

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
Aluminium	1	A15-B / A15+B / A22S	413	1.02	0.33	2000	2320	2800	3700	4200
Aluminium	2	A15-B / A15+B / A22S	413	1.02	0.33	1650	2183	2440	3061	3500
Aluminium	3	A15-B / A15+B / A22S	413	1.02	0.33	979	1232	1780	2494	3000
Aluminium	4	A15-B / A15+B / A22S	413	1.02	0.33	702	850	1200	1400	2300
Aluminium	5	A15-B / A15+B / A22S	413	1.02	0.33	544	900	1370	1700	2200
Aluminium	8	A15-B / A15+B / A22S	413	1.02	0.33	317	580	855	1000	1400
Aluminium	10	A15-B / A15+B / A22S	413	1.02	0.33	230	280	500	700	900
Aluminium	12	A15-B / A15+B / A22S	413	1.02	0.33	190	300	490	610	790
Aluminium	15	A15-B / A15+B / A22S	413	1.02	0.33	154	280	380	510	600
Aluminium	18	A15-B / A15+B / A22S	413	1.02	0.33	132	205	279	340	500
Aluminium	20	A15-B / A15+B / A22S	413	1.02	0.33	110	130	200	300	400
Aluminium	25	A15-B / A15+B / A22S	413	1.02	0.33	88	119	155	255	320
Aluminium	30	A15-B / A15+B / A22S	413	1.02	0.33	60	80	100	120	200
Aluminium	35	A15-B / A15+B / A22S	413	1.02	0.33	50	57	65	100	150
Aluminium	40	A15-B / A15+B / A22S	413	1.02	0.33	40	55	75	110	130
Aluminium	45	A15-B / A15+B / A22S	413	1.02	0.33	33	47	55	80	115
Aluminium	50	A15-B / A15+B / A22S	413	1.02	0.33	30	40	45	70	100
Aluminium	60	A15-B / A15+B / A22S	413	1.02	0.33	23	31	35	44	75
Aluminium	70	A15-B / A15+B / A22S	413	1.02	0.33	18	25	30	45	55
Aluminium	80	A15-B / A15+B / A22S	413	1.02	0.33	15	16	25	38	50
Aluminium	90	A15-B / A15+B / A22S	413	1.02	0.33	12	13	22	33	45
Aluminium	100	A15-B / A15+B / A22S	413	1.02	0.33	10	15	20	30	40
Aluminium	110	A15-B / A15+B / A22S	413	1.02	0.33	9	14	17	25	35
Aluminium	120	A15-B / A15+B / A22S	413	1.02	0.33	9	13	15	22	30
Aluminium	130	A15-B / A15+B / A22S	413	1.02	0.33	8	11	13	20	25
Aluminium	140	A15-B / A15+B / A22S	413	1.02	0.33	8	10	12	17	23
Aluminium	150	A15-B / A15+B / A22S	413	1.02	0.33	7	9	11	15	18
Aluminium	1	A24W-45 / V6-45	413	1.14	0.4	2300	2668	3220	4810	5460
Aluminium	2	A24W-45 / V6-45	413	1.14	0.4	1897.5	2510.45	2806	3979.3	4550
Aluminium	3	A24W-45 / V6-45	413	1.14	0.4	1125.85	1416.8	2047	3242.2	3900
Aluminium	4	A24W-45 / V6-45	413	1.14	0.4	807.3	977.5	1380	1820	2990
Aluminium	5	A24W-45 / V6-45	413	1.14	0.4	625.6	1035	1575.5	2210	2860
Aluminium	8	A24W-45 / V6-45	413	1.14	0.4	364.55	667	983.25	1300	1820
Aluminium	10	A24W-45 / V6-45	413	1.14	0.4	264.5	322	575	910	1170
Aluminium	12	A24W-45 / V6-45	413	1.14	0.4	218.5	345	563.5	793	1027
Aluminium	15	A24W-45 / V6-45	413	1.14	0.4	177.1	322	437	663	780
Aluminium	18	A24W-45 / V6-45	413	1.14	0.4	151.8	235.75	320.85	442	650
Aluminium	20	A24W-45 / V6-45	413	1.14	0.4	126.5	149.5	230	390	520
Aluminium	25	A24W-45 / V6-45	413	1.14	0.4	101.2	136.85	178.25	331.5	416
Aluminium	30	A24W-45 / V6-45	413	1.14	0.4	69	92	115	156	260
Aluminium	35	A24W-45 / V6-45	413	1.14	0.4	57.5	65.55	74.75	130	195

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
Aluminium	40	A24W-45 / V6-45	413	1.14	0.4	46	63.25	86.25	143	169
Aluminium	45	A24W-45 / V6-45	413	1.14	0.4	37.95	54.05	63.25	104	149.5
Aluminium	50	A24W-45 / V6-45	413	1.14	0.4	34.5	46	51.75	91	130
Aluminium	60	A24W-45 / V6-45	413	1.14	0.4	26.45	35.65	40.25	57.2	97.5
Aluminium	70	A24W-45 / V6-45	413	1.14	0.4	20.7	28.75	34.5	58.5	71.5
Aluminium	80	A24W-45 / V6-45	413	1.14	0.4	17.25	18.4	28.75	49.4	65
Aluminium	90	A24W-45 / V6-45	413	1.14	0.4	13.8	14.95	25.3	42.9	58.5
Aluminium	100	A24W-45 / V6-45	413	1.14	0.4	11.5	17.25	23	39	52
Aluminium	110	A24W-45 / V6-45	413	1.14	0.4	10.35	16.1	19.55	32.5	45.5
Aluminium	120	A24W-45 / V6-45	413	1.14	0.4	10.35	14.95	17.25	28.6	39
Aluminium	130	A24W-45 / V6-45	413	1.14	0.4	9.2	12.65	14.95	26	32.5
Aluminium	140	A24W-45 / V6-45	413	1.14	0.4	9.2	11.5	13.8	22.1	29.9
Aluminium	150	A24W-45 / V6-45	413	1.14	0.4	8.05	10.35	12.65	19.5	23.4
Aluminium	200	A24W-45 / V6-45	413	1.14	0.4	6	7	10	14	17
Aluminium	250	A24W-45 / V6-45	413	1.14	0.4	4	5	7	10	12
Aluminium	300	A24W-45 / V6-45	413	1.14	0.4	2	3	4	6	7
Aluminium	350	A24W-45 / V6-45	413	1.14	0.4	0.5	1	2.5	4	5
Aluminium	1	A24W-75 / V6W-75	413	1.27	0.45	2400	2784	3500	5180	5880
Aluminium	2	A24W-75 / V6W-75	413	1.27	0.45	1980	2619.6	3050	4285.4	4900
Aluminium	3	A24W-75 / V6W-75	413	1.27	0.45	1174.8	1478.4	2225	3491.6	4200
Aluminium	4	A24W-75 / V6W-75	413	1.27	0.45	842.4	1020	1500	1960	3220
Aluminium	5	A24W-75 / V6W-75	413	1.27	0.45	652.8	1080	1712.5	2380	3080
Aluminium	8	A24W-75 / V6W-75	413	1.27	0.45	380.4	696	1068.75	1400	1960
Aluminium	10	A24W-75 / V6W-75	413	1.27	0.45	276	336	625	980	1260
Aluminium	12	A24W-75 / V6W-75	413	1.27	0.45	228	360	612.5	854	1106
Aluminium	15	A24W-75 / V6W-75	413	1.27	0.45	184.8	336	475	714	840
Aluminium	18	A24W-75 / V6W-75	413	1.27	0.45	158.4	246	348.75	476	700
Aluminium	20	A24W-75 / V6W-75	413	1.27	0.45	132	156	250	420	560
Aluminium	25	A24W-75 / V6W-75	413	1.27	0.45	105.6	142.8	193.75	357	448
Aluminium	30	A24W-75 / V6W-75	413	1.27	0.45	72	96	125	168	280
Aluminium	35	A24W-75 / V6W-75	413	1.27	0.45	60	68.4	81.25	140	210
Aluminium	40	A24W-75 / V6W-75	413	1.27	0.45	48	66	93.75	154	182
Aluminium	45	A24W-75 / V6W-75	413	1.27	0.45	39.6	56.4	68.75	112	161
Aluminium	50	A24W-75 / V6W-75	413	1.27	0.45	36	48	56.25	98	140
Aluminium	60	A24W-75 / V6W-75	413	1.27	0.45	27.6	37.2	43.75	61.6	105
Aluminium	70	A24W-75 / V6W-75	413	1.27	0.45	21.6	30	37.5	63	77
Aluminium	80	A24W-75 / V6W-75	413	1.27	0.45	18	19.2	31.25	53.2	70
Aluminium	90	A24W-75 / V6W-75	413	1.27	0.45	14.4	15.6	27.5	46.2	63
Aluminium	100	A24W-75 / V6W-75	413	1.27	0.45	12	18	25	42	56
Aluminium	110	A24W-75 / V6W-75	413	1.27	0.45	10.8	16.8	21.25	35	49
Aluminium	120	A24W-75 / V6W-75	413	1.27	0.45	10.8	15.6	18.75	30.8	42

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
Aluminium	130	A24W-75 / V6W-75	413	1.27	0.45	9.6	13.2	16.25	28	35
Aluminium	140	A24W-75 / V6W-75	413	1.27	0.45	9.6	12	15	23.8	32.2
Aluminium	150	A24W-75 / V6W-75	413	1.27	0.45	8.4	10.8	13.75	21	25.2
Aluminium	200	A24W-75 / V6W-75	413	1.27	0.45	6	8	12	18	22
Aluminium	250	A24W-75 / V6W-75	413	1.27	0.45	4	6	9	13	18
Aluminium	300	A24W-75 / V6W-75	413	1.27	0.45	2	4	5.5	8.5	10
Aluminium	350	A24W-75 / V6W-75	413	1.27	0.45	1	2	3	4.5	7
Aluminium	400	A24W-75 / V6W-75	413	1.27	0.45	0.5	0.8	1.2	2.5	4
brass	1	A15-B / A15+B / A22S	413	1.02	0.33	1200	1500	1800	2500	3200
brass	2	A15-B / A15+B / A22S	413	1.02	0.33	800	1050	1300	2000	2600
brass	3	A15-B / A15+B / A22S	413	1.02	0.33	600	800	1100	1650	2100
brass	4	A15-B / A15+B / A22S	413	1.02	0.33	440	620	800	1200	1600
brass	5	A15-B / A15+B / A22S	413	1.02	0.33	260	340	500	750	1000
brass	8	A15-B / A15+B / A22S	413	1.02	0.33	190	240	350	490	680
brass	10	A15-B / A15+B / A22S	413	1.02	0.33	130	175	220	310	440
brass	12	A15-B / A15+B / A22S	413	1.02	0.33	100	140	180	270	375
brass	15	A15-B / A15+B / A22S	413	1.02	0.33	80	119	150	230	300
brass	18	A15-B / A15+B / A22S	413	1.02	0.33	60	88	120	180	240
brass	20	A15-B / A15+B / A22S	413	1.02	0.33	40	60	90	145	180
brass	25	A15-B / A15+B / A22S	413	1.02	0.33	37	52	80	125	160
brass	30	A15-B / A15+B / A22S	413	1.02	0.33	35	50	70	105	140
brass	35	A15-B / A15+B / A22S	413	1.02	0.33	30	43	58	75	120
brass	40	A15-B / A15+B / A22S	413	1.02	0.33	25	37	50	66	95
brass	45	A15-B / A15+B / A22S	413	1.02	0.33	21	32	42	57	78
brass	50	A15-B / A15+B / A22S	413	1.02	0.33	18	25	35	48	65
brass	60	A15-B / A15+B / A22S	413	1.02	0.33	16	22	30	40	60
brass	70	A15-B / A15+B / A22S	413	1.02	0.33	15	20	24	30	50
brass	80	A15-B / A15+B / A22S	413	1.02	0.33	12	15	22	29	40
brass	90	A15-B / A15+B / A22S	413	1.02	0.33	10	13	20	26	30
brass	100	A15-B / A15+B / A22S	413	1.02	0.33	8	10	15	17	20
brass	110	A15-B / A15+B / A22S	413	1.02	0.33	6	9	13	15	18
brass	120	A15-B / A15+B / A22S	413	1.02	0.33	5	8	12	14	16
brass	130	A15-B / A15+B / A22S	413	1.02	0.33	4	6	9	11	14
brass	140	A15-B / A15+B / A22S	413	1.02	0.33	4	5	8	10	12
brass	150	A15-B / A15+B / A22S	413	1.02	0.33	3	4	6	8	10
brass	1	A24W-45 / V6-45	413	1.14	0.4	1380	1725	2070	3250	4160
brass	2	A24W-45 / V6-45	413	1.14	0.4	920	1207.5	1495	2600	3380
brass	3	A24W-45 / V6-45	413	1.14	0.4	690	920	1265	2145	2730
brass	4	A24W-45 / V6-45	413	1.14	0.4	506	713	920	1560	2080
brass	5	A24W-45 / V6-45	413	1.14	0.4	299	391	575	975	1300
brass	8	A24W-45 / V6-45	413	1.14	0.4	218.5	276	402.5	637	884

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
brass	10	A24W-45 / V6-45	413	1.14	0.4	149.5	201.25	253	403	572
brass	12	A24W-45 / V6-45	413	1.14	0.4	115	161	207	351	487.5
brass	15	A24W-45 / V6-45	413	1.14	0.4	92	136.85	172.5	299	390
brass	18	A24W-45 / V6-45	413	1.14	0.4	69	101.2	138	234	312
brass	20	A24W-45 / V6-45	413	1.14	0.4	46	69	103.5	188.5	234
brass	25	A24W-45 / V6-45	413	1.14	0.4	42.55	59.8	92	162.5	208
brass	30	A24W-45 / V6-45	413	1.14	0.4	40.25	57.5	80.5	136.5	182
brass	35	A24W-45 / V6-45	413	1.14	0.4	34.5	49.45	66.7	97.5	156
brass	40	A24W-45 / V6-45	413	1.14	0.4	28.75	42.55	57.5	85.8	123.5
brass	45	A24W-45 / V6-45	413	1.14	0.4	24.15	36.8	48.3	74.1	101.4
brass	50	A24W-45 / V6-45	413	1.14	0.4	20.7	28.75	40.25	62.4	84.5
brass	60	A24W-45 / V6-45	413	1.14	0.4	18.4	25.3	34.5	52	78
brass	70	A24W-45 / V6-45	413	1.14	0.4	17.25	23	27.6	39	65
brass	80	A24W-45 / V6-45	413	1.14	0.4	13.8	17.25	25.3	37.7	52
brass	90	A24W-45 / V6-45	413	1.14	0.4	11.5	14.95	23	33.8	39
brass	100	A24W-45 / V6-45	413	1.14	0.4	9.2	11.5	17.25	22.1	26
brass	110	A24W-45 / V6-45	413	1.14	0.4	6.9	10.35	14.95	19.5	23.4
brass	120	A24W-45 / V6-45	413	1.14	0.4	5.75	9.2	13.8	18.2	20.8
brass	130	A24W-45 / V6-45	413	1.14	0.4	4.6	6.9	10.35	14.3	18.2
brass	140	A24W-45 / V6-45	413	1.14	0.4	4.6	5.75	9.2	13	15.6
brass	150	A24W-45 / V6-45	413	1.14	0.4	3.45	4.6	6.9	10.4	13
brass	1	A24W-75 / V6W-75	413	1.27	0.45	1440	1800	2250	3500	4480
brass	2	A24W-75 / V6W-75	413	1.27	0.45	960	1260	1625	2800	3640
brass	3	A24W-75 / V6W-75	413	1.27	0.45	720	960	1375	2310	2940
brass	4	A24W-75 / V6W-75	413	1.27	0.45	528	744	1000	1680	2240
brass	5	A24W-75 / V6W-75	413	1.27	0.45	312	408	625	1050	1400
brass	8	A24W-75 / V6W-75	413	1.27	0.45	228	288	437.5	686	952
brass	10	A24W-75 / V6W-75	413	1.27	0.45	156	210	275	434	616
brass	12	A24W-75 / V6W-75	413	1.27	0.45	120	168	225	378	525
brass	15	A24W-75 / V6W-75	413	1.27	0.45	96	142.8	187.5	322	420
brass	18	A24W-75 / V6W-75	413	1.27	0.45	72	105.6	150	252	336
brass	20	A24W-75 / V6W-75	413	1.27	0.45	48	72	112.5	203	252
brass	25	A24W-75 / V6W-75	413	1.27	0.45	44.4	62.4	100	175	224
brass	30	A24W-75 / V6W-75	413	1.27	0.45	42	60	87.5	147	196
brass	35	A24W-75 / V6W-75	413	1.27	0.45	36	51.6	72.5	105	168
brass	40	A24W-75 / V6W-75	413	1.27	0.45	30	44.4	62.5	92.4	133
brass	45	A24W-75 / V6W-75	413	1.27	0.45	25.2	38.4	52.5	79.8	109.2
brass	50	A24W-75 / V6W-75	413	1.27	0.45	21.6	30	43.75	67.2	91
brass	60	A24W-75 / V6W-75	413	1.27	0.45	19.2	26.4	37.5	56	84
brass	70	A24W-75 / V6W-75	413	1.27	0.45	18	24	30	42	70
brass	80	A24W-75 / V6W-75	413	1.27	0.45	14.4	18	27.5	40.6	56

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
brass	90	A24W-75 / V6W-75	413	1.27	0.45	12	15.6	25	36.4	42
brass	100	A24W-75 / V6W-75	413	1.27	0.45	9.6	12	18.75	23.8	28
brass	110	A24W-75 / V6W-75	413	1.27	0.45	7.2	10.8	16.25	21	25.2
brass	120	A24W-75 / V6W-75	413	1.27	0.45	6	9.6	15	19.6	22.4
brass	130	A24W-75 / V6W-75	413	1.27	0.45	4.8	7.2	11.25	15.4	19.6
brass	140	A24W-75 / V6W-75	413	1.27	0.45	4.8	6	10	14	16.8
brass	150	A24W-75 / V6W-75	413	1.27	0.45	3.6	4.8	7.5	11.2	14
CS、SS	1	A15-B / A15+B / A22S	413	1.02	0.33	550	650	831	1010	1700
CS、SS	2	A15-B / A15+B / A22S	413	1.02	0.33	354	410	458	637	1016
CS、SS	3	A15-B / A15+B / A22S	413	1.02	0.33	258	410	545	764	910
CS、SS	4	A15-B / A15+B / A22S	413	1.02	0.33	185	313	412	571	700
CS、SS	5	A15-B / A15+B / A22S	413	1.02	0.33	160	197	220	354	560
CS、SS	8	A15-B / A15+B / A22S	413	1.02	0.33	84	153	195	292	362
CS、SS	10	A15-B / A15+B / A22S	413	1.02	0.33	68	108	170	230	280
CS、SS	12	A15-B / A15+B / A22S	413	1.02	0.33	50	85	129	185	220
CS、SS	15	A15-B / A15+B / A22S	413	1.02	0.33	41	63	113	140	190
CS、SS	18	A15-B / A15+B / A22S	413	1.02	0.33	35	60	105	135	175
CS、SS	20	A15-B / A15+B / A22S	413	1.02	0.33	32	53	90	130	160
CS、SS	25	A15-B / A15+B / A22S	413	1.02	0.33	28	43	80	120	150
CS、SS	30	A15-B / A15+B / A22S	413	1.02	0.33	25	30	70	110	130
CS、SS	35	A15-B / A15+B / A22S	413	1.02	0.33	23	28	50	80	100
CS、SS	40	A15-B / A15+B / A22S	413	1.02	0.33	19	21	29	60	80
CS、SS	45	A15-B / A15+B / A22S	413	1.02	0.33	16	19	25	43	64
CS、SS	50	A15-B / A15+B / A22S	413	1.02	0.33	14	17	20	35	43
CS、SS	60	A15-B / A15+B / A22S	413	1.02	0.33	13	15	18	31	39
CS、SS	70	A15-B / A15+B / A22S	413	1.02	0.33	12	14	17	22	30
CS、SS	80	A15-B / A15+B / A22S	413	1.02	0.33	10	12	16	20	25
CS、SS	90	A15-B / A15+B / A22S	413	1.02	0.33	7	9	12	15	18
CS、SS	100	A15-B / A15+B / A22S	413	1.02	0.33	6	8	10	12	14
CS、SS	110	A15-B / A15+B / A22S	413	1.02	0.33	2	4	5	7	9
CS、SS	120	A15-B / A15+B / A22S	413	1.02	0.33	2	3	4	5	7
CS、SS	1	A24W-45 / V6-45	413	1.14	0.4	632.5	747.5	955.65	1313	2210
CS、SS	2	A24W-45 / V6-45	413	1.14	0.4	407.1	471.5	526.7	828.1	1320.8
CS、SS	3	A24W-45 / V6-45	413	1.14	0.4	296.7	471.5	626.75	993.2	1183
CS、SS	4	A24W-45 / V6-45	413	1.14	0.4	212.75	359.95	473.8	742.3	910
CS、SS	5	A24W-45 / V6-45	413	1.14	0.4	184	226.55	253	460.2	728
CS、SS	8	A24W-45 / V6-45	413	1.14	0.4	96.6	175.95	224.25	379.6	470.6
CS、SS	10	A24W-45 / V6-45	413	1.14	0.4	78.2	124.2	195.5	299	364
CS、SS	12	A24W-45 / V6-45	413	1.14	0.4	57.5	97.75	148.35	240.5	286
CS、SS	15	A24W-45 / V6-45	413	1.14	0.4	47.15	72.45	129.95	182	247
CS、SS	18	A24W-45 / V6-45	413	1.14	0.4	40.25	69	120.75	175.5	227.5

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
CS、SS	20	A24W-45 / V6-45	413	1.14	0.4	36.8	60.95	103.5	169	208
CS、SS	25	A24W-45 / V6-45	413	1.14	0.4	32.2	49.45	92	156	195
CS、SS	30	A24W-45 / V6-45	413	1.14	0.4	28.75	34.5	80.5	143	169
CS、SS	35	A24W-45 / V6-45	413	1.14	0.4	26.45	32.2	57.5	104	130
CS、SS	40	A24W-45 / V6-45	413	1.14	0.4	21.85	24.15	33.35	78	104
CS、SS	45	A24W-45 / V6-45	413	1.14	0.4	18.4	21.85	28.75	55.9	83.2
CS、SS	50	A24W-45 / V6-45	413	1.14	0.4	16.1	19.55	23	45.5	55.9
CS、SS	60	A24W-45 / V6-45	413	1.14	0.4	14.95	17.25	20.7	40.3	50.7
CS、SS	70	A24W-45 / V6-45	413	1.14	0.4	13.8	16.1	19.55	28.6	39
CS、SS	80	A24W-45 / V6-45	413	1.14	0.4	11.5	13.8	18.4	26	32.5
CS、SS	90	A24W-45 / V6-45	413	1.14	0.4	8.05	10.35	13.8	19.5	23.4
CS、SS	100	A24W-45 / V6-45	413	1.14	0.4	6.9	9.2	11.5	15.6	18.2
CS、SS	110	A24W-45 / V6-45	413	1.14	0.4	2.3	4.6	5.75	9.1	11.7
CS、SS	120	A24W-45 / V6-45	413	1.14	0.4	2.3	3.45	4.6	6.5	9.1
CS、SS	150	A24W-45 / V6-45	413	1.14	0.4	1.5	2.6	4.2	5.5	7
CS、SS	200	A24W-45 / V6-45	413	1.14	0.4	1	2	3	4	5
CS、SS	1	A24W-75 / V6W-75	413	1.27	0.45	660	780	1038.75	1414	2380
CS、SS	2	A24W-75 / V6W-75	413	1.27	0.45	424.8	492	572.5	891.8	1422.4
CS、SS	3	A24W-75 / V6W-75	413	1.27	0.45	309.6	492	681.25	1069.6	1274
CS、SS	4	A24W-75 / V6W-75	413	1.27	0.45	222	375.6	515	799.4	980
CS、SS	5	A24W-75 / V6W-75	413	1.27	0.45	192	236.4	275	495.6	784
CS、SS	8	A24W-75 / V6W-75	413	1.27	0.45	100.8	183.6	243.75	408.8	506.8
CS、SS	10	A24W-75 / V6W-75	413	1.27	0.45	81.6	129.6	212.5	322	392
CS、SS	12	A24W-75 / V6W-75	413	1.27	0.45	60	102	161.25	259	308
CS、SS	15	A24W-75 / V6W-75	413	1.27	0.45	49.2	75.6	141.25	196	266
CS、SS	18	A24W-75 / V6W-75	413	1.27	0.45	42	72	131.25	189	245
CS、SS	20	A24W-75 / V6W-75	413	1.27	0.45	38.4	63.6	112.5	182	224
CS、SS	25	A24W-75 / V6W-75	413	1.27	0.45	33.6	51.6	100	168	210
CS、SS	30	A24W-75 / V6W-75	413	1.27	0.45	30	36	87.5	154	182
CS、SS	35	A24W-75 / V6W-75	413	1.27	0.45	27.6	33.6	62.5	112	140
CS、SS	40	A24W-75 / V6W-75	413	1.27	0.45	22.8	25.2	36.25	84	112
CS、SS	45	A24W-75 / V6W-75	413	1.27	0.45	19.2	22.8	31.25	60.2	89.6
CS、SS	50	A24W-75 / V6W-75	413	1.27	0.45	16.8	20.4	25	49	60.2
CS、SS	60	A24W-75 / V6W-75	413	1.27	0.45	15.6	18	22.5	43.4	54.6
CS、SS	70	A24W-75 / V6W-75	413	1.27	0.45	14.4	16.8	21.25	30.8	42
CS、SS	80	A24W-75 / V6W-75	413	1.27	0.45	12	14.4	20	28	35
CS、SS	90	A24W-75 / V6W-75	413	1.27	0.45	8.4	10.8	15	21	25.2
CS、SS	100	A24W-75 / V6W-75	413	1.27	0.45	7.2	9.6	12.5	16.8	19.6
CS、SS	110	A24W-75 / V6W-75	413	1.27	0.45	4.5	5.5	7	9.8	12.6
CS、SS	120	A24W-75 / V6W-75	413	1.27	0.45	3.5	5	6	8	11
CS、SS	150	A24W-75 / V6W-75	413	1.27	0.45	3	4	5	5.5	7

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
CS、SS	200	A24W-75 / V6W-75	413	1.27	0.45	2.5	3	3.5	5	6
CS、SS	250	A24W-75 / V6W-75	413	1.27	0.45	1	2.5	2	3	4
CS、SS	300	A24W-75 / V6W-75	413	1.27	0.45	0.5	1	1.5	2	2
Titanium	1	A15-B / A15+B / A22S	413	1.02	0.33	1000	1500	2300	2450	2800
Titanium	2	A15-B / A15+B / A22S	413	1.02	0.33	600	800	1000	2055	2300
Titanium	3	A15-B / A15+B / A22S	413	1.02	0.33	454	690	860	1300	1900
Titanium	4	A15-B / A15+B / A22S	413	1.02	0.33	326	500	680	950	1300
Titanium	5	A15-B / A15+B / A22S	413	1.02	0.33	200	330	450	630	850
Titanium	8	A15-B / A15+B / A22S	413	1.02	0.33	147	230	300	440	500
Titanium	10	A15-B / A15+B / A22S	413	1.02	0.33	114	180	240	392	450
Titanium	12	A15-B / A15+B / A22S	413	1.02	0.33	98	155	200	305	360
Titanium	15	A15-B / A15+B / A22S	413	1.02	0.33	71	105	170	255	280
Titanium	18	A15-B / A15+B / A22S	413	1.02	0.33	52	80	130	200	240
Titanium	20	A15-B / A15+B / A22S	413	1.02	0.33	40	70	115	140	180
Titanium	25	A15-B / A15+B / A22S	413	1.02	0.33	39	62	88	107	140
Titanium	30	A15-B / A15+B / A22S	413	1.02	0.33	32	55	75	86	119
Titanium	35	A15-B / A15+B / A22S	413	1.02	0.33	27	50	62	77	105
Titanium	40	A15-B / A15+B / A22S	413	1.02	0.33	23	35	50	65	80
Titanium	45	A15-B / A15+B / A22S	413	1.02	0.33	16	20	35	55	70
Titanium	50	A15-B / A15+B / A22S	413	1.02	0.33	14	18	29	47	50
Titanium	60	A15-B / A15+B / A22S	413	1.02	0.33	13	17	25	28	35
Titanium	70	A15-B / A15+B / A22S	413	1.02	0.33	12	16	21	25	29
Titanium	80	A15-B / A15+B / A22S	413	1.02	0.33	10	14	18	20	25
Titanium	90	A15-B / A15+B / A22S	413	1.02	0.33	9	13	17	18	23
Titanium	100	A15-B / A15+B / A22S	413	1.02	0.33	8	12	16	17	20
Titanium	110	A15-B / A15+B / A22S	413	1.02	0.33	7	8	10	12	15
Titanium	120	A15-B / A15+B / A22S	413	1.02	0.33	6	7	8	9	10
Titanium	130	A15-B / A15+B / A22S	413	1.02	0.33	5	6	7	8	8
Titanium	140	A15-B / A15+B / A22S	413	1.02	0.33	3	4	5	6	6
Titanium	150	A15-B / A15+B / A22S	413	1.02	0.33	2	3	4	5	6
Titanium	1	A24W-45 / V6-45	413	1.14	0.4	1150	1725	2645	3185	3640
Titanium	2	A24W-45 / V6-45	413	1.14	0.4	690	920	1150	2671.5	2990
Titanium	3	A24W-45 / V6-45	413	1.14	0.4	522.1	793.5	989	1690	2470
Titanium	4	A24W-45 / V6-45	413	1.14	0.4	374.9	575	782	1235	1690
Titanium	5	A24W-45 / V6-45	413	1.14	0.4	230	379.5	517.5	819	1105
Titanium	8	A24W-45 / V6-45	413	1.14	0.4	169.05	264.5	345	572	650
Titanium	10	A24W-45 / V6-45	413	1.14	0.4	131.1	207	276	509.6	585
Titanium	12	A24W-45 / V6-45	413	1.14	0.4	112.7	178.25	230	396.5	468
Titanium	15	A24W-45 / V6-45	413	1.14	0.4	81.65	120.75	195.5	331.5	364
Titanium	18	A24W-45 / V6-45	413	1.14	0.4	59.8	92	149.5	260	312
Titanium	20	A24W-45 / V6-45	413	1.14	0.4	46	80.5	132.25	182	234

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPa)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
Titanium	25	A24W-45 / V6-45	413	1.14	0.4	44.85	71.3	101.2	139.1	182
Titanium	30	A24W-45 / V6-45	413	1.14	0.4	36.8	63.25	86.25	111.8	154.7
Titanium	35	A24W-45 / V6-45	413	1.14	0.4	31.05	57.5	71.3	100.1	136.5
Titanium	40	A24W-45 / V6-45	413	1.14	0.4	26.45	40.25	57.5	84.5	104
Titanium	45	A24W-45 / V6-45	413	1.14	0.4	18.4	23	40.25	71.5	91
Titanium	50	A24W-45 / V6-45	413	1.14	0.4	16.1	20.7	33.35	61.1	65
Titanium	60	A24W-45 / V6-45	413	1.14	0.4	14.95	19.55	28.75	36.4	45.5
Titanium	70	A24W-45 / V6-45	413	1.14	0.4	13.8	18.4	24.15	32.5	37.7
Titanium	80	A24W-45 / V6-45	413	1.14	0.4	11.5	16.1	20.7	26	32.5
Titanium	90	A24W-45 / V6-45	413	1.14	0.4	10.35	14.95	19.55	23.4	29.9
Titanium	100	A24W-45 / V6-45	413	1.14	0.4	9.2	13.8	18.4	22.1	26
Titanium	110	A24W-45 / V6-45	413	1.14	0.4	8.05	9.2	11.5	15.6	19.5
Titanium	120	A24W-45 / V6-45	413	1.14	0.4	6.9	8.05	9.2	11.7	13
Titanium	130	A24W-45 / V6-45	413	1.14	0.4	5.75	6.9	8.05	10.4	10.4
Titanium	140	A24W-45 / V6-45	413	1.14	0.4	3.45	4.6	5.75	7.8	7.8
Titanium	150	A24W-45 / V6-45	413	1.14	0.4	2.3	3.45	4.6	6.5	7.8
Titanium	200	A24W-45 / V6-45	413	1.14	0.4	1.5	2.5	3.8	5	6
Titanium	250	A24W-45 / V6-45	413	1.14	0.4	1.2	2	3	4	5
Titanium	300	A24W-45 / V6-45	413	1.14	0.4	0.8	1.2	1.5	3	4
Titanium	1	A24W-75 / V6W-75	413	1.27	0.45	1200	1800	2875	3430	3920
Titanium	2	A24W-75 / V6W-75	413	1.27	0.45	720	960	1250	2877	3220
Titanium	3	A24W-75 / V6W-75	413	1.27	0.45	544.8	828	1075	1820	2660
Titanium	4	A24W-75 / V6W-75	413	1.27	0.45	391.2	600	850	1330	1820
Titanium	5	A24W-75 / V6W-75	413	1.27	0.45	240	396	562.5	882	1190
Titanium	8	A24W-75 / V6W-75	413	1.27	0.45	176.4	276	375	616	700
Titanium	10	A24W-75 / V6W-75	413	1.27	0.45	136.8	216	300	548.8	630
Titanium	12	A24W-75 / V6W-75	413	1.27	0.45	117.6	186	250	427	504
Titanium	15	A24W-75 / V6W-75	413	1.27	0.45	85.2	126	212.5	357	392
Titanium	18	A24W-75 / V6W-75	413	1.27	0.45	62.4	96	162.5	280	336
Titanium	20	A24W-75 / V6W-75	413	1.27	0.45	48	84	143.75	196	252
Titanium	25	A24W-75 / V6W-75	413	1.27	0.45	46.8	74.4	110	149.8	196
Titanium	30	A24W-75 / V6W-75	413	1.27	0.45	38.4	66	93.75	120.4	166.6
Titanium	35	A24W-75 / V6W-75	413	1.27	0.45	32.4	60	77.5	107.8	147
Titanium	40	A24W-75 / V6W-75	413	1.27	0.45	27.6	42	62.5	91	112
Titanium	45	A24W-75 / V6W-75	413	1.27	0.45	19.2	24	43.75	77	98
Titanium	50	A24W-75 / V6W-75	413	1.27	0.45	16.8	21.6	36.25	65.8	70
Titanium	60	A24W-75 / V6W-75	413	1.27	0.45	15.6	20.4	31.25	39.2	49
Titanium	70	A24W-75 / V6W-75	413	1.27	0.45	14.4	19.2	26.25	35	40.6
Titanium	80	A24W-75 / V6W-75	413	1.27	0.45	12	16.8	22.5	28	35
Titanium	90	A24W-75 / V6W-75	413	1.27	0.45	10.8	15.6	21.25	25.2	32.2
Titanium	100	A24W-75 / V6W-75	413	1.27	0.45	9.6	14.4	20	23.8	28

APW waterjet cutting speed reference (mm / min) —Metal										
Material	thickness(mm)	Intensifier Type	Pressure (MPA)	Nozzle Dia (mm)	Orifice (mm)	cutting finish quality(mm / Min)				
						excellent	Good	fine	average	poor
Titanium	110	A24W-75 / V6W-75	413	1.27	0.45	8.4	9.6	12.5	16.8	21
Titanium	120	A24W-75 / V6W-75	413	1.27	0.45	7.2	8.4	10	12.6	14
Titanium	130	A24W-75 / V6W-75	413	1.27	0.45	6	7.2	8.75	11.2	11.2
Titanium	140	A24W-75 / V6W-75	413	1.27	0.45	3.6	4.8	6.25	8.4	8.4
Titanium	150	A24W-75 / V6W-75	413	1.27	0.45	2.4	3.6	5	7	8.4
Titanium	200	A24W-75 / V6W-75	413	1.27	0.45	2	3.5	4.5	6	7
Titanium	250	A24W-75 / V6W-75	413	1.27	0.45	1.6	2.8	4.2	5.5	6.5
Titanium	300	A24W-75 / V6W-75	413	1.27	0.45	1.2	2	3.8	4.2	6