CUTTING THICKNESS AND SPEED

		500W	1000W	2000W	3000W	4000W	6000W	8000W
Material	Thickness	speed m/min	speed m/min	speed m/min	speed m/min	speed m/min	speed m/min	speed m/min
Carbon steel	1	8-13	15-24	24-30	30-42	40-55	60-80	70-90
	2	3.0-4.5	5-7.5	5.5-8	7-9	8-10	9-12	10-13
	3	1.8-3.0	2.4-4	3.5-4.8	4-6.5	4.5-6.5	4-7	4-7
	4	1.3-1.5	2-2.4	2.8-3.5	3.5-4.5	4.0-5.0	4.2-5.5	4.7-5.5
	5	0.9-1.1	1.8-2	2.5-3	3-3.5	3.0-4.2	3.5-4.2	3.8-4.5
	6	0.6-0.9	1.4-1.6	1.8-2.6	2.5-3.2	3.0-3.5	3.0-4	3.3-4.2
	8		0.8-1.2	1.2-1.8	1.8-2.6	2.0-3.0	2.2-3.2	2.5-3.5
	10		0.6-1.0	1.1-1.3	1.4-2.0	1.5-2.5	1.8-2.5	2.2-2.7
	12		0.5-0.8	0.9-1.2	1.2-1.6	1.4-2	1.6-2	1.8-2.1
	14			0.7-0.8	0.9-1.4	1.0-1.6	1.5-1.8	1.7-1.9
	16			0.6-0.7	0.8-1.2	0.8-1.2	0.8-1.5	0.9-1.7
	18			0.4-0.6	0.7-1	0.8-1.1	0.9-1.2	0.9-1.2
	20				0.6-0.8	0.7--1	0.8-1.1	1.0-1.5
	22				0.4-0.6	0.6-0.8	0.7-0.9	0.8-1.0
	25					0.3-0.5	0.4-0.6	0.5-0.7
Stainless steel	1	8-13	18-25	24-30	30-42	40-55	60-80	70-90
	2	2.4-5.0	7-12	10-17	18-21	20-30	30-42	40-55
	3	0.6-0.8	1.8-2.5	4-6.5	8-12	12-18	18-24	30-38
	4		1.2-1.3	3-4.5	6-9	8-12	10-18	18-24
	5		0.6-0.7	1.8-2.5	3.0-5.0	4-6.5	8-12	12-17
	6			1.2-2.0	3.0-4.3	4.0-6.5	6-9	8-14
	8			0.7-1	1.5-2.0	1.8-3.0	4-5	6-8
	10				0.8-1	0.8-1.5	1.8-2.5	3-5
	12				0.5-0.8	0.6-1.0	1.2-1.8	1.8-3
	15					0.5-0.8	0.6-0.8	1.2-1.8
	20					0.4-0.5	0.5-0.8	0.6-0.7
	25						0.4-0.5	0.5-0.6
	30							0.4-0.5
Aluminum	1	4-5.5	6-10	20-25	25-40	40-55	55-65	80-90
	2	0.7-1.5	2.8-3.6	7-10	10-18	15-25	25-35	35-50
	3		0.7-1.5	4-6	7-10	10-15	13-18	21-30
	4			2-3	4-5.5	8-10	10-12	13-18
	5			1.2-1.8	3-4	5-7	6-10	9-12
	6			0.7-1	1.5-2.5	3.5-4	4-6	4.5-8
	8				0.7-1	1.5-2	2-3	4-6
	10				0.5-0.7	1-1.5	1.5-2.1	2.2-3
	12					0.7-0.9	0.8-1.4	1.5-2
	15					0.5-0.7	0.7-1	1-1.6
	20						0.5-0.7	0.7-1
	25							0.5-0.7
Brass	1	4-5.5	6-10	14-16	25-35	35-45	50-60	70-85
	2	0.5-1.0	2.8-3.6	4.5-6.5	10-15	10-15	25-30	30-40
	3		0.5-1.0	2.5-3.5	5-8	7-10	12-18	15-24
	4			1.5-2	3.5-5.0	5-8	8-10	9-15
	5			1.4-1.6	2.5-3.2	3.5-5.0	6-7	7-9
	6				1.2-2.0	1.5-2.5	3.5-4.5	4.5-6.5
	8				0.7-0.9	0.8-1.5	1.6-2.2	2.4-4
	10					0.5-0.8	0.8-1.4	1.5-2.2
	12						0.6-0.8	0.8-1.5
	16							0.6-0.8