



2018 catalog

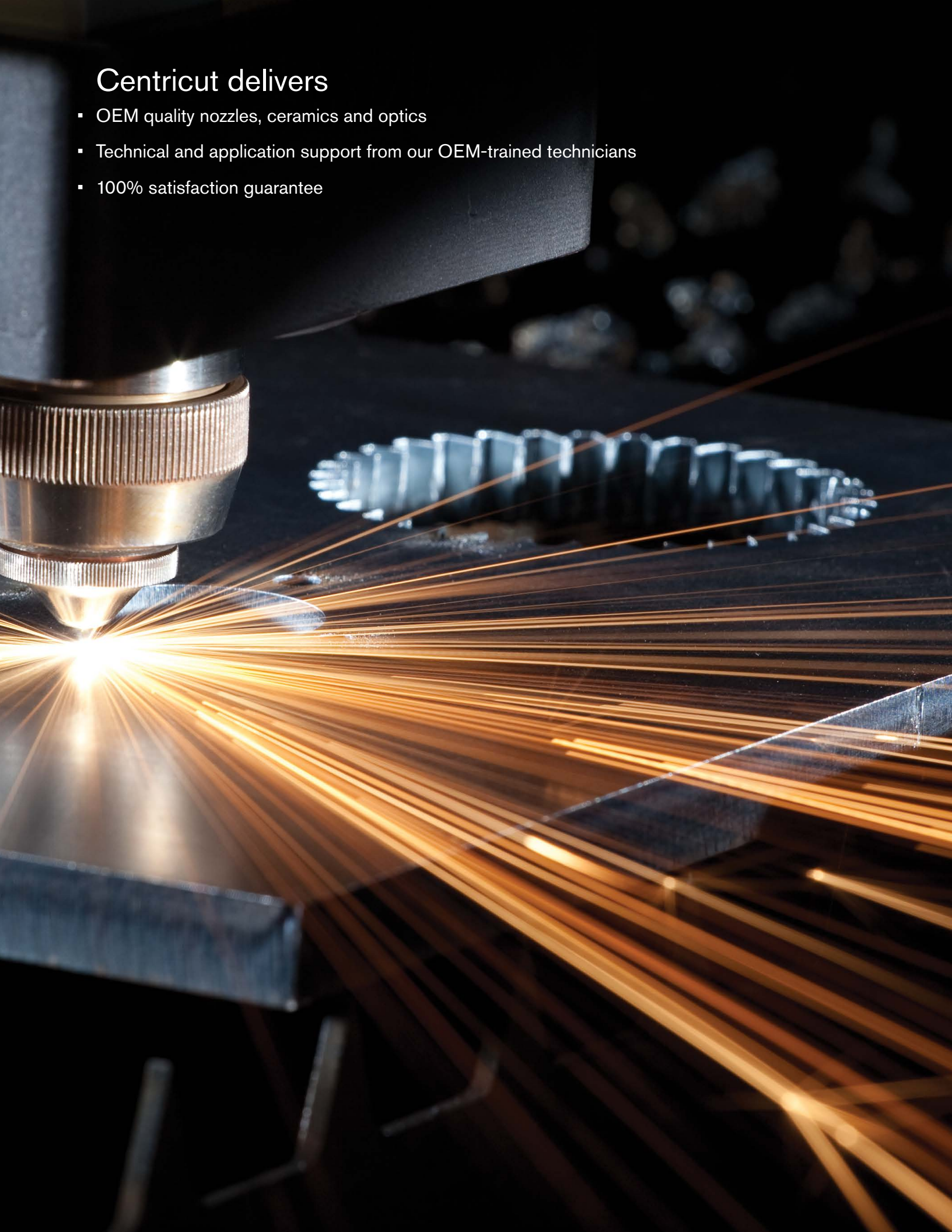
For CO₂ and fiber laser consumables

Replacement parts suitable for LVD®



Centricut delivers

- OEM quality nozzles, ceramics and optics
- Technical and application support from our OEM-trained technicians
- 100% satisfaction guarantee



CO₂ and fiber laser nozzles

Nozzle options

All Centricut nozzles are engineered and manufactured to the highest standards. Select the OEM quality nozzle best suited for your application needs

Copper

Most commonly used nozzle offering good durability and nozzle life. Primary nozzle type for fiber lasers.

Chrome plated

Shiny, mirror-like finish provides increased spatter resistance, improved durability and longer life than copper nozzles. Not recommended for use on fiber lasers.

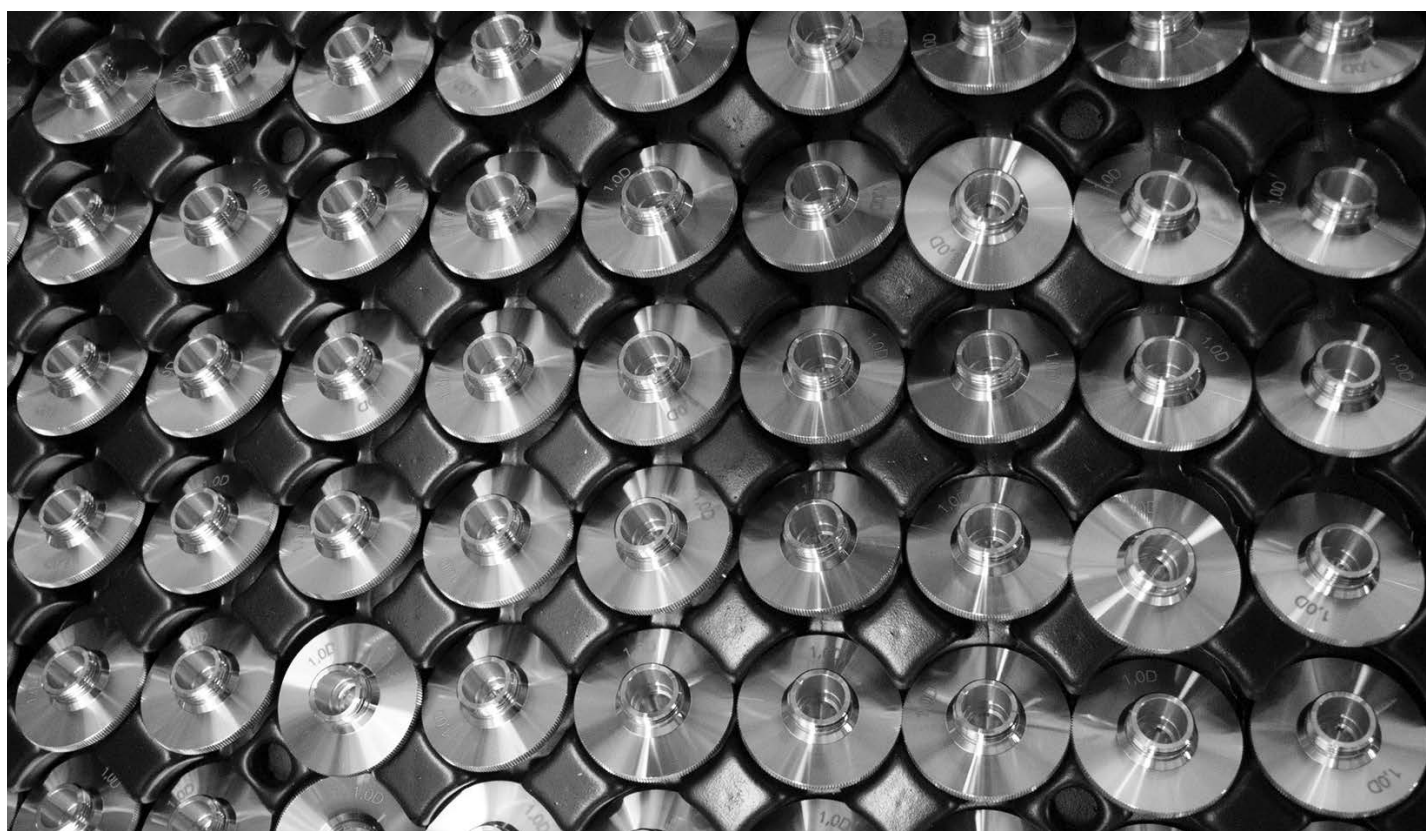
Look for CP in the part number to identify a chrome plated nozzle

Hard chrome plated

Premium nozzles offering the highest level of durability and longest nozzle life. These nozzles are not as shiny as chrome plated and have a dull appearance. Not recommended for use on fiber lasers.

Look for HCP in the part number to identify a hard chrome nozzle.

CP (chrome plated)	Nozzles plated with chrome for increased durability. These nozzles are easier to clean, resist damage due to 'tip-ups' and have better spatter resistance over non-plated nozzles. For use in all laser cutting applications.
Conical	Conical internal geometry for high pressure, non-ferrous cutting applications using nitrogen, air or argon.
Cylindrical	Cylindrical internal geometry for low pressure, mild steel cutting applications using oxygen.
Double	Insert pressed into a standard cylindrical nozzle for improved edge quality, laminar gas flow and spatter resistance. Primarily used in mild steel applications.
HCP (hard chrome plated)	Enhanced durability chrome plated nozzles. These nozzles are easier to clean, resist damage due to 'tip-ups' and have better spatter resistance over non-plated nozzles. For use in all laser cutting applications.
HP (high pressure) HD (high density)	Conical style nozzle for high pressure, non-ferrous cutting applications using nitrogen, air or argon.
Inner	Also referred to as a 'nozzle insert'. Works in conjunction with an outer nozzle to create a double nozzle. Primarily used in mild steel applications.
Low pressure	Cylindrical style nozzle for low pressure, mild steel cutting applications using oxygen.
Outer	Works in conjunction with an inner nozzle to create a double nozzle. Primarily used in mild steel applications.
Shower	Nozzles with a center orifice surrounded by smaller jets. The smaller jets focus the assist gas into the kerf, creating improved edge quality and the ability to cut thicker material. Primarily used in mild steel applications.



CO₂ and fiber laser optics

Optics key

Lens	
MEN	Meniscus
PLX	Plano-convex
MTD	Mounted
Not MTD	Not mounted
PO	Plano
MP5 or ULA	Ultra low absorption
AR	Anti-reflection
ZNSE	Sinc-selinide
FS	Fused silica
DIA	Diameter
FL	Focal length
ET	Edge thickness
WD	Working distance

How to handle optics

Follow these easy steps, when cleaning or changing your optic, to help maximize the life and performance of your lens

- Avoid touching coated surfaces of the lens and hold the optic by its sides
- Wear powder-free finger cots or latex gloves when handling
- Do not use any tools or sharp objects when handling the optic or when removing it from its packaging
- Ensure the work surface is clean and free of oils, grease and dirt
- Do not place the optic on hard surfaces as they scratch easily
- Once the optic has been unpacked, carefully place it on the lens tissue in which it was originally wrapped

Optics disposal

It is important to dispose of used laser optics at a licensed industrial waste facility which is in compliance with all local, state, and federal regulations.

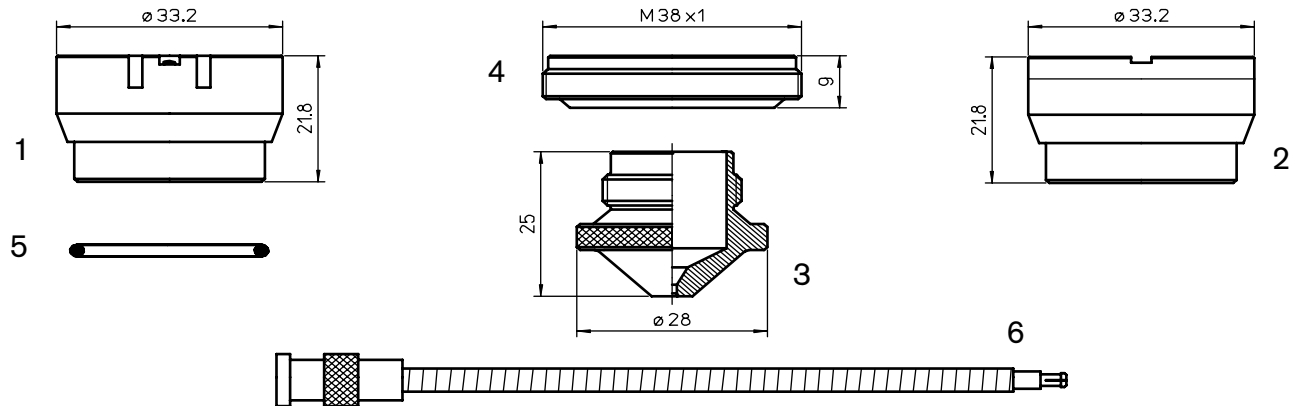
If you don't have access to a licensed industrial waste facility, and purchased your laser optics through Centricut, you may return them to Centricut for proper disposal. This service is only available to Centricut customers.

All optics returned to Centricut must:

- Include return authorization and invoice numbers
- Be sealed in a plastic bag to minimize any hazards
- Remove excess ZnSe powder prior to sealing

*Acceptance of goods will be refused if not packaged correctly or if the return authorization number isn't included

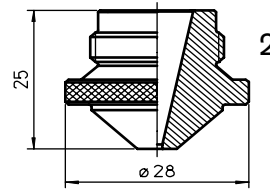
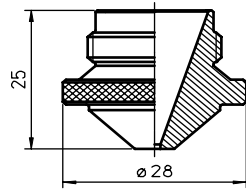




Consumables

	Centricut part number	Esse A part number	Reference number	Description	Pkg qty
1	PT311-1146	AL130/S	281146, P0380-211-00001, 29100033	PT-Nozzle holder ITM 1.5" DZ	1
	PT311-1146OEM	AL130	281146, P0380-211-00001, 29100033	PT-Nozzle holder ITM 1.5" DZ OEM	1
2	PT311-0298	AL298	P0497-68871	PT-Nozzle holder KTM 1.5" DXN, Ceramic	1
3	LV332-1993V	L20757	D5241993	LV-Nozzle cylindrical, 0.8 mm (5 pk)*	5
	LV332-5470V	L20141	D7945470	LV-Nozzle cylindrical, 1.0 mm (5 pk)*	5
	LV332-0001V	L20758	D5241982	LV-Nozzle cylindrical, 1.2 mm (5 pk)*	5
	LV332-5434V	L20142	D7945434	LV-Nozzle cylindrical, 1.5 mm (5 pk)*	5
	LV332-5452V	L20143	D7945452	LV-Nozzle cylindrical, 2.0 mm (5 pk)*	5
	LV332-5517V	L20144	D7945517	LV-Nozzle cylindrical, 2.5 mm (5 pk)*	5
	LV332-5518V	L20145		LV-Nozzle cylindrical, 3.0 mm (5 pk)*	5
	LV332-1993CPV	L20757X	D5241993	LV-Nozzle cylindrical, 0.8 mm CP (5 pk)*	5
	LV332-5470CPV	L20141X	D7945470	LV-Nozzle cylindrical, 1.0 mm CP (5 pk)*	5
	LV332-0001CPV	L20758X	D5241982	LV-Nozzle cylindrical, 1.2 mm CP (5 pk)*	5
	LV332-5434CPV	L20142X	D7945434	LV-Nozzle cylindrical, 1.5 mm CP (5 pk)*	5
	LV332-5452CPV	L20143X	D7945452	LV-Nozzle cylindrical, 2.0 mm CP (5 pk)*	5
	LV332-5517CPV	L20144X	D7945517	LV-Nozzle cylindrical, 2.5 mm CP (5 pk)*	5
	LV332-5518CPV	L20145X		LV-Nozzle cylindrical, 3.0 mm CP (5 pk)*	5
4	PT347-4297	AL198	P0492-702-00001, 29100021	PT-Insulating ring outer body	1
	PT311-0001	AL201	P0492-702-00002	PT-Insulating ring	1
5	AM326-6453	AL94	71366453	AM-O-ring for outer nozzle	1
6	PT347-0101	AL204	P0360-100-00500, 46713300100	PT-Sensor head connecting cable OEM	1
	PT347-0450	AL202	P0497-002-00450	PT-Sensor cable, 450 mm (17.7")	1

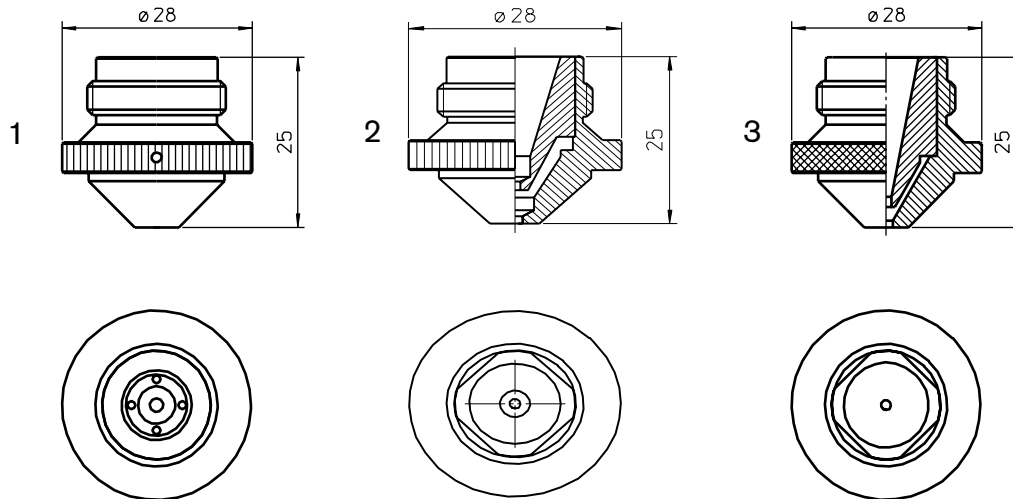
*Available in single packs. To order single packs, remove the 'V' at the end of the part number (e.g. LV123-4567V would be LV123-4567).



Consumables

	Centricut part number	Esse A part number	Reference number	Description	Pkg qty
1	LV332-1863V	L20151	D5241863	LV-Nozzle conical HD, 1.0 mm (5 pk)*	5
	LV332-1982V	L20759		LV-Nozzle conical HD, 1.2 mm (5 pk)*	5
	LV332-1862V	L20152	D5241862	LV-Nozzle conical HD, 1.5 mm (5 pk)*	5
	LV332-2512V	L20748	D5242512	LV-Nozzle conical HD, 1.7 mm (5 pk)*	5
	LV332-1855V	L20146	D5241855	LV-Nozzle conical HD, 2.0 mm (5 pk)*	5
	LV332-2513V	L20749	D5242513, Z000000539D	LV-Nozzle conical HD, 2.3 mm (5 pk)*	5
	LV332-1856V	L20147	D5241856, Z000000563B	LV-Nozzle conical HD, 2.5 mm (5 pk)*	5
	LV332-1857V	L20148	D5241857, Z000000540B	LV-Nozzle conical HD, 3.0 mm (5 pk)*	5
	LV332-1877V	L20149	D5241877, Z000000564B	LV-Nozzle conical HD, 3.5 mm (5 pk)*	5
	LV332-1878V	L20283	D5241878, Z000000565B	LV-Nozzle conical HD, 4.0 mm (5 pk)*	5
	LV332-2531V	L201303	D5242531, Z000000566B	LV-Nozzle conical HD, 4.5 mm (5 pk)*	5
	LV332-2535V	L201304	D5242535, Z000000567B	LV-Nozzle conical HD, 5.0 mm (5 pk)*	5
	LV332-2536V	L201305	D5242536, Z000000568B	LV-Nozzle conical HD, 6.0 mm (5 pk)*	5
	LV332-1863CPV	L20151X	D5241863	LV-Nozzle conical HD, 1.0 mm CP (5 pk)*	5
	LV332-1982CPV	L20759X		LV-Nozzle conical HD, 1.2 mm CP (5 pk)*	5
	LV332-1862CPV	L20152X	D5241862	LV-Nozzle conical HD, 1.5 mm CP (5 pk)*	5
	LV332-2512CPV	L20748X	D5242512	LV-Nozzle conical HD, 1.7 mm CP (5 pk)*	5
	LV332-1855CPV	L20146X	D5241855	LV-Nozzle conical HD, 2.0 mm CP (5 pk)*	5
	LV332-2513CPV	L20749X	D5242513	LV-Nozzle conical HD, 2.3 mm CP (5 pk)*	5
	LV332-1856CPV	L20147X	D5241856	LV-Nozzle conical HD, 2.5 mm CP (5 pk)*	5
	LV332-1857CPV	L20148X	D5241857	LV-Nozzle conical HD, 3.0 mm CP (5 pk)*	5
	LV332-1877CPV	L20149X	D5241877	LV-Nozzle conical HD, 3.5 mm CP (5 pk)*	5
	LV332-1878CPV	L20283X	D5241878	LV-Nozzle conical HD, 4.0 mm CP (5 pk)*	5
2	LV332-2453	L152-S	D5242453A	LV-Nozzle HD, 1.5 mm	1
	LV332-2416	L147-S	D5242416A	LV-Nozzle HD, 2.5 mm	1

*Available in single packs. To order single packs, remove the 'V' at the end of the part number (e.g. LV123-4567V would be LV123-4567).



Consumables

	Centricut part number	Esse A part number	Reference number	Description	Pkg qty
1	LV332-0013	L1290	G8040180	LV-Nozzle double w/spring, 2.5 mm/inner 1.3 mm	1
	LV332-0180	L1291	G8040135	LV-Nozzle double w/spring, 2.5 mm/inner 1.5 mm	1
	LV332-3013	L1293	G8040182	LV-Nozzle double w/spring, 3.0 mm/inner 1.3 mm	1
	LV332-3015	L1294		LV-Nozzle double w/spring, 3.0 mm/inner 1.5 mm	1
	LV332-0132	L1292	G8040132	LV-Nozzle double w/spring, 3.0 mm/inner 2.0 mm	1
	LV332-0013CP	L1290X	G8040180	LV-Nozzle double w/spring, 2.5 mm/inner 1.3 mm CP	1
	LV332-0180CP	L1291X	G8040135	LV-Nozzle double w/spring, 2.5 mm/inner 1.5 mm CP	1
	LV332-3013CP	L1293X	G8040182	LV-Nozzle double w/spring, 3.0 mm/inner 1.3 mm CP	1
	LV332-3015CP	L1294X		LV-Nozzle double w/spring, 3.0 mm/inner 1.5 mm CP	1
	LV332-0132CP	L1292X	G8040132	LV-Nozzle double w/spring, 3.0 mm/inner 2.0 mm CP	1
2	LV417-0002	L782		LV-Nozzle double, 1.2 mm	1
	LV417-0003	L784	29100304	LV-Nozzle double, 1.5 mm	1
	LV417-0004	L785	29100307	LV-Nozzle double, 2.0 mm	1
	LV410-0180	L786	29100305	LV-Nozzle double, 2.5 mm	1
	LV417-0006	L787	29100306	LV-Nozzle double, 3.0 mm	1
	LV417-0007	L788		LV-Nozzle double, 3.5 mm	1
	LV417-0008	L789		LV-Nozzle double, 4.0 mm	1
	LV417-0002CP	L782X		LV-Nozzle double, 1.2 mm CP	1
	LV417-0003CP	L784X		LV-Nozzle double, 1.5 mm CP	1
	LV417-0004CP	L785X		LV-Nozzle double, 2.0 mm CP	1
	LV417-0005CP	L786X		LV-Nozzle double, 2.5 mm CP	1
	LV417-0006CP	L787X		LV-Nozzle double, 3.0 mm CP	1
	LV417-0007CP	L788X		LV-Nozzle double, 3.5 mm CP	1
3	LV332-1297	L885	Z000001297	LV-Nozzle double, 4.0 mm/inner 2.0 mm	1
	LV332-1344	L886	Z000001344	LV-Nozzle double, 5.0 mm/inner 2.0 mm	1
	LV332-0130	L791	Z000000223A	LV-Nozzle double, 3.0 mm/inner 1.7 mm	1
	LV332-0131	L790	G8040131	LV-Nozzle double, 3.0 mm/inner 2.0 mm	1

Optics

Centricut part number	Reference number	Type	Diameter	Focal length	Edge thickness
Lenses					
LV333-0023	29100023	MEN	1.5"	5.0"	.290"
LV333-0176	480176	MEN	1.75"	5.0"	.354"
LV333-6326	206326	MEN	2.0"	5.0"	.354"
LV333-1004	458138	MEN	2.0"	5.0"	.380"
LV333-1005	291005-5	MEN	2.0"	7.5"	.380"
LV333-1551	981551	MEN	2.0"	10.0"	.378"
Ultra low absorption lenses					
LV333-0023MP5	29100023	MEN	1.5"	5.0"	.290"
LV333-1005MP5	291005-5	MEN	1.5"	7.5"	.380"

Optics care

Centricut part number	Reference number	Description	Pkg qty
TR300-6452		Lens cleaning Tiffen paper (50 pcs)	1
TR300-1115		Lens cleaning pre-cut cotton (100 pcs)	1
TR300-1010	AL1010	Dropper, lens cleaning fluid	1
TR300-1112		Optical cleaning fluid	1
TR300-0699	70675699 REVA	Lens cleaning swabs (25 pcs)	1
TR300-7991	27991	Polyester wipes 4" x 4" (100 pcs)	1
TR301-0282		Injector	1
TR300-LSA		Lens stress analyzer	1
TR300-255	AL255	Magnifying loop	1
TR300-271	AL271	Base, mirror maintenance	1
TR300-7388	787388	Mirror polish .1UM 250ML	1



Sensor cones



**Centricut sensor cones provide substantial cost savings
without sacrificing performance or quality**

- Available for Amada, Mazak, Mitsubishi and Precitec
- Delivers the same OEM performance at a lower cost
- Unmatched performance and reliability
- Engineered and manufactured to Hypertherm's precise quality standards
- Backed by our one-year warranty and 100% satisfaction guarantee

Centricut part number	OEM	Reference number	Description
AM343-0091	Amada	71360091	AM-Sensor cone, HS95 mini
AM343-1621	Amada	71341621	AM-Sensor cone, HS95
AM343-9107	Amada	ECO cone	AM-Sensor cone, ECO
AM343-1690	Amada	71341690	AM-Sensor cone, HS98
AM343-L3015C	Amada	71374509	AM-Sensor cone, LC3015
PT347-3323	Mazak	HNP	PT-Sensor cone, HNP
MZ335-HNPS	Mazak	HNPS	MZ-Sensor cone, HNP short version
PT347-0007	Mazak	56743300500	PT-Sensor cone, HNZ (Mazak)
PT347-0011	Mitsubishi	P0354-110-00002	PT-Sensor cone, HNZ (Mitsubishi)
MB334-W429A	Mitsubishi	P0461-270-00001	MB-Sensor cone, W429A
PT347-0238	Precitec	BQ930D238G01	PT-Sensor cone, HNZ SMA
PT347-8001	Precitec	P0361-203-00001	PT-Sensor cone, 2.5/J
PT347-0522	Precitec	P0599-520-00002	PT-Sensor cone, LRC
PT347-1145	Precitec	P0380-140-0002, P0380-130-00001, 281145	PT-Sensor cone, DZ

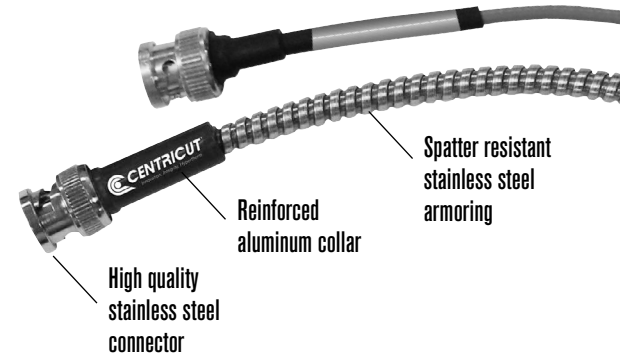
*Sensor cone repair service is available for most sensor cones in North America and select international regions. For more information contact Ctlaser@Hypertherm.com.

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Armored sensor cables

Centricut armored sensor cables outlast standard OEM cables

- Available for all major brands
- Robust design with extreme temperature rating (900–1200°)
- Longer life reduces downtime and production loss
- Spatter resistant stainless steel armoring
- Reinforced collars and high-quality connector



Armored sensor cables

Centricut part number	OEM	Reference number	Description
AM308-8965	Amada	71398965	AM-Sensor cable, 305 mm (12")
AM308-8965A	Amada	71398965	AM-Sensor cable, 305 mm (12") premium, armored
AM313-1901	Amada		AM-Sensor cable, 305 mm (12")
AM313-1901A	Amada	71341630	AM-Sensor cable HS-5, 305 mm (12") premium, armored
AM313-8292	Amada	71398292	AM-Sensor cable dual shield, 7 meters
AM313-9851A	Amada	71369851	AM-Sensor cable, 230 mm (8") premium
CN306-0654A	Cincinnati	909654, 922686	CN-Sensor cable, 114 mm (4.5") armored
CN306-0951A	Cincinnati	842951	CN-Sensor cable, 140 mm (5.5") armored
CN306-2951	Cincinnati	842951, PLTTW0015	CN-Sensor cable, 140 mm (5.5")
CN306-9654	Cincinnati	909654, 922686, PLTTW0002	CN-Sensor cable, 114 mm (4.5") armored
MZ335-0111A	Mazak	4674330111	MZ-Sensor cable, 280 mm (11") armored
MZ335-0181A	Mazak	46743300181	MZ-Sensor cable, 317.5 mm (12.5") armored
MZ335-1330A	Mazak	46683301330	MZ-Sensor cable, 305 mm (12") armored
MZ335-1980A	Mazak	46683301980	MZ-Sensor cable, 280 mm (11") armored
MZ335-5320	Mazak	6143355320	MZ-Sensor cable, 70 mm (2.8") armored
MZ335-630A	Mazak	00BSBA630MNC	MZ-Sensor cable, 630 mm (25") armored
MZ335-8290	Mazak	46143308290	MZ-Sensor cable, 75 mm (3")
NT426-1682	NTC	4R029911-001, J482D	NT-Sensor cable, 216 mm (8.5")
NT426-4991	NTC	3-0104991	NT-Sensor cable 0-OBNC/MCX, 482 mm (19")
NT426-7492	NTC	3-0117492	NT-Sensor cable 90BNC/90BNC, 482 mm (19")
NT426-8677	NTC	4R028677-001	NT-Sensor cable, 508 mm (20") armored
PR361-3150	Prima	820.63.150	PR-Sensor cable, 150 mm (6")
PT347-0014	Precitec	P36015000300, KE 300 gw Z MM	PT-Sensor cable OEM
PT347-0015A	Precitec	00B-15	PT-Sensor cable, 380 mm (15")
PT347-0040	Precitec	00BB-A-17i, BEC004-000.4	PT-Sensor cable, 431 mm (17") armored
PT347-0101A	Precitec	P0360-100-00500	PT-Sensor cable, 500 mm (20") armored
PT347-0181	Precitec	46743300181	PT-Sensor cable
PT347-0250	Precitec	342475	PT-Sensor cable, 250 mm (10") armored
PT347-0300A	Precitec	P0492-014-00300	PT-Sensor cable KE, 300 mm (12") armored
PT347-0450	Precitec	P0497-002-00450	PT-Sensor cable, 450 mm (17.7")
PT347-KS13	Precitec/Gunkyo	00BMTKA-A-HS500mm	PT-Sensor cable, 390 mm (15.5") armored
PT347-0600OEM	Precitec	P0360-210-00600	PT-Sensor cable, 600 ZWW OEM
PT347-1250	Precitec	D5001-040-00250	PT-Sensor cable, 250 mm (10") armored
PT348-0390	Precitec		PT-Sensor cable, 390 mm (15.5")
TR301-0930	Trumpf	280930	TR-Sensor cable, 152 mm (6") armored
TR301-1086	Trumpf	351086, S0492-001-00000	TR-Sensor cable
TR301-7833	Trumpf	227833	TR-Sensor cable, 432 mm (17")
TR301-9983	Trumpf	359983, 342474	TR-Sensor cable, 190 mm (7.5") armored

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Lens cleaning tips



Centricut supplies suitable for all OEM CO₂ and fiber laser lenses

- Lens maintenance base is designed to secure a wide range of optics sizes for the cleaning process
- Centricut optical cleaning fluid is a safe, economical alternative to traditional high-purity and reagent-grade solvents
- Cleaning materials suited for all lens cleaning needs; lens paper, polyester swabs and polyester wipes

Lens paper

Recommended for the routine maintenance cleaning of flat lenses.

Polyester swabs

Recommended for cleaning curved lenses and where a more aggressive cleaning is required (interchangeable with polyester wipes).

Polyester wipes

Recommended for cleaning CO₂ and fiber lenses and windows (interchangeable with polyester swabs and lens paper).

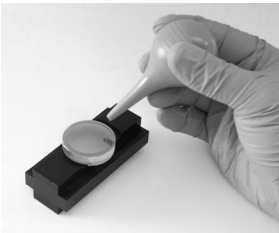
Product description	Part number	Quantity per order
Optical cleaning fluid (3 oz.)	TR300-1112	1
Lens cleaning swab	TR300-0699	25
Lens cleaning paper, Tiffen	TR300-6452	50
Polyester wipes 4" x 4"	TR300-7991	100
Base, lens maintenance	TR300-271	1

Lens paper

Recommended for the routine maintenance cleaning of flat lenses.

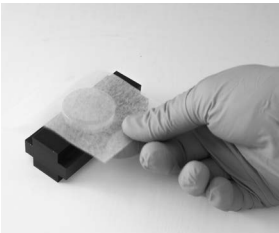
You will need:

- Lens maintenance base (lens holder)
- Optical cleaning fluid
- Air bulb
- Lint-free lens paper
- Latex or rubber gloves



To get started

Using rubber gloves, place the lens in the lens holder and remove all loose contaminants with an air bulb. When contaminants are no longer visible, begin the cleaning process.



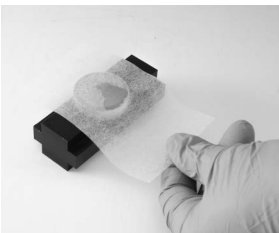
Step 1

Place lens paper over the optic, covering it completely.



Step 2

Apply a couple drops of lens cleaning fluid to the lens paper (far side of the lens).



Step 3

Slowly pull the lens paper across the lens so the cleaning fluid comes in contact with the entire lens surface. Finish pulling the paper across so all of the fluid has dried from the lens.



Step 4

Inspect the surface of the lens for dust and cleaning residue using a flashlight. Examine the lens from different angles. Repeat the process on the other side of the lens.

Final step:

Place the cleaned lens in the machine quickly to avoid contamination from airborne particles. If spots, pits, or scratches are still noticeable, the lens may need to be replaced.

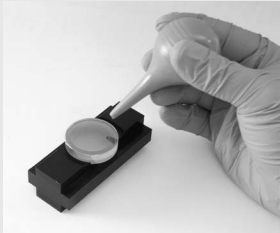
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Polyester swabs

Recommended for cleaning curved lenses and where more aggressive cleaning is required. Interchangeable with polyester wipes.

You will need:

- Lens maintenance base (lens holder)
- Optical cleaning fluid
- Air bulb
- Polyester swabs
- Latex or rubber gloves



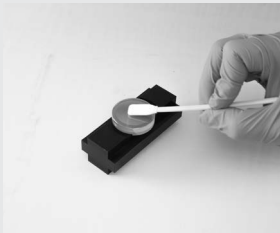
To get started

Using rubber gloves, place the lens in the lens holder and remove all loose contaminants with an air bulb. When contaminants are no longer visible, begin the cleaning process.



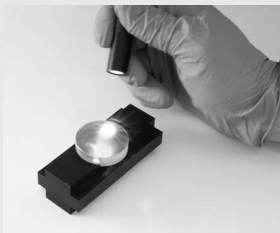
Step 1

Place a few drops of the optical cleaning fluid onto the swab.



Step 2

Move the larger dirt particles and then finer contaminants to the edge of the lens using the swab. Do not rest the swab on the lens or on the work table. Do not reuse swabs.



Step 3

Inspect the surface of the lens for dust and cleaning residue using a flashlight. Examine the lens from different angles. Repeat the process on the other side of the lens.

Final step:

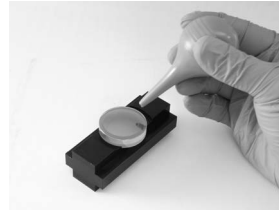
Place the cleaned lens in the machine quickly to avoid contamination from airborne particles. If spots, pits, or scratches are still noticeable, the lens may need to be replaced.

Polyester wipes

Recommended for cleaning CO₂ and fiber lenses and windows. Interchangeable with polyester swabs and lens paper.

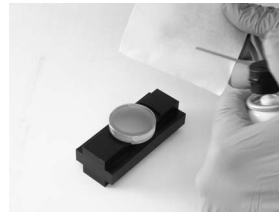
You will need:

- Lens maintenance base (lens holder)
- Optical cleaning fluid
- Air bulb
- Polyester wipes
- Latex or rubber gloves



To get started

Using rubber gloves, place the lens in the lens holder and remove all loose contaminants with an air bulb. When contaminants are no longer visible, begin the cleaning process.



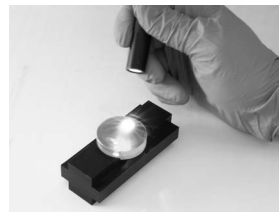
Step 1

Place a few drops of the optical cleaning fluid onto the polyester wipe



Step 2

Place the wipe with the wet side down on the lens and slide it across the lens, applying light pressure to the top of the wipe. Avoid contamination to the wipe and do not reuse wipes.



Step 3

Inspect the surface of the lens for dust and cleaning residue using a flashlight. Examine the lens from different angles. Repeat the process on the other side of the lens.

Final step:

Place the cleaned lens in the machine quickly to avoid contamination from airborne particles. If spots, pits, or scratches are still noticeable, the lens may need to be replaced.

Steps to help optimize cut quality.

Striation marks, angularity and dross tell the story.

Optimizing CO₂ and fiber lasers to achieve maximum cut quality is a very important step in the overall cutting process. The critical points that produce good cuts are the width of the kerf (the material that is lost during the cut), oxidation and roughness of the cut surface, the geometry of the cut parts and the allowable tolerances. Some factors to be considered are the cut speed or 'feed rate', beam focus, gas pressure, standoff and nozzle size/type.

Factory cut chart settings

The following samples show 12 mm, 6 mm and 3.2 mm (1/2", 1/4" and 10 ga.) mild steel, cut with O₂ on a 2 kW fiber laser with one variable changed to show how cut quality is affected. The adjustments will be similar for all CO₂ and fiber laser, cutting mild steel with O₂.

Is the kerf too narrow?

When the kerf is too narrow the cut will have a very smooth edge on the top, a lack of oxidation on the bottom and/or heavy dross.

Probable causes:

- Focus is too low
- Feed rate is too fast
- Gas pressure is too low
- Nozzle size is too small
- Standoff is too low

Follow these steps to optimize cut quality:

1. Use the closest known settings for the material being cut.
2. Use a test part that has both interior and exterior features.
3. Verify that the lens and/or window is clean and in good condition.
4. Verify that the nozzle is centered properly and is in good condition.
5. Adjust the focus up and down until the cut quality starts to get bad and then set to the middle of that range.
6. Adjust the gas pressure up and down until the cut starts to get bad and then set to the middle of that range.
7. Adjust the feed rate up by 5% increments. When the cut starts to get bad, set the feed rate 10% slower.

Strike a balance between heat levels and gas flow

Cutting mild steel with a laser is a balance of how much material is heated by the laser beam and how much assist gas flows through the cut.

- Heating up too small of an area, or not having enough assist gas flow through the cut will result with the kerf (width of the cut) being too narrow.
- Heating up too large of an area or having too much assist gas flow through the cut will result in the kerf being too wide.

Is the kerf too wide?

When the kerf is too wide the cut will have a rougher edge, more self burning in the corners of the part, more angularity on the cut edge and occasionally, dross.

Probable causes:

- Focus is too high
- Feed rate is too slow
- Gas pressure is too high
- Nozzle size is too big
- Standoff is too high
- Incorrect nozzle type

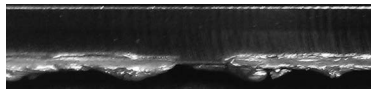
3.2 mm (10 ga.) mild steel cut resulting in too narrow kerf

Factory cut chart settings



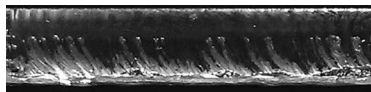
Focus is too low

The kerf is too narrow and doesn't allow enough O₂ into the cut to remove all the molten material.



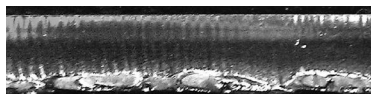
Feed rate is too fast

The cut striations are trailing the direction of cutting and there is not enough time to remove all the molten material.



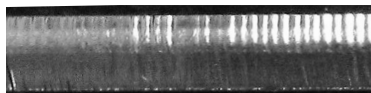
Gas pressure is too low

There is not enough O₂ to remove all the molten material.



Stand off is too low

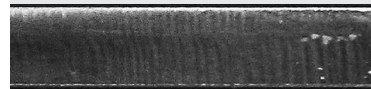
The focus spot is in the wrong location, causing the rough edge.



Cut direction

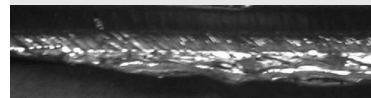
3.2 mm (10 ga.) mild steel cut resulting in too wide kerf

Factory cut chart settings



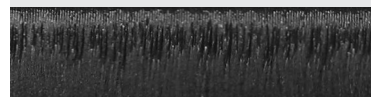
Focus is too high

The laser is melting more material than can be removed from the cut.



Feed rate is too slow

The cut surface is too rough and productivity is decreased.



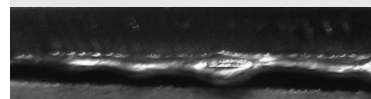
Gas pressure is too high

Too much O₂ results in overheating of the cut and causes intermittent gouges.



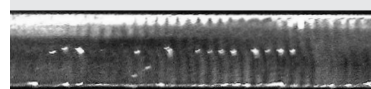
Stand off is too high

The laser is melting more material than can be removed from the cut.



Nozzle size is too big

Too much O₂ results in overheating of the cut and causes intermittent gouges.

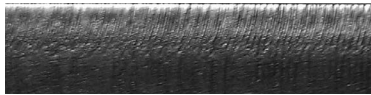


Cut direction

*Above samples have been cut with O₂ on 2 kW fiber laser. Results will be similar for CO₂ laser cutting mild steel with O₂.

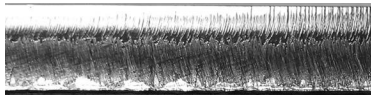
6 mm (1/4") mild steel cut resulting in too narrow kerf

Factory cut chart settings



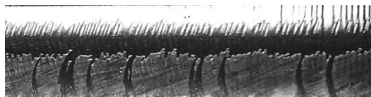
Focus is too low

The kerf is too narrow and doesn't allow enough O₂ into the cut to remove all the molten material.



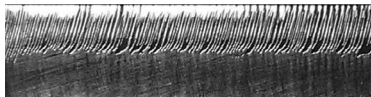
Feed rate is too fast

The cut striations are trailing the direction of cutting and there is not enough time to remove all the molten material.



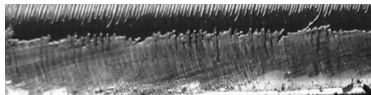
Gas pressure is too low

There is not enough O₂ to remove all the molten material.



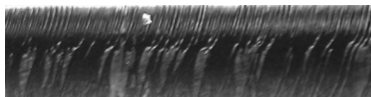
Stand off is too low

The focus spot is in the wrong location, causing the rough edge.



Nozzle size is too small

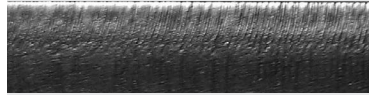
There is not enough O₂ to cut uniformly



Cut direction

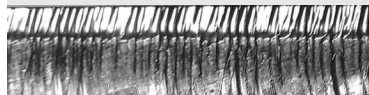
6 mm (1/4") mild steel cut resulting in too wide kerf

Factory cut chart settings



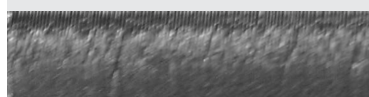
Focus is too high

The wider focus spot is letting too much O₂ into the cut and burning the material.



Feed rate is too slow

The cut surface is too rough and productivity is decreased.



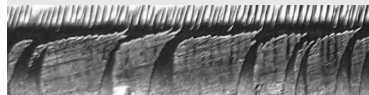
Gas pressure is too high

Too much O₂ is entering the cut, causing a rougher edge and inconsistent cutting.



Stand off is too high

Too much O₂ is entering the cut, causing a rougher edge and inconsistent cutting.



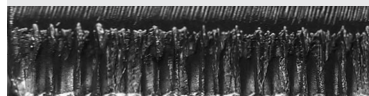
Nozzle size is too big

Too much O₂ results in overheating of the cut and causes intermittent gouges.



Nozzle type is incorrect

The shape of the gas flow is incorrect, causing a rougher edge.



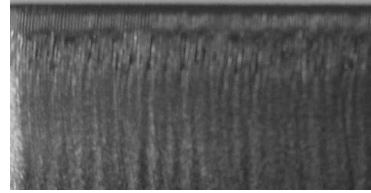
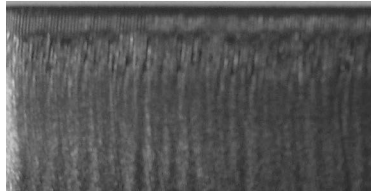
Cut direction

*Above samples have been cut with O₂ on 2 kW fiber laser. Results will be similar for CO₂ laser cutting mild steel with O₂.

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12 mm (1/2") mild steel cut resulting in too narrow kerf

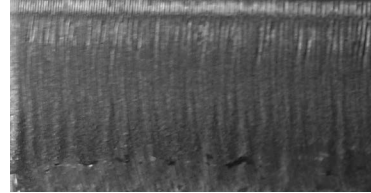
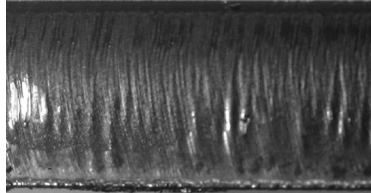
Factory cut chart settings



Factory cut chart settings

Focus is too low

The kerf is too narrow and doesn't allow enough O_2 into the cut to remove all the molten material.

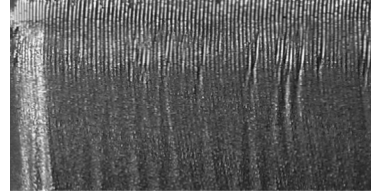
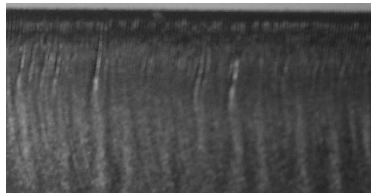


Stand off is too low

The kerf is too narrow to allow enough O_2 into the cut. The oxidation is not covering the entire surface and cutting will be inconsistent.

Feed rate is too fast

The machine is moving too fast to allow enough O_2 into the cut for consistent cutting.

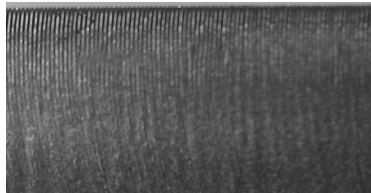


Nozzle size is too small

There is not enough O_2 to cut uniformly

Gas pressure is too low

The pressure is too low to allow enough O_2 into the cut. The oxidation is not covering the entire surface and cutting will be inconsistent.



Cut direction

Cut direction

*Above samples have been cut with O_2 on 2 kW fiber laser. Results will be similar for CO_2 laser cutting mild steel with O_2 .

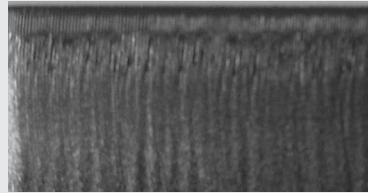
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12 mm (1/2") mild steel cut resulting in too wide kerf

Factory cut chart settings

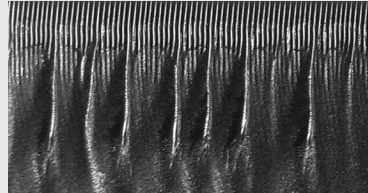
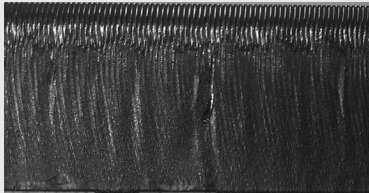


Factory cut chart settings



Focus is too high

Too much O₂ is entering the cut causing intermittent over burning.

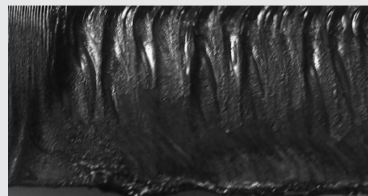
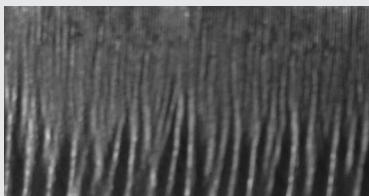


Stand off is too high

Too much O₂ is entering the cut resulting in intermittent over burning.

Feed rate is too slow

The machine is moving too slow resulting in the over burning of the bottom half of the cut. The slower feed rate also reduces productivity.

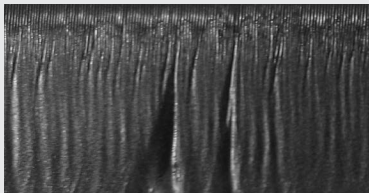


Incorrect nozzle type

The gas flow shape is not correct resulting in inconsistent cutting.

Gas pressure is too high

Too much O₂ is entering the cut resulting in intermittent over burning.



Cut direction

Cut direction

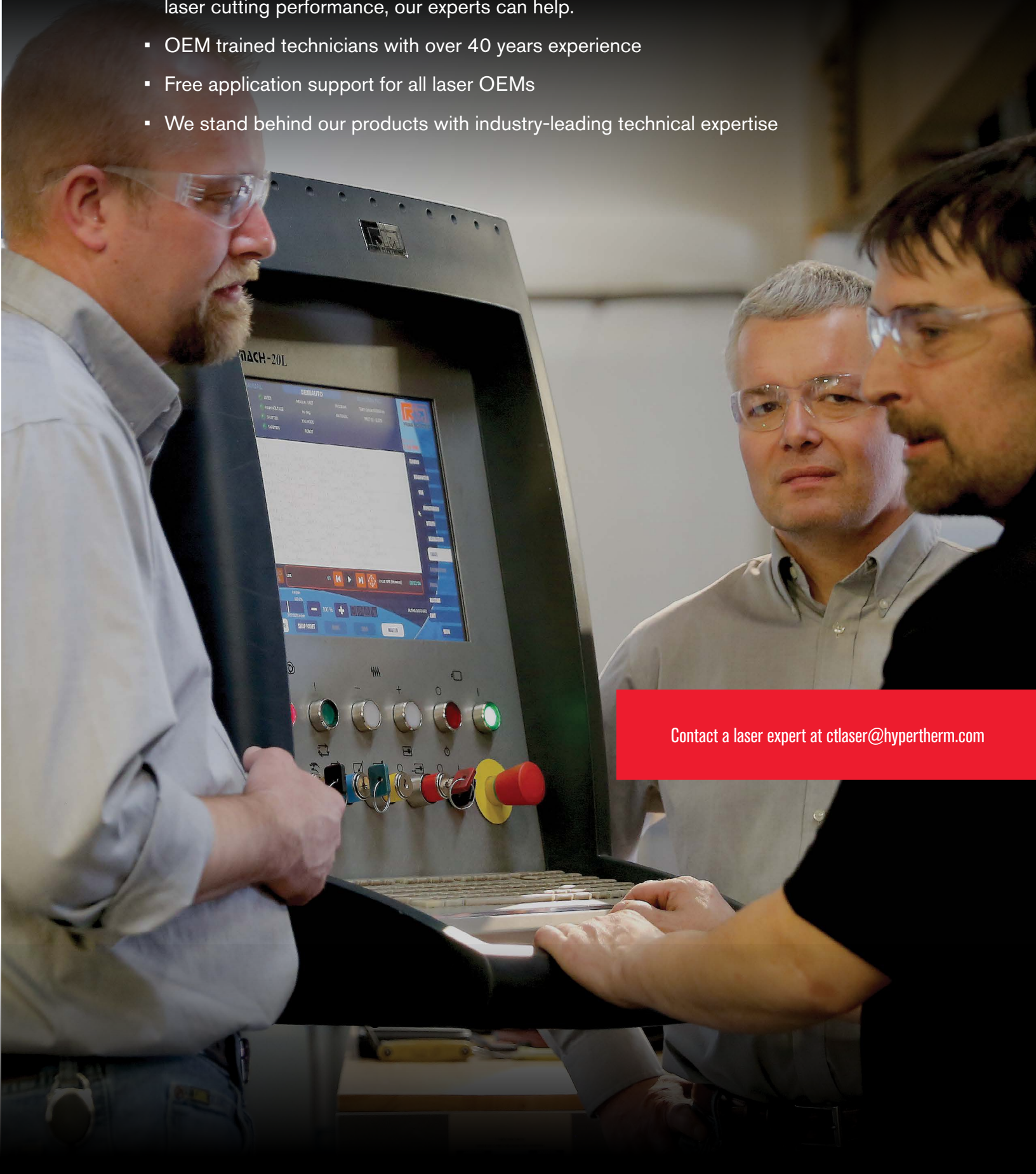
*Above samples have been cut with O₂ on 2 kW fiber laser. Results will be similar for CO₂ laser cutting mild steel with O₂.

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