



Parametrii de debitare

Parametrii de debitare pentru modelele de laser VersyCNC de la 1,5kw până la 15kw pentru Oțel carbon, Oțel inoxidabil, aluminiu, alamă, cupru*;

* cupru se poate debita doar cu un laser de minim 12kw.



1500 W

MATERIAL	GRO-SIME (mm)	VITEZA (m/min)	PUTERE (W)	GAZ	PRESI-UNE AER (bar)	DUZA (mm)	FOCUS-ARE (mm)	ÎNĂLȚIME DE TĂIERE (mm)
Oțel Carbon	1	20	1500	N2 / Aer	10	1.5 S	0	1
	2	5			O2	2	1.2 D	+3
	3	3.6		0.6		1.2 D	+3	0.8
	4	2.5		0.6		1.2 D	+3	0.8
	5	1.8		0.6		1.2 D	+3	0.8
	6	1.4		0.6		1.5 D	+3	0.8
	8	1.2		0.6		1.5 D	+3	0.8
	10	1		0.6		2.0 D	+2.5	0.8
	12	0.8		0.6	2.5 D	+2.5	0.8	
Oțel Inox-idabil	1	20	1500	N2	10	1.5 S	0	0.8
	2	7			12	2.0 S	-1	0.5
	3	4.5			12	2.5 S	-1.5	0.5
	5	1.5			14	3.0 S	-2.5	0.5
Aluminiu	1	18	1500	N2	12	1.5 S	0	0.5
	2	6			14	2.0 S	-1	0.5
	3	2.5			14	2.5 S	-1.5	0.5
Alamă	1	15	1500	N2	12	1.5 S	0	0.5
	2	15			14	2.0 S	-1	0.5

3000 W

MATERIAL	GRO-SIME (mm)	VITEZA (m/min)	PUTERE (W)	GAZ	PRESI-UNE AER (bar)	DUZA (mm)	FOCUS-ARE (mm)	ÎNĂLȚIME DE TĂIERE (mm)
Oțel Carbon	1	35	3000	N2 / Aer	10	1.5 S	0	1
	2	20			10	2.0 S	0	0.5
	2	5.5	1200	O2	1.6	1.0 D	+3	0.8
	3	4	2000		0.6	1.0 D	+4	0.8
	4	3.5	2400		0.6	1.0 D	+4	0.8
	5	3.2	2400		0.6	1.2 D	+4	0.8
	6	2.7	3000		0.6	1.2 D	+4	0.8
	8	2.2	3000		0.6	1.2 D	+4	0.8
	10	1.5	3000		0.6	1.2 D	+4	0.8
	12	1	2400		0.6	3.0 D	+4	0.8



	14	0.9	2400		0.6	3.0 D	+4	0.8
	16	0.75	2400		0.6	3.5 D	+4	0.8
Oțel Inox-idabil	1	45	3000	N2	10	1.5 S	0	0.8
	2	24			12	2.0 S	0	0.5
	3	10			12	2.5 S	-0.5	0.5
	4	6.5			14	2.5 S	-1.5	0.5
	5	3.6			14	3.0 S	-2.5	0.5
	6	2.7			14	3.0 S	-3	0.5
	8	1.2			16	3.5 S	-4.5	0.5
	Aluminiu	1			30	3000	N2	12
2		18	12	2.0 S	0			0.5
3		8	14	2.0 S	-1			0.5
4		6	14	2.5 S	-2			0.5
5		3.2	16	3.0 S	-3			0.5
6		2	16	3.0 S	-3.5			0.5
Alamă	1	28	3000	N2	12	1.5 S	0	0.8
	2	15			12	2.0 S	0	0.5
	3	6			14	2.5 S	-1	0.5
	4	3			14	3.0 S	-2	0.5
	5	2.2			14	3.0 S	-2.5	0.5

6000 W

MATERIAL	GRO-SIME (mm)	VITEZA (m/min)	PUTERE (W)	GAZ	PRESI-UNE AER (bar)	DUZA (mm)	FOCUS-ARE (mm)	ÎNĂLȚIME DE TĂIERE (mm)
Oțel Carbon	1	45	6000	N2 / Aer	12	1.5 S	0	1
	2	25			12	2.0 S	-1	0.5
	3	14			14	2.0 S	-1.5	0.5
	4	8			14	2.0 S	-2	0.5
	5	6.4			16	3.0 S	-2.5	0.5
	6	5			16	3.5 S	-3	0.5
	3	3.6 - 4.2	2400	O2	0.6	1.2 E	+3	0.8
	4	3.3 - 3.8	2400		0.6	1.2 E	+3	0.8
	5	3.0 - 3.6	3000		0.6	1.2 E	+3	0.8
	6	2.7 - 3.2	3300		0.6	1.2 E	+3	0.8
	8	2.2 - 2.5	4200		0.6	1.2 E	+3	0.8
	10	2.0 - 2.3	5500		0.6	1.2 E	+4	0.8
	12	0.9 - 1.0	2200		0.6	3.0 D	+2.5	0.8
	12	1.9 - 2.1	6000		0.6	1.2 E	+5	0.8
14	0.8 - 9	2200	0.6	3.5 D	+2.5	0.8		
14	1.4 - 1.7	6000	0.6	1.4 E	+5	1		



	16	0.8 - 0.9	2200		0.6	4.0 D	+2.5	0.8
	16	1.2 - 1.4	6000		0.6	1.4 E	+6	1
	18	0.65 - 0.7	2200		0.6	4.0 D	+2.5	0.8
	20	0.6 - 0.7	2400		0.6	4.0 D	+3	0.8
Oțel Inox-idabil	1	60	6000	N2	10	1.5 S	0	0.8
	2	30			12	2.0 S	-1	0.5
	3	18			12	2.5 S	-1.5	0.5
	4	12			14	2.5 S	-2	0.5
	5	8			14	3.0 S	-2.5	0.5
	6	5			15	3.0 S	-3	0.5
	8	3.8			15	3.0 S	-4	0.5
	10	2			15	3.5 S	-6	0.5
	12	1.2			16	3.5 S	-7.5	0.5
	14	1			16	4.0 S	-9	0.5
	16	0.6			18	4.0 S	-10.5	0.5
	Aluminiu	1			50	6000	N2	12
2		25	12	2.0 S	-1			0.5
3		16	14	2.5 S	-1.5			0.5
4		10	14	2.5 S	-2			0.5
5		6	14	3.0 S	-3			0.5
6		4	16	3.0 S	-3			0.5
8		2	16	3.0 S	-4			0.5
10		1.2	18	3.5 S	-4.5			0.5
12		0.7	18	4.0 S	-5			0.5
Alamă		1	40	6000	N2			12
	2	20	12			2.0 S	-1	0.5
	3	14	14			2.5 S	-1	0.5
	4	9	14			3.0 S	-1.5	0.5
	5	5.5	14			3.0 S	-2	0.5
	6	3.8	16			3.0 S	-2.5	0.5
	8	1.8	16			3.5 S	-3	0.5
	10	1	16			3.5 S	-3	0.5

12000 W

MATERIAL	GRO-SIME (mm)	VITEZA (m/min)	PUTERE (W)	GAZ	PRESI-UNE AER (bar)	DUZA (mm)	FOCUS-ARE (mm)	ÎNĂLȚIME DE TĂIERE (mm)
Oțel Carbon	1	50 - 80	12000	N2 / Aer	12	1.5 S	0	1
	2	45 - 48			12	2.0 S	0	0.5
	3	30 - 38			13	2.0 S	0	0.5



	4	20 - 26			13	2.5 S	0	0.5
	5	15 - 20			13	2.5 S	0	0.5
	6	10 - 13			13	2.5 S	0	0.5
	8	7 - 10			13	3.0 S	-1.5	0.5
	10	5 - 6.5			13	4.0 S	-3	0.5
	10	2.3	6000	O2	0.6	1.2 E	+6	0.8
	12	2	7500		0.6	1.2 E	+7	0.8
	14	1.8	8500		0.6	1.4 E	+7	0.8
	16	1.6	9500		0.6	1.4 E	+8	0.8
	20	1.4	12000		0.6	1.6 E	+8	0.8
	22	1.2			0.7	1.8 E	+9	0.8
	25	0.85			0.7	1.8 E	+11	0.8
	30	0.4			1.3	1.8 E	+11	1.2
Oțel Inox- idabil	1	63	12000	N2	10	2.0 S	0	1
	2	42			12	2.0 S	0	0.5
	3	33			13	2.0 S	0	0.5
	4	27			12	2.0 S	0	0.5
	5	18			15	2.5 S	0	0.5
	6	15			8	3.5 B	0	0.5
	8	10			7	5.0 B	0	0.5
	10	7.5			5	5.0 B	-1	0.5
	12	5.5			6	6.0 B	-4	0.5
	14	3.5			6	7.0 B	-6	0.3
	16	2.3			6	7.0 B	-8	0.3
	18	1.5			6	7.0 B	-9	0.5
	20	1.45			6	7.0 B	-11	0.3
	25	0.9			6	7.0 B	-13	0.3
	1	60	12000	Aer	10	2.0 S	0	1
	2	38			10	2.5 S	0	0.5
	3	28			10	2.5 S	0	0.5
	4	25			10	3.5 B	0	0.5
	5	18			10	3.5 B	0	0.5
	6	15			10	3.5 B	0	0.5
	8	10			10	3.5 B	0	0.5
	10	6.5			10	3.5 B	-1	0.5
	12	4.5			10	5.0 B	-4	0.5
	14	2.6			10	5.0 B	-6	0.5
	16	2.3			10	5.0 B	-8	0.5
	18	1.9			10	5.0 B	-9	0.5
	20	1.4			10	5.0 B	-11	0.3
	25	1			10	5.0 B	-13	0.3



Aluminiu	1	45	12000	N2	12	2.0 S	0	0.8
	2	35			12	2.0 S	-1	0.5
	3	25			12	2.0 S	-1	0.5
	4	20			12	2.0 S	-2	0.5
	5	16			14	2.5 S	-3	0.5
	6	11			14	2.5 S	-3	0.5
	8	7			14	2.5 S	-4	0.5
	10	5			14	5.0 B	-5	0.5
	12	2.6			16	5.0 B	-5	0.5
	14	1.7			16	5.0 B	-5	0.5
	16	1.6			16	5.0 B	-5	0.5
	18	1.3			16	5.0 B	-5	0.5
	20	1			16	7.0 B	-5	0.3
	25	0.6			16	7.0 B	-5	0.3
	Alamă	1			40	12000	N2	12
2		35	12	2.0 S	-1			0.5
3		22	12	2.0 S	-1			0.5
4		18	12	2.0 S	-2			0.5
5		15	14	2.5 S	-3			0.5
6		10	14	2.5 S	-3			0.5
8		7	14	2.5 S	-4			0.5
10		5	14	5.0 B	-5			0.5
12		2.4	14	5.0 B	-5			0.5
Cupru		1	35	12000	O2			5
	2	25	5			2.0 S	-1	0.5
	3	18	6			2.0 S	-2	0.5
	4	12	8			2.0 S	-3	0.5
	5	8	8			2.5 S	-4.5	0.5
	6	5	8			2.5 S	-5	0.5
	8	2.5	10			3.0 S	-6	0.5

15000 W

MATERIAL	GRO-SIME (mm)	VITEZA (m/min)	PUTERE (W)	GAZ	PRESI-UNE AER (bar)	DUZA (mm)	FOCUS-ARE (mm)	ÎNĂLȚIME DE TĂIERE (mm)
Oțel Carbon	1	50 - 80	15000	N2 / Aer	10	1.5 S	0	1
	2	45 - 48			10	2.0 S	0	0.5
	3	30 - 38			12	2.0 S	0	0.5
	4	26 - 29			12	2.5 S	0	0.5
	5	20 - 23			12	2.5 S	0	0.5



	6	17 - 19			12	2.5 S	0	0.5
	8	10 - 12			12	3.0 S	-1	0.5
	10	7 - 8.5			13	4.0 S	-1	0.5
	12	5 - 6			13	4.0 S	-2	0.5
	14	4.5 - 5.5			13	4.0 S	-6	0.5
	16	3 - 3.5			13	5.0 B	-8	0.5
	10	2.3	6000	O2	0.6	1.2 E	+6	0.8
	12	2	7500		0.6	1.2 E	+7	0.8
	14	1.8	8500		0.6	1.4 E	+7	0.8
	16	1.7	9500		0.6	1.4 E	+8	0.8
	20	1.5	15000		0.6	1.6 E	+8	0.8
	22	1.4			0.7	1.8 E	+9	0.8
	25	1.2			0.7	1.8 E	+10	0.8
	30	0.8			0.8	1.8 E	+11	1.2
	40	0.45			1.5	1.8 E	+11.5	1.2
Oțel Inox- idabil	1	65	15000	N2	10	2.0 S	0	1
	2	42			12	2.0 S	0	0.5
	3	35			13	2.5 S	0	0.5
	4	29			12	2.5 S	0	0.5
	5	22			15	2.5 S	0	0.5
	6	18			8	3.5 B	0	0.5
	8	12			7	5.0 B	0	0.5
	10	9			5	5.0 B	-1	0.5
	12	7			6	6.0 B	-4	0.5
	14	4.2			6	7.0 B	-6	0.3
	16	2.8			6	7.0 B	-8	0.3
	18	2.3			6	7.0 B	-9	0.5
	20	2			6	7.0 B	-11	0.3
	25	1.1			6	7.0 B	-13	0.3
	1	65	15000	Aer	10	2.0 S	0	1
	2	40			10	2.5 S	0	0.5
	3	32			10	2.5 S	0	0.5
	4	25			10	3.5 B	0	0.5
	5	20			10	3.5 B	0	0.5
	6	16			10	3.5 B	0	0.5
	8	11			10	3.5 B	0	0.5
	10	9			10	3.5 B	-1	0.5
	12	6.5			10	5.0 B	-4	0.5
	14	4			10	5.0 B	-6	0.5
	16	3.1			10	5.0 B	-8	0.5
	18	2.3			10	5.0 B	-9	0.5



	20	2			10	5.0 B	-11	0.3			
	25	1.3			10	5.0 B	-13	0.3			
Aluminiu	1	60	15000	N2	12	2.0 S	0	0.8			
	2	50			12	2.0 S	-1	0.5			
	3	40			12	2.0 S	-1	0.5			
	4	35			12	2.0 S	-2	0.5			
	5	26			14	2.5 S	-3	0.5			
	6	16			14	2.5 S	-3	0.5			
	8	10			14	2.5 S	-4	0.5			
	10	5.5			14	5.0 B	-5	0.5			
	12	4.5			16	5.0 B	-5	0.5			
	14	3.4			16	5.0 B	-5	0.5			
	16	2.1			16	5.0 B	-5	0.5			
	18	1.8			16	5.0 B	-5	0.5			
	Alamă	1			50	15000	N2	12	2.0 S	0	1
		2			40			12	2.0 S	-1	0.5
		3			32			12	2.0 S	-1	0.5
4		28	12	2.0 S	-2			0.5			
5		20	14	2.5 S	-3			0.5			
6		14	14	2.5 S	-3			0.5			
8		8	14	2.5 S	-4			0.5			
10		5.5	14	5.0 B	-5			0.5			
12		3.2	14	5.0 B	-5			0.5			
14		2.7	16	5.0 B	-8			0.5			
Cupru		1	40	15000	O2			5	2.0 S	-0.5	1
		2	30					5	2.0 S	-1	0.5
	3	28	6			2.0 S	-2	0.5			
	4	20	8			2.0 S	-3	0.5			
	5	15	8			2.5 S	-4.5	0.5			
	6	10	8			2.5 S	-5	0.5			
	8	6	10			3.0 S	-6	0.5			
	10	2	12			4.0 S	-8	0.5			

