	120	3500	3000	100	0.000	0.80	0	3.000	1800	3000	100	0.000	0
210	120	3500	3000	100	0.000	0.80	0	3.000	1800	3000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



# C-SUS6.0S

[Material] C-SUS6.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 6.00 [CutWay] Clean [NzlType] D\*:C [Head] Standard  
 [Foc] -3.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3000	100	40	0.80	4	0.3	0.700	0.170	0	201	0	101	0.00	Standard	No
2	1000	3000	1000	70	0.80	4	0.0	0.500	0.170	0	201	0	102	0.00	Standard	No
3	1600	3500	1600	85	0.80	4	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
4	2000	3500	2000	100	0.80	4	0.0	0.300	0.170	204	202	904	102	0.00	Standard	No
5	2200	3500	2000	100	0.80	4	0.0	0.300	0.170	203	202	904	102	0.00	Standard	No
6	2000	3500	2000	100	0.80	4	0.0	0.300	0.170	203	202	904	102	0.00	Standard	No
7	2000	3500	2000	100	0.80	4	0.0	0.300	0.170	203	202	904	102	0.00	Standard	No
8	2000	3500	2000	100	0.80	4	0.0	0.300	0.170	203	202	904	102	0.00	Standard	No
9	2000	3500	2000	100	0.80	4	0.0	0.300	0.170	203	202	904	105	0.00	Standard	No
(Etch)																
10	8000	1200	1000	20	0.10	4	0.0	1.500	0.000	0	0	905	0	3.50	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3200	500	25	0	0	0.000	0	1.500	0.20	4	0.5	5.000	0.00	OFF
102	3500	100	100	0	0	0.000	0	0.700	0.25	4	0.3	5.000	0.00	OFF
103	3500	100	100	0	0	0.000	0	0.700	0.25	4	0.3	5.000	0.00	OFF
104	3500	100	100	0	0	0.000	0	0.700	0.25	4	0.3	5.000	0.00	OFF
105	3500	100	100	0	0	0.000	0	0.120	0.40	4	0.0	5.000	0.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	300	15	10	0
902	3500	300	20	10	0
903	3500	300	30	10	0
904	3500	300	40	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1200	100	0.80	4	4.00	250	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	28	0.000	0.60	4	1.500	100	100	28	1.000	0
202	0	3500	1200	90	0.000	0.80	0	2.500	700	1200	90	0.700	0
203	120	3500	1200	95	0.000	0.80	0	3.000	1500	1200	95	0.000	0
204	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
206	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
207	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
208	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
209	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
210	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
			Pie.	Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

### C-SUS8.0S

[Material] C-SUS8.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 8.00 [CutWay] Clean [NzlType] D\*:\*C [Head] Standard  
 [Foc] -3.0 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 7 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3000	100	50	1.20	4	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	800	3500	1000	60	1.20	4	0.0	0.300	0.170	203	202	0	102	0.00	Standard	No
3	1200	3500	1000	85	1.20	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
4	1500	3500	1000	100	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
5	1650	3500	1000	100	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
6	1500	3500	1000	100	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
7	1500	3500	1000	100	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
8	1500	3500	1000	100	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
9	1500	3500	1000	100	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
(Etch)																
10	6000	1200	1000	15	0.10	4	0.0	1.500	0.000	0	0	905	0	3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	1.000	0.20	4	0.5	5.000	-0.50	OFF
102	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
103	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
104	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
105	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	20	0
902	3500	100	30	20	0
903	3500	100	30	20	0
904	3500	100	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	100	100	0.80	4	4.00	400	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	35	0.000	0.60	4	2.000	100	100	35	1.000	0
202	0	3500	1000	60	0.000	0.90	4	4.000	400	1000	70	0.700	0
203	120	3500	1000	65	0.000	1.20	0	6.000	700	1000	65	0.000	0
204	120	3500	1000	70	0.000	1.20	0	6.000	950	1000	70	0.000	0
205	120	3500	1000	90	0.000	1.20	0	6.000	1100	1000	85	0.000	0
206	120	3500	1000	90	0.000	1.20	0	6.000	1100	1000	85	0.000	0
207	120	3500	1000	90	0.000	1.20	0	6.000	1100	1000	85	0.000	0
208	120	3500	1000	90	0.000	1.20	0	6.000	1100	1000	85	0.000	0
209	120	3500	1000	90	0.000	1.20	0	6.000	1100	1000	85	0.000	0
210	120	3500	1000	90	0.000	1.20	0	6.000	1100	1000	85	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	No	
2	0	0	0	No	
3	0	0	0	No	
4	0	0	0	No	
5	0	0	0	No	
6	0	0	0	No	
7	0	0	0	No	
8	0	0	0	No	
9	0	0	0	No	
10	0	0	0	No	

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

C-SUS9.0S

[Material] C-SUS9.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 9.00 [CutWay] Clean [NzlType] D\*:C [Head] Standard  
 [Foc] -3.0 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 7 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	55	1.20	4	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	700	3500	1000	70	1.30	4	0.0	0.300	0.170	203	202	0	102	0.00	Standard	No
3	1000	3500	1000	85	1.30	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
4	1100	3500	1000	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
5	1200	3500	1000	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
6	1100	3500	1000	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
7	1100	3500	1000	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
8	1100	3500	1000	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
9	1100	3500	1000	100	1.30	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
(Etch)																
10	6000	1200	1000	15	0.10	4	0.0	1.500	0.000	0	0	905	0	3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	1.500	0.20	4	0.5	5.000	-0.50	OFF
102	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
103	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
104	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF
105	3500	100	100	0	0	0.000	0	1.000	0.25	4	0.3	5.000	-0.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	20	0
902	3500	100	30	20	0
903	3500	100	30	20	0
904	3500	100	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	100	100	0.80	4	4.00	450	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	50	0.000	0.60	4	2.000	100	50	100	1.000	0
202	0	3500	1000	80	0.000	1.00	4	4.000	500	600	80	0.700	0
203	120	3500	1000	65	0.000	1.30	0	6.000	600	1000	65	0.000	0
204	120	3500	1000	85	0.000	1.30	0	6.000	800	1000	85	0.000	0
205	120	3500	1000	100	0.000	1.30	0	6.000	900	1000	100	0.000	0
206	120	3500	1000	100	0.000	1.30	0	6.000	900	1000	100	0.000	0
207	120	3500	1000	100	0.000	1.30	0	6.000	900	1000	100	0.000	0
208	120	3500	1000	100	0.000	1.30	0	6.000	900	1000	100	0.000	0
209	120	3500	1000	100	0.000	1.30	0	6.000	900	1000	100	0.000	0
210	120	3500	1000	100	0.000	1.30	0	6.000	900	1000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SECC0.5

[Material] E-SECC0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	8	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3200	800	30	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	9000	3200	9000	90	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	10000	3200	10000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	10000	3200	10000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	10000	3200	10000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	10000	3200	10000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	10000	3200	10000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	10000	3200	10000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	5	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	200	10	30	0
902	3200	200	20	30	0
903	3200	200	30	30	0
904	3200	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3200	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**E-SECC0.8**

[Material] E-SECC0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	8	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	8500	3200	8500	90	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	9500	3200	9500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	9500	3200	9500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	9500	3200	9500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	9500	3200	9500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	9500	3200	9500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	9500	3200	9500	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	200	10	30	0
902	3200	200	20	30	0
903	3200	200	30	30	0
904	3200	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3200	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SECC1.0

[Material] E-SECC1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	8	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	8000	3200	8000	90	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	9000	3200	9000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	9000	3200	9000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	9000	3200	9000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	9000	3200	9000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	9000	3200	9000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	9000	3200	9000	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	5	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	200	10	30	0
902	3200	200	20	30	0
903	3200	200	30	30	0
904	3200	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3200	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SECC1.0S

[Material] E-SECC1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.70	5	0.3	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	35	0.70	5	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	7000	3500	7000	90	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	7500	3500	7500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
5	7500	3500	7500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	7500	3500	7500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	7500	3500	7500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	7500	3500	7500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	7500	3500	7500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	300	20	30	0
904	3500	300	30	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

### E-SECC1.2

[Material] E-SECC1.2 [Oscillator] AF35LCG0EU-001  
 [Quality] SECC [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	35	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	7500	3200	7500	85	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	8000	3200	8000	100	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
5	8500	3500	8500	100	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
6	8000	3200	8000	100	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
7	8000	3200	8000	100	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
8	8000	3200	8000	100	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
9	8000	3200	8000	100	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3200	200	10	30	0
902	3200	200	20	30	0
903	3200	200	30	30	0
904	3200	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3200	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3200	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
204	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
205	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
206	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
207	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
208	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
209	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
210	120	3200	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**E-SECC1.2S**

[Material] E-SECC1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.70	5	0.3	0.500	0.160	0	201	0	101	-0.70	Standard	No
2	2000	3500	1000	40	0.70	5	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	6000	3500	6000	90	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	6500	3500	6500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
5	6500	3500	6500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	6500	3500	6500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	6500	3500	6500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	6500	3500	6500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	6500	3500	6500	100	0.70	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	100	100	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	25	0.000	0.70	0	1.000	300	300	25	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	4500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	4500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	4500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	4500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	4500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	4500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	4500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SECC1.5

[Material] E-SECC1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	12	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	5800	3500	5800	85	0.70	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	6300	3500	6300	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	6300	3500	6300	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	6300	3500	6300	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	6300	3500	6300	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	6300	3500	6300	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	6300	3500	6300	100	0.70	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	15	60	0
902	3000	200	20	60	0
903	3500	200	30	60	0
904	3500	200	40	60	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	22	0.000	0.70	0	1.000	300	200	22	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	700	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**E-SECC1.5S**

[Material] E-SECC1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	16	0.80	5	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1500	35	0.80	5	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	5500	3500	5500	90	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
4	6000	3500	6000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
5	6300	3500	6000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
6	6000	3500	6000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
7	6000	3500	6000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
8	6000	3500	6000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
9	6000	3500	6000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	35	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	26	0.000	0.80	0	1.000	300	200	26	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	88	0.000	0.80	0	3.000	4500	2000	88	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SECC2.0

[Material] E-SECC2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	25	0.95	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.95	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	4500	3500	4500	90	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	5000	3500	5000	100	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
5	5000	3500	5000	100	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
6	5000	3500	5000	100	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
7	5000	3500	5000	100	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
8	5000	3500	5000	100	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
9	5000	3500	5000	100	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	30	0.000	0.95	0	1.000	250	200	30	0.700	0
202	0	3500	2000	100	0.000	0.95	0	1.500	450	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	4700	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**E-SECC2.0S**

[Material] E-SECC2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	5	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	35	0.80	5	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	4500	3500	4500	90	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
4	5000	3500	5000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
5	5000	3500	5000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
6	5000	3500	5000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
7	5000	3500	5000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
8	5000	3500	5000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
9	5000	3500	5000	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	5	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	40	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1500	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	30	0.000	0.80	0	1.000	200	200	30	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	800	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.80	0	3.000	4000	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SECC2.5

[Material] E-SECC2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.95	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3500	800	45	0.95	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	3600	3500	3600	90	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	4000	3500	4000	100	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	4000	3500	4000	100	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	4000	3500	4000	100	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	4000	3500	4000	100	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	4000	3500	4000	100	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.20	5	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	27	0.000	0.95	0	1.000	300	200	27	0.700	0
202	0	3500	2000	100	0.000	0.95	0	1.500	400	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	3500	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	4400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	4400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	4400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	4400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	4400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	4400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	4400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**E-SECC2.5S**

[Material] E-SECC2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	23	0.80	5	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	40	0.80	5	0.0	0.500	0.170	0	201	902	105	0.00	Medium	No
3	3600	3500	3600	90	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
5	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
6	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
7	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
8	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
9	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	5	0.0	1.500	0.000	0	0	905	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	20	0
902	3500	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	33	0.000	0.80	0	1.000	200	200	33	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	800	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.80	0	3.000	3600	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

### E-SECC3.0

[Material] E-SECC3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	100	25	0.95	5	0.3	0.500	0.130	0	201	0	101	0.20	Standard	No
2	1500	3500	800	65	0.95	5	0.0	0.300	0.130	0	201	902	105	0.00	Medium	No
3	2800	4000	2800	75	0.95	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	3300	4000	3300	75	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	3300	4000	3300	75	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	3300	4000	3300	75	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	3300	4000	3300	75	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	3300	4000	3300	75	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	3300	4000	3300	75	0.95	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.10	5	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	40	60	0
902	3500	200	50	60	0
903	4000	200	50	60	0
904	4000	200	60	60	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	5	4.00	1000	2.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	30	0.000	0.80	5	1.000	100	200	30	0.500	0
202	0	4000	2000	100	0.000	0.80	5	1.500	300	2000	100	0.500	0
203	120	4000	2000	80	0.000	0.95	0	3.000	2800	2000	80	0.000	0
204	120	4000	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
205	120	4000	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
206	120	4000	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
207	120	4000	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
208	120	4000	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
209	120	4000	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0
210	120	4000	2000	100	0.000	0.95	0	3.000	3300	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**E-SECC3.0S**

[Material] E-SECC3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	100	25	0.90	5	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	65	0.90	5	0.0	0.300	0.170	0	202	902	105	0.00	Medium	No
3	3000	4000	3000	70	0.90	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
4	3500	4000	3500	75	0.90	5	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
5	3500	4000	3500	75	0.90	5	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
6	3500	4000	3500	75	0.90	5	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
7	3500	4000	3500	75	0.90	5	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
8	3500	4000	3500	75	0.90	5	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
9	3500	4000	3500	75	0.90	5	0.0	0.300	0.170	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.20	5	0.0	1.500	0.000	0	0	905	0	2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	4000	200	50	60	0
904	4000	200	60	60	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.90	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	35	0.000	0.90	0	1.000	100	100	35	0.700	0
202	0	3500	1200	90	0.000	0.90	0	1.000	500	1200	90	0.700	0
203	120	3500	2000	90	0.000	0.90	0	3.000	2800	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	3200	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC0.5

[Material] E-SPC0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8500	3500	8500	85	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	11000	3500	11000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	11000	3500	11000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	11000	3500	11000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	11000	3500	11000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	11000	3500	11000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	11000	3500	11000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.30	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.30	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.30	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

E-SPC0.8

[Material] E-SPC0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	9000	3500	9000	90	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	10000	3500	10000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.30	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.30	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.30	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC1.0

[Material] E-SPC1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.70	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	30	0.70	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8000	3500	8000	85	0.70	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	9500	3500	9500	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	9000	3500	9000	100	0.70	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.70	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.70	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	7000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC1.0S

[Material] E-SPC1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.80	5	0.3	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	45	0.80	5	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	8000	3500	8000	85	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	8500	3500	8500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
5	8500	3500	8500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	8500	3500	8500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	8500	3500	8500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	8500	3500	8500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	8500	3500	8500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	300	30	30	0
904	3500	300	40	30	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6200	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6800	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC1.2

[Material] E-SPC1.2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.90	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	35	0.90	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	6800	3500	6800	85	0.90	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	7500	3500	7500	100	0.90	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	8000	3500	8000	100	0.90	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	7500	3500	7500	100	0.90	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	7500	3500	7500	100	0.90	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	7500	3500	7500	100	0.90	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	7500	3500	7500	100	0.90	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1000	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.90	5	4.00	1000	4.000

Laser Gain Recv. Mont.

6 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.90	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.90	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	7000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC1.2S

[Material] E-SPC1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	12	0.80	5	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	50	0.80	5	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	6800	3500	6800	90	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	7500	3500	7500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
5	7500	3500	7500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	7500	3500	7500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	7500	3500	7500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	7500	3500	7500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	7500	3500	7500	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	20	30	0
904	3500	200	30	30	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

6 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	22	0.000	0.80	0	1.000	300	300	22	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	5500	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC1.5

[Material] E-SPC1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.90	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.90	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	6300	3500	6300	90	0.90	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	7200	3500	7200	100	0.90	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	7200	3500	7500	100	0.90	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	7200	3500	7200	100	0.90	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	7200	3500	7200	100	0.90	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	7200	3500	7200	100	0.90	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	7200	3500	7200	100	0.90	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	13	30	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.90	5	4.00	1000	4.000

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5 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	22	0.000	0.90	0	1.000	300	200	22	0.700	0
202	0	3500	2000	100	0.000	0.90	0	1.500	700	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.90	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.90	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



# E-SPC1.5S

[Material] E-SPC1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	16	0.80	5	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	50	0.80	5	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	5400	3500	5400	85	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
4	6000	3500	6000	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
5	6300	3500	6300	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
6	6000	3500	6000	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
7	6000	3500	6000	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
8	6000	3500	6000	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
9	6000	3500	6000	100	0.80	5	0.0	0.500	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
105	3500	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	5	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	26	0.000	0.80	0	1.000	300	200	26	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.80	0	3.000	4500	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC2.0

[Material] E-SPC2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.70	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.70	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	4700	3500	4700	90	0.70	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	5200	3500	5200	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	5500	3500	5500	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	5200	3500	5200	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	5200	3500	5200	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	5200	3500	5200	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	5200	3500	5200	100	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	30	0
902	3000	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.70	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.70	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC2.0S

[Material] E-SPC2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	5	0.0	0.700	0.160	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	40	0.80	5	0.0	0.500	0.160	0	201	902	105	0.00	Medium	No
3	5000	3500	5000	90	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
4	5500	3500	5500	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
5	5500	3500	5500	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
6	5500	3500	5500	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
7	5500	3500	5500	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
8	5500	3500	5500	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
9	5500	3500	5500	100	0.80	5	0.0	0.300	0.160	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-3.00	OFF
105	3500	100	100	0	0	0.000	0	0.030	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	30	0
902	3500	200	20	30	0
903	3500	200	30	30	0
904	3500	200	40	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	30	0.000	0.80	0	1.000	200	200	30	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	800	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.80	0	3.000	4000	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	4500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC2.5

[Material] E-SPC2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	25	0.80	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3500	800	50	0.80	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	4000	3500	4000	90	0.80	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	4300	3500	4300	100	0.80	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	4300	3500	4300	100	0.80	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	4300	3500	4300	100	0.80	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	4300	3500	4300	100	0.80	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	4300	3500	4300	100	0.80	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	4300	3500	4300	100	0.80	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	15	30	0
902	3500	200	25	30	0
903	3500	200	35	30	0
904	3500	200	40	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	27	0.000	0.80	0	1.000	300	200	27	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.500	400	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC2.5S

[Material] E-SPC2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	25	0.80	5	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	50	0.80	5	0.0	0.500	0.170	0	201	902	105	0.00	Medium	No
3	3600	3500	3600	90	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
5	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
6	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
7	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
8	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
9	4000	3500	4000	100	0.80	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	30	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-2.50	OFF
102	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-2.50	OFF
103	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-2.50	OFF
104	3500	100	100	0	0	0.000	0	0.200	0.35	5	0.0	5.000	-2.50	OFF
105	3500	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	30	0
902	3500	200	40	30	0
903	3500	200	50	30	0
904	3500	200	60	30	0
905	1200	1000	20	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	200	33	0.000	0.80	0	1.000	200	200	33	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	700	2000	100	0.700	0
203	120	3500	2000	90	0.000	0.80	0	3.000	3600	2000	90	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

### E-SPC3.0

[Material] E-SPC3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 3.00 [Lens] 5"  
 [AC] 13 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	250	3500	100	25	0.70	5	0.3	0.500	0.130	0	201	0	101	0.00	Standard	No
2	1500	3500	800	65	0.70	5	0.0	0.300	0.130	0	201	902	105	0.00	Medium	No
3	2500	4000	2500	70	0.70	5	0.0	0.300	0.130	0	202	903	105	0.00	Medium	No
4	3000	4000	3000	75	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
5	3000	4000	3000	75	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
6	3000	4000	3000	75	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
7	3000	4000	3000	75	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
8	3000	4000	3000	75	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
9	3000	4000	3000	75	0.70	5	0.0	0.300	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	22	0.10	5	0.0	1.500	0.000	0	0	905	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3200	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	30	0
902	3500	200	30	30	0
903	4000	200	20	30	0
904	4000	200	30	30	0
905	1200	1000	18	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	80	0.70	5	4.00	1000	2.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	60	0.000	0.70	0	1.000	100	200	60	0.500	0
202	0	3500	2000	100	0.000	0.70	0	1.500	200	2000	100	0.500	0
203	120	3500	2000	100	0.000	0.70	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	3500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SPC3.0S

[Material] E-SPC3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	3000	100	30	0.90	5	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	3500	1200	65	0.90	5	0.0	0.300	0.170	0	202	902	105	0.00	Medium	No
3	3000	4000	3000	70	0.90	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
4	3500	4000	3000	75	0.90	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
5	3500	4000	3000	75	0.90	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
6	3500	4000	3000	75	0.90	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
7	3500	4000	3000	75	0.90	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
8	3500	4000	3000	75	0.90	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
9	3500	4000	3000	75	0.90	5	0.0	0.300	0.170	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	40	0	0	0.000	0	0.300	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	30	0
902	3500	200	40	30	0
903	4000	200	30	30	0
904	4000	200	40	30	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1500	90	0.90	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	100	45	0.000	0.90	0	1.000	100	100	45	0.700	0
202	0	3500	1500	90	0.000	0.90	0	1.500	300	1500	90	0.700	0
203	120	3500	2000	90	0.000	0.90	0	3.000	2800	2000	90	0.000	0
204	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
205	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
206	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
207	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
208	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
209	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0
210	120	3500	2000	90	0.000	0.90	0	3.000	3000	2000	90	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS0.5

[Material] E-SUS0.5 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 0.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.80	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.80	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	9000	3500	9000	90	0.80	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	11000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	11000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	11000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	11000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	11000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	11000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	0	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



# E-SUS0.8

[Material] E-SUS0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 0.80 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.80	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.80	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	9000	3500	9000	90	0.80	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	10000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	10000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	10000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	10000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	10000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	10000	3500	10000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	0	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.80	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS1.0

[Material] E-SUS1.0 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	15	0.80	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3000	800	40	0.80	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	8500	3500	8500	90	0.80	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	9500	3500	9500	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	9500	3500	9500	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	9500	3500	9500	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	9500	3500	9500	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	9500	3500	9500	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	9500	3500	9500	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	2000	100	100	0	0	0.000	0	0.010	0.80	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	10	20	0
903	3500	200	30	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS1.0S

[Material] E-SUS1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.60	5	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.60	5	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	6300	3500	6300	85	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	7500	3500	7500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	7500	3500	7500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
6	7500	3500	7500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	7500	3500	7500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	7500	3500	7500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	7500	3500	7500	100	0.60	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3500	100	100	0	0	0.000	0	0.010	0.60	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	20	20	0
904	3500	300	30	20	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.60	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.60	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.60	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.60	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.60	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS1.2

[Material] E-SUS1.2 [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3500	200	10	0.80	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	2000	3500	800	35	0.80	5	0.0	0.500	0.120	0	201	902	105	0.00	Medium	No
3	7500	3500	7500	90	0.80	5	0.0	0.500	0.120	0	202	903	105	0.00	Medium	No
4	8000	3500	8000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
5	8000	3500	8000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
6	8000	3500	8000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
7	8000	3500	8000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
8	8000	3500	8000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
9	8000	3500	8000	100	0.80	5	0.0	0.500	0.120	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.000	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	2000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	10	20	0
902	3500	200	20	20	0
903	3500	200	30	20	0
904	3500	200	40	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	0.500	1000	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS1.2S

[Material] E-SUS1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.20 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.70	5	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.70	5	0.0	0.500	0.200	0	201	902	105	0.00	Medium	No
3	6500	3500	6500	85	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
4	7000	3500	7000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
5	7000	3500	7000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
6	7000	3500	7000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
7	7000	3500	7000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
8	7000	3500	7000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
9	7000	3500	7000	100	0.70	5	0.0	0.500	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	2500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	2500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	20	20	0
904	3500	300	30	20	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.70	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.70	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.70	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.70	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS1.5

[Material] E-SUS1.5 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2500	200	20	0.80	5	0.3	0.700	0.130	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.80	5	0.0	0.500	0.130	0	201	902	105	0.00	Medium	No
3	6500	3500	6500	90	0.80	5	0.0	0.500	0.130	0	202	903	105	0.00	Medium	No
4	7000	3500	7000	100	0.80	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
5	7000	3500	7000	100	0.80	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
6	7000	3500	7000	100	0.80	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
7	7000	3500	7000	100	0.80	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
8	7000	3500	7000	100	0.80	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
9	7000	3500	7000	100	0.80	5	0.0	0.500	0.130	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.020	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	90	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	300	25	0.000	0.80	0	1.000	300	200	25	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.500	800	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	5000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS1.5S

[Material] E-SUS1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.80	5	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.80	5	0.0	0.300	0.200	0	201	902	105	0.00	Medium	No
3	5500	3500	5500	90	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
4	6500	3500	6500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
5	6500	3500	6500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
6	6500	3500	6500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
7	6500	3500	6500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
8	6500	3500	6500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
9	6500	3500	6500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3000	100	100	0	0	0.000	0	0.010	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	20	20	0
904	3500	300	30	20	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS2.0

[Material] E-SUS2.0 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	5	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.80	5	0.0	0.300	0.140	0	201	902	105	0.00	Medium	No
3	5000	3500	5000	90	0.80	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	5500	3500	5500	100	0.80	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
5	5500	3500	5500	100	0.80	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
6	5500	3500	5500	100	0.80	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
7	5500	3500	5500	100	0.80	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
8	5500	3500	5500	100	0.80	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
9	5500	3500	5500	100	0.80	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.50	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	40	0
902	3000	200	20	40	0
903	3500	200	20	40	0
904	3500	200	30	40	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.80	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



# E-SUS2.0S

[Material] E-SUS2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 2.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	10	0.80	5	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	40	0.80	5	0.0	0.300	0.200	0	201	902	105	0.00	Medium	No
3	4500	3500	4500	90	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
4	5000	3500	5000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
5	5500	3500	5500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
6	5000	3500	5000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
7	5000	3500	5000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
8	5000	3500	5000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
9	5000	3500	5000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-3.00	OFF
105	3500	100	100	0	0	0.000	0	0.100	0.50	5	0.0	5.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	300	20	20	0
904	3500	300	30	20	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS2.5

[Material] E-SUS2.5 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.50 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	14	0.85	5	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	2000	3000	800	50	0.85	5	0.0	0.300	0.140	0	201	902	105	0.00	Medium	No
3	3500	3500	3500	85	0.85	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.85	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
5	4000	3500	4000	100	0.85	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
6	4000	3500	4000	100	0.85	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
7	4000	3500	4000	100	0.85	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
8	4000	3500	4000	100	0.85	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
9	4000	3500	4000	100	0.85	5	0.0	0.300	0.140	0	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	5	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.200	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	20	0
902	3000	200	20	20	0
903	3500	200	20	20	0
904	3500	200	30	20	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.85	0	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.85	0	1.500	500	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.85	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.85	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.85	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.85	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.85	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.85	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.85	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.85	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS2.5S

[Material] E-SUS2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 2.50 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	15	0.80	5	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3000	1000	45	0.80	5	0.0	0.300	0.200	0	201	902	105	0.00	Medium	No
3	4000	3500	4000	85	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
4	4500	3500	4500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
5	4500	3500	4500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
6	4500	3500	4500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
7	4500	3500	4500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
8	4500	3500	4500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
9	4500	3500	4500	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	0.100	0.40	5	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	10	0
902	3000	200	20	10	0
903	3500	300	30	10	0
904	3500	300	40	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	6000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	6500	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS3.0

[Material] E-SUS3.0 [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 12 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.95	5	0.3	0.700	0.140	0	201	0	101	0.00	Standard	No
2	1000	3000	800	65	0.95	5	0.0	0.500	0.140	0	201	902	105	0.00	Medium	No
3	2500	3500	2500	90	0.95	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
4	3000	3500	3000	100	0.95	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
5	3000	3500	3000	100	0.95	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
6	3000	3500	3000	100	0.95	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
7	3000	3500	3000	100	0.95	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
8	3000	3500	3000	100	0.95	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
9	3000	3500	3000	100	0.95	5	0.0	0.300	0.140	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1300	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-1.50	OFF
102	3000	100	100	0	0	0.000	0	0.300	0.35	5	0.0	5.000	-1.50	OFF
103	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
104	3000	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-1.50	OFF
105	3000	100	100	0	0	0.000	0	0.030	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	60	0
902	3000	200	40	60	0
903	3500	200	50	60	0
904	3500	200	60	60	0
905	1300	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.95	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	24	0.000	0.80	5	1.000	300	200	24	0.700	0
202	0	3500	2000	100	0.000	0.80	5	1.500	300	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.95	0	3.000	4000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.95	0	3.000	5400	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS3.0S

[Material] E-SUS3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 3.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	200	20	0.80	5	0.3	0.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	3500	1000	60	0.80	5	0.0	0.300	0.200	0	201	902	105	0.00	Medium	No
3	3600	3500	3600	90	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
4	4000	3500	4000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
5	4000	3500	4000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
6	4000	3500	4000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
7	4000	3500	4000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
8	4000	3500	4000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
9	4000	3500	4000	100	0.80	5	0.0	0.300	0.200	0	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	0.050	0.40	5	0.0	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	200	30	60	0
902	3500	200	40	60	0
903	3500	300	50	60	0
904	3500	300	50	60	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.80	5	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	20	0.000	0.80	0	1.000	300	200	20	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	1000	2000	100	0.700	0
203	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	3000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS4.0S

[Material] E-SUS4.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 4.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 3.00 [Lens] 7.5"  
 [AC] 5 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	3000	250	35	0.80	5	0.3	0.700	0.120	0	201	0	101	0.00	Standard	No
2	1300	3000	1300	60	0.80	5	0.0	0.300	0.120	0	201	902	102	0.00	Standard	No
3	2000	3500	2000	85	0.80	5	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
4	2500	3500	2500	100	0.80	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
5	2500	3500	2500	100	0.80	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
6	2500	3500	2500	100	0.80	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
7	2500	3500	2500	100	0.80	5	0.0	0.300	0.120	0	202	904	102	0.00	Standard	No
8	2500	3500	2500	100	0.80	5	0.0	0.300	0.120	0	202	903	102	0.00	Standard	No
9	2500	3500	2500	100	0.80	5	0.0	0.300	0.120	0	202	904	105	0.00	Standard	No
(Etch)																
10	8000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	1.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	0.100	0.25	5	0.3	5.000	-2.50	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
103	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
104	3500	100	100	0	0	0.000	0	0.100	0.35	5	0.0	5.000	-2.50	OFF
105	3500	100	100	0	0	0.000	0	0.010	0.40	5	0.0	5.000	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	10	10	0
902	3000	200	20	10	0
903	3500	200	20	10	0
904	3500	200	30	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	80	0.80	5	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	300	18	0.000	0.80	0	1.000	300	200	18	0.700	0
202	0	3500	2000	100	0.000	0.80	0	1.000	200	2000	100	0.700	0
203	120	3500	2000	80	0.000	0.80	0	3.000	7000	2000	80	0.000	0
204	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
205	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
206	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
207	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
208	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
209	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0
210	120	3500	2000	100	0.000	0.80	0	3.000	8000	2000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS5.0S

[Material] E-SUS5.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 5.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 3.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3000	100	40	0.80	5	0.3	0.700	0.170	0	201	0	101	0.00	Standard	No
2	1000	3000	1000	70	0.80	5	0.0	0.500	0.170	0	201	0	102	0.00	Standard	No
3	1800	3500	2000	85	0.80	5	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
4	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
5	2200	3500	2000	100	0.80	5	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
6	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
7	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
8	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	204	202	903	102	0.00	Standard	No
9	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	204	202	903	105	0.00	Standard	No
(Etch)																
10	8000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	2.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	500	20	0	0	0.000	0	3.000	0.25	5	0.3	5.000	-1.50	OFF
102	3500	100	100	0	0	0.000	0	0.700	0.35	5	0.0	5.000	-1.50	OFF
103	3500	100	100	0	0	0.000	0	0.700	0.35	5	0.0	5.000	-1.50	OFF
104	3500	100	100	0	0	0.000	0	0.700	0.35	5	0.0	5.000	-1.50	OFF
105	3500	100	100	0	0	0.000	0	0.120	0.40	5	0.0	5.000	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	2.5	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	300	20	10	0
902	3500	300	30	10	0
903	3500	300	40	10	0
904	3500	300	50	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1200	100	0.80	5	4.00	500	4.000

Laser Gain Recv.  
 Mont.

12 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	28	0.000	0.60	5	1.500	100	100	28	1.000	0
202	0	3500	1200	90	0.000	0.80	0	2.500	800	1200	90	0.700	0
203	120	3500	1200	90	0.000	0.80	0	3.000	1100	2500	90	0.000	0
204	120	3500	3000	100	0.000	0.80	0	3.000	1300	3000	100	0.000	0
205	120	3500	3000	100	0.000	0.80	0	3.000	1300	3000	100	0.000	0
206	120	3500	3000	100	0.000	0.80	0	3.000	1300	3000	100	0.000	0
207	120	3500	3000	100	0.000	0.80	0	3.000	1300	3000	100	0.000	0
208	120	3500	3000	100	0.000	0.80	0	3.000	1300	3000	100	0.000	0
209	120	3500	3000	100	0.000	0.80	0	3.000	1300	3000	100	0.000	0
210	120	3500	3000	100	0.000	0.80	0	3.000	1300	3000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# E-SUS6.0S

[Material] E-SUS6.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 6.00 [CutWay] Clean [NzlType] S\*\* [Head] Standard  
 [Foc] -3.5 [Reflect.] OFF [WACS] OFF [NzlDia] 3.00 [Lens] 7.5"  
 [AC] 6 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3000	100	40	0.80	5	0.3	0.700	0.170	0	201	0	101	0.00	Standard	No
2	1000	3000	1000	70	0.80	5	0.0	0.500	0.170	0	201	0	102	0.00	Standard	No
3	1600	3500	1600	85	0.80	5	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
4	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
5	2200	3500	2000	100	0.80	5	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
6	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
7	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
8	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	203	202	903	102	0.00	Standard	No
9	2000	3500	2000	100	0.80	5	0.0	0.300	0.170	203	202	903	105	0.00	Standard	No
(Etch)																
10	8000	1200	1000	20	0.10	5	0.0	1.500	0.000	0	0	905	0	3.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3200	500	25	0	0	0.000	0	1.500	0.20	5	0.5	5.000	0.00	OFF
102	3500	100	100	0	0	0.000	0	0.700	0.25	5	0.3	5.000	0.00	OFF
103	3500	100	100	0	0	0.000	0	0.700	0.25	5	0.3	5.000	0.00	OFF
104	3500	100	100	0	0	0.000	0	0.700	0.25	5	0.3	5.000	0.00	OFF
105	3500	100	100	0	0	0.000	0	0.120	0.40	5	0.0	5.000	0.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	2.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	3.0	0	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	300	15	10	0
902	3500	300	20	10	0
903	3500	300	30	10	0
904	3500	300	40	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	1200	100	0.80	5	4.00	250	4.000

Laser Gain Recv. Mont.

12 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	28	0.000	0.60	5	1.500	100	100	28	1.000	0
202	0	3500	1200	90	0.000	0.80	0	2.500	700	1200	90	0.700	0
203	120	3500	1200	95	0.000	0.80	0	3.000	1500	1200	95	0.000	0
204	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
205	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
206	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
207	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
208	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
209	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0
210	120	3500	1500	100	0.000	0.80	0	3.000	1600	1500	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



# FOR-ADJUST-FOCUS

[Material] FOR-ADJUST-FOCUS [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 1.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 10.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] (N/A)  
 [AC] 1 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	2000	2000	1500	100	0.80	4	0.5	1.500	0.200	0	201	0	101	0.00	Standard	No
2	2000	2000	1500	100	0.80	4	0.5	1.500	0.200	0	201	0	101	0.00	Standard	No
3	2000	2000	1500	100	0.80	4	0.5	1.500	0.400	0	201	0	101	0.00	Standard	No
4	2000	2000	1500	100	0.80	4	0.5	1.500	0.200	0	201	0	101	0.00	Standard	No
5	2000	2000	1500	100	0.80	4	0.5	1.500	0.200	0	201	0	101	0.00	Standard	No
6	2000	2000	1500	100	0.80	4	0.5	1.500	0.200	0	201	0	101	0.00	Standard	No
7	2000	2000	1500	100	0.80	4	0.5	1.500	0.200	0	201	0	101	0.00	Standard	No
8	2000	2000	1500	100	0.80	4	0.5	1.500	0.200	0	201	0	101	0.00	Standard	No
9	2000	2000	1500	100	0.80	4	0.5	1.500	0.200	0	201	0	101	0.00	Standard	No
(Etch)																
10	6000	1250	1000	22	0.10	4	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	100	0	0	0.000	0	0.300	0.80	4	0.5	2.000	0.00	OFF
102	2000	100	100	0	0	0.000	0	0.300	0.80	4	0.5	2.000	0.00	OFF
103	2000	100	100	0	0	0.000	0	0.300	0.80	4	0.5	2.000	0.00	OFF
104	2000	100	100	0	0	0.000	0	0.300	0.80	4	0.5	2.000	0.00	OFF
105	2000	100	100	0	0	0.000	0	0.300	0.80	4	0.5	2.000	0.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	500	100	60	0
902	2000	500	100	60	0
903	2000	500	100	60	0
904	2000	500	100	60	0
905	1250	500	20	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	0	0	0	0.00	0	0.00	0	0.000

Laser Mont.	Gain	Recv.
	0	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	100	0.000	0.80	0	1.000	500	100	100	0.000	0
202	0	2000	100	100	0.000	0.80	0	1.000	500	100	100	0.000	0
203	0	2000	100	100	0.000	0.80	0	1.000	500	100	100	0.000	0
204	0	2000	100	100	0.000	0.80	0	1.000	500	100	100	0.000	0
205	0	2000	100	100	0.000	0.80	0	1.000	500	100	100	0.000	0
206	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
207	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
208	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
209	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
210	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**POWER**

[Material] POWER [Oscillator] AF35LCG0EU-001  
 [Quality] POWER [Thic] 100.00 [CutWay] Acrylic [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] (N/A)  
 [AC] 20 [PreGas] 0 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	0	500	5	100	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
2	0	1000	5	100	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
3	0	2000	5	100	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
4	0	3000	5	100	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
5	0	3500	100	100	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
6	0	3500	100	50	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
7	0	3500	200	15	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
8	0	0	5	0	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
9	0	0	5	0	0.50	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No
(Etch)																
10	0	1250	1000	17	0.20	5	0.0	1.500	0.000	0	0	0	0	0.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	0	5	0	0	0	0.000	0	0.100	0.20	5	0.0	1.500	0.00	OFF
102	0	5	0	0	0	0.000	0	0.100	0.20	5	0.0	1.500	0.00	OFF
103	0	5	0	0	0	0.000	0	0.100	0.20	5	0.0	1.500	0.00	OFF
104	0	5	0	0	0	0.000	0	0.100	0.20	5	0.0	1.500	0.00	OFF
105	0	5	0	0	0	0.000	0	0.100	0.20	5	0.0	1.500	0.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	0	5	5	0	0
902	0	5	5	0	0
903	0	5	5	0	0
904	0	5	5	0	0
905	0	5	5	0	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	0	5	0	0.20	5	0.00	0	0.000

Laser Mont.	Gain	Recv.
	0	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	0	5	0	0.000	0.20	0	0.000	0	5	0	0.000	0
202	0	0	5	0	0.000	0.20	0	0.000	0	5	0	0.000	0
203	0	0	5	0	0.000	0.20	0	0.000	0	5	0	0.000	0
204	0	0	5	0	0.000	0.20	0	0.000	0	5	0	0.000	0
205	0	0	5	0	0.000	0.20	0	0.000	0	5	0	0.000	0
206	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
207	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
208	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
209	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0
210	0	0	5	0	0.000	0.00	0	0.000	0	5	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SC-SUS10.0S

[Material] SC-SUS10.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 10.00 [CutWay] Clean [NzlType] D\*:SC [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 7.00 [Lens] 7.5"  
 [AC] 8 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	4000	200	50	1.00	4	0.3	0.700	0.170	0	201	0	101	0.00	Standard	No
2	500	4000	500	65	1.00	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
3	600	4000	600	75	1.00	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
4	800	4000	800	75	1.00	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
5	800	4000	800	75	1.00	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
6	800	4000	800	75	1.00	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
7	800	4000	800	75	1.00	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
8	800	4000	800	75	1.00	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
9	800	4000	800	75	1.00	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
(Etch)																
10	6000	1200	1000	18	0.10	4	0.0	1.500	0.000	0	0	0	0	2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.5	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	2.000	0.30	4	0.3	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	2.000	0.30	4	0.3	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	2.000	0.30	4	0.3	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	2.000	0.30	4	0.3	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	1.5	0	Trace	No	0
OFF	OFF	6.0	0	Trace	No	0
OFF	OFF	6.0	0	Trace	No	0
OFF	OFF	6.0	0	Trace	No	0
OFF	OFF	6.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	30	0
902	3500	100	30	30	0
903	3500	100	30	30	0
904	3500	100	30	30	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	100	100	0.80	4	4.00	200	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	55	0.000	0.60	4	2.000	100	55	1.000	0	
202	0	3500	700	100	0.000	0.80	4	5.000	150	700	100	0.500	0
203	150	3500	100	40	0.000	1.00	0	7.000	100	100	40	0.000	0
204	150	3500	700	85	0.000	1.00	0	7.000	400	700	85	0.000	0
205	175	3500	700	90	0.000	1.00	0	7.000	500	700	90	0.000	0
206	175	3500	700	90	0.000	1.00	0	7.000	500	700	90	0.000	0
207	175	3500	700	90	0.000	1.00	0	7.000	500	700	90	0.000	0
208	175	3500	700	90	0.000	1.00	0	7.000	500	700	90	0.000	0
209	175	3500	700	90	0.000	1.00	0	7.000	500	700	90	0.000	0
210	175	3500	700	90	0.000	1.00	0	7.000	500	700	90	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SC-SUS12.0S-RF**

[Material] SC-SUS12.0S-RF [Oscillator] AF35LCG0EU-001  
 [Quality] SUS304 [Thic] 12.00 [CutWay] Clean [NzlType] D\*:\*SC [Head] Standard  
 [Foc] -1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 7.00 [Lens] 7.5"  
 [AC] 8 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	3500	100	45	1.20	4	0.3	0.700	0.170	0	201	0	101	0.00	Standard	No
2	250	3500	250	50	1.20	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
3	450	4000	500	70	1.20	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
4	500	4000	500	75	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
5	500	4000	500	75	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
6	500	4000	500	75	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
7	500	4000	500	75	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
8	500	4000	500	75	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
9	500	4000	500	75	1.20	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
(Etch)																
10	8000	1200	1000	18	0.10	4	0.0	1.500	0.000	0	0	0	0	1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.5	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	2.000	0.35	4	0.3	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	2.000	0.35	4	0.3	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	2.000	0.35	4	0.3	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	2.000	0.35	4	0.3	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	1.5	0	Trace	No	0
OFF	OFF	7.0	0	Trace	No	0
OFF	OFF	7.0	0	Trace	No	0
OFF	OFF	7.0	0	Trace	No	0
OFF	OFF	7.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	40	30	0
902	3500	100	40	30	0
903	3500	100	40	30	0
904	3500	100	40	30	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	4000	100	75	1.00	4	4.00	150	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	60	0.000	0.60	4	2.000	100	100	60	1.000	0
202	0	3500	100	100	0.000	0.80	4	7.000	150	100	100	0.300	0
203	150	3500	100	40	0.000	1.20	0	7.000	100	100	40	0.000	0
204	150	3500	500	85	0.000	1.20	0	7.000	600	500	85	0.000	0
205	175	3500	500	100	0.000	1.20	0	7.000	600	500	100	0.000	0
206	175	3500	500	100	0.000	1.20	0	7.000	600	500	100	0.000	0
207	175	3500	500	100	0.000	1.20	0	7.000	600	500	100	0.000	0
208	175	3500	500	100	0.000	1.20	0	7.000	600	500	100	0.000	0
209	175	3500	500	100	0.000	1.20	0	7.000	600	500	100	0.000	0
210	175	3500	500	100	0.000	1.20	0	7.000	600	500	100	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SC-SUS8.0S

[Material] SC-SUS8.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 8.00 [CutWay] Clean [NzlType] D\*:SC [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 7.00 [Lens] 7.5"  
 [AC] 8 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	4000	100	55	0.80	4	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	700	4000	700	70	0.80	4	0.0	0.300	0.170	203	202	0	101	0.00	Standard	No
3	1000	4000	1000	70	0.80	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
4	1200	4000	1200	75	0.80	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
5	1200	4000	1200	75	0.80	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
6	1200	4000	1200	75	0.80	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
7	1200	4000	1200	75	0.80	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
8	1200	4000	1200	75	0.80	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
9	1200	4000	1200	75	0.80	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
(Etch)																
10	6000	1200	1000	18	0.10	4	0.0	1.500	0.000	0	0	905	0	2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.5	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	1.500	0.35	4	0.3	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	1.500	0.35	4	0.3	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	1.500	0.35	4	0.3	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	1.500	0.35	4	0.3	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	4.0	0	Trace	No	0
OFF	OFF	4.0	0	Trace	No	0
OFF	OFF	4.0	0	Trace	No	0
OFF	OFF	4.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	20	0
902	3500	100	30	20	0
903	3500	100	30	20	0
904	3500	100	30	20	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	100	100	0.80	4	4.00	450	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	50	0.000	0.60	4	2.000	100	50	1.000	0	
202	0	3500	1000	100	0.000	0.80	4	4.000	450	600	100	0.500	0
203	120	3500	1000	65	0.000	0.80	0	6.000	600	1000	65	0.000	0
204	120	3500	1000	85	0.000	0.80	0	6.000	800	1000	85	0.000	0
205	120	3500	1000	100	0.000	0.80	0	6.000	800	1000	100	0.000	0
206	120	3500	1000	100	0.000	0.80	0	6.000	800	1000	100	0.000	0
207	120	3500	1000	100	0.000	0.80	0	6.000	800	1000	100	0.000	0
208	120	3500	1000	100	0.000	0.80	0	6.000	800	1000	100	0.000	0
209	120	3500	1000	100	0.000	0.80	0	6.000	800	1000	100	0.000	0
210	120	3500	1000	100	0.000	0.80	0	6.000	800	1000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2
			Pie.	Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SC-SUS9.0S**

[Material] SC-SUS9.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SUS304 [Thic] 9.00 [CutWay] Clean [NzlType] D\*:\*SC [Head] Standard  
 [Foc] -2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 7.00 [Lens] 7.5"  
 [AC] 8 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	4000	100	55	0.90	4	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	700	4000	700	70	0.90	4	0.0	0.300	0.170	203	202	0	102	0.00	Standard	No
3	800	4000	800	70	0.90	4	0.0	0.300	0.170	204	202	0	102	0.00	Standard	No
4	900	4000	900	75	0.90	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
5	900	4000	900	75	0.90	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
6	900	4000	900	75	0.90	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
7	900	4000	900	75	0.90	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
8	900	4000	900	75	0.90	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
9	900	4000	900	75	0.90	4	0.0	0.300	0.170	205	202	0	102	0.00	Standard	No
(Etch)																
10	6000	1200	1000	18	0.10	4	0.0	1.500	0.000	0	0	905	0	2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	100	100	0	0	0.000	0	2.000	0.25	4	0.5	5.000	-2.00	OFF
102	3500	100	100	0	0	0.000	0	1.500	0.30	4	0.3	5.000	-2.00	OFF
103	3500	100	100	0	0	0.000	0	1.500	0.30	4	0.3	5.000	-2.00	OFF
104	3500	100	100	0	0	0.000	0	1.500	0.30	4	0.3	5.000	-2.00	OFF
105	3500	100	100	0	0	0.000	0	1.500	0.30	4	0.3	5.000	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	3.5	0	Trace	No	0
OFF	OFF	3.5	0	Trace	No	0
OFF	OFF	3.5	0	Trace	No	0
OFF	OFF	3.5	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	20	0
902	3500	100	30	20	0
903	3500	100	30	20	0
904	3500	100	30	20	0
905	1200	1000	13	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	100	100	0.80	4	4.00	450	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	100	50	0.000	0.60	4	2.000	100	100	50	1.000	0
202	0	3500	1000	100	0.000	0.90	4	4.000	500	600	100	0.500	0
203	120	3500	1000	65	0.000	0.90	0	6.000	600	1000	65	0.000	0
204	120	3500	1000	85	0.000	0.90	0	6.000	800	1000	85	0.000	0
205	120	3500	1000	100	0.000	0.90	0	6.000	900	1000	100	0.000	0
206	120	3500	1000	100	0.000	0.90	0	6.000	900	1000	100	0.000	0
207	120	3500	1000	100	0.000	0.90	0	6.000	900	1000	100	0.000	0
208	120	3500	1000	100	0.000	0.90	0	6.000	900	1000	100	0.000	0
209	120	3500	1000	100	0.000	0.90	0	6.000	900	1000	100	0.000	0
210	120	3500	1000	100	0.000	0.90	0	6.000	900	1000	100	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC0.5**

[Material] SECC0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 0.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	10	0.25	3	0.0	1.500	0.120	0	0	0	101	0.00	Standard	No
2	1500	2000	500	35	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	45	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
4	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
5	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
6	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
7	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
8	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
9	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	200	8	0	1	0.300	4	0.500	0.15	2	0.3	3.500	-1.50	OFF
102	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
103	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
104	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
105	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	10	30	0
902	2000	100	10	30	0
903	2000	100	10	30	0
904	2000	100	10	30	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1000	45	0.20	3	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

10 0

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	10	0.000	0.25	0	1.000	250	200	10	0.000	0
202	0	2000	200	10	0.000	0.25	0	1.000	250	200	10	0.000	0
203	55	2000	100	10	0.000	0.25	0	1.500	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.25	0	1.000	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC0.8**

[Material] SECC0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 0.80 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	10	0.25	3	0.0	1.500	0.120	0	0	0	101	0.00	Standard	No
2	1500	2000	500	35	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	45	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
4	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
5	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
6	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
7	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
8	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
9	3000	2000	2000	55	0.25	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	200	8	0	1	0.300	4	0.500	0.15	2	0.3	3.500	-1.50	OFF
102	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
103	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
104	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
105	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	10	30	0
902	2000	100	10	30	0
903	2000	100	10	30	0
904	2000	100	10	30	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1000	45	0.20	3	4.00	1000	4.000

Laser Mont.	Gain	Recv.
	10	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	10	0.000	0.25	0	1.000	250	200	10	0.000	0
202	0	2000	200	10	0.000	0.25	0	1.000	250	200	10	0.000	0
203	55	2000	100	10	0.000	0.25	0	1.500	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.25	0	1.000	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.25	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**SECC1.0**

[Material] SECC1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	10	0.30	3	0.0	1.500	0.120	0	0	0	101	0.00	Standard	No
2	1500	2000	500	35	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	45	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
4	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
5	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
6	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
7	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
8	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
9	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	200	8	0	1	0.300	4	0.500	0.15	2	0.3	3.500	-1.50	OFF
102	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
103	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
104	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
105	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	5	30	0
902	2000	100	10	30	0
903	2000	100	20	30	0
904	2000	100	30	30	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1000	45	0.20	3	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	10	0.000	0.30	0	1.000	250	200	10	0.000	0
202	0	2000	200	10	0.000	0.30	0	1.000	250	200	10	0.000	0
203	55	2000	100	10	0.000	0.30	0	1.500	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.000	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC1.0S**

[Material] SECC1.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SECC [Thic] 1.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	10	0.30	3	0.0	1.500	0.150	0	0	0	101	0.00	Standard	No
2	1500	2000	500	45	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	60	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
4	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
5	3200	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
6	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
7	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
8	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
9	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.400	0.15	2	0.3	3.500	-2.00	OFF
102	2000	100	6	0	0	0.000	0	0.200	0.15	2	0.3	3.500	-2.00	OFF
103	2000	100	6	0	0	0.000	0	0.200	0.15	2	0.3	3.500	-2.00	OFF
104	2000	100	6	0	0	0.000	0	0.200	0.15	2	0.3	3.500	-2.00	OFF
105	2000	100	6	0	0	0.000	0	0.200	0.15	2	0.3	3.500	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	10	10	0
902	2000	100	20	10	0
903	2000	100	30	10	0
904	2000	100	40	10	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2500	1000	45	0.20	3	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	10	0.000	0.30	0	1.000	250	200	10	0.000	0
202	0	2000	200	10	0.000	0.30	0	1.000	250	200	10	0.000	0
203	55	2000	100	10	0.000	0.30	0	1.500	600	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.000	600	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC1.2**

[Material] SECC1.2 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.20 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	10	0.30	3	0.0	1.500	0.120	0	0	0	101	0.00	Standard	No
2	1500	2000	500	35	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	45	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
4	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
5	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
6	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
7	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
8	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
9	3000	2000	2000	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	200	8	0	1	0.300	4	0.500	0.15	2	0.3	3.500	-1.50	OFF
102	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
103	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
104	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
105	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	5	30	0
902	2000	100	10	30	0
903	2000	100	20	30	0
904	2000	100	30	30	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1000	45	0.20	3	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	10	0.000	0.30	0	1.000	250	200	10	0.000	0
202	0	2000	200	10	0.000	0.30	0	1.000	250	200	10	0.000	0
203	55	2000	100	10	0.000	0.30	0	1.500	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.000	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SECC1.2S

[Material] SECC1.2S [Oscillator] AF35LCG0EU-001  
 [Quality] SECC [Thic] 1.20 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	10	0.30	3	0.0	1.500	0.150	0	0	0	101	0.00	Standard	No
2	1500	2000	500	45	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	60	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
4	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
5	3200	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
6	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
7	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
8	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
9	3000	2000	1000	70	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.400	0.15	2	0.3	3.500	-3.00	OFF
102	2000	100	6	0	0	0.000	0	0.200	0.15	2	0.3	3.500	-3.00	OFF
103	2000	100	6	0	0	0.000	0	0.200	0.15	2	0.3	3.500	-3.00	OFF
104	2000	100	6	0	0	0.000	0	0.200	0.15	2	0.3	3.500	-3.00	OFF
105	2000	100	6	0	0	0.000	0	0.200	0.15	2	0.3	3.500	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	10	20	0
902	2000	100	20	20	0
903	2000	100	30	20	0
904	2000	100	40	20	0
905	1200	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2500	1000	45	0.20	3	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	10	0.000	0.30	0	1.000	250	200	10	0.000	0
202	0	2000	200	10	0.000	0.30	0	1.000	250	200	10	0.000	0
203	55	2000	100	10	0.000	0.30	0	1.500	600	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.000	600	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC1.5**

[Material] SECC1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 1.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1200	200	30	0.30	3	0.0	1.500	0.120	0	0	0	101	0.00	Standard	No
2	1500	1200	500	60	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
3	2500	1200	1500	90	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
4	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
5	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
6	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
7	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
8	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
9	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	200	8	0	1	0.300	4	0.600	0.15	2	0.3	3.500	-1.50	OFF
102	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
103	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
104	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
105	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1200	100	10	30	0
902	1200	100	20	30	0
903	1200	100	30	30	0
904	1200	100	40	30	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.30	3	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1200	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
202	0	1200	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
203	55	1200	100	10	0.000	0.30	0	1.500	300	100	10	0.000	0
204	95	1200	100	10	0.000	0.30	0	1.000	300	100	10	0.000	0
205	130	1200	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
206	130	1200	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
207	130	1200	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
208	130	1200	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
209	130	1200	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
210	130	1200	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC1.5S**

[Material] SECC1.5S [Oscillator] AF35LCG0EU-001  
 [Quality] SECC [Thic] 1.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	15	0.30	3	0.0	1.500	0.150	0	0	0	101	0.00	Standard	No
2	1500	2000	500	55	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	75	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
4	3000	2000	1000	85	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
5	3200	2000	1000	85	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
6	3000	2000	1000	85	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
7	3000	2000	1000	85	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
8	3000	2000	1000	85	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
9	3000	2000	1000	85	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-3.00	OFF
102	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
103	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
104	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
105	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	10	30	0
902	2000	100	20	30	0
903	2000	100	30	30	0
904	2000	100	40	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1000	70	0.20	3	4.00	1000	4.000

Laser Gain Recv. Mont.

5 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
202	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
203	55	2000	100	10	0.000	0.30	0	1.500	600	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC2.0**

[Material] SECC2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1000	200	30	0.30	3	0.0	1.500	0.120	0	0	0	101	0.00	Standard	No
2	1500	1000	500	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
3	2500	1000	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
4	3000	1000	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
5	3000	1000	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
6	3000	1000	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
7	3000	1000	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
8	3000	1000	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
9	3000	1000	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	200	8	0	1	0.300	4	0.600	0.15	2	0.3	3.500	-1.50	OFF
102	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
103	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
104	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
105	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1000	100	10	10	0
902	1000	100	20	10	0
903	1000	100	30	10	0
904	1000	100	40	10	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.30	3	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
202	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
203	55	2000	100	10	0.000	0.30	0	2.500	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.500	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC2.0S**

[Material] SECC2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	15	0.30	3	0.0	1.500	0.150	0	0	0	101	0.00	Standard	No
2	1500	2000	500	55	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	75	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
4	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
5	3000	2000	1000	85	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
6	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
7	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
8	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
9	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	20	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-3.00	OFF
102	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
103	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
104	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
105	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	10	30	0
902	2000	100	10	30	0
903	2000	100	10	30	0
904	2000	100	10	30	0
905	1000	1000	12	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1000	70	0.20	3	4.00	1000	4.000

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5 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
202	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
203	55	2000	100	10	0.000	0.30	0	1.500	600	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**SECC2.5**

[Material] SECC2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 2.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1000	200	30	0.30	3	0.0	1.500	0.120	0	0	0	101	0.00	Standard	No
2	1500	1000	500	55	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
3	2500	1000	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
4	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
5	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
6	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
7	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
8	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
9	3000	1200	1500	100	0.30	3	0.0	1.500	0.120	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	200	8	0	1	0.300	4	0.600	0.15	2	0.3	3.500	-1.50	OFF
102	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
103	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
104	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF
105	2000	200	10	0	0	0.000	0	0.300	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1200	100	10	30	0
902	1200	100	10	30	0
903	1200	100	10	30	0
904	1200	100	10	30	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.30	3	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

8 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
202	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
203	55	2000	100	10	0.000	0.30	0	2.000	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.000	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC2.5S**

[Material] SECC2.5S [Oscillator] AF35LCG0EU-001  
 [Quality] SECC [Thic] 2.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	15	0.30	3	0.0	1.500	0.150	0	0	0	101	0.00	Standard	No
2	1500	2000	500	55	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
3	2500	2000	1000	75	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
4	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
5	3000	2000	1000	85	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
6	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
7	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
8	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
9	3000	2000	1000	80	0.30	3	0.0	1.500	0.150	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-3.00	OFF
102	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
103	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
104	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF
105	2000	100	6	0	0	0.000	0	0.700	0.15	2	0.3	3.500	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	10	30	0
902	2000	100	15	30	0
903	2000	100	20	30	0
904	2000	100	25	30	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1000	70	0.20	3	4.00	1000	4.000

Laser Mont.	Gain	Recv.
	5	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
202	0	2000	200	15	0.000	0.30	0	1.000	250	200	15	0.000	0
203	55	2000	100	10	0.000	0.30	0	2.000	600	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.000	600	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	600	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC3.0**

[Material] SECC3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 3.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	800	100	20	0.30	3	0.3	1.500	0.120	0	201	0	101	-0.70	Standard	No
2	1500	800	1000	45	0.30	3	0.3	1.500	0.120	200	201	903	102	0.00	Standard	No
3	2000	1000	1500	100	0.30	3	0.3	1.500	0.120	200	201	903	102	0.00	Standard	No
4	2500	1200	2000	100	0.30	3	0.3	1.500	0.120	200	201	903	102	0.00	Standard	No
5	2500	1200	2000	100	0.30	3	0.3	1.500	0.120	200	201	903	102	0.00	Standard	No
6	2500	1200	2000	100	0.30	3	0.3	1.500	0.120	200	201	903	102	0.00	Standard	No
7	2500	1200	2000	100	0.30	3	0.3	1.500	0.120	200	201	903	102	0.00	Standard	No
8	2500	1200	2000	100	0.30	3	0.3	1.500	0.120	200	201	903	102	0.00	Standard	No
9	2500	1200	2000	100	0.30	3	0.3	1.500	0.120	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	200	8	0	1	0.300	4	1.200	0.15	2	0.3	3.500	-1.50	OFF
102	2000	80	10	0	0	0.000	0	0.900	0.15	2	0.3	3.500	-1.50	OFF
103	2000	80	10	0	0	0.000	0	0.900	0.15	2	0.3	3.500	-1.50	OFF
104	2000	80	10	0	0	0.000	0	0.900	0.15	2	0.3	3.500	-1.50	OFF
105	2000	80	10	0	0	0.000	0	0.900	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1200	50	20	10	0
902	1200	50	30	10	0
903	1200	50	40	10	0
904	1200	50	50	10	0
905	1200	1000	11	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	60	0.30	3	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

6 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1200	50	35	0.000	0.30	0	1.000	100	50	35	0.000	0
202	0	1200	50	35	0.000	0.30	0	1.000	100	50	35	0.000	0
203	55	1200	50	15	0.000	0.30	0	3.000	200	50	10	0.000	0
204	95	1200	50	15	0.000	0.30	0	1.500	200	50	10	0.000	0
205	130	1200	50	15	0.000	0.30	0	0.500	200	50	10	0.000	0
206	130	1200	50	15	0.000	0.30	0	0.500	200	50	10	0.000	0
207	130	1200	50	15	0.000	0.30	0	0.500	200	50	10	0.000	0
208	130	1200	50	15	0.000	0.30	0	0.500	200	50	10	0.000	0
209	130	1200	50	15	0.000	0.30	0	0.500	200	50	10	0.000	0
210	130	1200	50	15	0.000	0.30	0	0.500	200	50	10	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SECC3.0S**

[Material] SECC3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SECC [Thic] 3.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	300	2000	100	15	0.30	3	0.0	1.500	0.150	0	201	0	101	0.00	Standard	No
2	1000	2000	300	20	0.30	3	0.0	1.500	0.150	200	201	902	102	0.00	Standard	No
3	2000	2000	1500	40	0.30	3	0.0	1.500	0.150	200	201	902	102	0.00	Standard	No
4	2500	2000	2000	50	0.30	3	0.0	1.500	0.150	200	201	902	102	0.00	Standard	No
5	2500	2000	2000	50	0.30	3	0.0	1.500	0.150	200	201	902	102	0.00	Standard	No
6	2500	2000	2000	50	0.30	3	0.0	1.500	0.150	200	201	902	102	0.00	Standard	No
7	2500	2000	2000	50	0.30	3	0.0	1.500	0.150	200	201	902	102	0.00	Standard	No
8	2500	2000	2000	50	0.30	3	0.0	1.500	0.150	200	201	902	102	0.00	Standard	No
9	2500	2000	2000	50	0.30	3	0.0	1.500	0.150	200	201	902	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	2.000	0.15	2	0.3	3.500	-3.00	OFF
102	2000	100	8	0	0	0.000	0	1.500	0.15	2	0.3	3.500	-3.00	OFF
103	2000	100	8	0	0	0.000	0	1.500	0.15	2	0.3	3.500	-3.00	OFF
104	2000	100	8	0	0	0.000	0	1.500	0.15	2	0.3	3.500	-3.00	OFF
105	2000	100	8	0	0	0.000	0	1.500	0.15	2	0.3	3.500	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	100	10	50	0
902	2000	100	20	50	0
903	2000	100	30	50	0
904	2000	100	40	50	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	60	0.20	3	4.00	1000	4.000

Laser Gain Recv. Mont.

5 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	25	0.000	0.30	0	1.000	200	100	25	0.000	0
202	0	2000	100	25	0.000	0.30	0	1.000	200	100	25	0.000	0
203	55	2000	100	30	0.000	0.30	0	2.000	100	100	30	0.000	0
204	95	2000	100	30	0.000	0.30	0	1.000	100	100	30	0.000	0
205	130	2000	100	30	0.000	0.30	0	0.500	100	100	30	0.000	0
206	130	2000	100	30	0.000	0.30	0	0.500	100	100	30	0.000	0
207	130	2000	100	30	0.000	0.30	0	0.500	100	100	30	0.000	0
208	130	2000	100	30	0.000	0.30	0	0.500	100	100	30	0.000	0
209	130	2000	100	30	0.000	0.30	0	0.500	100	100	30	0.000	0
210	130	2000	100	30	0.000	0.30	0	0.500	100	100	30	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SPC0.5

[Material] SPC0.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 0.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	900	200	10	0.20	3	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	900	500	20	0.20	2	0.0	1.500	0.140	0	0	0	102	0.00	Standard	No
3	6300	900	2000	90	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
4	7000	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
5	7300	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	7000	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
7	7000	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
8	7000	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
9	7000	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.500	0.15	3	0.3	3.500	-1.50	OFF
102	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
103	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
104	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
105	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	20	70	0
902	900	100	30	70	0
903	1000	100	20	70	0
904	1000	100	30	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	2000	65	0.12	2	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

5 0

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	900	100	35	0.000	0.20	0	1.000	300	100	35	0.000	0
202	0	900	100	35	0.000	0.20	0	1.000	300	100	35	0.000	0
203	55	900	100	10	0.000	0.20	0	2.500	300	100	10	0.000	0
204	95	900	100	10	0.000	0.20	0	1.500	300	100	10	0.000	0
205	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
206	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
207	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
208	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
209	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
210	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC0.8**

[Material] SPC0.8 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 0.80 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	900	200	10	0.20	3	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	900	500	20	0.20	2	0.0	1.500	0.140	0	0	0	102	0.00	Standard	No
3	6300	900	2000	90	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
4	6700	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
5	7000	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	6700	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
7	6700	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
8	6700	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
9	6700	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.500	0.15	3	0.3	3.500	-1.50	OFF
102	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
103	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
104	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
105	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	20	70	0
902	900	100	30	70	0
903	1000	100	20	70	0
904	1000	100	30	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	2000	65	0.12	2	4.00	1000	4.000

Laser Gain Recv. Mont.

5 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	900	100	35	0.000	0.20	0	1.000	300	100	35	0.000	0
202	0	900	100	35	0.000	0.20	0	1.000	300	100	35	0.000	0
203	55	900	100	10	0.000	0.20	0	2.500	300	100	10	0.000	0
204	95	900	100	10	0.000	0.20	0	1.500	300	100	10	0.000	0
205	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
206	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
207	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
208	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
209	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
210	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
	Pie.	Appr.		
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SPC1.0

[Material] SPC1.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	900	200	10	0.20	3	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	900	500	20	0.20	2	0.0	1.500	0.140	0	0	0	102	0.00	Standard	No
3	5300	900	2000	90	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
4	6300	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
5	6500	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	6300	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
7	6300	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
8	6300	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
9	6300	900	5000	100	0.20	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.500	0.15	3	0.3	3.500	-1.50	OFF
102	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
103	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
104	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
105	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	20	70	0
902	900	100	30	70	0
903	1000	100	20	70	0
904	1000	100	30	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	2000	65	0.12	2	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

5 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	900	100	35	0.000	0.20	0	1.000	300	100	35	0.000	0
202	0	900	100	35	0.000	0.20	0	1.000	300	100	35	0.000	0
203	55	900	100	10	0.000	0.20	0	1.500	300	100	10	0.000	0
204	95	900	100	10	0.000	0.20	0	1.000	300	100	10	0.000	0
205	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
206	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
207	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
208	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
209	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
210	130	900	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SPC1.0E

[Material] SPC1.0E [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Standard [NzlType] S\*\*E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 5"  
 [AC] 12 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	15	0.25	1	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	3000	2000	2000	50	0.25	1	0.0	0.700	0.160	0	201	0	105	0.00	Medium	No
3	7200	2000	4000	70	0.25	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
4	8000	2000	5000	75	0.25	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
5	8500	2000	5000	80	0.25	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
6	8000	2000	5000	75	0.25	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
7	8000	2000	5000	75	0.25	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
8	7200	2000	4000	70	0.25	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
9	8000	2000	5000	75	0.25	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1700	200	10	10	1	0.500	4	1.200	0.15	2	0.3	3.500	-2.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	6.000	-2.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	6.000	-2.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	6.000	-2.00	1
105	2000	100	100	0	0	0.000	0	0.050	0.25	1	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	200	5	10	0
902	2000	200	10	10	0
903	2000	200	15	10	0
904	2000	200	20	10	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.10	3	4.00	1000	4.000

Laser Mont.	Gain	Recv.
	5	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	100	0.000	0.25	0	1.500	500	100	100	0.000	0
202	0	2000	100	100	0.000	0.25	0	1.500	1000	100	100	0.000	0
203	150	2000	200	0	0.080	0.25	0	0.000	500	100	70	0.000	0
204	150	2000	200	0	0.080	0.25	0	0.000	500	100	70	0.000	0
205	170	2000	200	0	0.080	0.25	0	0.000	500	100	70	0.000	0
206	170	2000	200	0	0.000	0.25	0	0.000	500	100	70	0.000	0
207	170	2000	200	0	0.000	0.25	0	0.000	500	100	70	0.000	0
208	170	2000	200	0	0.000	0.25	0	0.000	500	100	70	0.000	0
209	170	2000	200	0	0.000	0.25	0	0.000	500	100	70	0.000	0
210	170	2000	200	0	0.000	0.25	0	0.000	500	100	70	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



SPC1.0E-2

[Material] SPC1.0E-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Standard [NzlType] S\*:E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 5"  
 [AC] 12 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	15	0.30	1	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	3000	2000	2000	60	0.30	1	0.0	0.700	0.160	0	201	0	105	0.00	Medium	No
3	7200	2000	4000	70	0.30	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
4	8500	2000	5000	75	0.30	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
5	9000	2000	5000	80	0.30	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
6	8500	2000	5000	75	0.30	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
7	8500	2000	5000	75	0.30	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
8	7200	2000	5000	70	0.30	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
9	8500	2000	5000	75	0.30	1	0.0	0.700	0.160	203	201	0	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1700	200	10	10	1	0.500	4	1.200	0.15	2	0.3	3.500	-2.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.30	1	0.0	6.000	-2.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.30	1	0.0	6.000	-2.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.30	1	0.0	6.000	-2.00	1
105	2000	100	100	0	0	0.000	0	0.050	0.30	1	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	200	5	10	0
902	2000	200	10	10	0
903	2000	200	15	10	0
904	2000	200	20	10	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.10	3	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	100	0.000	0.30	0	1.500	500	100	100	0.000	0
202	0	2000	100	100	0.000	0.30	0	1.500	1000	100	100	0.000	0
203	150	2000	200	0	0.080	0.30	0	0.000	500	100	70	0.000	0
204	150	2000	200	0	0.080	0.30	0	0.000	500	100	70	0.000	0
205	170	2000	200	0	0.080	0.30	0	0.000	500	100	70	0.000	0
206	170	2000	200	0	0.080	0.30	0	0.000	500	100	70	0.000	0
207	170	2000	200	0	0.080	0.30	0	0.000	500	100	70	0.000	0
208	170	2000	200	0	0.080	0.30	0	0.000	500	100	70	0.000	0
209	170	2000	200	0	0.080	0.30	0	0.000	500	100	70	0.000	0
210	170	2000	200	0	0.080	0.30	0	0.000	500	100	70	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC1.0S**

[Material] SPC1.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] -0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	900	200	20	0.15	3	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	900	500	30	0.15	2	0.0	1.500	0.140	0	0	0	102	0.00	Standard	No
3	4500	900	2000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	5500	1000	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.500	0.15	3	0.3	3.500	-1.50	OFF
102	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
103	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
104	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
105	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	20	50	0
902	900	100	20	50	0
903	900	100	20	50	0
904	900	100	20	50	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	2000	65	0.12	2	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	900	100	20	0.000	0.15	0	1.000	300	100	20	0.000	0
202	0	900	100	20	0.000	0.15	0	1.000	300	100	20	0.000	0
203	55	900	100	10	0.000	0.15	0	1.500	300	100	10	0.000	0
204	95	900	100	10	0.000	0.15	0	1.000	300	100	10	0.000	0
205	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
206	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
207	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
208	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
209	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
210	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC1.0SE**

[Material] SPC1.0SE [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Standard [NzlType] S\*:E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 2 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	1600	100	20	0.20	3	0.0	0.700	0.140	0	0	0	101	0.00	Standard	No
2	2000	1600	2000	35	0.20	3	0.0	0.700	0.140	0	202	0	105	0.00	Medium	No
3	6300	1600	2000	80	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
4	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
5	7500	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
6	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
7	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
8	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
9	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1100	1000	13	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	8	7	1	0.400	15	0.800	0.15	2	0.3	3.500	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
105	2000	100	100	0	0	0.000	0	0.010	0.20	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1600	250	5	10	0
902	1600	250	10	10	0
903	1600	250	15	10	0
904	1600	250	20	10	0
905	1100	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1500	1000	35	0.10	1	3.00	800	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1500	150	17	0.000	0.20	0	1.000	300	150	30	1.200	0
202	0	1500	1000	50	0.000	0.20	0	1.000	2000	2000	100	1.500	0
203	120	1600	20	20	0.000	0.20	0	1.000	100	20	20	0.000	0
204	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
205	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
206	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
207	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
208	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
209	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
210	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC1.0SE-2**

[Material] SPC1.0SE-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	1600	100	20	0.20	3	0.0	0.700	0.140	0	0	0	101	0.00	Standard	No
2	2000	1600	2000	35	0.20	3	0.0	0.700	0.140	0	202	0	105	0.00	Medium	No
3	6800	1600	2000	80	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
4	7500	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
5	8000	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
6	7500	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
7	7500	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
8	7500	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
9	7500	1600	2000	85	0.20	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1100	1000	13	0.10	1	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	8	7	1	0.400	15	0.800	0.15	2	0.3	3.500	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.2	5.000	-3.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
105	2000	100	100	0	0	0.000	0	0.010	0.20	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1600	250	5	10	0
902	1600	250	10	10	0
903	1600	250	15	10	0
904	1600	250	20	10	0
905	1100	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1500	1000	35	0.10	1	3.00	800	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1500	150	17	0.000	0.20	0	1.000	300	150	30	1.200	0
202	0	1300	1000	50	0.000	0.20	0	1.000	2000	2000	100	1.500	0
203	120	1600	20	20	0.000	0.20	0	1.000	100	20	20	0.000	0
204	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
205	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
206	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
207	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
208	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
209	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0
210	120	1600	500	30	0.000	0.20	0	1.000	1000	500	30	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SPC1.2

[Material] SPC1.2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	900	200	10	0.15	3	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	900	500	20	0.15	2	0.0	1.500	0.140	0	0	0	102	0.00	Standard	No
3	5000	900	2000	100	0.15	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
4	5800	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
5	6200	1000	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	5800	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
7	5800	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
8	5800	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
9	5800	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	901	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.500	0.15	3	0.3	3.500	-1.50	OFF
102	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
103	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
104	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF
105	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	20	70	0
902	900	100	30	70	0
903	1000	100	20	70	0
904	1000	100	30	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	2000	65	0.12	2	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	900	100	30	0.000	0.15	0	1.000	300	100	30	0.000	0
202	0	900	100	30	0.000	0.15	0	1.000	300	100	30	0.000	0
203	55	900	100	20	0.000	0.15	0	2.000	300	100	20	0.000	0
204	95	900	100	20	0.000	0.15	0	1.000	300	100	20	0.000	0
205	130	900	100	20	0.000	0.15	0	0.500	300	100	20	0.000	0
206	130	900	100	20	0.000	0.15	0	0.500	300	100	20	0.000	0
207	130	900	100	20	0.000	0.15	0	0.500	300	100	20	0.000	0
208	130	900	100	20	0.000	0.15	0	0.500	300	100	20	0.000	0
209	130	900	100	20	0.000	0.15	0	0.500	300	100	20	0.000	0
210	130	900	100	20	0.000	0.15	0	0.500	300	100	20	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SPC1.2E

[Material] SPC1.2E [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 5"  
 [AC] 12 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	15	0.25	1	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	3000	2000	2000	50	0.25	1	0.0	0.700	0.160	0	201	0	105	0.00	Medium	No
3	6500	2000	4000	70	0.25	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
4	7500	2000	5000	75	0.25	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
5	8000	2000	5000	80	0.25	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
6	7500	2000	5000	75	0.25	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
7	7500	2000	5000	75	0.25	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
8	6500	2000	4000	70	0.25	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
9	7500	2000	5000	75	0.25	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1700	200	10	10	1	0.500	4	1.200	0.15	2	0.3	3.500	-2.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	6.000	-2.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	6.000	-2.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	6.000	-2.00	1
105	2000	100	100	0	0	0.000	0	0.050	0.25	1	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	200	20	30	0
902	2000	200	25	30	0
903	2000	200	30	30	0
904	2000	200	35	30	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.10	3	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	100	0.000	0.25	0	1.500	500	100	100	0.000	0
202	0	2000	100	100	0.000	0.25	0	1.500	800	100	100	0.000	0
203	150	2000	200	0	0.080	0.25	0	0.500	2000	100	50	0.000	0
204	150	2000	200	0	0.080	0.25	0	0.500	2000	100	50	0.000	0
205	170	2000	200	0	0.080	0.25	0	0.500	2000	100	50	0.000	0
206	170	2000	200	0	0.080	0.25	0	0.500	2000	100	50	0.000	0
207	170	2000	200	0	0.080	0.25	0	0.500	2000	100	50	0.000	0
208	170	2000	200	0	0.080	0.25	0	0.500	2000	100	50	0.000	0
209	170	2000	200	0	0.080	0.25	0	0.500	2000	100	50	0.000	0
210	170	2000	200	0	0.080	0.25	0	0.500	2000	100	50	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SPC1.2E-2

[Material] SPC1.2E-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 5"  
 [AC] 12 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	15	0.30	1	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	3000	2000	2000	50	0.30	1	0.0	0.700	0.160	0	201	0	105	0.00	Medium	No
3	7300	2000	4000	75	0.30	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
4	8000	2000	5000	80	0.30	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
5	8500	2000	5000	85	0.30	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
6	8000	2000	5000	80	0.30	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
7	8000	2000	5000	80	0.30	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
8	7300	2000	4000	75	0.30	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
9	8000	2000	5000	80	0.30	1	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1700	200	10	10	1	0.500	4	1.200	0.15	2	0.3	3.500	-2.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.30	1	0.0	6.000	-2.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.30	1	0.0	6.000	-2.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.30	1	0.0	6.000	-2.00	1
105	2000	100	100	0	0	0.000	0	0.050	0.30	1	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	200	20	30	0
902	2000	200	25	30	0
903	2000	200	30	30	0
904	2000	200	35	30	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.10	3	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	100	0.000	0.30	0	1.500	500	100	100	0.000	0
202	0	2000	100	100	0.000	0.30	0	1.500	1000	100	100	0.000	0
203	150	2000	200	0	0.080	0.30	0	1.000	2000	100	20	0.000	0
204	150	2000	200	0	0.080	0.30	0	0.500	2000	100	55	0.000	0
205	170	2000	200	0	0.080	0.30	0	0.500	2000	100	55	0.000	0
206	170	2000	200	0	0.080	0.30	0	0.500	2000	100	55	0.000	0
207	170	2000	200	0	0.080	0.30	0	0.500	2000	100	55	0.000	0
208	170	2000	200	0	0.080	0.30	0	0.500	2000	100	55	0.000	0
209	170	2000	200	0	0.080	0.30	0	0.500	2000	100	55	0.000	0
210	170	2000	200	0	0.080	0.30	0	0.500	2000	100	55	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SPC1.2S

[Material] SPC1.2S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	900	200	20	0.15	3	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	900	500	35	0.15	2	0.0	1.500	0.140	0	0	0	102	0.00	Standard	No
3	4500	900	2000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	5000	900	5000	100	0.15	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.500	0.15	3	0.3	3.500	-2.00	OFF
102	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-2.00	OFF
103	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-2.00	OFF
104	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-2.00	OFF
105	2000	100	6	0	0	0.000	0	0.200	0.15	3	0.3	3.500	-2.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	10	50	0
902	900	100	20	50	0
903	900	100	30	50	0
904	900	100	40	50	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	2000	65	0.12	2	4.00	1000	4.000

Laser Gain Recv. Mont.

5 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	900	100	45	0.000	0.15	0	1.000	300	100	45	0.000	0
202	0	900	100	45	0.000	0.15	0	1.000	300	100	45	0.000	0
203	55	900	100	10	0.000	0.15	0	1.500	300	100	10	0.000	0
204	95	900	100	10	0.000	0.15	0	1.000	300	100	10	0.000	0
205	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
206	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
207	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
208	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
209	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0
210	130	900	100	10	0.000	0.15	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**SPC1.2SE**

[Material] SPC1.2SE [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 2 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	1600	100	20	0.20	3	0.0	0.700	0.140	0	0	0	101	0.00	Standard	No
2	2000	1600	2000	45	0.20	3	0.0	0.700	0.140	0	202	0	105	0.00	Medium	No
3	6000	1600	2000	80	0.20	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
4	6500	1600	2000	85	0.20	3	0.0	0.700	0.140	204	202	904	105	0.00	Medium	No
5	7000	1600	2000	90	0.20	3	0.0	0.700	0.140	204	202	904	105	0.00	Medium	No
6	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	204	202	904	105	0.00	Medium	No
7	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	204	202	904	105	0.00	Medium	No
8	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	204	202	904	105	0.00	Medium	No
9	7000	1600	2000	85	0.20	3	0.0	0.700	0.140	204	202	904	105	0.00	Medium	No
(Etch)																
10	10000	1100	1000	13	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	8	7	1	0.400	15	0.800	0.25	2	0.5	3.500	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
105	2000	100	100	0	0	0.000	0	0.010	0.20	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1600	250	5	30	0
902	1600	250	10	30	0
903	1600	250	20	30	0
904	1600	250	30	30	0
905	1600	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1500	1000	35	0.10	1	3.00	800	4.000

Laser Gain Recv.  
 Mont.

8 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1600	150	17	0.000	0.20	0	1.000	300	150	30	1.200	0
202	0	1600	1000	50	0.000	0.20	0	1.000	2000	2000	100	1.500	0
203	120	1600	20	20	0.000	0.20	0	1.000	100	20	20	0.000	0
204	120	1600	500	30	0.000	0.20	0	1.000	2000	500	30	0.000	0
205	120	1600	500	30	0.000	0.20	0	1.000	2000	500	30	0.000	0
206	120	1600	500	30	0.000	0.20	0	1.000	2000	500	30	0.000	0
207	120	1600	500	30	0.000	0.20	0	1.000	2000	500	30	0.000	0
208	120	1600	500	30	0.000	0.20	0	1.000	2000	500	30	0.000	0
209	120	1600	500	30	0.000	0.20	0	1.000	2000	500	30	0.000	0
210	120	1600	500	30	0.000	0.20	0	1.000	2000	500	30	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC1.2SE-2**

[Material] SPC1.2SE-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.20 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	1600	100	20	0.25	3	0.0	0.700	0.140	0	0	0	101	0.00	Standard	No
2	2000	1600	2000	45	0.25	3	0.0	0.700	0.140	0	202	0	105	0.00	Medium	No
3	6000	1600	2000	80	0.25	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
4	7000	1600	2000	85	0.25	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
5	7500	1600	2000	90	0.25	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
6	7000	1600	2000	85	0.25	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
7	7000	1600	2000	85	0.25	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
8	7000	1600	2000	85	0.25	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
9	7000	1600	2000	85	0.25	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1100	1000	13	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	8	7	1	0.400	15	0.800	0.15	2	0.3	3.500	-3.00	OFF
102	2200	100	100	0	0	0.000	0	0.100	0.25	1	0.0	5.000	-3.00	1
103	2200	100	100	0	0	0.000	0	0.100	0.25	1	0.0	5.000	-3.00	1
104	2200	100	100	0	0	0.000	0	0.100	0.25	1	0.0	5.000	-3.00	1
105	2200	100	100	0	0	0.000	0	0.010	0.25	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1600	250	5	30	0
902	1600	250	10	30	0
903	1600	250	20	30	0
904	1600	250	30	30	0
905	1600	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1500	1000	35	0.10	1	3.00	800	4.000

Laser Gain Recv. Mont.

8 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1600	150	17	0.000	0.25	0	1.000	300	150	30	1.200	0
202	0	1600	1000	50	0.000	0.25	0	1.000	2000	2000	100	1.500	0
203	120	1600	20	20	0.000	0.25	0	1.000	100	20	20	0.000	0
204	120	1600	500	30	0.000	0.25	0	1.000	2000	500	30	0.000	0
205	120	1600	500	30	0.000	0.25	0	1.000	2000	500	30	0.000	0
206	120	1600	500	30	0.000	0.25	0	1.000	2000	500	30	0.000	0
207	120	1600	500	30	0.000	0.25	0	1.000	2000	500	30	0.000	0
208	120	1600	500	30	0.000	0.25	0	1.000	2000	500	30	0.000	0
209	120	1600	500	30	0.000	0.25	0	1.000	2000	500	30	0.000	0
210	120	1600	500	30	0.000	0.25	0	1.000	2000	500	30	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SPC1.5

[Material] SPC1.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	700	200	15	0.30	2	0.0	1.500	0.140	0	0	0	101	0.50	Standard	No
2	1000	900	500	20	0.30	2	0.0	1.500	0.140	0	0	902	102	0.00	Standard	No
3	5000	900	5000	100	0.30	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	5500	1000	5000	100	0.30	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
5	5500	1000	5000	100	0.30	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
6	5500	1000	5000	100	0.30	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
7	5500	1000	5000	100	0.30	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
8	5500	1000	5000	100	0.30	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
9	5500	1000	5000	100	0.30	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-1.50	OFF
102	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
103	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
104	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
105	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	10	70	0
902	900	100	15	70	0
903	1000	100	20	70	0
904	1000	100	25	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.15	2	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	20	0.000	0.30	0	1.000	300	100	20	0.000	0
202	0	2000	100	20	0.000	0.30	0	1.000	300	100	20	0.000	0
203	55	2000	100	10	0.000	0.30	0	2.000	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.000	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SPC1.5E

[Material] SPC1.5E [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 5"  
 [AC] 12 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1200	200	20	0.30	3	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	3000	1200	2000	55	0.30	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
3	5400	1200	5400	100	0.30	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
4	6000	1200	6000	100	0.30	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
5	6500	1200	6500	100	0.30	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
6	6000	1200	6000	100	0.30	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
7	6000	1200	6000	100	0.30	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
8	5400	1200	5400	100	0.30	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
9	6000	1200	6000	100	0.30	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	10	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-2.00	OFF
102	2000	80	50	0	0	0.000	0	0.100	0.30	3	0.0	6.000	-2.00	1
103	1500	100	100	0	0	0.000	0	0.100	0.30	3	0.0	6.000	-2.00	1
104	1500	100	100	0	0	0.000	0	0.100	0.30	3	0.0	6.000	-2.00	1
105	1500	100	100	0	0	0.000	0	0.050	0.30	3	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1200	200	5	30	0
902	1200	200	10	30	0
903	1200	200	15	30	0
904	1200	200	20	30	0
905	1000	1000	10	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.20	3	4.00	1000	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1600	100	20	0.000	0.30	0	1.000	300	100	20	0.000	0
202	0	3000	100	20	0.000	0.30	0	1.000	500	100	20	0.000	0
203	150	1200	200	0	0.080	0.30	0	0.000	900	200	20	0.000	0
204	150	1200	200	0	0.080	0.30	0	0.000	2000	200	30	0.000	0
205	170	1200	200	0	0.080	0.30	0	0.000	2000	200	30	0.000	0
206	170	1200	200	0	0.080	0.30	0	0.000	2000	200	30	0.000	0
207	170	1200	200	0	0.080	0.30	0	0.000	2000	200	30	0.000	0
208	170	1200	200	0	0.080	0.30	0	0.000	2000	200	30	0.000	0
209	170	1200	200	0	0.080	0.30	0	0.000	2000	200	30	0.000	0
210	170	1200	200	0	0.080	0.30	0	0.000	2000	200	30	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC1.5E-2**

[Material] SPC1.5E-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 5"  
 [AC] 12 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1200	200	20	0.25	3	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	3000	1200	2000	55	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
3	6000	1200	6000	100	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
4	6500	1200	6000	100	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
5	6500	1200	7000	100	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
6	6500	1200	6000	100	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
7	6500	1200	6000	100	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
8	6000	1200	6000	100	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
9	6500	1200	6000	100	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	10	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-2.00	OFF
102	2000	80	50	0	0	0.000	0	0.100	0.25	3	0.0	6.000	-2.00	1
103	1500	100	100	0	0	0.000	0	0.100	0.25	3	0.0	6.000	-2.00	1
104	1500	100	100	0	0	0.000	0	0.100	0.25	3	0.0	6.000	-2.00	1
105	1500	100	100	0	0	0.000	0	0.050	0.25	3	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1200	200	10	30	0
902	1200	200	20	30	0
903	1200	200	30	30	0
904	1200	200	40	30	0
905	1000	1000	10	10	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.20	3	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1600	100	20	0.000	0.25	0	1.000	300	100	20	0.000	0
202	0	3000	100	20	0.000	0.25	0	1.000	500	100	20	0.000	0
203	150	3000	200	0	0.080	0.25	0	0.000	900	200	20	0.000	0
204	150	3000	200	0	0.080	0.25	0	0.000	2000	200	30	0.000	0
205	170	3000	200	0	0.080	0.25	0	0.000	2000	200	30	0.000	0
206	170	3000	200	0	0.080	0.25	0	0.000	2000	200	30	0.000	0
207	170	3000	200	0	0.080	0.25	0	0.000	2000	200	30	0.000	0
208	170	3000	200	0	0.080	0.25	0	0.000	2000	200	30	0.000	0
209	170	3000	200	0	0.080	0.25	0	0.000	2000	200	30	0.000	0
210	170	3000	200	0	0.080	0.25	0	0.000	2000	200	30	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SPC1.5S

[Material] SPC1.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1000	200	30	0.20	2	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	2000	1000	500	55	0.20	2	0.0	1.500	0.140	0	0	902	102	0.00	Standard	No
3	4500	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	5000	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
5	5000	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
6	5000	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
7	5000	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
8	5000	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
9	5000	1000	5000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-2.50	OFF
102	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-2.50	OFF
103	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-2.50	OFF
104	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-2.50	OFF
105	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1000	100	20	50	0
902	1000	100	20	50	0
903	1000	100	20	50	0
904	1000	100	20	50	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.15	2	4.00	1000	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
202	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
203	55	2000	100	10	0.000	0.20	0	2.000	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.20	0	1.000	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SPC1.5SE

[Material] SPC1.5SE [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Standard [NzlType] S\*:E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 2 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	2000	100	15	0.20	3	0.0	0.700	0.140	0	0	0	101	0.00	Standard	No
2	2000	2000	1500	25	0.20	3	0.0	0.700	0.140	0	202	0	105	0.00	Medium	No
3	5500	2000	2000	65	0.20	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
4	6000	2000	2000	70	0.20	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
5	6000	2000	2000	70	0.20	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
6	6000	2000	2000	70	0.20	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
7	6000	2000	2000	70	0.20	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
8	6000	2000	2000	70	0.20	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
9	6000	2000	2000	70	0.20	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	13	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	8	7	1	0.400	15	0.800	0.15	2	0.5	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
103	3500	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
104	3500	100	100	0	0	0.000	0	0.100	0.20	1	0.0	5.000	-3.00	1
105	3500	100	100	0	0	0.000	0	0.010	0.20	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	250	15	30	0
902	2000	250	20	30	0
903	2000	250	25	30	0
904	2000	250	30	30	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1500	1000	35	0.10	1	3.00	800	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1500	150	17	0.000	0.20	0	1.000	300	150	30	1.200	0
202	0	1300	1000	50	0.000	0.20	0	1.000	2000	2000	100	1.500	0
203	120	2000	20	10	0.000	0.20	0	1.000	300	20	20	0.000	0
204	120	2000	500	20	0.000	0.20	0	1.000	2000	500	30	0.000	0
205	120	2000	500	20	0.000	0.20	0	1.000	2000	500	30	0.000	0
206	120	2000	500	20	0.000	0.20	0	1.000	2000	500	30	0.000	0
207	120	2000	500	20	0.000	0.20	0	1.000	2000	500	30	0.000	0
208	120	2000	500	20	0.000	0.20	0	1.000	2000	500	30	0.000	0
209	120	2000	500	20	0.000	0.20	0	1.000	2000	500	30	0.000	0
210	120	2000	500	20	0.000	0.20	0	1.000	2000	500	30	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC1.5SE-2**

[Material] SPC1.5SE-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 1.50 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	1000	100	15	0.30	3	0.0	0.700	0.140	0	0	0	101	0.00	Standard	No
2	2000	1000	1500	20	0.30	3	0.0	0.700	0.140	0	202	0	105	0.00	Medium	No
3	6000	1000	2000	100	0.30	3	0.0	0.700	0.140	203	202	903	105	0.00	Medium	No
4	6500	1000	2000	100	0.30	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
5	6500	1000	2000	100	0.30	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
6	6500	1000	2000	100	0.30	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
7	6500	1000	2000	100	0.30	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
8	6500	1000	2000	100	0.30	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
9	6500	1000	2000	100	0.30	3	0.0	0.700	0.140	204	202	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	13	0.10	1	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2000	100	8	7	1	0.400	15	0.800	0.15	2	0.5	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.30	1	0.0	5.000	-3.00	1
103	3500	100	100	0	0	0.000	0	0.100	0.30	1	0.0	5.000	-3.00	1
104	3500	100	100	0	0	0.000	0	0.100	0.30	1	0.0	5.000	-3.00	1
105	3500	100	100	0	0	0.000	0	0.010	0.30	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1000	250	15	30	0
902	1000	250	20	30	0
903	1000	250	25	30	0
904	1000	250	30	30	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1500	1000	35	0.10	1	3.00	800	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1500	150	17	0.000	0.30	0	1.000	300	150	30	1.200	0
202	0	1300	1000	50	0.000	0.30	0	1.000	2000	2000	100	1.500	0
203	120	1000	20	10	0.000	0.30	0	1.000	100	20	20	0.000	0
204	120	1000	20	0	0.300	0.30	0	0.000	2000	20	0	0.000	0
205	120	1000	20	0	0.300	0.30	0	0.000	2000	20	0	0.000	0
206	120	1000	20	0	0.300	0.30	0	0.000	2000	20	0	0.000	0
207	120	1000	20	0	0.300	0.30	0	0.000	2000	20	0	0.000	0
208	120	1000	20	0	0.300	0.30	0	0.000	2000	20	0	0.000	0
209	120	1000	20	0	0.300	0.30	0	0.000	2000	20	0	0.000	0
210	120	1000	20	0	0.300	0.30	0	0.000	2000	20	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**SPC2.0**

[Material] SPC2.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	700	200	15	0.20	2	0.0	1.500	0.140	0	0	0	101	0.50	Standard	No
2	1000	700	500	20	0.20	2	0.0	1.500	0.140	0	0	902	102	0.00	Standard	No
3	3600	900	4000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	4000	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
5	4200	1100	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
6	4000	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
7	4000	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
8	4000	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
9	4000	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-1.50	OFF
102	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
103	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
104	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
105	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	20	70	0
902	900	100	20	70	0
903	1000	100	20	70	0
904	1100	100	20	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.15	2	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
202	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
203	55	2000	100	10	0.000	0.20	0	2.500	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.20	0	1.500	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.0E**

[Material] SPC2.0E [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 5"  
 [AC] 12 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1000	200	25	0.20	3	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	2500	1000	2000	55	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
3	5000	1000	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
4	5500	1000	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
5	5500	1000	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
6	5500	1000	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
7	5500	1000	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
8	5000	1000	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
9	5500	1000	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	10	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-2.00	OFF
102	2000	80	50	0	0	0.000	0	0.100	0.20	3	0.0	6.000	-2.00	1
103	1500	100	100	0	0	0.000	0	0.100	0.20	3	0.0	6.000	-2.00	1
104	1500	100	100	0	0	0.000	0	0.100	0.20	3	0.0	6.000	-2.00	1
105	1500	100	100	0	0	0.000	0	0.050	0.20	3	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1000	200	10	30	0
902	1000	200	15	30	0
903	1000	200	20	30	0
904	1000	200	25	30	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.20	3	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
202	0	1000	100	20	0.000	0.20	0	1.000	500	100	20	0.000	0
203	150	1000	200	10	0.080	0.20	0	0.000	900	200	10	0.000	0
204	150	1000	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
205	170	1000	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
206	170	1000	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
207	170	1000	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
208	170	1000	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
209	170	1000	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
210	170	1000	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.0E-2**

[Material] SPC2.0E-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 5"  
 [AC] 12 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1200	200	25	0.20	3	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	2500	1200	2000	55	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
3	5400	1200	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
4	6000	1200	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
5	6000	1200	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
6	6000	1200	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
7	6000	1200	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
8	5400	1200	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
9	6000	1200	5000	100	0.20	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	10	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-2.00	OFF
102	2000	80	50	0	0	0.000	0	0.100	0.20	3	0.0	6.000	-2.00	1
103	1500	100	100	0	0	0.000	0	0.100	0.20	3	0.0	6.000	-2.00	1
104	1500	100	100	0	0	0.000	0	0.100	0.20	3	0.0	6.000	-2.00	1
105	1500	100	100	0	0	0.000	0	0.050	0.20	3	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1200	200	10	30	0
902	1200	200	15	30	0
903	1200	200	20	30	0
904	1200	200	25	30	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.20	3	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
202	0	1000	100	20	0.000	0.20	0	1.000	500	100	20	0.000	0
203	150	1200	200	10	0.080	0.20	0	0.000	900	200	10	0.000	0
204	150	1200	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
205	170	1200	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
206	170	1200	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
207	170	1200	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
208	170	1200	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
209	170	1200	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0
210	170	1200	200	10	0.080	0.20	0	0.000	2000	200	20	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.0S**

[Material] SPC2.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	900	200	30	0.20	2	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	2000	900	500	70	0.20	2	0.0	1.500	0.140	0	0	902	102	0.00	Standard	No
3	4000	900	4000	100	0.20	2	0.0	1.500	0.140	200	201	902	102	0.00	Standard	No
4	4300	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
5	4300	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
6	4300	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
7	4300	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
8	4300	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
9	4300	1000	4000	100	0.20	2	0.0	1.500	0.140	200	201	904	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-2.50	OFF
102	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-2.50	OFF
103	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-2.50	OFF
104	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-2.50	OFF
105	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	10	50	0
902	900	100	20	50	0
903	1000	100	10	50	0
904	1000	100	20	50	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.15	2	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
202	0	1000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
203	55	1000	100	10	0.000	0.20	0	2.000	300	100	10	0.000	0
204	95	1000	100	10	0.000	0.20	0	1.000	300	100	10	0.000	0
205	130	1000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
206	130	1000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
207	130	1000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
208	130	1000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
209	130	1000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0
210	130	1000	100	10	0.000	0.20	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.0SE**

[Material] SPC2.0SE [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 4 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2300	200	20	0.25	3	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	2000	2300	2000	55	0.25	3	0.0	0.700	0.160	0	201	0	105	0.00	Medium	No
3	4000	2300	2000	90	0.25	3	0.0	0.700	0.160	203	201	903	105	0.00	Medium	No
4	4500	2300	3000	100	0.25	3	0.0	0.700	0.160	204	201	904	105	0.00	Medium	No
5	4500	2300	3000	100	0.25	3	0.0	0.700	0.160	204	201	904	105	0.00	Medium	No
6	4500	2300	3000	100	0.25	3	0.0	0.700	0.160	204	201	904	105	0.00	Medium	No
7	4500	2300	3000	100	0.25	3	0.0	0.700	0.160	204	201	904	105	0.00	Medium	No
8	4500	2300	3000	100	0.25	3	0.0	0.700	0.160	204	201	903	105	0.00	Medium	No
9	4500	2300	3000	100	0.25	3	0.0	0.700	0.160	204	201	904	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	10	10	1	0.400	4	1.500	0.15	2	0.5	3.500	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	5.000	-3.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	5.000	-3.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.25	1	0.0	5.000	-3.00	1
105	2000	100	100	0	0	0.000	0	0.020	0.25	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2300	200	20	30	0
902	2300	200	25	30	0
903	2300	200	30	30	0
904	2300	200	35	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.10	3	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2300	100	35	0.000	0.25	0	1.000	300	100	35	0.000	0
202	0	2300	100	65	0.000	0.25	0	1.000	1000	100	65	0.000	0
203	150	2300	500	20	0.100	0.25	0	0.500	2000	500	30	0.000	0
204	150	2300	500	20	0.100	0.25	0	1.000	2000	500	30	0.000	0
205	170	2300	500	20	0.100	0.25	0	1.000	2000	500	30	0.000	0
206	170	2300	500	20	0.100	0.25	0	1.000	2000	500	30	0.000	0
207	170	2300	500	20	0.100	0.25	0	1.000	2000	500	30	0.000	0
208	170	2300	500	20	0.100	0.25	0	1.000	2000	500	30	0.000	0
209	170	2300	500	20	0.100	0.25	0	1.000	2000	500	30	0.000	0
210	170	2300	500	20	0.100	0.25	0	1.000	2000	500	30	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.0SE-2**

[Material] SPC2.0SE-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2700	200	20	0.30	3	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	2000	2700	2000	55	0.30	3	0.0	0.700	0.160	0	201	0	101	0.00	Medium	No
3	4500	2700	3000	100	0.06	3	0.0	0.700	0.160	203	201	902	105	0.00	Medium	No
4	5000	3000	3000	100	0.06	3	0.0	0.700	0.160	204	201	903	105	0.00	Medium	No
5	5500	3300	3000	100	0.06	3	0.0	0.700	0.160	204	201	903	105	0.00	Medium	No
6	5000	3000	3000	100	0.06	3	0.0	0.700	0.160	204	201	903	105	0.00	Medium	No
7	5000	3000	3000	100	0.06	3	0.0	0.700	0.160	204	201	903	105	0.00	Medium	No
8	5000	3000	3000	100	0.06	3	0.0	0.700	0.160	204	201	902	105	0.00	Medium	No
9	5000	3000	3000	100	0.06	3	0.0	0.700	0.160	204	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	10	10	1	0.400	4	1.500	0.15	2	0.3	3.500	-3.00	OFF
102	2000	100	100	0	0	0.000	0	0.100	0.06	1	0.0	5.000	-3.00	1
103	2000	100	100	0	0	0.000	0	0.100	0.06	1	0.0	5.000	-3.00	1
104	2000	100	100	0	0	0.000	0	0.100	0.06	1	0.0	5.000	-3.00	1
105	2000	100	100	0	0	0.000	0	0.020	0.06	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2700	200	20	30	0
902	2700	200	30	30	0
903	3000	200	20	30	0
904	3000	200	30	30	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.10	3	4.00	1000	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2300	100	35	0.000	0.30	0	1.000	300	100	35	0.000	0
202	0	2300	100	65	0.000	0.06	0	1.000	1000	100	65	0.000	0
203	150	2300	500	20	0.100	0.06	0	0.500	2500	500	30	0.000	0
204	150	2300	500	20	0.100	0.06	0	1.000	2500	500	30	0.000	0
205	170	2300	500	20	0.100	0.06	0	1.000	2500	500	30	0.000	0
206	170	2300	500	20	0.100	0.06	0	1.000	2500	500	30	0.000	0
207	170	2300	500	20	0.100	0.06	0	1.000	2500	500	30	0.000	0
208	170	2300	500	20	0.100	0.06	0	1.000	2500	500	30	0.000	0
209	170	2300	500	20	0.100	0.06	0	1.000	2500	500	30	0.000	0
210	170	2300	500	20	0.100	0.06	0	1.000	2500	500	30	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.5**

[Material] SPC2.5 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	700	200	15	0.30	2	0.0	1.500	0.140	0	0	0	101	0.50	Standard	No
2	1000	700	500	20	0.30	2	0.0	1.500	0.140	0	0	901	102	0.00	Standard	No
3	2700	1000	2000	100	0.30	2	0.0	1.500	0.140	200	201	902	102	0.00	Standard	No
4	3200	1200	2000	100	0.30	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	3200	1200	2000	100	0.30	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	3200	1200	2000	100	0.30	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	3200	1200	2000	100	0.30	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	3200	1200	2000	100	0.30	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	3200	1200	2000	100	0.30	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1100	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	0.800	0.15	2	0.3	3.500	-1.50	OFF
102	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
103	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
104	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF
105	2000	100	6	0	0	0.000	0	0.500	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1000	100	10	70	0
902	1000	100	20	70	0
903	1200	100	30	70	0
904	1200	100	40	70	0
905	1100	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.15	2	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	20	0.000	0.30	0	1.000	300	100	20	0.000	0
202	0	2000	100	20	0.000	0.30	0	1.000	300	100	20	0.000	0
203	55	2000	100	10	0.000	0.30	0	2.000	300	100	10	0.000	0
204	95	2000	100	10	0.000	0.30	0	1.000	300	100	10	0.000	0
205	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
206	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
207	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
208	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
209	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0
210	130	2000	100	10	0.000	0.30	0	0.500	300	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.5E**

[Material] SPC2.5E [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 5"  
 [AC] 13 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1300	100	25	0.35	3	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	1600	2000	30	0.35	3	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
3	4000	1600	4000	100	0.35	3	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
4	4500	1600	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
5	4500	1600	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
6	4500	1600	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
7	4500	1600	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
8	4000	1600	4000	100	0.35	3	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
9	4500	1600	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	2	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	12	10	1	0.400	4	2.000	0.15	3	0.3	3.500	-2.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	1	0.0	6.000	-2.00	1
103	3000	100	100	0	0	0.000	0	0.100	0.35	1	0.0	6.000	-2.00	1
104	3000	100	100	0	0	0.000	0	0.100	0.35	1	0.0	6.000	-2.00	1
105	3000	100	100	0	0	0.000	0	0.050	0.35	1	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1300	200	20	70	0
902	1300	200	30	70	0
903	1600	200	20	70	0
904	1600	200	30	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2200	2000	100	0.05	1	4.00	1000	4.000

Laser Mont.	Gain	Recv.
	0	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1600	100	40	0.000	0.35	0	1.500	250	100	45	0.000	0
202	0	1600	100	40	0.000	0.35	0	1.500	250	100	45	0.000	0
203	150	1600	200	0	0.100	0.35	0	0.000	900	200	0	0.000	0
204	150	1600	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0
205	170	1600	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0
206	170	1600	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0
207	170	1600	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0
208	170	1600	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0
209	170	1600	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0
210	170	1600	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2
	Pie.	Appr.		
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**SPC2.5E-2**

[Material] SPC2.5E-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 5"  
 [AC] 13 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1300	100	25	0.35	3	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	1300	2000	35	0.35	3	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
3	4500	1900	4000	100	0.35	3	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
4	4800	1900	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
5	5000	1900	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
6	4800	1900	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
7	4800	1900	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
8	4500	1900	4000	100	0.35	3	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
9	4800	1900	4500	100	0.35	3	0.0	0.700	0.170	203	201	904	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	2	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	12	10	1	0.400	4	2.000	0.15	3	0.3	3.500	-2.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.35	1	0.0	6.000	-2.00	1
103	3000	100	100	0	0	0.000	0	0.100	0.35	1	0.0	6.000	-2.00	1
104	3000	100	100	0	0	0.000	0	0.100	0.35	1	0.0	6.000	-2.00	1
105	3000	100	100	0	0	0.000	0	0.050	0.35	1	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1300	200	20	70	0
902	1300	200	30	70	0
903	1900	200	30	70	0
904	1900	200	40	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2200	2000	100	0.05	1	4.00	1000	4.000

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 Mont.

0 0

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1900	100	40	0.000	0.35	0	1.500	250	100	50	0.000	0
202	0	1900	100	40	0.000	0.35	0	1.500	250	100	50	0.000	0
203	150	1900	200	0	0.100	0.35	0	0.000	900	200	0	0.000	0
204	150	1900	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0
205	170	1900	200	0	0.100	0.35	0	0.000	1000	200	0	0.000	0
206	170	1900	200	0	0.000	0.35	0	0.000	1000	200	0	0.000	0
207	170	1900	200	0	0.000	0.35	0	0.000	1000	200	0	0.000	0
208	170	1900	200	0	0.000	0.35	0	0.000	1000	200	0	0.000	0
209	170	1900	200	0	0.000	0.35	0	0.000	1000	200	0	0.000	0
210	170	1900	200	0	0.000	0.35	0	0.000	1000	200	0	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SPC2.5S

[Material] SPC2.5S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	600	200	20	0.20	2	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	900	300	30	0.20	2	0.0	1.500	0.140	0	0	902	102	0.00	Standard	No
3	3000	900	2500	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	3300	1000	3000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	3300	1000	3000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	3300	1000	3000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	3300	1000	3000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	3300	1000	3000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	3300	1000	3000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	1.500	0.15	2	0.3	3.500	-2.50	OFF
102	2000	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-2.50	OFF
103	2000	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-2.50	OFF
104	2000	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-2.50	OFF
105	2000	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	900	100	20	50	0
902	900	100	25	50	0
903	1000	100	25	50	0
904	1000	100	30	50	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	88	0.15	2	4.00	1000	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
202	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
203	55	1000	50	10	0.000	0.20	0	2.000	300	50	10	0.000	0
204	95	1000	50	10	0.000	0.20	0	1.000	300	50	10	0.000	0
205	130	1000	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
206	130	1000	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
207	130	1000	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
208	130	1000	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
209	130	1000	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
210	130	1000	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.5SE**

[Material] SPC2.5SE [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Standard [NzlType] S\*:E [Head] ECO  
 [Foc] 2.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 4 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	20	0.20	3	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	2500	2000	2000	80	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
3	4000	2800	4000	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
4	4500	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
5	4800	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
6	4500	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
7	4500	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
8	4500	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
9	4500	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.10	1	0.0	1.500	0.000	0	0	905	0	-2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1700	200	10	10	1	0.500	4	1.500	0.15	2	0.3	3.500	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
103	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
104	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
105	3000	100	100	0	0	0.000	0	0.050	0.07	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2800	200	5	5	0
902	2800	200	10	5	0
903	2800	200	15	5	0
904	2800	200	20	5	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.10	3	4.00	1000	4.000

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 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	25	0.000	0.07	0	1.000	300	100	25	0.000	0
202	0	2000	100	65	0.000	0.07	0	1.000	1000	100	65	0.000	0
203	150	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
204	150	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
205	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
206	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
207	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
208	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
209	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
210	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC2.5SE-2**

[Material] SPC2.5SE-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 2.50 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 2.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	2000	200	20	0.20	3	0.0	0.700	0.160	0	0	0	101	0.00	Standard	No
2	2500	2000	2000	80	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
3	4200	2800	4000	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
4	4800	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
5	5000	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
6	4800	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
7	4800	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
8	4800	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
9	4800	2800	4500	100	0.07	1	0.0	0.700	0.160	203	201	901	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	18	0.10	1	0.0	1.500	0.000	0	0	905	0	-2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1700	200	10	10	1	0.500	4	1.500	0.15	2	0.3	3.500	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
103	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
104	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
105	3000	100	100	0	0	0.000	0	0.050	0.07	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2800	200	5	5	0
902	2800	200	10	5	0
903	2800	200	15	5	0
904	2800	200	20	5	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	80	0.10	3	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	25	0.000	0.07	0	1.000	300	100	25	0.000	0
202	0	2000	100	65	0.000	0.07	0	1.000	1000	100	65	0.000	0
203	150	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
204	150	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
205	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
206	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
207	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
208	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
209	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0
210	170	2800	200	0	0.080	0.07	0	0.200	50	10	5	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC3.0**

[Material] SPC3.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.0 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	700	200	20	0.20	2	0.0	1.500	0.140	0	0	0	101	0.50	Standard	No
2	1000	1000	500	25	0.20	2	0.0	1.500	0.140	0	0	902	102	0.00	Standard	No
3	2500	1000	2000	100	0.20	2	0.0	1.500	0.140	200	201	902	102	0.00	Standard	No
4	3000	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	3000	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	3000	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	3000	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	3000	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	3000	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1100	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	-0.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1700	100	9	0	0	0.000	0	1.200	0.15	2	0.3	3.500	-1.50	OFF
102	2100	100	7	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-1.50	OFF
103	2100	100	7	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-1.50	OFF
104	2100	100	7	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-1.50	OFF
105	2100	100	7	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1000	100	20	50	0
902	1000	100	30	50	0
903	1300	100	30	50	0
904	1300	100	40	50	0
905	1100	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.15	2	4.00	1000	4.000

Laser Gain Recv.  
 Mont.

5 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
202	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
203	55	1300	100	10	0.000	0.20	0	2.500	200	100	10	0.000	0
204	95	1300	100	10	0.000	0.20	0	1.500	200	100	10	0.000	0
205	130	1300	100	10	0.000	0.20	0	0.500	200	100	10	0.000	0
206	130	1300	100	10	0.000	0.20	0	0.500	200	100	10	0.000	0
207	130	1300	100	10	0.000	0.20	0	0.500	200	100	10	0.000	0
208	130	1300	100	10	0.000	0.20	0	0.500	200	100	10	0.000	0
209	130	1300	100	10	0.000	0.20	0	0.500	200	100	10	0.000	0
210	130	1300	100	10	0.000	0.20	0	0.500	200	100	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2
			Pie.	Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC3.0E**

[Material] SPC3.0E [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 2.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 5"  
 [AC] 13 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1500	100	30	0.15	3	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	1500	1500	1000	50	0.08	1	0.0	0.700	0.170	203	201	901	105	0.00	Medium	No
3	2700	1600	3000	100	0.08	1	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
4	3000	1800	3000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
5	3200	2000	3000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
6	3000	1800	3000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
7	3000	1800	3000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
8	2700	1600	3000	100	0.08	1	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
9	3000	1800	3000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	200	10	10	1	0.400	4	2.000	0.15	3	0.3	3.500	-2.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.08	1	0.0	6.000	-2.00	1
103	3000	100	100	0	0	0.000	0	0.100	0.08	1	0.0	6.000	-2.00	1
104	3000	100	100	0	0	0.000	0	0.100	0.08	1	0.0	6.000	-2.00	1
105	3000	100	100	0	0	0.000	0	0.050	0.08	1	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1600	200	25	50	0
902	1600	200	30	50	0
903	1800	200	35	50	0
904	1800	200	40	50	0
905	1000	1200	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2200	2000	100	0.05	1	4.00	1000	4.000

Laser Mont.	Gain	Recv.
	0	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1800	100	50	0.000	0.08	0	1.000	300	100	50	0.000	0
202	0	1800	100	70	0.000	0.08	0	1.000	300	100	70	0.000	0
203	150	1800	200	0	0.100	0.08	0	0.000	900	200	0	0.000	0
204	150	1800	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
205	170	1800	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
206	170	1800	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
207	170	1800	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
208	170	1800	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
209	170	1800	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
210	170	1800	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC3.0E-2**

[Material] SPC3.0E-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 2.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 5"  
 [AC] 13 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1500	100	30	0.15	3	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	1500	1500	1000	50	0.07	1	0.0	0.700	0.170	203	201	901	105	0.00	Medium	No
3	4000	1800	3000	100	0.07	1	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
4	4500	2000	3000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
5	4500	2000	3000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
6	4500	2000	3000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
7	4500	2000	3000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
8	4000	1800	3000	100	0.07	1	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
9	4500	2000	3000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1000	1000	15	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1600	200	10	10	1	0.400	4	2.000	0.15	3	0.3	3.500	-2.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	6.000	-2.00	1
103	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	6.000	-2.00	1
104	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	6.000	-2.00	1
105	3000	100	100	0	0	0.000	0	0.050	0.07	1	0.0	6.000	-2.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1800	200	25	50	0
902	1800	200	30	50	0
903	2000	200	35	50	0
904	2000	200	40	50	0
905	1000	1200	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2200	2000	100	0.05	1	4.00	1000	4.000

Laser Mont.	Gain	Recv.
	0	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	1800	100	50	0.000	0.07	0	1.000	300	100	50	0.000	0
202	0	1800	100	70	0.000	0.07	0	1.000	300	100	70	0.000	0
203	150	1800	200	0	0.100	0.07	0	0.000	900	200	0	0.000	0
204	150	1800	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
205	170	1800	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
206	170	1800	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
207	170	1800	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
208	170	1800	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
209	170	1800	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
210	170	1800	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC3.0S**

[Material] SPC3.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 0.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 2 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	700	200	30	0.20	2	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	900	300	40	0.20	2	0.0	1.500	0.140	0	0	902	102	0.00	Standard	No
3	2000	1000	2000	100	0.20	2	0.0	1.500	0.140	200	201	902	102	0.00	Standard	No
4	2500	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	2500	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	2500	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	2500	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	2500	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	2500	1300	2000	100	0.20	2	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	15	0.10	1	0.0	1.500	0.000	0	0	905	0	0.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1500	100	8	0	0	0.000	0	1.500	0.15	2	0.3	3.500	-2.50	OFF
102	2000	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-2.50	OFF
103	2000	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-2.50	OFF
104	2000	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-2.50	OFF
105	2000	100	8	0	0	0.000	0	1.000	0.15	2	0.3	3.500	-2.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	1000	100	15	70	0
902	1000	100	20	70	0
903	1300	100	25	70	0
904	1300	100	30	70	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	1600	2000	88	0.15	2	4.00	1000	4.000

Laser Gain Recv. Mont.

6 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
202	0	2000	100	20	0.000	0.20	0	1.000	300	100	20	0.000	0
203	55	1300	50	10	0.000	0.20	0	2.000	300	50	10	0.000	0
204	95	1300	50	10	0.000	0.20	0	1.000	300	50	10	0.000	0
205	130	1300	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
206	130	1300	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
207	130	1300	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
208	130	1300	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
209	130	1300	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0
210	130	1300	50	10	0.000	0.20	0	0.500	300	50	10	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**SPC3.0SE**

[Material] SPC3.0SE [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 3.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 4 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1500	100	22	0.15	3	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	1500	2000	60	0.07	1	0.0	0.700	0.170	203	201	901	105	0.00	Medium	No
3	4000	2500	2000	100	0.07	1	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
4	4500	3000	2000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
5	4500	3000	2000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
6	4500	3000	2000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
7	4500	3000	2000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
8	4000	2500	2000	100	0.07	1	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
9	4500	3000	2000	100	0.07	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	2	0.0	1.500	0.000	0	0	905	0	-2.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1600	200	10	10	1	0.400	4	2.000	0.15	3	0.3	3.500	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
103	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
104	3000	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
105	3000	100	100	0	0	0.000	0	0.020	0.07	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2500	200	20	50	0
902	2500	200	30	50	0
903	3000	200	40	50	0
904	3000	200	50	50	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2200	2000	100	0.05	1	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2700	100	25	0.000	0.07	0	1.000	300	100	25	0.000	0
202	0	2700	100	50	0.000	0.07	0	1.000	1500	100	50	0.000	0
203	150	2700	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
204	150	2700	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
205	170	2700	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
206	170	2700	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
207	170	2700	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
208	170	2700	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
209	170	2700	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0
210	170	2700	200	0	0.100	0.07	0	0.000	1000	200	0	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPC3.0SE-2**

[Material] SPC3.0SE-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SPC [Thic] 3.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 3.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	500	1500	100	22	0.15	3	0.0	0.700	0.170	0	201	0	101	0.00	Standard	No
2	2000	1500	2000	60	0.08	1	0.0	0.700	0.170	203	201	901	105	0.00	Medium	No
3	4200	2700	2000	100	0.08	1	0.0	0.700	0.170	203	201	902	105	0.00	Medium	No
4	4700	3200	2000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
5	4700	3200	2000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
6	4700	3200	2000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
7	4700	3200	2000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
8	4700	3200	2000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
9	4700	3200	2000	100	0.08	1	0.0	0.700	0.170	203	201	903	105	0.00	Medium	No
(Etch)																
10	10000	1200	1000	15	0.10	2	0.0	1.500	0.000	0	0	905	0	-2.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	1600	200	10	10	1	0.400	4	2.000	0.15	3	0.3	3.500	-3.00	OFF
102	3000	100	100	0	0	0.000	0	0.100	0.08	1	0.0	5.000	-3.00	1
103	3000	100	100	0	0	0.000	0	0.100	0.08	1	0.0	5.000	-3.00	1
104	3000	100	100	0	0	0.000	0	0.100	0.08	1	0.0	5.000	-3.00	1
105	3000	100	100	0	0	0.000	0	0.020	0.08	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2700	200	20	50	0
902	2700	200	30	50	0
903	3200	200	40	50	0
904	3200	200	50	50	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2200	2000	100	0.05	1	4.00	1000	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2700	100	25	0.000	0.08	0	1.000	300	100	25	0.000	0
202	0	2700	100	50	0.000	0.08	0	1.000	1500	100	50	0.000	0
203	150	2700	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
204	150	2700	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
205	170	2700	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
206	170	2700	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
207	170	2700	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
208	170	2700	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
209	170	2700	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0
210	170	2700	200	0	0.100	0.08	0	0.000	1000	200	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPH4.0**

[Material] SPH4.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPH [Thic] 4.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2000	100	20	0.15	2	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	2000	1000	35	0.07	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
3	1800	2000	1500	60	0.07	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	2100	2000	1500	65	0.07	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	2200	2000	1500	65	0.07	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	2100	2000	1500	65	0.07	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	2100	2000	1500	65	0.07	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	2100	2000	1500	65	0.07	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	2100	2000	1500	65	0.07	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF
102	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF
103	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF
104	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF
105	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	20	20	10	0
902	2000	20	20	10	0
903	2000	20	20	10	0
904	2000	20	20	10	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.07	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	25	0.000	0.07	0	1.000	200	100	25	0.000	0
202	0	2000	100	25	0.000	0.07	0	1.000	300	100	25	0.000	0
203	55	2000	30	20	0.000	0.07	0	3.000	200	30	20	0.000	0
204	95	2000	30	20	0.000	0.07	0	1.500	200	30	20	0.000	0
205	130	2000	30	20	0.000	0.07	0	0.500	200	30	20	0.000	0
206	130	2000	30	20	0.000	0.07	0	0.500	200	30	20	0.000	0
207	130	2000	30	20	0.000	0.07	0	0.500	200	30	20	0.000	0
208	130	2000	30	20	0.000	0.07	0	0.500	200	30	20	0.000	0
209	130	2000	30	20	0.000	0.07	0	0.500	200	30	20	0.000	0
210	130	2000	30	20	0.000	0.07	0	0.500	200	30	20	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SPH4.0S

[Material] SPH4.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPH [Thic] 4.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2000	100	20	0.15	2	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	2000	1000	35	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
3	1800	2000	1500	65	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	2100	2000	1500	75	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	2200	2000	1500	75	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	2100	2000	1500	75	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	2100	2000	1500	75	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	2100	2000	1500	75	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	2100	2000	1500	75	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF
102	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF
103	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF
104	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF
105	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	20	20	10	0
902	2000	20	20	10	0
903	2000	20	20	10	0
904	2000	20	20	10	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.07	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	25	0.000	0.08	0	1.000	200	100	25	0.000	0
202	0	2000	100	25	0.000	0.08	0	1.000	300	100	25	0.000	0
203	55	2000	30	20	0.000	0.08	0	3.000	200	30	20	0.000	0
204	95	2000	30	20	0.000	0.08	0	1.500	200	30	20	0.000	0
205	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
206	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
207	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
208	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
209	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
210	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPH4.0SE**

[Material] SPH4.0SE [Oscillator] AF35LGG0EU-001  
 [Quality] SPH [Thic] 4.00 [CutWay] Standard [NzlType] S\*:E [Head] ECO  
 [Foc] 3.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 4 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2500	100	16	0.15	3	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3200	2000	60	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
3	3500	3500	2000	90	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
4	4000	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
5	4000	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
6	4000	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
7	4000	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
8	4000	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
9	4000	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	105	0.00	Standard	No
(Etch)																
10	10000	1100	1000	13	0.10	2	0.0	1.500	0.000	0	0	905	0	-2.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	80	6	10	1	0.400	6	2.000	0.15	3	0.3	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
103	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
104	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
105	3500	100	100	0	0	0.000	0	0.050	0.07	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	10	0
902	3200	200	30	10	0
903	3200	200	30	10	0
904	3500	200	30	10	0
905	1100	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3200	2000	100	0.05	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2500	100	25	0.000	0.15	0	1.500	100	100	25	1.200	0
202	0	3200	2000	100	0.000	0.07	0	2.000	1000	100	100	1.200	0
203	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
204	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
205	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
206	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
207	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
208	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
209	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
210	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	807	808	809	No
4	807	808	809	No
5	807	808	809	No
6	807	808	809	No
7	807	808	809	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	1.500	600	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
802	1.500	600	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
803	1.500	600	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
804	1.500	600	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
805	1.500	600	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
806	1.500	600	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
807	1.500	600	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
808	1.900	600	2700	100	10	0.07	0	0.0	0.700	0.00	0.000
809	0.550	600	2500	100	6	0.14	1	1.0	1.200	0.00	1.000
810	0.550	600	2500	100	6	0.14	1	1.0	1.200	0.00	1.000

Comment

**SPH5.0**

[Material] SPH5.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPH [Thic] 5.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2000	100	20	0.15	3	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	2000	1000	35	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
3	1500	2000	1500	55	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF
102	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF
103	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF
104	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF
105	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	20	20	10	0
902	2000	20	20	10	0
903	2000	20	20	10	0
904	2000	20	20	10	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.07	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	25	0.000	0.08	0	1.000	200	100	25	0.000	0
202	0	2000	100	25	0.000	0.08	0	1.000	300	100	25	0.000	0
203	55	2000	30	20	0.000	0.08	0	3.000	200	30	20	0.000	0
204	95	2000	30	20	0.000	0.08	0	1.500	200	30	20	0.000	0
205	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
206	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
207	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
208	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
209	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
210	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SPH5.0S

[Material] SPH5.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPH [Thic] 5.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2000	100	20	0.15	3	0.0	1.500	0.140	0	0	0	101	0.00	Standard	No
2	1000	2000	1000	35	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
3	1500	2000	1500	60	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
4	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
5	1800	2000	1500	70	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
6	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
7	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
8	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
9	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF
102	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF
103	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF
104	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF
105	2500	80	5	12	1	0.400	5	1.500	0.15	3	0.3	3.500	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	20	20	10	0
902	2000	20	20	10	0
903	2000	20	20	10	0
904	2000	20	20	10	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1500	65	0.07	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	100	25	0.000	0.08	0	1.000	200	100	25	0.000	0
202	0	2000	100	25	0.000	0.08	0	1.000	300	100	25	0.000	0
203	55	2000	30	20	0.000	0.08	0	3.000	200	30	20	0.000	0
204	95	2000	30	20	0.000	0.08	0	1.500	200	30	20	0.000	0
205	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
206	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
207	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
208	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
209	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0
210	130	2000	30	20	0.000	0.08	0	0.500	200	30	20	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPH5.0SE**

[Material] SPH5.0SE [Oscillator] AF35LCG0EU-001  
 [Quality] SPH [Thic] 5.00 [CutWay] Standard [NzlType] S\*:\*E [Head] ECO  
 [Foc] 3.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 4 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2500	100	16	0.15	3	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2000	3200	2000	60	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
3	3000	3500	2000	90	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
4	3200	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
5	3200	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
6	3200	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
7	3200	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
8	3200	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
9	3200	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	105	0.00	Standard	No
(Etch)																
10	10000	1100	1000	13	0.10	2	0.0	1.500	0.000	0	0	905	0	-3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	80	6	10	1	0.400	6	2.000	0.15	3	0.3	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
103	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
104	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
105	3500	100	100	0	0	0.000	0	0.050	0.07	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3000	200	30	10	0
902	3200	200	30	10	0
903	3200	200	30	10	0
904	3500	200	30	10	0
905	1100	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3200	2000	100	0.05	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2500	100	25	0.000	0.15	0	1.500	100	100	25	1.200	0
202	0	3200	2000	100	0.000	0.07	0	2.000	1000	100	100	1.200	0
203	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
204	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
205	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
206	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
207	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
208	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
209	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0
210	120	0	200	0	0.050	0.07	0	0.000	500	200	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2
	Pie.	Appr.		
1	0	0	0	No
2	0	0	0	No
3	807	808	809	No
4	807	808	809	No
5	807	808	809	No
6	807	808	809	No
7	807	808	809	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	1.500	500	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
802	1.500	500	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
803	1.500	500	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
804	1.500	500	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
805	1.500	500	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
806	1.500	500	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
807	1.500	500	2500	100	10	0.07	0	0.0	0.700	0.00	0.000
808	2.050	500	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
809	0.600	500	3000	100	6	0.14	1	1.0	1.200	0.00	1.500
810	0.600	500	3000	100	6	0.14	1	1.0	1.200	0.00	1.500

Comment



**SPH6.0**

[Material] SPH6.0 [Oscillator] AF35LGG0EU-001  
 [Quality] SPH [Thic] 6.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 5"  
 [AC] 11 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2000	100	25	0.10	2	0.0	1.500	0.140	0	201	0	101	0.00	Standard	No
2	1000	2000	800	45	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
3	1500	2000	1500	55	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
4	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
5	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
6	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
7	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
8	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
9	1600	2000	1500	60	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-1.50	OFF
102	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-1.50	OFF
103	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-1.50	OFF
104	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-1.50	OFF
105	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-1.50	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	20	30	10	0
902	2000	20	30	10	0
903	2000	20	30	10	0
904	2000	20	30	10	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1700	65	0.07	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	50	25	0.000	0.08	0	1.000	100	50	25	0.000	0
202	0	2000	50	25	0.000	0.08	0	1.000	100	50	25	0.000	0
203	55	2000	30	20	0.000	0.08	0	3.500	200	30	20	0.000	0
204	95	2000	50	20	0.000	0.08	0	1.500	200	50	20	0.000	0
205	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
206	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
207	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
208	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
209	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
210	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPH6.0S**

[Material] SPH6.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SPH [Thic] 6.00 [CutWay] Standard [NzlType] S\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 2.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2000	100	25	0.10	2	0.0	1.500	0.140	0	201	0	101	0.00	Standard	No
2	1000	2000	800	50	0.08	1	0.0	1.500	0.140	200	201	903	102	0.00	Standard	No
3	1500	2000	1500	60	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
4	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
5	1800	2000	1500	70	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
6	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
7	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
8	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
9	1600	2000	1500	65	0.08	1	0.0	1.500	0.140	200	202	903	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Standard	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-3.00	OFF
102	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-3.00	OFF
103	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-3.00	OFF
104	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-3.00	OFF
105	2500	80	8	10	1	0.500	5	2.500	0.15	3	0.3	3.500	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	2000	20	30	10	0
902	2000	20	30	10	0
903	2000	20	30	10	0
904	2000	20	30	10	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	2000	1700	65	0.07	1	4.00	500	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2000	50	25	0.000	0.08	0	1.000	100	50	25	0.000	0
202	0	2000	50	25	0.000	0.08	0	1.000	100	50	25	0.000	0
203	55	2000	30	20	0.000	0.08	0	3.500	200	30	20	0.000	0
204	95	2000	50	20	0.000	0.08	0	1.500	200	50	20	0.000	0
205	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
206	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
207	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
208	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
209	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0
210	130	2000	50	20	0.000	0.08	0	0.500	200	50	20	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SPH6.0SE**

[Material] SPH6.0SE [Oscillator] AF35LGG0EU-001  
 [Quality] SPH [Thic] 6.00 [CutWay] Standard [NzlType] S\*:E [Head] ECO  
 [Foc] 4.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 3 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	200	2500	100	22	0.15	3	0.3	0.700	0.200	0	201	0	101	0.00	Standard	No
2	2500	3500	2000	80	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
3	2800	3500	2000	85	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
4	3000	3500	3000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
5	3200	3500	3000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
6	3000	3500	3000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
7	3000	3500	3000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
8	3000	3500	2000	100	0.07	1	0.0	0.700	0.250	0	202	0	102	0.00	Standard	No
9	3000	3500	3000	100	0.07	1	0.0	0.700	0.250	0	202	0	105	0.00	Standard	No
(Etch)																
10	10000	1100	1000	13	0.10	2	0.0	1.500	0.000	0	0	0	905	0 -3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	80	10	10	1	0.500	6	3.000	0.15	3	0.3	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
103	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
104	3500	100	100	0	0	0.000	0	0.100	0.07	1	0.0	5.000	-3.00	1
105	3500	100	100	0	0	0.000	0	0.050	0.07	1	0.0	5.000	-3.00	1

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	2	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	300	30	10	0
902	3500	300	30	10	0
903	3500	300	30	10	0
904	3500	300	30	10	0
905	1100	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.07	1	4.00	500	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	2500	100	30	0.000	0.15	0	1.500	100	100	30	1.200	0
202	0	3500	2000	100	0.000	0.07	0	1.500	1000	100	100	1.200	0
203	120	0	2000	0	0.040	0.07	0	0.000	100	2000	0	0.000	0
204	120	0	2000	0	0.040	0.07	0	0.000	100	2000	0	0.000	0
205	120	0	2000	0	0.040	0.07	0	0.000	100	2000	0	0.000	0
206	120	0	2000	0	0.040	0.07	0	0.000	100	2000	0	0.000	0
207	120	0	2000	0	0.040	0.07	0	0.000	100	2000	0	0.000	0
208	120	0	2000	0	0.040	0.07	0	0.000	100	2000	0	0.000	0
209	120	0	2000	0	0.040	0.07	0	0.000	100	2000	0	0.000	0
210	120	0	2000	0	0.040	0.07	0	0.000	100	2000	0	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	807	808	809	No
4	807	808	809	No
5	807	808	809	No
6	807	808	809	No
7	807	808	809	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	1.500	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
802	1.500	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
803	1.500	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
804	1.500	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
805	1.500	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
806	1.500	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
807	1.500	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
808	2.150	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000
809	0.600	450	3000	100	6	0.14	1	1.0	1.200	0.00	1.500
810	1.500	450	3000	100	10	0.07	0	0.0	0.700	0.00	0.000

Comment

SS400-10.0S

[Material] SS400-10.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 10.00 [CutWay] Thick [NzlType] D\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	80	3500	20	20	0.10	2	0.5	1.500	0.200	0	0	0	101	0.00	Standard	No
2	900	3500	700	45	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
3	1100	3500	1000	60	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
4	1400	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
5	1400	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
6	1400	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
7	1400	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
8	1400	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
9	1400	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	20	10	5	1	0.700	20	5.500	0.10	2	0.5	4.000	-3.00	OFF
102	3500	20	10	5	1	0.700	20	5.500	0.10	2	0.5	4.000	-3.00	OFF
103	3500	20	10	5	1	0.700	20	5.500	0.10	2	0.5	4.000	-3.00	OFF
104	3500	20	10	5	1	0.700	20	5.500	0.10	2	0.5	4.000	-3.00	OFF
105	3500	20	10	5	1	0.700	20	5.500	0.10	2	0.5	4.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	20	30	10	0
902	3500	20	30	10	0
903	3500	20	30	10	0
904	3500	20	30	10	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	1000	60	0.07	1	4.00	500	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	20	30	0.000	0.07	0	1.000	100	20	30	0.000	0
202	0	3500	20	30	0.000	0.07	0	1.000	100	20	30	0.000	0
203	55	3500	15	15	0.000	0.07	0	4.000	80	15	15	0.000	0
204	95	3500	15	20	0.000	0.07	0	2.000	80	15	20	0.000	0
205	140	3500	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
206	140	3500	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
207	140	3500	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
208	140	3500	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
209	140	3500	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
210	140	3500	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

SS400-10.0SE

[Material] SS400-10.0SE [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 10.00 [CutWay] Thick [NzlType] S\*:E [Head] ECO  
 [Foc] 4.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 3 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	100	3000	20	17	0.15	3	0.3	1.500	0.200	0	201	0	101	0.00	Standard	No
2	1600	3500	2000	80	0.08	1	0.0	0.700	0.270	203	202	0	102	0.00	Standard	No
3	1800	3500	2000	85	0.08	1	0.0	0.700	0.270	203	202	0	102	0.00	Standard	No
4	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
5	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
6	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
7	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
8	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
9	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	12	0.10	2	0.0	1.500	0.000	0	0	905	0	-3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3300	20	10	5	2	1.500	10	10.000	0.15	3	0.3	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
103	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
104	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
105	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	ON	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	10	0
902	3500	100	30	10	0
903	3500	100	30	10	0
904	3500	100	30	10	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.08	1	4.00	500	4.000

Laser Gain Recv.  
 Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	20	20	0.000	0.15	0	1.500	50	20	20	1.200	0
202	0	3500	100	100	0.000	0.08	0	2.000	700	100	100	1.200	0
203	120	0	100	0	0.100	0.08	0	0.000	700	100	0	0.000	0
204	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
205	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
206	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
207	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
208	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
209	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
210	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2
	Pie.	Appr.		
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SS400-10.0SE-2**

[Material] SS400-10.0SE-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 10.00 [CutWay] Thick [NzlType] D\*:\*E [Head] ECO  
 [Foc] 4.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.40 [Lens] 7.5"  
 [AC] 3 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	100	3000	20	17	0.15	3	0.3	1.500	0.200	0	201	0	101	0.00	Standard	No
2	1600	3500	2000	80	0.08	1	0.0	0.700	0.270	203	202	0	102	0.00	Standard	No
3	1800	3500	2000	85	0.08	1	0.0	0.700	0.270	203	202	0	102	0.00	Standard	No
4	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
5	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
6	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
7	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
8	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
9	2000	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	12	0.10	2	0.0	1.500	0.000	0	0	905	0	-3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3300	20	10	5	2	1.500	10	10.000	0.15	3	0.3	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
103	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
104	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
105	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	ON	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	10	0
902	3500	100	30	10	0
903	3500	100	30	10	0
904	3500	100	30	10	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.08	1	4.00	500	4.000

Laser Gain Recv. Mont.

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	20	20	0.000	0.15	0	1.500	50	20	20	1.200	0
202	0	3500	100	100	0.000	0.08	0	2.000	700	100	100	1.200	0
203	120	0	100	0	0.100	0.08	0	0.000	700	100	0	0.000	0
204	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
205	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
206	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
207	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
208	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
209	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
210	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SS400-12.0S**

[Material] SS400-12.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 12.00 [CutWay] Thick [NzlType] D\*:\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	70	3500	20	25	0.10	2	0.5	1.500	0.230	0	0	0	101	-1.50	Standard	No
2	800	3500	700	50	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
3	1000	3500	700	60	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
4	1200	3500	700	65	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
5	1200	3500	700	65	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
6	1200	3500	700	65	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
7	1200	3500	700	65	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
8	1200	3500	700	65	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
9	100	3500	100	90	0.50	5	1.0	1.500	0.230	0	202	0	101	-1.50	Standard	No
(Etch)																
10	10000	1200	1000	13	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Initial Duty	Increase Freq.	Increase Duty	Step Time	Step Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	20	7	10	1	1.000	6	8.000	0.10	2	0.5	4.000	-3.00	OFF
102	3500	20	7	10	1	1.000	6	8.000	0.10	2	0.5	4.000	-3.00	OFF
103	3500	20	7	10	1	1.000	6	8.000	0.10	2	0.5	4.000	-3.00	OFF
104	3500	20	7	10	1	1.000	6	8.000	0.10	2	0.5	4.000	-3.00	OFF
105	3500	20	7	10	1	1.000	6	8.000	0.10	2	0.5	4.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	ON	0.0	0	Trace	No	0
OFF	ON	0.0	0	Trace	No	0
OFF	ON	0.0	0	Trace	No	0
OFF	ON	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	30	30	10	0
902	3500	30	30	10	0
903	3500	30	30	10	0
904	3500	30	30	10	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	700	60	0.07	1	4.00	400	4.000

Laser Mont.	Gain	Recv.
	7	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	10	30	0.000	0.08	0	1.500	50	10	30	0.000	0
202	0	3500	100	90	0.000	0.80	5	1.000	20	100	90	2.000	0
203	55	3500	20	15	0.000	0.08	0	5.000	50	20	15	0.000	0
204	95	3500	20	25	0.000	0.08	0	2.500	50	20	25	0.000	0
205	140	3500	20	25	0.000	0.08	0	1.500	50	20	25	0.000	0
206	140	3500	20	25	0.000	0.08	0	1.500	50	20	25	0.000	0
207	140	3500	20	25	0.000	0.08	0	1.500	50	20	25	0.000	0
208	140	3500	20	25	0.000	0.08	0	1.500	50	20	25	0.000	0
209	140	3500	20	25	0.000	0.08	0	1.500	50	20	25	0.000	0
210	140	3500	20	25	0.000	0.08	0	1.500	50	20	25	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

# SS400-12.0SE

[Material] SS400-12.0SE [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 12.00 [CutWay] Thick [NzlType] D\*\*E [Head] ECO  
 [Foc] 4.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.40 [Lens] 7.5"  
 [AC] 3 [PreGas] 16 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	70	3500	20	20	0.20	3	0.3	0.700	0.200	0	201	0	101	-1.50	Standard	No
2	800	3500	700	45	0.08	1	0.3	0.700	0.270	203	201	0	101	0.00	Standard	No
3	1400	3500	2000	90	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
4	1600	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
5	1600	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
6	1600	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
7	1600	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
8	1600	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
9	1600	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	14	0.10	2	0.0	1.500	0.000	0	0	905	0	-3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3000	20	5	5	1	1.500	15	10.000	0.15	3	0.3	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	1.000	0.08	1	0.0	5.000	-3.00	4
103	3500	100	100	0	0	0.000	0	1.000	0.08	1	0.0	5.000	-3.00	4
104	3500	100	100	0	0	0.000	0	1.000	0.08	1	0.0	5.000	-3.00	4
105	3500	100	100	0	0	0.000	0	1.000	0.08	1	0.0	5.000	-3.00	4

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH	Pie. Mont.	AO2
OFF	ON	0.0	0	Trace	No	0
OFF	OFF	0.0	7	Trace	No	0
OFF	OFF	0.0	7	Trace	No	0
OFF	OFF	0.0	7	Trace	No	0
OFF	OFF	0.0	7	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	10	0
902	3500	100	30	10	0
903	3500	100	30	10	0
904	3500	100	30	10	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.08	1	4.00	400	4.000

Laser Gain Recv. Mont.

6 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	15	30	0.000	0.08	0	1.500	50	15	30	1.500	0
202	0	3500	100	100	0.000	0.08	0	2.000	300	100	100	1.200	0
203	120	3000	10	30	0.000	0.08	0	1.500	50	10	30	0.000	0
204	120	0	10	0	0.800	0.08	0	0.000	80	10	0	0.000	0
205	120	0	10	0	0.800	0.08	0	0.000	80	10	0	0.000	0
206	120	0	10	0	0.800	0.08	0	0.000	80	10	0	0.000	0
207	120	0	10	0	0.800	0.08	0	0.000	80	10	0	0.000	0
208	120	0	10	0	0.800	0.08	0	0.000	80	10	0	0.000	0
209	120	0	10	0	0.800	0.08	0	0.000	80	10	0	0.000	0
210	120	0	10	0	0.800	0.08	0	0.000	80	10	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment



**SS400-15.0S**

[Material] SS400-15.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 15.00 [CutWay] Thick [NzlType] D\*\* [Head] Standard  
 [Foc] 2.0 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	3500	400	75	0.08	1	0.5	1.500	0.230	200	201	0	101	0.00	Standard	No
2	800	3500	400	75	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
3	850	3500	500	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
4	950	3500	500	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
5	950	3500	500	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
6	950	3500	500	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
7	950	3500	500	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
8	950	3500	500	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
9	20	3500	20	85	0.50	5	2.0	1.500	0.200	0	202	0	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	13	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.50	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	10	5	10	1	1.000	10	22.000	0.10	2	0.5	4.000	-3.00	OFF
102	3500	80	20	0	0	0.000	0	15.000	0.15	2	0.5	4.000	-3.00	OFF
103	4000	200	14	0	1	1.200	7	5.000	0.08	1	0.0	3.000	-3.00	OFF
104	4000	5	40	0	0	0.000	0	0.500	0.06	1	0.0	35.000	-3.00	OFF
105	4000	7	25	0	0	0.000	0	0.500	0.08	1	0.2	15.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2	
OFF	ON	0.0	0	Trace	No	0	
OFF	ON	0.0	8	Trace	No	0	
104	105	ON	0.0	0	Trace	No	0
OFF	ON	0.0	0	Trace	No	0	
OFF	ON	0.0	0	Trace	No	0	

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	20	30	10	0
902	3500	20	30	10	0
903	3500	20	30	10	0
904	3500	20	30	10	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	500	60	0.07	1	4.00	400	1.500

Laser Gain Recv.  
 Mont.

8 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	10	35	0.000	0.08	0	3.500	20	10	35	0.000	0
202	0	3500	20	90	0.000	0.50	1	0.100	20	20	90	0.000	0
203	55	3500	10	18	0.000	0.08	0	5.000	50	10	18	0.000	0
204	115	3500	10	25	0.000	0.08	0	4.000	50	10	25	0.000	0
205	170	3500	10	25	0.000	0.08	0	1.500	50	10	25	0.000	0
206	170	3500	10	25	0.000	0.08	0	1.500	50	10	25	0.000	0
207	170	3500	10	25	0.000	0.08	0	1.500	50	10	25	0.000	0
208	170	3500	10	25	0.000	0.08	0	1.500	50	10	25	0.000	0
209	170	3500	10	25	0.000	0.08	0	1.500	50	10	25	0.000	0
210	170	3500	10	25	0.000	0.08	0	1.500	50	10	25	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	801	0	0	No
2	802	0	0	No
3	803	0	0	No
4	804	0	0	No
5	805	0	0	No
6	806	0	0	No
7	807	0	0	No
8	808	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	1.700	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	1.700	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	1.800	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	2.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	2.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	2.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	2.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	2.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SS400-18.0S**

[Material] SS400-18.0S [Oscillator] AF35LCG0EU-001  
 [Quality] SS400 [Thic] 18.00 [CutWay] Thick [NzlType] D\*\* [Head] Standard  
 [Foc] 2.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	3500	400	75	0.08	1	0.5	1.500	0.230	200	201	0	101	0.00	Standard	No
2	800	3500	400	75	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
3	850	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
4	900	3500	400	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
5	900	3500	400	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
6	900	3500	400	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
7	900	3500	400	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
8	900	3500	400	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
9	20	3500	20	85	0.50	5	2.0	1.500	0.200	0	202	0	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	13	0.10	2	0.0	1.500	0.000	0	0	905	0	-2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	10	5	10	1	1.000	10	22.000	0.10	2	0.5	4.000	-3.00	OFF
102	3500	80	20	0	0	0.000	0	15.000	0.15	2	0.5	4.000	-3.00	OFF
103	4000	200	14	0	1	1.200	7	7.000	0.08	1	0.0	3.000	-3.00	OFF
104	4000	5	40	0	0	0.000	0	0.500	0.06	1	0.0	35.000	-3.00	OFF
105	4000	7	25	0	0	0.000	0	0.500	0.08	1	0.0	15.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2	
OFF	ON	0.0	0	Trace	No	0	
OFF	ON	0.0	8	Trace	No	0	
104	105	ON	0.0	0	Trace	No	0
OFF	ON	0.0	0	Trace	No	0	
OFF	ON	0.0	0	Trace	No	0	

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	20	30	10	0
902	3500	20	30	10	0
903	3500	20	30	10	0
904	3500	20	30	10	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	500	60	0.07	1	4.00	400	1.500

Laser Mont.	Gain	Recv.
	8	0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	10	40	0.000	0.08	0	3.500	30	10	40	0.000	0
202	0	3500	20	90	0.000	0.50	1	0.100	20	20	90	0.000	0
203	55	3500	10	15	0.000	0.08	0	5.000	30	10	15	0.000	0
204	115	3500	10	25	0.000	0.08	0	3.000	30	10	25	0.000	0
205	170	3500	10	25	0.000	0.08	0	1.500	30	10	25	0.000	0
206	170	3500	10	25	0.000	0.08	0	1.500	30	10	25	0.000	0
207	170	3500	10	25	0.000	0.08	0	1.500	30	10	25	0.000	0
208	170	3500	10	25	0.000	0.08	0	1.500	30	10	25	0.000	0
209	170	3500	10	25	0.000	0.08	0	1.500	30	10	25	0.000	0
210	170	3500	10	25	0.000	0.08	0	1.500	30	10	25	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	801	0	0	No
2	802	0	0	No
3	803	0	0	No
4	804	0	0	No
5	805	0	0	No
6	806	0	0	No
7	807	0	0	No
8	808	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	1.700	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	1.700	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	2.200	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SS400-20.0S**

[Material] SS400-20.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 20.00 [CutWay] Thick [NzlType] D\*\* [Head] Standard  
 [Foc] 2.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	3500	400	75	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
2	800	3500	400	75	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
3	850	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
4	850	3500	400	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
5	850	3500	400	85	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
6	850	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
7	850	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
8	850	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
9	20	3500	20	85	0.50	5	2.0	1.500	0.200	0	210	0	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	13	0.10	2	0.0	1.500	0.000	0	0	905	0	-2.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	10	5	10	1	1.000	10	23.000	0.10	2	0.5	4.000	-3.00	OFF
102	3500	80	20	0	0	0.000	0	17.000	0.15	2	0.5	4.000	-3.00	OFF
103	4000	200	14	0	1	1.200	7	7.000	0.08	1	0.0	3.000	-3.00	OFF
104	4000	5	40	0	0	0.000	0	0.500	0.06	1	0.0	35.000	-3.00	OFF
105	4000	7	25	0	0	0.000	0	0.500	0.08	1	0.0	15.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2	
OFF	ON	0.0	0	Trace	No	0	
OFF	ON	0.0	8	Trace	No	0	
104	105	ON	0.0	0	Trace	No	0
OFF	ON	0.0	0	Trace	No	0	
OFF	ON	0.0	0	Trace	No	0	

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	20	30	10	0
902	3500	20	30	10	0
903	3500	20	30	10	0
904	3500	20	30	10	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	500	60	0.07	1	4.00	400	1.500

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	10	40	0.000	0.10	0	3.500	30	10	40	0.000	0
202	0	3500	20	90	0.000	0.10	1	0.100	20	20	90	0.000	0
203	55	3500	10	15	0.000	0.10	0	5.000	30	10	15	0.000	0
204	115	3500	10	25	0.000	0.10	0	3.000	30	10	25	0.000	0
205	170	3500	10	25	0.000	0.10	0	1.500	30	10	25	0.000	0
206	170	3500	10	25	0.000	0.10	0	1.500	30	10	25	0.000	0
207	170	3500	10	25	0.000	0.10	0	1.500	30	10	25	0.000	0
208	170	3500	10	25	0.000	0.10	0	1.500	30	10	25	0.000	0
209	170	3500	10	25	0.000	0.10	0	1.500	30	10	25	0.000	0
210	170	3500	10	25	0.000	0.10	0	1.500	30	10	25	0.000	0

Cut No.	Type1	Type2	Type2 Pie.	Type2 Appr.
1	801	0	0	No
2	802	0	0	No
3	803	0	0	No
4	804	0	0	No
5	805	0	0	No
6	806	0	0	No
7	807	0	0	No
8	808	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	1.700	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	1.700	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	2.300	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SS400-22.0S-RF**

[Material] SS400-22.0S-RF [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 22.00 [CutWay] Thick [NzlType] D\*\* [Head] Standard  
 [Foc] 3.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
2	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
3	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
4	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
5	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
6	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
7	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
8	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
9	800	3500	400	80	0.08	1	0.5	1.500	0.230	200	201	0	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	13	0.10	2	0.0	1.500	0.000	0	0	905	0	-3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	80	20	0	0	0.000	0	20.000	0.12	3	0.5	4.000	-3.00	OFF
102	3500	80	20	0	0	0.000	0	20.000	0.12	3	0.5	4.000	-3.00	OFF
103	3500	80	20	0	0	0.000	0	20.000	0.12	3	0.5	4.000	-3.00	OFF
104	3500	80	20	0	0	0.000	0	20.000	0.12	3	0.5	4.000	-3.00	OFF
105	3500	80	20	0	0	0.000	0	20.000	0.12	3	0.5	4.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	ON	0.0	8	Trace	No	0
OFF	ON	0.0	8	Trace	No	0
OFF	ON	0.0	8	Trace	No	0
OFF	ON	0.0	8	Trace	No	0
OFF	ON	0.0	8	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	20	30	10	0
902	3500	20	30	10	0
903	3500	20	30	10	0
904	3500	20	30	10	0
905	1200	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	500	60	0.07	1	4.00	400	1.500

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3500	10	35	0.000	0.07	0	4.000	20	10	35	0.000	0
202	0	3500	10	35	0.000	0.07	0	4.000	20	10	35	0.000	0
203	55	3500	10	20	0.000	0.08	0	5.500	30	10	20	0.000	0
204	115	3500	10	30	0.000	0.08	0	4.000	30	10	30	0.000	0
205	170	3500	10	30	0.000	0.08	0	2.000	30	10	30	0.000	0
206	170	3500	10	30	0.000	0.08	0	2.000	30	10	30	0.000	0
207	170	3500	10	30	0.000	0.08	0	2.000	30	10	30	0.000	0
208	170	3500	10	30	0.000	0.08	0	2.000	30	10	30	0.000	0
209	170	3500	10	30	0.000	0.08	0	2.000	30	10	30	0.000	0
210	170	3500	10	30	0.000	0.08	0	2.000	30	10	30	0.000	0

Cut No.	Type1	Type2	Type2	Type2	Pie. Appr.
1	0	0	0	0	No
2	0	0	0	0	No
3	0	0	0	0	No
4	0	0	0	0	No
5	0	0	0	0	No
6	0	0	0	0	No
7	0	0	0	0	No
8	0	0	0	0	No
9	0	0	0	0	No
10	0	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SS400-8.0S**

[Material] SS400-8.0S [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 8.00 [CutWay] Thick [NzlType] D\*\* [Head] Standard  
 [Foc] 1.5 [Reflect.] OFF [WACS] OFF [NzlDia] 4.00 [Lens] 7.5"  
 [AC] 4 [PreGas] 2 [DA] OFF

1:Oxygen L 2:Oxygen M 3:Oxygen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	80	3500	20	20	0.10	2	0.5	1.500	0.200	0	0	0	101	0.00	Standard	No
2	1000	3500	700	45	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
3	1300	3500	1000	60	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
4	1600	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
5	1600	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
6	1600	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
7	1600	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
8	1600	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
9	1600	3500	1000	65	0.07	1	0.5	1.500	0.220	200	201	0	102	0.00	Standard	No
(Etch)																
10	10000	1200	1000	18	0.10	2	0.0	1.500	0.000	0	0	905	0	-1.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3500	20	10	5	1	0.700	20	5.000	0.10	2	0.5	4.000	-3.00	OFF
102	3500	20	10	5	1	0.700	20	5.000	0.10	2	0.5	4.000	-3.00	OFF
103	3500	20	10	5	1	0.700	20	5.000	0.10	2	0.5	4.000	-3.00	OFF
104	3500	20	10	5	1	0.700	20	5.000	0.10	2	0.5	4.000	-3.00	OFF
105	3500	20	10	5	1	0.700	20	5.000	0.10	2	0.5	4.000	-3.00	OFF

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0
OFF	OFF	0.0	0	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	20	30	10	0
902	3500	20	30	10	0
903	3500	20	30	10	0
904	3500	20	30	10	0
905	1200	1000	15	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3000	1000	60	0.07	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	20	30	0.000	0.07	0	1.000	100	20	30	0.000	0
202	0	3000	20	30	0.000	0.07	0	1.000	100	20	30	0.000	0
203	55	3000	15	15	0.000	0.07	0	4.000	80	15	15	0.000	0
204	95	3000	15	20	0.000	0.07	0	2.000	80	15	20	0.000	0
205	140	3000	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
206	140	3000	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
207	140	3000	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
208	140	3000	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
209	140	3000	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0
210	140	3000	15	20	0.000	0.07	0	1.500	80	15	20	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SS400-8.0SE**

[Material] SS400-8.0SE [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 8.00 [CutWay] Thick [NzlType] S\*\*E [Head] ECO  
 [Foc] 4.0 [Reflect.] OFF [WACS] OFF [NzlDia] 1.20 [Lens] 7.5"  
 [AC] 3 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	100	3000	20	17	0.15	3	0.3	1.500	0.200	0	201	0	101	0.00	Standard	No
2	1600	3500	2000	80	0.08	1	0.0	0.700	0.270	203	202	0	102	0.00	Standard	No
3	2200	3500	2000	85	0.08	1	0.0	0.700	0.270	203	202	0	102	0.00	Standard	No
4	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
5	2500	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
6	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
7	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
8	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
9	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	12	0.10	2	0.0	1.500	0.000	0	0	905	0	-3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3200	20	10	5	2	1.500	10	9.000	0.15	3	0.3	3.500	-3.50	OFF
102	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.50	2
103	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.50	2
104	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.50	2
105	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.50	2

Pre Pie.	After Pie.	BCut	Pie. Type	RSSH M	Pie. Mont.	AO2
OFF	ON	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	10	0
902	3500	100	30	10	0
903	3500	100	30	10	0
904	3500	100	30	10	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.08	1	4.00	500	4.000

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Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	20	20	0.000	0.15	0	1.500	50	20	20	1.200	0
202	0	3500	100	100	0.000	0.08	0	2.000	700	100	100	1.200	0
203	120	0	100	0	0.100	0.08	0	0.000	700	100	0	0.000	0
204	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
205	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
206	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
207	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
208	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
209	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
210	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2
	Pie.	Appr.		
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

**SS400-8.0SE-2**

[Material] SS400-8.0SE-2 [Oscillator] AF35LGG0EU-001  
 [Quality] SS400 [Thic] 8.00 [CutWay] Thick [NzlType] D\*:E [Head] ECO  
 [Foc] 3.5 [Reflect.] OFF [WACS] OFF [NzlDia] 1.40 [Lens] 7.5"  
 [AC] 3 [PreGas] 16 [DA] OFF

1:Oxgen L 2:Oxgen M 3:Oxgen H  
 4:Nitrogen 5:Air

Cut No.	Feed [F]	Power [S]	Freq. [P]	Duty [Q]	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Comp.	Edge	Appr.	Fine	Pie. No.	Focal Comp.	Head Contro	Cut Mont.
1	100	3000	20	17	0.15	3	0.3	1.500	0.200	0	201	0	101	0.00	Standard	No
2	1600	3500	2000	80	0.08	1	0.0	0.700	0.270	203	202	0	102	0.00	Standard	No
3	2200	3500	2000	85	0.08	1	0.0	0.700	0.270	203	202	0	102	0.00	Standard	No
4	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
5	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
6	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
7	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
8	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
9	2400	3500	2000	100	0.08	1	0.0	0.700	0.270	204	202	0	102	0.00	Standard	No
(Etch)																
10	10000	1000	1000	12	0.10	2	0.0	1.500	0.000	0	0	905	0	-3.00	Medium	No

Pie. No.	Power [S]	Initial Freq.	Duty	Increase Freq.	Duty	Step Time	Num.	Pie. Time	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Blow
101	3300	20	10	5	2	1.500	10	9.000	0.15	3	0.3	3.500	-3.00	OFF
102	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
103	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
104	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2
105	3500	100	100	0	0	0.000	0	0.500	0.08	1	0.0	5.000	-3.00	2

Pre Pie.	After Pie.	BCut	Pie. Type	RSSHMM	Pie. Mont.	AO2
OFF	ON	0.0	0	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0
OFF	OFF	0.0	6	Trace	No	0

Fine No.	Power	Freq.	Duty	Param	Fine Ctrl
901	3500	100	30	10	0
902	3500	100	30	10	0
903	3500	100	30	10	0
904	3500	100	30	10	0
905	1000	1000	10	60	0

Pre Cut	Power	Freq.	Duty	Gas Pres.	Gas Kind	Dist.	Feed	Nozl. Gap
	3500	2000	100	0.08	1	4.00	500	4.000

Laser Gain Recv.  
 Mont.

1 0

Edg No.	Angl.	Edge Power	Edge Freq.	Edge Duty	Pie. Time	Edge Gas Pres.	Edge Gas Kind	Rec. Dist.	Rec. Feed	Rec. Freq.	Rec. Duty	Nozl. Gap	Edg Ctrl.
201	0	3000	20	20	0.000	0.15	0	1.500	50	20	20	1.200	0
202	0	3500	100	100	0.000	0.08	0	2.000	700	100	100	1.200	0
203	120	0	100	0	0.100	0.08	0	0.000	700	100	0	0.000	0
204	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
205	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
206	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
207	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
208	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
209	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0
210	120	0	100	0	0.300	0.08	0	0.000	700	100	0	0.000	0

Cut No.	Type1	Type2	Type2	Type2
		Pie.	Appr.	
1	0	0	0	No
2	0	0	0	No
3	0	0	0	No
4	0	0	0	No
5	0	0	0	No
6	0	0	0	No
7	0	0	0	No
8	0	0	0	No
9	0	0	0	No
10	0	0	0	No

Ext. No.	Dist.	Feed	Power	Freq.	Duty	Gas Pres.	Gas Kind	Gas Time	Nozl. Gap	Focal Comp.	Pie. Time
801	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
802	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
803	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
804	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
805	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
806	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
807	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
808	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
809	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000
810	0.000	0	0	0	0	0.00	0	0.0	0.000	0.00	0.000

Comment

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