

## OCULUS FIBRE LASER – MATERIAL CUTTING DEPTHS

**Power – 500w**

Material	Thickness (mm)	Speed (m/min)	Gas
Mild Steel	1	8-12	O <sub>2</sub>
Mild Steel	2	4-5	O <sub>2</sub>
Mild Steel	3	2-2.5	O <sub>2</sub>
Mild Steel	4	1.2-2	O <sub>2</sub>
Mild Steel	5	1-1.5	O <sub>2</sub>
Mild Steel	6	0.6-1	O <sub>2</sub>
Stainless Steel	1	8-10	N <sub>2</sub>
Stainless Steel	2	2-3	N <sub>2</sub>
Stainless Steel	3	0.6-0.8	N <sub>2</sub>

**Power – 750w**

Material	Thickness (mm)	Speed (m/min)	Gas
Mild Steel	1	10-15	O <sub>2</sub>
Mild Steel	2	4-6	O <sub>2</sub>
Mild Steel	3	2.5-3.5	O <sub>2</sub>
Mild Steel	4	1.5-2	O <sub>2</sub>
Mild Steel	5	1.2-1.5	O <sub>2</sub>
Mild Steel	6	1-1.3	O <sub>2</sub>
Mild Steel	8	0.6-0.8	O <sub>2</sub>
Stainless Steel	1	15-20	N <sub>2</sub>
Stainless Steel	2	4-6	N <sub>2</sub>
Stainless Steel	3	0.8-1.2	N <sub>2</sub>
Stainless Steel	4	0.6	N <sub>2</sub>
Aluminium	1	8	N <sub>2</sub>
Aluminium	2	3	N <sub>2</sub>

**Power – 1000w**

Material	Thickness (mm)	Speed (m/min)	Gas
Mild Steel	1	15	O <sub>2</sub>
Mild Steel	2	6-8	O <sub>2</sub>
Mild Steel	3	3-4	O <sub>2</sub>
Mild Steel	4	2	O <sub>2</sub>
Mild Steel	5	1.5	O <sub>2</sub>
Mild Steel	6	1.2-1.5	O <sub>2</sub>
Mild Steel	8	1	O <sub>2</sub>
Mild Steel	10	0.6-0.8	O <sub>2</sub>
Mild Steel	12	0.6	O <sub>2</sub>
Stainless Steel	1	18	N <sub>2</sub>
Stainless Steel	2	5-7	N <sub>2</sub>
Stainless Steel	3	2-3	N <sub>2</sub>
Stainless Steel	4	1.2-1.5	N <sub>2</sub>
Stainless Steel	5	0.8	N <sub>2</sub>
Aluminium	1	8-10	N <sub>2</sub>
Aluminium	2	4.5	N <sub>2</sub>
Aluminium	3	1.2	N <sub>2</sub>
Copper	1	10	N <sub>2</sub>