

| Материал | Толщина [мм] | Скорость [м/мин] | Мощность [Вт] | газ | Атмосферное давление [бар] | Сопло [мм] | Положение фокуса [мм] | Высота реза [мм] |
|--------------------|-------------------|------------------|---------------|---------------------|----------------------------|------------|-----------------------|------------------|
| углеродистая сталь | 1 | 15-20 | 1500 | N ₂ /Air | 10 | 2.0S | 0 | 1 |
| | 2 | 4-5 | 1500 | | 10 | 2.0S | 0 | 0.5 |
| углеродистая сталь | 2 | 4 | 1500 | O ₂ | 1.6 | 1.0D | +3 | 0.8 |
| | 3 | 3-4 | | | 0.6 | 1.0D | +4 | 0.8 |
| | 4 | 2.3-2.8 | | | 0.6 | 1.0D | +4 | 0.8 |
| | 5 | 1.8-2.3 | | | 0.6 | 1.2D | +4 | 0.8 |
| | 6 | 1.6-2.0 | | | 0.6 | 1.2D | +4 | 0.8 |
| | 8 | 1.2-1.5 | | | 0.6 | 1.2D | +4 | 0.8 |
| | 10 | 0.9-1.2 | | | 0.6 | 1.2D | +4 | 0.8 |
| | 12 | 0.8 | | | 0.6 | 4.0D | +4 | 0.8 |
| | 14 | 0.6 | | | 0.6 | 4.0D | +4 | 0.8 |
| | нержавеющая сталь | 1 | | | 20-25 | 1500 | N ₂ | 10 |
| 2 | | 8-10 | 12 | 2.0S | 0 | | | 0.5 |
| 3 | | 4.5-5.5 | 12 | 2.0S | -0.5 | | | 0.5 |
| 4 | | 3.0-3.5 | 14 | 3.0S | -1.5 | | | 0.5 |
| 5 | | 1.5-2.0 | 14 | 3.0S | -5 | | | 0.5 |
| 6 | | 0.7-0.9 | 14 | 4.0S | -5 | | | 0.5 |
| алюминий | 1 | 12-16 | 1500 | N ₂ | 12 | 2.0S | 0 | 0.8 |
| | 2 | 4.0-5.0 | | | 12 | 2.0S | 0 | 0.5 |
| | 3 | 1.5-2.5 | | | 14 | 2.0S | -1 | 0.5 |
| | 4 | 1.0-1.3 | | | 14 | 3.0S | -2 | 0.5 |
| латунь | 1 | 12-15 | 1500 | N ₂ | 12 | 2.0S | 0 | 0.8 |
| | 2 | 4.0-5.0 | | | 12 | 2.0S | 0 | 0.5 |
| | 3 | 1.5-2.0 | | | 14 | 3.0S | -1 | 0.5 |