

**METALS**



**ALUMINIUM**



**STAINLESS STEEL**



**TOOL STEEL**



**LOW CARBON STEEL**

Material	Thickness (mm)	Cut Rate (mm per minute)	Max Thickness (mm)
Aluminium 6061	0.5	212	12.5
	1	115	
	2	63	
	3	44	
	6	24	
	8.0	18	
	10.0	15	
	12.5	12	
Aluminium 7075	0.5	191	4.5
	1.0	114	
	2.0	68	
	3.0	50	
	4.5	37	
Copper 110	0.5	70	4.5
	1.0	40	
	2.0	23	
	3.0	17	
	4.5	12	
Stainless Steel 316	0.5	62	3.0
	0.75	46	
	1.0	38	
	1.5	28	
	2.0	23	
	3.0	17	
Stainless Steel 440C	1.6	23	3.2
	3.2	15	
Steel 01	1.6	24	3.2
	3.2	14	
Steel 1008	0.5	72	3.0
	0.75	55	
	1.0	46	
	1.5	35	
	2.0	29	
	3.0	22	
Steel 4130	0.5	62	3.0
	0.75	47	
	1.0	39	
	1.5	29	
	2.0	24	
	3.0	18	

This cutting data supplied in this table is indicative and based on straight line cutting, actual cutting data may be different depending on cut quality desired, material specification, garnet type & volume used, as well as work piece geometry. E&OE

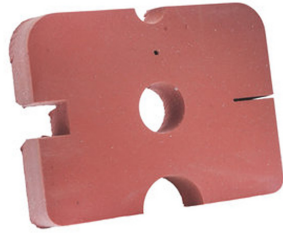
**METALS Cont....**

Steel 1018	3.2 4.8	15 12	4.8
Titanium G5	0.5 1.0 2.0 3.0	85 47 26 18	3.0

**PLASTICS & RUBBERS**



**HDPE**



**SILICONE**

Material	Thickness (mm)	Cut Rate (mm per minute)	Max Thickness (mm)
Acrylic	2.0 3.0 6.0 8.0 12.5	198 117 48 33 18	12.5
HDPE	2.0 6.0 8.0 12.5	165 46 33 19	12.5
Neoprene, 50A	2.0 6.0 8.0 12.5	1900 175 84 27	12.5
Polycarbonate	2.0 3.0 4.5 6.0 8.0	119 74 46 32 23	8.0
Polyurethane, 60A	2.0 3.0 4.5 6.0 8.0 12.5	1900 1000 255 96 36 8	12.5
Silicone, 50A	2.0 3.0 6.0 8.0 10.0 12.5	1900 1900 652 263 130 65	12.5

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**CERAMICS & STONE**



**MARBLE**



**BORO GLASS**

Material	Thickness (mm)	Cut Rate (mm per minute)	Max Thickness (mm)
Glass, Borosilicate	2.0	782	12.5
	3.0	337	
	4.5	145	
	6.0	80	
	8.0	44	
	10.0	27	
	12.5	17	
Glass, Soda Lime	2.0	407	6.0
	2.3	330	
	2.7	260	
	3.0	222	
	3.3	192	
	3.7	162	
	4.0	144	
	4.5	120	
	6.0	78	
Tile, Ceramic	9.5	243	9.5
Tile, Porcelain	9.5	47	9.5

**OTHER MATERIALS**



**CARBON FIBER**

Material	Thickness (mm)	Cut Rate (mm per minute)	Max Thickness (mm)
Carbon Fiber	0.5	222	4.5
	1.0	107	
	2.0	52	
	3.0	31	
	4.5	22	

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