


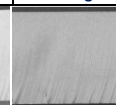
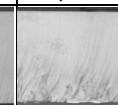





APW waterjet cutting speed reference (mm / min) —Glass

Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
										
glass	2	A15-B / A15+B / A22S	413	1.02	0.33	1200	1600	2000	2500	3000
glass	3	A15-B / A15+B / A22S	413	1.02	0.33	1050	1300	1700	2200	2700
glass	4	A15-B / A15+B / A22S	413	1.02	0.33	950	1180	1400	1900	2400
glass	5	A15-B / A15+B / A22S	413	1.02	0.33	800	900	1200	1600	2000
glass	6	A15-B / A15+B / A22S	413	1.02	0.33	650	800	1150	1350	1800
glass	8	A15-B / A15+B / A22S	413	1.02	0.33	500	700	1100	1200	1600
glass	10	A15-B / A15+B / A22S	413	1.02	0.33	420	600	900	1150	1300
glass	12	A15-B / A15+B / A22S	413	1.02	0.33	360	550	750	950	1200
glass	15	A15-B / A15+B / A22S	413	1.02	0.33	300	480	650	820	1100
glass	18	A15-B / A15+B / A22S	413	1.02	0.33	250	400	550	710	900
glass	20	A15-B / A15+B / A22S	413	1.02	0.33	200	320	450	630	800
glass	25	A15-B / A15+B / A22S	413	1.02	0.33	160	270	350	460	650
glass	30	A15-B / A15+B / A22S	413	1.02	0.33	120	190	260	380	500
glass	35	A15-B / A15+B / A22S	413	1.02	0.33	100	170	240	340	420
glass	40	A15-B / A15+B / A22S	413	1.02	0.33	80	150	210	300	370
glass	45	A15-B / A15+B / A22S	413	1.02	0.33	65	120	180	240	300
glass	50	A15-B / A15+B / A22S	413	1.02	0.33	50	90	160	190	250
glass	60	A15-B / A15+B / A22S	413	1.02	0.33	45	75	90	160	200
glass	70	A15-B / A15+B / A22S	413	1.02	0.33	40	60	80	110	150
glass	80	A15-B / A15+B / A22S	413	1.02	0.33	35	45	60	78	90
glass	90	A15-B / A15+B / A22S	413	1.02	0.33	30	40	50	65	80
glass	100	A15-B / A15+B / A22S	413	1.02	0.33	20	30	40	55	70
glass	2	A24W-45 / V6-45	413	1.14	0.4	1380	1840	2300	3250	3900
glass	3	A24W-45 / V6-45	413	1.14	0.4	1207.5	1495	1955	2860	3510
glass	4	A24W-45 / V6-45	413	1.14	0.4	1092.5	1357	1610	2470	3120
glass	5	A24W-45 / V6-45	413	1.14	0.4	920	1035	1380	2080	2600
glass	6	A24W-45 / V6-45	413	1.14	0.4	747.5	920	1322.5	1755	2340
glass	8	A24W-45 / V6-45	413	1.14	0.4	575	805	1265	1560	2080
glass	10	A24W-45 / V6-45	413	1.14	0.4	483	690	1035	1495	1690
glass	12	A24W-45 / V6-45	413	1.14	0.4	414	632.5	862.5	1235	1560
glass	15	A24W-45 / V6-45	413	1.14	0.4	345	552	747.5	1066	1430
glass	18	A24W-45 / V6-45	413	1.14	0.4	287.5	460	632.5	923	1170
glass	20	A24W-45 / V6-45	413	1.14	0.4	230	368	517.5	819	1040
glass	25	A24W-45 / V6-45	413	1.14	0.4	184	310.5	402.5	598	845
glass	30	A24W-45 / V6-45	413	1.14	0.4	138	218.5	299	494	650
glass	35	A24W-45 / V6-45	413	1.14	0.4	115	195.5	276	442	546
glass	40	A24W-45 / V6-45	413	1.14	0.4	92	172.5	241.5	390	481
glass	45	A24W-45 / V6-45	413	1.14	0.4	74.75	138	207	312	390
glass	50	A24W-45 / V6-45	413	1.14	0.4	57.5	103.5	184	247	325
glass	60	A24W-45 / V6-45	413	1.14	0.4	51.75	86.25	103.5	208	260

APW waterjet cutting speed reference (mm / min) —Glass

Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
										
glass	70	A24W-45 / V6-45	413	1.14	0.4	46	69	92	143	195
glass	80	A24W-45 / V6-45	413	1.14	0.4	40.25	51.75	69	101.4	117
glass	90	A24W-45 / V6-45	413	1.14	0.4	34.5	46	57.5	84.5	104
glass	100	A24W-45 / V6-45	413	1.14	0.4	23	34.5	46	71.5	91
glass	2	A24W-75 / V6W-75	413	1.27	0.45	1440	1920	2500	3500	4200
glass	3	A24W-75 / V6W-75	413	1.27	0.45	1260	1560	2125	3080	3780
glass	4	A24W-75 / V6W-75	413	1.27	0.45	1140	1416	1750	2660	3360
glass	5	A24W-75 / V6W-75	413	1.27	0.45	960	1080	1500	2240	2800
glass	6	A24W-75 / V6W-75	413	1.27	0.45	780	960	1437.5	1890	2520
glass	8	A24W-75 / V6W-75	413	1.27	0.45	600	840	1375	1680	2240
glass	10	A24W-75 / V6W-75	413	1.27	0.45	504	720	1125	1610	1820
glass	12	A24W-75 / V6W-75	413	1.27	0.45	432	660	937.5	1330	1680
glass	15	A24W-75 / V6W-75	413	1.27	0.45	360	576	812.5	1148	1540
glass	18	A24W-75 / V6W-75	413	1.27	0.45	300	480	687.5	994	1260
glass	20	A24W-75 / V6W-75	413	1.27	0.45	240	384	562.5	882	1120
glass	25	A24W-75 / V6W-75	413	1.27	0.45	192	324	437.5	644	910
glass	30	A24W-75 / V6W-75	413	1.27	0.45	144	228	325	532	700
glass	35	A24W-75 / V6W-75	413	1.27	0.45	120	204	300	476	588
glass	40	A24W-75 / V6W-75	413	1.27	0.45	96	180	262.5	420	518
glass	45	A24W-75 / V6W-75	413	1.27	0.45	78	144	225	336	420
glass	50	A24W-75 / V6W-75	413	1.27	0.45	60	108	200	266	350
glass	60	A24W-75 / V6W-75	413	1.27	0.45	54	90	112.5	224	280
glass	70	A24W-75 / V6W-75	413	1.27	0.45	48	72	100	154	210
glass	80	A24W-75 / V6W-75	413	1.27	0.45	42	54	75	109.2	126
glass	90	A24W-75 / V6W-75	413	1.27	0.45	36	48	62.5	91	112
glass	100	A24W-75 / V6W-75	413	1.27	0.45	24	36	50	77	98
organic glass	1	A15-B / A15+B / A22S	413	1.02	0.33	4000	4500	5000	5500	6000
organic glass	2	A15-B / A15+B / A22S	413	1.02	0.33	3000	3500	4000	4700	5500
organic glass	3	A15-B / A15+B / A22S	413	1.02	0.33	2500	3000	3500	4100	4700
organic glass	4	A15-B / A15+B / A22S	413	1.02	0.33	2100	2550	3000	3600	4200
organic glass	5	A15-B / A15+B / A22S	413	1.02	0.33	1800	2100	2500	3000	3500
organic glass	8	A15-B / A15+B / A22S	413	1.02	0.33	1400	1700	2100	2600	3150
organic glass	10	A15-B / A15+B / A22S	413	1.02	0.33	1000	1300	1600	2200	2800
organic glass	15	A15-B / A15+B / A22S	413	1.02	0.33	750	1020	1250	1750	2300
organic glass	20	A15-B / A15+B / A22S	413	1.02	0.33	500	700	900	1300	1800
organic glass	25	A15-B / A15+B / A22S	413	1.02	0.33	375	620	800	1100	1400
organic glass	30	A15-B / A15+B / A22S	413	1.02	0.33	250	500	700	850	1000
organic glass	35	A15-B / A15+B / A22S	413	1.02	0.33	230	430	600	740	880
organic glass	40	A15-B / A15+B / A22S	413	1.02	0.33	210	395	500	620	750
organic glass	45	A15-B / A15+B / A22S	413	1.02	0.33	185	360	440	570	680

APW waterjet cutting speed reference (mm / min) —Glass										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
organic glass	50	A15-B / A15+B / A22S	413	1.02	0.33	160	340	380	530	600
organic glass	60	A15-B / A15+B / A22S	413	1.02	0.33	135	210	300	400	500
organic glass	70	A15-B / A15+B / A22S	413	1.02	0.33	110	160	220	310	400
organic glass	80	A15-B / A15+B / A22S	413	1.02	0.33	96	135	180	260	340
organic glass	90	A15-B / A15+B / A22S	413	1.02	0.33	85	113	150	215	285
organic glass	100	A15-B / A15+B / A22S	413	1.02	0.33	60	88	115	185	230
organic glass	110	A15-B / A15+B / A22S	413	1.02	0.33	50	70	90	150	205
organic glass	120	A15-B / A15+B / A22S	413	1.02	0.33	40	55	70	110	160
organic glass	130	A15-B / A15+B / A22S	413	1.02	0.33	31	44	57	79	135
organic glass	140	A15-B / A15+B / A22S	413	1.02	0.33	22	33	46	67	105
organic glass	150	A15-B / A15+B / A22S	413	1.02	0.33	18	24	35	55	75
organic glass	1	A24W-45 / V6-45	413	1.14	0.4	4600	5175	5750	7150	7800
organic glass	2	A24W-45 / V6-45	413	1.14	0.4	3450	4025	4600	6110	7150
organic glass	3	A24W-45 / V6-45	413	1.14	0.4	2875	3450	4025	5330	6110
organic glass	4	A24W-45 / V6-45	413	1.14	0.4	2415	2932.5	3450	4680	5460
organic glass	5	A24W-45 / V6-45	413	1.14	0.4	2070	2415	2875	3900	4550
organic glass	8	A24W-45 / V6-45	413	1.14	0.4	1610	1955	2415	3380	4095
organic glass	10	A24W-45 / V6-45	413	1.14	0.4	1150	1495	1840	2860	3640
organic glass	15	A24W-45 / V6-45	413	1.14	0.4	862.5	1173	1437.5	2275	2990
organic glass	20	A24W-45 / V6-45	413	1.14	0.4	575	805	1035	1690	2340
organic glass	25	A24W-45 / V6-45	413	1.14	0.4	431.25	713	920	1430	1820
organic glass	30	A24W-45 / V6-45	413	1.14	0.4	287.5	575	805	1105	1300
organic glass	35	A24W-45 / V6-45	413	1.14	0.4	264.5	494.5	690	962	1144
organic glass	40	A24W-45 / V6-45	413	1.14	0.4	241.5	454.25	575	806	975
organic glass	45	A24W-45 / V6-45	413	1.14	0.4	212.75	414	506	741	884
organic glass	50	A24W-45 / V6-45	413	1.14	0.4	184	391	437	689	780
organic glass	60	A24W-45 / V6-45	413	1.14	0.4	155.25	241.5	345	520	650
organic glass	70	A24W-45 / V6-45	413	1.14	0.4	126.5	184	253	403	520
organic glass	80	A24W-45 / V6-45	413	1.14	0.4	110.4	155.25	207	338	442
organic glass	90	A24W-45 / V6-45	413	1.14	0.4	97.75	129.95	172.5	279.5	370.5
organic glass	100	A24W-45 / V6-45	413	1.14	0.4	69	101.2	132.25	240.5	299
organic glass	110	A24W-45 / V6-45	413	1.14	0.4	57.5	80.5	103.5	195	266.5
organic glass	120	A24W-45 / V6-45	413	1.14	0.4	46	63.25	80.5	143	208
organic glass	130	A24W-45 / V6-45	413	1.14	0.4	35.65	50.6	65.55	102.7	175.5
organic glass	140	A24W-45 / V6-45	413	1.14	0.4	25.3	37.95	52.9	87.1	136.5
organic glass	150	A24W-45 / V6-45	413	1.14	0.4	20.7	27.6	40.25	71.5	97.5
organic glass	1	A24W-75 / V6W-75	413	1.27	0.45	4800	5400	6250	7700	8400
organic glass	2	A24W-75 / V6W-75	413	1.27	0.45	3600	4200	5000	6580	7700
organic glass	3	A24W-75 / V6W-75	413	1.27	0.45	3000	3600	4375	5740	6580
organic glass	4	A24W-75 / V6W-75	413	1.27	0.45	2520	3060	3750	5040	5880

APW waterjet cutting speed reference (mm / min) —Glass										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
organic glass	5	A24W-75 / V6W-75	413	1.27	0.45	2160	2520	3125	4200	4900
organic glass	8	A24W-75 / V6W-75	413	1.27	0.45	1680	2040	2625	3640	4410
organic glass	10	A24W-75 / V6W-75	413	1.27	0.45	1200	1560	2000	3080	3920
organic glass	15	A24W-75 / V6W-75	413	1.27	0.45	900	1224	1562.5	2450	3220
organic glass	20	A24W-75 / V6W-75	413	1.27	0.45	600	840	1125	1820	2520
organic glass	25	A24W-75 / V6W-75	413	1.27	0.45	450	744	1000	1540	1960
organic glass	30	A24W-75 / V6W-75	413	1.27	0.45	300	600	875	1190	1400
organic glass	35	A24W-75 / V6W-75	413	1.27	0.45	276	516	750	1036	1232
organic glass	40	A24W-75 / V6W-75	413	1.27	0.45	252	474	625	868	1050
organic glass	45	A24W-75 / V6W-75	413	1.27	0.45	222	432	550	798	952
organic glass	50	A24W-75 / V6W-75	413	1.27	0.45	192	408	475	742	840
organic glass	60	A24W-75 / V6W-75	413	1.27	0.45	162	252	375	560	700
organic glass	70	A24W-75 / V6W-75	413	1.27	0.45	132	192	275	434	560
organic glass	80	A24W-75 / V6W-75	413	1.27	0.45	115.2	162	225	364	476
organic glass	90	A24W-75 / V6W-75	413	1.27	0.45	102	135.6	187.5	301	399
organic glass	100	A24W-75 / V6W-75	413	1.27	0.45	72	105.6	143.75	259	322
organic glass	110	A24W-75 / V6W-75	413	1.27	0.45	60	84	112.5	210	287
organic glass	120	A24W-75 / V6W-75	413	1.27	0.45	48	66	87.5	154	224
organic glass	130	A24W-75 / V6W-75	413	1.27	0.45	37.2	52.8	71.25	110.6	189
organic glass	140	A24W-75 / V6W-75	413	1.27	0.45	26.4	39.6	57.5	93.8	147
organic glass	150	A24W-75 / V6W-75	413	1.27	0.45	21.6	28.8	43.75	77	105