

Cutting Speeds - TruLaser 1030

Maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, focal lens, assist gas (O₂ N₂ Air) and gas pressure. Flow rates are estimated in CFH. Actual consumption rates may vary.

Materials			TruCoax 2500watt					TruDisk 2001 (2000watt)					TruDisk 3001 (3000watt)				
	inch	mm	in/min	Lens	Nozzle	PSI	Flow ²	in/min	Lens	Nozzle	PSI	Flow ²	in/min	Lens	Nozzle	PSI	Flow ²
Steel O ₂	0.040	1.0	290-310	7.5"	1.0	55	65 CFH	295-315	200mm	1.0	44	55 CFH	374-394	200mm	1.0	36	45 CFH
	0.060	1.5	240-275	7.5"	1.0	50	65 CFH	216-236	200mm	1.0	44	55 CFH	252-276	200mm	0.8	36	30 CFH
	0.080	2.0	170-195	7.5"	1.0	50	65 CFH	177-197	200mm	1.0	36	45 CFH	200-217	200mm	1.2	36	65 CFH
	0.100	2.5	160-175	7.5"	1.0	50	65 CFH	153-173	200mm	1.0	36	45 CFH	173-193	200mm	0.8	12	10 CFH
	0.120	3.0	140-150	7.5"	1.0	35	45 CFH	140-150	200mm	1.0	9	10 CFH	150-170	200mm	0.8	9	8 CFH
	0.180	4.5	115-125	7.5"	1.0	50	65 CFH	100-110	200mm	1.0	9	10 CFH	128-138	200mm	0.8	12	10 CFH
	0.250	6.4	85-95	7.5"	1.0	55	68 CFH	77-87	200mm	1.2	9	25 CFH	105-118	200mm	1.0	10	15 CFH
	0.375	9.5	55-65	7.5"	1.4	10	35 CFH	46-51	200mm	1.2	9	25 CFH	61-71	200mm	1.2	12	25 CFH
0.500	12.7	35-40	7.5"	1.4	10	35 CFH	30-35	200mm	1.4	9	25 CFH	41-47	200mm	1.4	9	30 CFH	
0.625	16	25-35	7.5"	2.3	10	35 CFH	-	-	-	-	-	31-35	200mm	1.4	9	30 CFH	
Steel N ₂	0.040	1.0	430-470	7.5"	1.4	150	410 CFH	799-866	200mm	2.0	145	813 CFH	1160-1260	200mm	2.0	218	1156 CFH
	0.060	1.5	255-275	7.5"	1.4	150	410 CFH	475-512	200mm	2.0	145	813 CFH	750-787	200mm	2.7	218	1513 CFH
	0.080	2.0	225-235	7.5"	1.4	150	410 CFH	374-394	200mm	2.3	232	1606 CFH	600-610	200mm	2.7	218	1513 CFH
	0.120	3.0	110-115	7.5"	2.3	180	1233 CFH	137-157	200mm	2.3	290	1980 CFH	290-300	200mm	2.7	247	2443 CFH
Steel Air	0.040	1.0	646-666	7.5"	1.7	75	290 CFH	799-866	200mm	1.4	75	190 CFH	1160-1260	200mm	1.7	75	290 CFH
	0.060	1.5	370-390	7.5"	2.3	75	570 CFH	531-551	200mm	1.7	75	290 CFH	750-787	200mm	2.0	75	470 CFH
	0.080	2.0	290-310	7.5"	2.3	75	570 CFH	334-354	200mm	2.3	75	570 CFH	531-551	200mm	2.3	75	570 CFH
	0.120	3.0	-	-	-	-	-	-	-	-	-	-	295-315	200mm	2.3	75	570 CFH
Stainless N ₂	0.040	1.0	370-390	7.5"	1.4	90	240 CFH	910-984	200mm	1.7	174	703 CFH	1081-1181	200mm	1.7	210	821 CFH
	0.060	1.5	255-275	7.5"	1.4	140	380 CFH	630-669	200mm	1.7	174	703 CFH	964-984	200mm	1.7	240	939 CFH
	0.080	2.0	215-235	7.5"	1.4	140	380 CFH	405-433	200mm	2.3	174	1233 CFH	655-669	200mm	2.3	240	1606 CFH
	0.120	3.0	125-135	7.5"	2.3	180	1233 CFH	216-236	200mm	2.7	232	2313 CFH	325-335	200mm	2.7	255	2443 CFH
	0.180	4.5	60-65	7.5"	2.3	225	1513 CFH	72-79	200mm	2.7	247	2443 CFH	145-157	200mm	2.7	270	2573 CFH
	0.250	6.4	34-39	7.5"	2.3	240	1606 CFH	35-39	200mm	2.7	290	2833 CFH	69-79	200mm	2.7	300	2883 CFH
	0.310	7.8	-	-	-	-	-	-	-	-	-	-	50-55	200mm	2.7	300	2833 CFH
Stainless Air	0.040	1.0	690-745	7.5"	2.3	75	570 CFH	799-866	200mm	2.0	145	813 CFH	1160-1260	200mm	1.4	75	190 CFH
	0.060	1.5	380-410	7.5"	2.3	75	570 CFH	475-512	200mm	2.0	145	813 CFH	886-906	200mm	1.7	75	290 CFH
	0.080	2.0	265-285	7.5"	2.3	75	570 CFH	374-394	200mm	2.3	232	1606 CFH	334-354	200mm	2.3	75	570 CFH
	0.120	3.0	-	-	-	-	-	137-157	200mm	2.3	290	1980 CFH	295-315	200mm	2.3	75	570 CFH
Alumin. N ₂	0.040	1.0	450-470	7.5"	1.4	105	270 CFH	802-827	200mm	2.0	145	813 CFH	850-964	200mm	2.0	73	470 CFH
	0.060	1.5	255-275	7.5"	1.4	105	270 CFH	420-433	200mm	2.0	145	813 CFH	452-472	200mm	2.0	95	575 CFH
	0.080	2.0	195-215	7.5"	1.7	135	526 CFH	260-276	200mm	2.0	145	813 CFH	374-394	200mm	2.0	116	675 CFH
	0.120	3.0	105-115	7.5"	1.7	195	762 CFH	130-138	200mm	1.2	120	795 CFH	147-157	200mm	2.0	174	950 CFH
	0.180	4.5	45-50	7.5"	2.3	195	1326 CFH	55-59	200mm	2.3	203	2105 CFH	91-96	200mm	2.3	174	1233 CFH
	0.200	5.1	30-35	7.5"	2.3	195	1326 CFH	34-39	200mm	2.3	203	2105 CFH	86-91	200mm	2.3	270	1793 CFH
	0.250	6.4	26-31	7.5"	2.3	195	1326 CFH	-	-	-	-	-	78-83	200mm	2.3	270	1793 CFH
Alumin. Air	0.040	1.0	645-665	7.5"	2.7	75	882 CFH	757-787	200mm	2.7	75	882 CFH	1278-1378	200mm	2.7	75	882 CFH
	0.060	1.5	330-350	7.5"	2.7	75	882 CFH	374-394	200mm	2.7	75	882 CFH	728-748	200mm	2.7	75	882 CFH
	0.080	2.0	215-235	7.5"	2.7	75	882 CFH	295-315	200mm	2.7	75	882 CFH	610-630	200mm	2.7	75	882 CFH
Copper O ₂	0.040	1.0						498-512	200mm	1.2	73	120 CFH	765-787	200mm	1.2	75	130 CFH
	0.060	1.5						265-275	200mm	1.2	116	250 CFH	452-472	200mm	2.0	120	675 CFH
	0.080	2.0						150-157	200mm	1.2	116	250 CFH	295-315	200mm	2.0	120	675 CFH
	0.120	3.0						90-97	200mm	2.3	180	1233 CFH	140-150	200mm	2.3	180	1233 CFH
	0.140	3.5						-	-	-	-	-	92-102	200mm	2.3	180	1233 CFH
	0.160	4.0						-	-	-	-	-	78-83	200mm	2.3	180	1233 CFH
Brass N ₂	0.040	1.0						498-512	200mm	1.7	145	585 CFH	767-787	200mm	1.7	150	585 CFH
	0.060	1.5						300-315	200mm	1.7	145	585 CFH	452-472	200mm	1.7	150	585 CFH
	0.080	2.0						185-196	200mm	2.3	203	1419 CFH	315-325	200mm	2.3	210	1419 CFH
	0.120	3.0						70-78	200mm	2.3	232	1606 CFH	140-150	200mm	2.3	240	1606 CFH
	0.140	3.5						-	-	-	-	-	128-138	200mm	2.3	240	1606 CFH
	0.160	4.0						-	-	-	-	-	100-110	200mm	2.3	240	1606 CFH

Worst case set-up time at a TRUMPF Laser Cutting Machine is just 10 seconds a nozzle change. Therefore the customer practically has no down time, even with an optimally adjusted machine !
(Cutting speeds may be reduced if higher cutting quality is required or lower material quality is used !)

¹ High Focus Technique only

² Flow rates are estimated

Cutting Speeds - TruDisk Laser 3030/5030

Maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines
depending on laser power, focal lens, assist gas (O₂, N₂, Air) and gas pressure.
Flow rates are estimated in CFH. Actual consumption rates may vary.

Materials		3001 (3000watt)						5001 (5000watt)						BrightLine5001 (5000watt) ²					
	inch	mm	in/min	Lens	Nozzle	PSI	Flow ¹	in/min	Lens	Nozzle	PSI	Flow ¹		in/min	Lens	Nozzle	PSI ²	Flow ³	
Steel	0.040	1.0	340-360	200mm	1.0	36	45 CFH	340-360	200mm	1.2	58	90 CFH	-	-	-	-	-	-	-
	0.060	1.5	252-276	200mm	0.8	36	30 CFH	252-276	200mm	1.2	58	90 CFH	-	-	-	-	-	-	-
	0.080	2.0	200-217	200mm	1.2	36	65 CFH	200-217	200mm	1.2	36	55 CFH	-	-	-	-	-	-	-
	0.100	2.5	173-193	200mm	0.8	12	10 CFH	173-193	200mm	1.2	58	90 CFH	-	-	-	-	-	-	-
	0.120	3.0	150-170	200mm	0.8	9	8 CFH	150-170	200mm	1.2	58	90 CFH	-	-	-	-	-	-	-
	0.180	4.5	128-138	200mm	0.8	12	10 CFH	130-140	200mm	0.8	9	10 CFH	-	-	-	-	-	-	-
	0.250	6.4	105-118	200mm	1.0	10	15 CFH	115-128	200mm	1.0	9	15 CFH	-	-	-	-	-	-	-
	0.375	9.5	61-71	200mm	1.2	12	25 CFH	85-95	200mm	1.2	9	25 CFH	-	-	-	-	-	-	-
	0.500	12.7	41-47	200mm	1.4	9	30 CFH	55-63	200mm	1.2	10	30 CFH	-	-	-	-	-	-	-
	0.625	16	31-35	200mm	1.4	9	30 CFH	44-50	200mm	1.4	10	35 CFH	-	-	-	-	-	-	-
Steel	0.040	1.0	1160-1260	200mm	2.0	218	1156 CFH	1800-1890	200mm	2.0	174	950 CFH	-	-	-	-	-	-	-
	0.060	1.5	750-787	200mm	2.7	218	1513 CFH	1210-1300	200mm	2.0	189	1019 CFH	-	-	-	-	-	-	-
	0.080	2.0	600-610	200mm	2.7	218	1513 CFH	950-985	200mm	2.0	189	1019 CFH	-	-	-	-	-	-	-
	0.120	3.0	290-300	200mm	2.7	247	2443 CFH	400-413	200mm	2.3	203	1419 CFH	-	-	-	-	-	-	-
	0.180	4.5	100-108	200mm	2.7	261	2573 CFH	234-244	200mm	2.7	232	2313 CFH	-	-	-	-	-	-	-
	0.250	6.4	60-65	200mm	2.7	261	2573 CFH	125-134	200mm	2.7	261	2573 CFH	-	-	-	-	-	-	-
	0.375	9.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	0.500	12.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	0.625	16	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	0.750	20	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Stainless	0.040	1.0	1300-1339	200mm	1.7	218	880 CFH	1950-2050	200mm	1.7	189	762 CFH	-	-	-	-	-	-	-
	0.060	1.5	964-984	200mm	2.0	218	1156 CFH	1220-1320	200mm	2.3	218	1513 CFH	-	-	-	-	-	-	-
	0.080	2.0	655-669	200mm	2.3	218	1513 CFH	965-985	200mm	2.3	218	1513 CFH	-	-	-	-	-	-	-
	0.120	3.0	325-335	200mm	2.7	174	1792 CFH	410-433	200mm	2.7	189	1922 CFH	-	-	-	-	-	-	-
	0.180	4.5	145-157	200mm	2.3	247	1699 CFH	205-217	200mm	2.7	203	2052 CFH	-	-	-	-	-	-	-
	0.250	6.4	71-95	200mm	2.0	232	1225 CFH	140-150	200mm	2.7	232	2313 CFH	-	-	-	-	-	-	-
	0.375	9.5	25-28	200mm	2.7	290	2833 CFH	35-45	200mm	2.7	290	2833 CFH	-	-	-	-	-	-	-
	0.500	12.7	10-14	200mm	2.7	290	2833 CFH	14-24	200mm	2.7	290	2833 CFH	-	-	-	-	-	-	-
	0.625	16.0	-	-	-	-	-	12-18	200mm	2.7	290	2833 CFH	-	-	-	-	-	-	-
	0.750	20.0	-	-	-	-	-	10-12	200mm	2.7	290	2833 CFH	-	-	-	-	-	-	-
Alumin.	0.040	1.0	850-964	200mm	2.0	73	470 CFH	1050-1182	200mm	1.7	73	250 CFH	-	-	-	-	-	-	-
	0.060	1.5	532-462	200mm	2.0	95	575 CFH	690-750	200mm	2.0	87	600 CFH	-	-	-	-	-	-	-
	0.080	2.0	354-394	200mm	2.0	116	675 CFH	475-512	200mm	2.0	131	675 CFH	-	-	-	-	-	-	-
	0.120	3.0	147-157	200mm	2.0	174	950 CFH	280-296	200mm	2.0	174	900 CFH	-	-	-	-	-	-	-
	0.180	4.5	88-98	200mm	2.3	174	1233 CFH	140-150	200mm	2.0	189	1019 CFH	-	-	-	-	-	-	-
	0.250	6.4	70-83	200mm	2.0	218	1156 CFH	80-90	200mm	2.0	232	1250 CFH	-	-	-	-	-	-	-
	0.375	9.5	30-35	200mm	2.0	276	1431 CFH	60-70	200mm	2.3	232	1600 CFH	-	-	-	-	-	-	-
	0.500	12.7	15-20	200mm	2.3	174	1233 CFH	25-30	200mm	2.3	232	1600 CFH	-	-	-	-	-	-	-
	0.625	16.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	0.750	20.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Alumin.	0.040	1.0	2165-2362	200mm	1.7	145	585 CFH	3000-4000	200mm	1.4	116	250 CFH	-	-	-	-	-	-	-
	0.060	1.5	1063-1300	200mm	1.7	102	408 CFH	1650-1722	200mm	1.4	109	225 CFH	-	-	-	-	-	-	-
	0.080	2.0	680-787	200mm	2.7	116	675 CFH	1200-1379	200mm	2.3	87	625 CFH	-	-	-	-	-	-	-
	0.040	1.0	765-787	200mm	1.2	73	120 CFH	960-1063	200mm	1.2	73	120 CFH	-	-	-	-	-	-	-
	0.060	1.5	472-492	200mm	1.2	73	120 CFH	762-787	200mm	2.0	116	110 CFH	-	-	-	-	-	-	-
	0.080	2.0	315-323	200mm	1.2	73	120 CFH	615-630	200mm	2.0	174	950 CFH	-	-	-	-	-	-	-
	0.120	3.0	115-130	200mm	2.3	73	570 CFH	250-276	200mm	2.3	174	1250 CFH	-	-	-	-	-	-	-
	0.180	4.5	47-59	200mm	2.7	102	1142 CFH	90-100	200mm	2.7	160	1662 CFH	-	-	-	-	-	-	-
	0.200	5.0	35-39	200mm	2.7	102	1142 CFH	55-59	200mm	2.7	160	1662 CFH	-	-	-	-	-	-	-
	0.250	6.4	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
Brass	0.040	1.0	787-815	200mm	1.7	145	585 CFH	1002-1102	200mm	1.7	145	585 CFH	-	-	-	-	-	-	-
	0.060	1.5	472-543	200mm	1.7	145	585 CFH	795-827	200mm	1.7	145	585 CFH	-	-	-	-	-	-	-
	0.080	2.0	335-378	200mm	2.0	145	813 CFH	600-650	200mm	2.0	145	813 CFH	-	-	-	-	-	-	-
	0.120	3.0	150-189	200mm	2.0	174	950 CFH	275-295	200mm	2.0	174	950 CFH	-	-	-	-	-	-	-
	0.180	4.5	80-85	200mm	2.7	218	2183 CFH	130-142	200mm	2.7	218	2183 CFH	-	-	-	-	-	-	-
	0.250	6.4	42-47	200mm	2.7	290	2833 CFH	80-90	200mm	2.7	290	2833 CFH	-	-	-	-	-	-	-
	0.375	9.5	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	0.500	12.7	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	0.625	16.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-
	0.750	20.0	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-	-

Worst case set-up time at a TRUMPF Laser Cutting Machine is just 10 seconds a nozzle change.

Therefore the customer practically has no down time, even with an optimally adjusted machine !

(Cutting speeds may be reduced if higher cutting quality is required or lower material quality is used !)

¹Flow rates are estimated

²Extended ranges of materials and thicknesses are in development at this time

³Pressure and Flow Rates to be determined

Cutting Speeds - TruFlow Laser

Maximum cutting speeds in inches per minute for TRUMPF Laser Cutting Machines depending on laser power, focal lens, assist gas (O₂, N₂, Air) and gas pressure.

Flow rates are estimated in CFH. Actual consumption rates may vary.

Materials			3200 watt					4000 watt					5000 watt					6000 watt				
	inch	mm	in/min	Lens	Nozzle	PSI	Flow ²	in/min	Lens	Nozzle	PSI	Flow ²	in/min	Lens	Nozzle	PSI	Flow ²	in/min	Lens	Nozzle	PSI	Flow ²
Steel	0.040	1.0	246-256	9.8	0.8	19	15 CFH	246-256	9.8	0.8	19	15 CFH	246-256	9.8	0.8	25	17 CFH	246-256	9.8	0.8	19	15 CFH
	0.060	1.5	226-236	9.8	0.8	6	4 CFH	226-236	9.8	0.8	6	4 CFH	226-236	9.8	0.8	8	6 CFH	226-236	9.8	0.8	8	6 CFH
	0.080	2.0	203-213	9.8	0.8	8	6 CFH	203-213	9.8	0.8	8	6 CFH	203-213	9.8	0.8	8	6 CFH	203-213	9.8	0.8	8	6 CFH
	0.100	2.5	191-201	9.8	0.8	9	8 CFH	191-201	9.8	0.8	9	8 CFH	191-201	9.8	0.8	9	8 CFH	191-201	9.8	0.8	6	4 CFH
	0.120	3.0	187-197	9.8	0.8	9	8 CFH	187-197	9.8	0.8	9	8 CFH	187-197	9.8	0.8	9	8 CFH	187-197	9.8	0.8	9	8 CFH
	0.180	4.5	112-122	9.8	0.8	12	10 CFH	128-138	9.8	0.8	12	10 CFH	146-156	9.8	0.8	12	10 CFH	163-173	9.8	0.8	12	10 CFH
	0.250	6.4	100-110	9.8	1.0	12	16 CFH	110-120	9.8	1.0	12	16 CFH	120-130	9.8	1.0	9	12 CFH	130-146	9.8	1.0	10	14 CFH
	0.375	9.5	61-71	9.8	1.2	10	25 CFH	69-79	9.8	1.2	10	25 CFH	81-91	9.8	1.2	10	25 CFH	84-94	9.8	1.2	10	25 CFH
	0.500	12.7	45-55	9.8	1.4	9	26 CFH	49-59	9.8	1.4	9	26 CFH	60-67	9.8	1.4	10	30 CFH	65-75	9.8	1.4	10	30 CFH
	0.625	16	34-39	9.8	1.4	10	30 CFH	42-47	9.8	1.4	10	30 CFH	50-55	9.8	1.4	10	30 CFH	57-63	9.8	1.4	10	30 CFH
Steel	0.040	1.0	761-781*	5.1	1.7	100	408 CFH	807-827*	5.1	1.7	100	408 CFH	1004-1024*	5.1	1.7	100	408 CFH	1240-1260*	5.1	1.7	100	408 CFH
	0.060	1.5	433-453*	5.1	1.7	100	408 CFH	452-472*	5.1	1.7	100	408 CFH	650-669*	5.1	1.7	100	408 CFH	787-807*	5.1	1.7	100	408 CFH
	0.080	2.0	179-189	9.8	1.4	150	430 CFH	226-236*	5.1	1.7	100	408 CFH	344-354*	5.1	1.7	100	408 CFH	541-551*	5.1	1.7	100	408 CFH
	0.100	2.5	140-150	9.8	1.4	165	450 CFH	183-193	9.8	1.7	235	945 CFH	218-228	9.8	2.3	206	1425 CFH	226-236	9.8	2.3	206	1425 CFH
	0.120	3.0	108-118	9.8	1.7	225	880 CFH	136-146	9.8	1.7	235	945 CFH	183-193	9.8	2.3	235	1615 CFH	207-217	9.8	2.3	235	1615 CFH
	0.180	4.5	57-67	9.8	1.7	225	880 CFH	80-90	9.8	2.3	250	1750 CFH	100-110	9.8	2.3	250	1750 CFH	136-146	9.8	2.3	250	1750 CFH
	0.250	6.4	-	-	-	-	-	75-79	9.8	2.3	220	1550 CFH	86-96	9.8	2.3	280	1960 CFH	100-110	9.8	2.3	280	1960 CFH
	0.310	8.0	-	-	-	-	-	-	-	-	-	-	60-65	9.8	2.3	294	1995 CFH	66-71	9.8	2.3	294	1995 CFH
	0.040	1.0	650-670	5.1	1.7	45	110 CFH	728-748	9.8	1.4	74	195 CFH	767-787	9.8	1.4	74	195 CFH	901-921	9.8	1.4	74	195 CFH
	0.060	1.5	248-268	5.1	1.7	45	110 CFH	531-551	9.8	1.7	66	270 CFH	610-630	9.8	1.7	74	300 CFH	649-669	9.8	1.7	74	300 CFH
Steel	0.080	2.0	180-197	5.1	2.3	45	200 CFH	384-394	9.8	2.3	59	530 CFH	437-457	9.8	2.3	74	580 CFH	456-476	9.8	2.3	74	580 CFH
	0.040	1.0	807-827*	5.1	1.7	105	408 CFH	929-949*	5.1	1.7	100	408 CFH	964-984*	5.1	1.7	100	408 CFH	1004-1024*	5.1	1.7	100	408 CFH
	0.060	1.5	433-453*	5.1	1.7	105	408 CFH	496-516*	5.1	1.7	100	408 CFH	689-709*	5.1	1.7	100	408 CFH	846-866*	5.1	1.7	100	408 CFH
	0.080	2.0	195-205	9.8	1.4	225	590 CFH	216-236	9.8	1.7	200	820 CFH	492-512*	5.1	1.7	100	408 CFH	610-630*	5.1	1.7	100	408 CFH
	0.100	2.5	137-157	9.8	1.7	225	880 CFH	191-201	9.8	2.0	220	1170 CFH	199-209	9.8	1.7	220	895 CFH	218-228	9.8	1.7	220	895 CFH
	0.120	3.0	100-110	9.8	1.7	240	939 CFH	151-161	9.8	2.0	220	1170 CFH	165-175	9.8	1.7	235	945 CFH	175-185	9.8	1.7	235	945 CFH
	0.180	4.5	73-83	9.8	2.3	240	1606 CFH	88-98	9.8	2.3	220	1530 CFH	116-126	9.8	2.3	220	1530 CFH	132-142	9.8	2.3	206	1425 CFH
	0.250	6.4	57-67	9.8	2.3	240	1606 CFH	77-87	9.8	2.3	235	1615 CFH	84-94	9.8	2.3	206	1425 CFH	106-116	9.8	2.3	206	1425 CFH
	0.375	9.5	11-16	9.8	2.7	300	2833 CFH	27-33	9.8	2.7	250	2460 CFH	39-49	9.8	2.7	250	2460 CFH	49-59	9.8	2.7	250	2460 CFH
	0.500	12.7	5-8	9.8	2.7	315	3100 CFH	11-16	9.8	2.7	325	3200 CFH	26-31	9.8	2.7	325	3200 CFH	34-39	9.8	2.7	295	2875 CFH
Stainless	0.040	1.0	650-670	5.1	1.7	75	290 CFH	767-787	9.8	1.7	74	300 CFH	925-945	9.8	1.7	74	300 CFH	964-984	9.8	1.7	74	300 CFH
	0.060	1.5	305-315	5.1	1.7	75	290 CFH	480-500	9.8	1.7	74	300 CFH	571-591	9.8	1.7	74	300 CFH	610-630	9.8	1.7	74	300 CFH
	0.080	2.0	246-266	5.1	1.7	75	290 CFH	362-379	9.8	1.7	74	300 CFH	381-394	9.8	1.7	74	300 CFH	452-472	9.8	1.7	74	300 CFH
	0.040	1.0	1082-1102*	5.1	1.7	90	349 CFH	1358-1378*	5.1	1.7	100	408 CFH	1476-1496*	5.1	1.7	100	408 CFH	1555-1575*	5.1	1.7	100	408 CFH
	0.060	1.5	748-768*	5.1	1.7	105	408 CFH	886-906*	5.1	1.7	100	408 CFH	1043-1063*	5.1	1.7	100	408 CFH	1260-1280*	5.1	1.7	100	408 CFH
	0.080	2.0	212-232	9.8	1.7	150	585 CFH	511-531*	5.1	1.7	100	408 CFH	767-787*	5.1	1.7	100	408 CFH	905-925*	5.1	1.7	100	408 CFH
	0.100	2.5	141-161	9.8	1.7	150	585 CFH	216-236	9.8	1.7	147	590 CFH	256-276	9.8	1.7	220	895 CFH	299-319	9.8	1.7	220	895 CFH
	0.120	3.0	136-146	9.8	2	180	950 CFH	183-193	9.8	2.0	147	820 CFH	215-228	9.8	2.0	235	1235 CFH	258-268	9.8	2.0	235	1235 CFH
	0.180	4.5	53-63	9.8	2	210	1088 CFH	88-98	9.8	2.0	160	885 CFH	128-138	9.8	2.3	220	1530 CFH	151-161	9.8	2.3	206	1425 CFH
	0.250	6.4	35-39	9.8	2.3	225	1513 CFH	65-71	9.8	2.3	132	960 CFH	81-91	9.8	2.7	206	2070 CFH	96-106	9.8	2.7	206	2070 CFH
Alumin.	0.040	1.0	571-591	5.1	2.3	75	570 CFH	689-709	9.8	2.0	74	480 CFH	1092-1102	9.8	2.0	74	480 CFH	1220-1240	9.8	2.0	74	480 CFH
	0.060	1.5	334-354	5.1	2.3	75	570 CFH	492-512	9.8	2.3	74	580 CFH	649-669	9.8	2.3	74	580 CFH	972-992	9.8	2.3	74	580 CFH
	0.080	2.0	187-197	5.1	2.3	75	570 CFH	344-354	9.8	2.3	74	580 CFH	452-472	9.8	2.3	59	540 CFH	610-630	9.8	2.3	59	540 CFH
	0.040	1.0	761-781*	5.1	1.7	100	408 CFH	807-827*	5.1	1.7	100	408 CFH	1004-1024*	5.1	1.7	100	408 CFH	1240-1260*	5.1	1.7	100	408 CFH
	0.060	1.5	433-453*	5.1	1.7	100	408 CFH	452-472*	5.1	1.7	100	408 CFH	650-669*	5.1	1.7	100	408 CFH	787-807*	5.1	1.7	100	408 CFH
	0.080	2.0	179-189	9.8	1.4	150	430 CFH	226-236*	5.1	1.7	100	408 CFH	344-354*	5.1	1.7	100	408 CFH	541-551*	5.1	1.7	100	408 CFH
	0.100	2.5	140-150	9.8	1.4	165	450 CFH	183-193	9.8	1.7	235	945 CFH	218-228	9.8	2.3	206	1425 CFH	226-236	9.8	2.3	206	1425 CFH
	0.120	3.0	108-118	9.8	1.7	225	880 CFH	136-146	9.8	1.7	235	945 CFH	183-193	9.8	2.3	235	1615 CFH	207-217	9.8	2.3	235	1615 CFH
	0.180	4.5	57-67	9.8	1.7	225	880 CFH	80-90	9.8	2.3	250	1750 CFH	100-110	9.8	2.3	250	1750 CFH	136-146	9.8	2.3	250	1750 CFH
	0.250	6.4	-	-	-	-	-	75-79	9.8	2.3	220	1550 CFH	86-96	9.8	2.3	280	1960 CFH	100-110	9.8	2.3	280	1960 CFH

Worst case set-up time at a TRUMPF Laser Cutting Machine is just 10 seconds a nozzle change.
Therefore the customer practically has no down time, even with an optimally adjusted machine!
(Cutting speeds may be reduced if higher cutting quality is required or lower material quality is used !)

1 High Focus Technique only
2 Flow rates are estimated