

### The Four part: Cutting parameter

<b>material</b>	<b>Thickness (mm)</b>	<b>Cutting speed (mm/min)</b>
stainless steel	1	1300
	3	600
	6	300
	10	200
	16	120
	20	85
	30	40
	55	20
	65	10
copperplate	3	1500
	5	950
Aluminum plate	10	700
	20	500
	30	250
	70	70
Marble	20	1300
	30	700
Granite	20	1000
	30	700
Ceramic	10	1400
	28	400
Glass	6	1700
	10	800
	19	400
Foam	20	6000
	50	3000
	80	2000