

| APW waterjet cutting speed reference (mm / min) |               |                      |                |                 |              |                                  |        |        |         |      |
|---|---------------|----------------------|----------------|-----------------|--------------|----------------------------------|--------|--------|---------|------|
| Nylon / Plastic / Rubber / Leather / Foam       |               |                      |                |                 |              |                                  |        |        |         |      |
| Material  | thickness(mm) | Intensifier Type     | Pressure (MPa) | Nozzle Dia (mm) | Orifice (mm) | cutting finish quality(mm / Min) |        |        |         |      |
|   |               |                      |                |                 |              | excellent                        | Good   | fine   | average | poor |
| foam  | 1             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 3500                             | 4000   | 4500   | 5000    | 6000 |
| foam  | 2             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 2550                             | 3100   | 4000   | 4800    | 6000 |
| foam  | 3             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 2150                             | 2600   | 3700   | 4500    | 5000 |
| foam  | 4             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1850                             | 2300   | 3000   | 3500    | 4000 |
| foam  | 5             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1650                             | 2000   | 2700   | 3000    | 3500 |
| foam  | 8             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1450                             | 1800   | 2300   | 2650    | 3200 |
| foam  | 10            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1300                             | 1500   | 1900   | 2400    | 3000 |
| foam  | 15            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1100                             | 1350   | 1650   | 2100    | 2750 |
| foam  | 20            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 900                              | 1200   | 1400   | 1950    | 2500 |
| foam  | 25            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 780                              | 950    | 1290   | 1800    | 2300 |
| foam  | 30            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 690                              | 860    | 1150   | 1600    | 2100 |
| foam  | 35            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 600                              | 800    | 1000   | 1400    | 1800 |
| foam  | 40            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 500                              | 690    | 880    | 1250    | 1550 |
| foam  | 45            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 400                              | 580    | 750    | 1100    | 1350 |
| foam  | 50            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 320                              | 460    | 600    | 800     | 1000 |
| foam  | 60            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 300                              | 410    | 540    | 650     | 900  |
| foam  | 70            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 280                              | 380    | 470    | 590     | 800  |
| foam  | 80            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 260                              | 350    | 420    | 520     | 700  |
| foam  | 90            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 230                              | 320    | 380    | 470     | 600  |
| foam  | 100           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 200                              | 300    | 350    | 430     | 500  |
| foam  | 110           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 180                              | 260    | 330    | 390     | 460  |
| foam  | 120           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 160                              | 240    | 310    | 350     | 420  |
| foam  | 130           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 140                              | 220    | 290    | 330     | 380  |
| foam  | 140           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 120                              | 200    | 270    | 310     | 350  |
| foam  | 150           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 100                              | 180    | 250    | 290     | 330  |
| foam  | 1             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 4025                             | 4600   | 5175   | 6500    | 7800 |
| foam  | 2             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2932.5                           | 3565   | 4600   | 6240    | 7800 |
| foam  | 3             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2472.5                           | 2990   | 4255   | 5850    | 6500 |
| foam  | 4             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2127.5                           | 2645   | 3450   | 4550    | 5200 |
| foam  | 5             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1897.5                           | 2300   | 3105   | 3900    | 4550 |
| foam  | 8             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1667.5                           | 2070   | 2645   | 3445    | 4160 |
| foam  | 10            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1495                             | 1725   | 2185   | 3120    | 3900 |
| foam  | 15            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1265                             | 1552.5 | 1897.5 | 2730    | 3575 |
| foam  | 20            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1035                             | 1380   | 1610   | 2535    | 3250 |
| foam  | 25            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 897                              | 1092.5 | 1483.5 | 2340    | 2990 |
| foam  | 30            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 793.5                            | 989    | 1322.5 | 2080    | 2730 |
| foam  | 35            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 690                              | 920    | 1150   | 1820    | 2340 |
| foam  | 40            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 575                              | 793.5  | 1012   | 1625    | 2015 |
| foam  | 45            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 460                              | 667    | 862.5  | 1430    | 1755 |
| foam  | 50            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 368                              | 529    | 690    | 1040    | 1300 |

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| Nylon / Plastic / Rubber / Leather / Foam       |               |                      |                |                 |              |                                  |       |        |         |      |
| Material  | thickness(mm) | Intensifier Type     | Pressure (MPa) | Nozzle Dia (mm) | Orifice (mm) | cutting finish quality(mm / Min) |       |        |         |      |
|   |               |                      |                |                 |              | excellent                        | Good  | fine   | average | poor |
| foam  | 60            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 345                              | 471.5 | 621    | 845     | 1170 |
| foam  | 70            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 322                              | 437   | 540.5  | 767     | 1040 |
| foam  | 80            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 299                              | 402.5 | 483    | 676     | 910  |
| foam  | 90            | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 264.5                            | 368   | 437    | 611     | 780  |
| foam  | 100           | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 230                              | 345   | 402.5  | 559     | 650  |
| foam  | 110           | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 207                              | 299   | 379.5  | 507     | 598  |
| foam  | 120           | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 184                              | 276   | 356.5  | 455     | 546  |
| foam  | 130           | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 161                              | 253   | 333.5  | 429     | 494  |
| foam  | 140           | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 138                              | 230   | 310.5  | 403     | 455  |
| foam  | 150           | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 115                              | 207   | 287.5  | 377     | 429  |
| foam  | 1             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 4200                             | 4800  | 5625   | 7000    | 8400 |
| foam  | 2             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 3060                             | 3720  | 5000   | 6720    | 8400 |
| foam  | 3             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 2580                             | 3120  | 4625   | 6300    | 7000 |
| foam  | 4             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 2220                             | 2760  | 3750   | 4900    | 5600 |
| foam  | 5             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 1980                             | 2400  | 3375   | 4200    | 4900 |
| foam  | 8             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 1740                             | 2160  | 2875   | 3710    | 4480 |
| foam  | 10            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 1560                             | 1800  | 2375   | 3360    | 4200 |
| foam  | 15            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 1320                             | 1620  | 2062.5 | 2940    | 3850 |
| foam  | 20            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 1080                             | 1440  | 1750   | 2730    | 3500 |
| foam  | 25            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 936                              | 1140  | 1612.5 | 2520    | 3220 |
| foam  | 30            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 828                              | 1032  | 1437.5 | 2240    | 2940 |
| foam  | 35            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 720                              | 960   | 1250   | 1960    | 2520 |
| foam  | 40            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 600                              | 828   | 1100   | 1750    | 2170 |
| foam  | 45            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 480                              | 696   | 937.5  | 1540    | 1890 |
| foam  | 50            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 384                              | 552   | 750    | 1120    | 1400 |
| foam  | 60            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 360                              | 492   | 675    | 910     | 1260 |
| foam  | 70            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 336                              | 456   | 587.5  | 826     | 1120 |
| foam  | 80            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 312                              | 420   | 525    | 728     | 980  |
| foam  | 90            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 276                              | 384   | 475    | 658     | 840  |
| foam  | 100           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 240                              | 360   | 437.5  | 602     | 700  |
| foam  | 110           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 216                              | 312   | 412.5  | 546     | 644  |
| foam  | 120           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 192                              | 288   | 387.5  | 490     | 588  |
| foam  | 130           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 168                              | 264   | 362.5  | 462     | 532  |
| foam  | 140           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 144                              | 240   | 337.5  | 434     | 490  |
| foam  | 150           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 120                              | 216   | 312.5  | 406     | 462  |
| leather   | 1             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 3500                             | 4000  | 4500   | 5000    | 6000 |
| leather   | 2             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 2550                             | 3100  | 4000   | 4800    | 6000 |
| leather   | 3             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 2150                             | 2600  | 3700   | 4500    | 5000 |
| leather   | 4             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1850                             | 2300  | 3000   | 3500    | 4000 |
| leather   | 5             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1650                             | 2000  | 2700   | 3000    | 3500 |

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| Nylon / Plastic / Rubber / Leather / Foam       |               |                      |                |                 |              |                                  |      |      |         |      |
| Material  | thickness(mm) | Intensifier Type     | Pressure (MPa) | Nozzle Dia (mm) | Orifice (mm) | cutting finish quality(mm / Min) |      |      |         |      |
|   |               |                      |                |                 |              | excellent                        | Good | fine | average | poor |
| leather   | 1             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 4025                             | 4600 | 5175 | 6500    | 7800 |
| leather   | 2             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2932.5                           | 3565 | 4600 | 6240    | 7800 |
| leather   | 3             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2472.5                           | 2990 | 4255 | 5850    | 6500 |
| leather   | 4             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2127.5                           | 2645 | 3450 | 4650    | 5200 |
| leather   | 5             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1897.5                           | 2300 | 3105 | 3900    | 4550 |
| leather   | 1             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 4200                             | 4800 | 5625 | 7000    | 8400 |
| leather   | 2             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 3060                             | 3720 | 5000 | 6720    | 8400 |
| leather   | 3             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 2580                             | 3120 | 4625 | 6300    | 7000 |
| leather   | 4             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 2220                             | 2760 | 3750 | 4900    | 5600 |
| leather   | 5             | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 1980                             | 2400 | 3375 | 4200    | 4900 |
| Nylon、Plastic                                   | 1             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1500                             | 3500 | 3400 | 4200    | 4950 |
| Nylon、Plastic                                   | 2             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1380                             | 2200 | 3100 | 3800    | 4600 |
| Nylon、Plastic                                   | 3             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1250                             | 2000 | 2800 | 3500    | 4250 |
| Nylon、Plastic                                   | 4             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1120                             | 1800 | 2500 | 3100    | 3900 |
| Nylon、Plastic                                   | 5             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1000                             | 1600 | 2200 | 2900    | 3500 |
| Nylon、Plastic                                   | 8             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 900                              | 1400 | 1900 | 2500    | 3100 |
| Nylon、Plastic                                   | 10            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 800                              | 1200 | 1500 | 2150    | 2800 |
| Nylon、Plastic                                   | 12            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 700                              | 1000 | 1300 | 1950    | 2550 |
| Nylon、Plastic                                   | 15            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 600                              | 800  | 1150 | 1800    | 2300 |
| Nylon、Plastic                                   | 18            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 500                              | 600  | 950  | 1500    | 2000 |
| Nylon、Plastic                                   | 20            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 400                              | 500  | 800  | 1200    | 1700 |
| Nylon、Plastic                                   | 25            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 320                              | 450  | 700  | 950     | 1300 |
| Nylon、Plastic                                   | 30            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 250                              | 390  | 600  | 780     | 900  |
| Nylon、Plastic                                   | 35            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 220                              | 340  | 500  | 650     | 800  |
| Nylon、Plastic                                   | 40            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 180                              | 290  | 400  | 550     | 700  |
| Nylon、Plastic                                   | 45            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 160                              | 250  | 340  | 480     | 630  |
| Nylon、Plastic                                   | 50            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 140                              | 210  | 280  | 410     | 550  |
| Nylon、Plastic                                   | 60            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 120                              | 160  | 230  | 330     | 440  |
| Nylon、Plastic                                   | 70            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 100                              | 145  | 190  | 240     | 380  |
| Nylon、Plastic                                   | 80            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 80                               | 115  | 150  | 210     | 320  |
| Nylon、Plastic                                   | 90            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 65                               | 90   | 120  | 190     | 260  |
| Nylon、Plastic                                   | 100           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 50                               | 78   | 105  | 170     | 219  |
| Nylon、Plastic                                   | 110           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 40                               | 68   | 79   | 120     | 180  |
| Nylon、Plastic                                   | 120           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 30                               | 45   | 65   | 90      | 150  |
| Nylon、Plastic                                   | 130           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 25                               | 33   | 45   | 70      | 120  |
| Nylon、Plastic                                   | 140           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 20                               | 29   | 38   | 59      | 90   |
| Nylon、Plastic                                   | 150           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 15                               | 22   | 30   | 50      | 70   |
| Nylon、Plastic                                   | 1             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1725                             | 4025 | 3910 | 5460    | 6435 |
| Nylon、Plastic                                   | 2             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1587                             | 2530 | 3565 | 4940    | 5980 |
| Nylon、Plastic                                   | 3             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1437.5                           | 2300 | 3220 | 4550    | 5525 |

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| Nylon / Plastic / Rubber / Leather / Foam       |               |                  |                |                 |              |                                  |        |        |         |       |
| Material  | thickness(mm) | Intensifier Type | Pressure (MPa) | Nozzle Dia (mm) | Orifice (mm) | cutting finish quality(mm / Min) |        |        |         |       |
|   |               |                  |                |                 |              | excellent                        | Good   | fine   | average | poor  |
| Nylon, Plastic                                  | 4             | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 1288                             | 2070   | 2875   | 4030    | 5070  |
| Nylon, Plastic                                  | 5             | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 1150                             | 1840   | 2530   | 3770    | 4550  |
| Nylon, Plastic                                  | 8             | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 1035                             | 1610   | 2185   | 3250    | 4080  |
| Nylon, Plastic                                  | 10            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 920                              | 1380   | 1725   | 2795    | 3640  |
| Nylon, Plastic                                  | 12            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 805                              | 1150   | 1495   | 2535    | 3315  |
| Nylon, Plastic                                  | 15            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 690                              | 920    | 1322.5 | 2340    | 2990  |
| Nylon, Plastic                                  | 18            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 575                              | 690    | 1092.5 | 1950    | 2600  |
| Nylon, Plastic                                  | 20            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 460                              | 575    | 920    | 1560    | 2210  |
| Nylon, Plastic                                  | 25            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 368                              | 517.5  | 805    | 1235    | 1690  |
| Nylon, Plastic                                  | 30            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 287.5                            | 448.5  | 690    | 1014    | 1170  |
| Nylon, Plastic                                  | 35            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 253                              | 391    | 575    | 845     | 1040  |
| Nylon, Plastic                                  | 40            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 207                              | 333.5  | 460    | 715     | 910   |
| Nylon, Plastic                                  | 45            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 184                              | 287.5  | 391    | 624     | 819   |
| Nylon, Plastic                                  | 50            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 161                              | 241.5  | 322    | 533     | 715   |
| Nylon, Plastic                                  | 60            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 138                              | 184    | 264.5  | 429     | 572   |
| Nylon, Plastic                                  | 70            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 115                              | 166.75 | 218.5  | 312     | 494   |
| Nylon, Plastic                                  | 80            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 92                               | 132.25 | 172.5  | 273     | 416   |
| Nylon, Plastic                                  | 90            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 74.75                            | 103.5  | 138    | 247     | 338   |
| Nylon, Plastic                                  | 100           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 57.5                             | 89.7   | 120.75 | 221     | 284.7 |
| Nylon, Plastic                                  | 110           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 46                               | 78.2   | 90.85  | 156     | 234   |
| Nylon, Plastic                                  | 120           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 34.5                             | 51.75  | 74.75  | 117     | 195   |
| Nylon, Plastic                                  | 130           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 28.75                            | 37.95  | 51.75  | 91      | 156   |
| Nylon, Plastic                                  | 140           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 23                               | 33.35  | 43.7   | 76.7    | 117   |
| Nylon, Plastic                                  | 150           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 17.25                            | 25.3   | 34.5   | 65      | 91    |
| Nylon, Plastic                                  | 1             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 1800                             | 4200   | 4250   | 5880    | 6930  |
| Nylon, Plastic                                  | 2             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 1656                             | 2640   | 3875   | 5320    | 6440  |
| Nylon, Plastic                                  | 3             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 1500                             | 2400   | 3500   | 4900    | 5950  |
| Nylon, Plastic                                  | 4             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 1344                             | 2160   | 3125   | 4340    | 5460  |
| Nylon, Plastic                                  | 5             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 1200                             | 1920   | 2750   | 4060    | 4900  |
| Nylon, Plastic                                  | 8             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 1080                             | 1680   | 2375   | 3600    | 4340  |
| Nylon, Plastic                                  | 10            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 960                              | 1440   | 1875   | 3010    | 3920  |
| Nylon, Plastic                                  | 12            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 840                              | 1200   | 1625   | 2730    | 3570  |
| Nylon, Plastic                                  | 15            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 720                              | 960    | 1437.5 | 2520    | 3220  |
| Nylon, Plastic                                  | 18            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 600                              | 720    | 1187.5 | 2100    | 2800  |
| Nylon, Plastic                                  | 20            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 480                              | 600    | 1000   | 1680    | 2380  |
| Nylon, Plastic                                  | 25            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 384                              | 540    | 875    | 1330    | 1820  |
| Nylon, Plastic                                  | 30            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 300                              | 468    | 750    | 1092    | 1260  |
| Nylon, Plastic                                  | 35            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 264                              | 408    | 625    | 910     | 1120  |
| Nylon, Plastic                                  | 40            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 216                              | 348    | 500    | 770     | 980   |
| Nylon, Plastic                                  | 45            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 192                              | 300    | 425    | 672     | 882   |

| APW waterjet cutting speed reference (mm / min) |               |                      |                |                 |              |                                  |      |        |         |       |
|---|---------------|----------------------|----------------|-----------------|--------------|----------------------------------|------|--------|---------|-------|
| Nylon / Plastic / Rubber / Leather / Foam       |               |                      |                |                 |              |                                  |      |        |         |       |
| Material  | thickness(mm) | Intensifier Type     | Pressure (MPa) | Nozzle Dia (mm) | Orifice (mm) | cutting finish quality(mm / Min) |      |        |         |       |
|   |               |                      |                |                 |              | excellent                        | Good | fine   | average | poor  |
| Nylon, Plastic                                  | 50            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 168                              | 252  | 350    | 574     | 770   |
| Nylon, Plastic                                  | 60            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 144                              | 192  | 287.5  | 462     | 616   |
| Nylon, Plastic                                  | 70            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 120                              | 174  | 237.5  | 336     | 532   |
| Nylon, Plastic                                  | 80            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 96                               | 138  | 187.5  | 294     | 448   |
| Nylon, Plastic                                  | 90            | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 78                               | 108  | 150    | 266     | 364   |
| Nylon, Plastic                                  | 100           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 60                               | 93.6 | 131.25 | 238     | 306.6 |
| Nylon, Plastic                                  | 110           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 48                               | 81.6 | 98.75  | 168     | 252   |
| Nylon, Plastic                                  | 120           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 36                               | 54   | 81.25  | 126     | 210   |
| Nylon, Plastic                                  | 130           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 30                               | 39.6 | 56.25  | 98      | 168   |
| Nylon, Plastic                                  | 140           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 24                               | 34.8 | 47.5   | 82.6    | 126   |
| Nylon, Plastic                                  | 150           | A24W-75 / V6W-75     | 413            | 1.27            | 0.45         | 18                               | 26.4 | 37.5   | 70      | 98    |
| rubber  | 2             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 3500                             | 4000 | 4500   | 5000    | 6000  |
| rubber  | 3             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 2550                             | 3100 | 3600   | 4150    | 5300  |
| rubber  | 4             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 2150                             | 2600 | 3100   | 3650    | 4300  |
| rubber  | 5             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1850                             | 2200 | 2600   | 3100    | 3550  |
| rubber  | 8             | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1450                             | 1800 | 2200   | 2650    | 3200  |
| rubber  | 10            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 1050                             | 1400 | 1700   | 2300    | 3850  |
| rubber  | 15            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 800                              | 1100 | 1350   | 1800    | 2350  |
| rubber  | 20            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 550                              | 750  | 1000   | 1350    | 1800  |
| rubber  | 25            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 430                              | 700  | 900    | 1150    | 1430  |
| rubber  | 30            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 300                              | 550  | 800    | 900     | 1030  |
| rubber  | 35            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 280                              | 480  | 700    | 800     | 900   |
| rubber  | 40            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 240                              | 430  | 600    | 690     | 780   |
| rubber  | 45            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 210                              | 400  | 510    | 620     | 720   |
| rubber  | 50            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 180                              | 350  | 430    | 530     | 620   |
| rubber  | 60            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 155                              | 260  | 370    | 430     | 510   |
| rubber  | 70            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 120                              | 190  | 290    | 340     | 420   |
| rubber  | 80            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 105                              | 170  | 240    | 300     | 340   |
| rubber  | 90            | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 90                               | 140  | 185    | 240     | 290   |
| rubber  | 100           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 65                               | 99   | 110    | 215     | 235   |
| rubber  | 110           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 54                               | 79   | 100    | 170     | 215   |
| rubber  | 120           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 42                               | 63   | 88     | 140     | 170   |
| rubber  | 130           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 32                               | 45   | 65     | 85      | 145   |
| rubber  | 140           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 23                               | 35   | 50     | 70      | 115   |
| rubber  | 150           | A15-B / A15+B / A22S | 413            | 1.02            | 0.33         | 19                               | 29   | 36     | 55      | 80    |
| rubber  | 2             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 4025                             | 4600 | 5175   | 6500    | 7800  |
| rubber  | 3             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2932.5                           | 3565 | 4140   | 5395    | 6890  |
| rubber  | 4             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2472.5                           | 2990 | 3565   | 4745    | 5590  |
| rubber  | 5             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 2127.5                           | 2530 | 2990   | 4030    | 4615  |
| rubber  | 8             | A24W-45 / V6-45      | 413            | 1.14            | 0.4          | 1667.5                           | 2070 | 2530   | 3445    | 4160  |

| APW waterjet cutting speed reference (mm / min) |               |                  |                |                 |              |                                  |        |        |         |       |
|---|---------------|------------------|----------------|-----------------|--------------|----------------------------------|--------|--------|---------|-------|
| Nylon / Plastic / Rubber / Leather / Foam       |               |                  |                |                 |              |                                  |        |        |         |       |
| Material  | thickness(mm) | Intensifier Type | Pressure (MPa) | Nozzle Dia (mm) | Orifice (mm) | cutting finish quality(mm / Min) |        |        |         |       |
|   |               |                  |                |                 |              | excellent                        | Good   | fine   | average | poor  |
| rubber  | 10            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 1207.5                           | 1610   | 1955   | 2990    | 5005  |
| rubber  | 15            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 920                              | 1265   | 1552.5 | 2340    | 3055  |
| rubber  | 20            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 632.5                            | 862.5  | 1150   | 1755    | 2340  |
| rubber  | 25            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 494.5                            | 805    | 1035   | 1495    | 1859  |
| rubber  | 30            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 345                              | 632.5  | 920    | 1170    | 1339  |
| rubber  | 35            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 322                              | 552    | 805    | 1040    | 1170  |
| rubber  | 40            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 276                              | 494.5  | 690    | 897     | 1014  |
| rubber  | 45            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 241.5                            | 460    | 586.5  | 806     | 936   |
| rubber  | 50            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 207                              | 402.5  | 494.5  | 689     | 806   |
| rubber  | 60            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 178.25                           | 299    | 425.5  | 559     | 663   |
| rubber  | 70            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 138                              | 218.5  | 333.5  | 442     | 546   |
| rubber  | 80            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 120.75                           | 195.5  | 276    | 390     | 442   |
| rubber  | 90            | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 103.5                            | 161    | 212.75 | 312     | 377   |
| rubber  | 100           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 74.75                            | 113.85 | 126.5  | 279.5   | 305.5 |
| rubber  | 110           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 62.1                             | 90.85  | 115    | 221     | 279.5 |
| rubber  | 120           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 48.3                             | 72.45  | 101.2  | 182     | 221   |
| rubber  | 130           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 36.8                             | 51.75  | 74.75  | 110.5   | 188.5 |
| rubber  | 140           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 26.45                            | 40.25  | 57.5   | 91      | 149.5 |
| rubber  | 150           | A24W-45 / V6-45  | 413            | 1.14            | 0.4          | 21.85                            | 33.35  | 41.4   | 71.5    | 104   |
| rubber  | 2             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 4200                             | 4800   | 5625   | 7000    | 8400  |
| rubber  | 3             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 3060                             | 3720   | 4500   | 5810    | 7420  |
| rubber  | 4             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 2580                             | 3120   | 3875   | 5110    | 6020  |
| rubber  | 5             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 2220                             | 2640   | 3250   | 4340    | 4970  |
| rubber  | 8             | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 1740                             | 2160   | 2750   | 3710    | 4480  |
| rubber  | 10            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 1260                             | 1680   | 2125   | 3220    | 5390  |
| rubber  | 15            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 960                              | 1320   | 1687.5 | 2520    | 3290  |
| rubber  | 20            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 660                              | 900    | 1250   | 1890    | 2520  |
| rubber  | 25            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 516                              | 840    | 1125   | 1610    | 2002  |
| rubber  | 30            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 360                              | 660    | 1000   | 1260    | 1442  |
| rubber  | 35            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 336                              | 576    | 875    | 1120    | 1260  |
| rubber  | 40            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 288                              | 516    | 750    | 966     | 1092  |
| rubber  | 45            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 252                              | 480    | 637.5  | 868     | 1008  |
| rubber  | 50            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 216                              | 420    | 537.5  | 742     | 868   |
| rubber  | 60            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 186                              | 312    | 462.5  | 602     | 714   |
| rubber  | 70            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 144                              | 228    | 362.5  | 476     | 588   |
| rubber  | 80            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 126                              | 204    | 300    | 420     | 476   |
| rubber  | 90            | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 108                              | 168    | 231.25 | 336     | 406   |
| rubber  | 100           | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 78                               | 118.8  | 137.5  | 301     | 329   |
| rubber  | 110           | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 64.8                             | 94.8   | 125    | 238     | 301   |
| rubber  | 120           | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 50.4                             | 75.6   | 110    | 196     | 238   |

| <b>APW waterjet cutting speed reference (mm / min)</b><br><b>Nylon / Plastic / Rubber / Leather / Foam</b> |               |                  |                |                 |              |                                  |      |       |         |      |
|--|---------------|------------------|----------------|-----------------|--------------|----------------------------------|------|-------|---------|------|
| Material   | thickness(mm) | Intensifier Type | Pressure (MPa) | Nozzle Dia (mm) | Orifice (mm) | cutting finish quality(mm / Min) |      |       |         |      |
|  |               |                  |                |                 |              | excellent                        | Good | fine  | average | poor |
| rubber   | 130           | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 38.4                             | 54   | 81.25 | 119     | 203  |
| rubber   | 140           | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 27.6                             | 42   | 62.5  | 98      | 161  |
| rubber   | 150           | A24W-75 / V6W-75 | 413            | 1.27            | 0.45         | 22.8                             | 34.8 | 45    | 77      | 112  |