

super fast + and Fly Piercing

Specification:

- Enable Fly Piercing(123)
- Globals-lead-up set to Sync. (45)
- Globals-Advancd(6) -execution
 mode-superfast(7)
- lead-in speed lower than 2000



P ENTALASER 奔腾激光

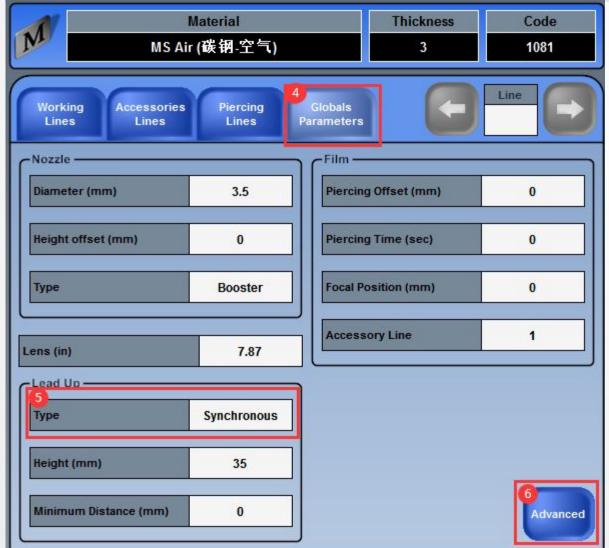
LASER CUTTING & WELDING EXPERT

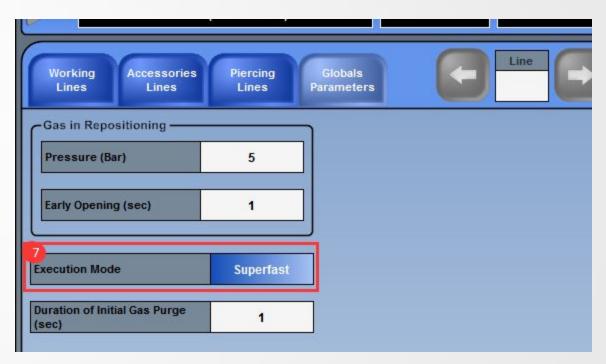












LASER CUTTING & WELDING EXPERT







Super Fast+ Attention:

- Lead-in line must longer then 3mm, too long
 is not suggested, will increase the cutting
 time, we recommend to 3mm-4mm (so
 contrminal cutting is not recommended to
 use Super Fast+)
- About Piercing Config. The piercing offset should set to shorter then 9mm, Piercing time less than 0.1 Sec., We usually set the offset to 6mm, Piercing time to 0.01 Sec, For thick material, we could increase the piercing time, but less than 0.1 Sec., If the lead-in line of small hole is shorter than 3mm, we suggest offset lower than 6mm. Recommend use high pulse to piercing



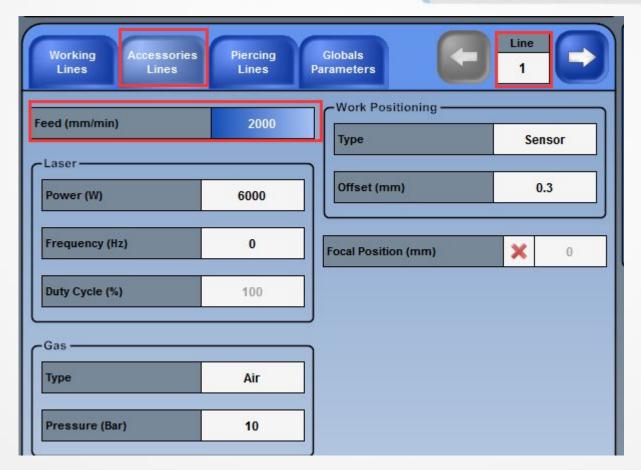












Lead-in CFG:1st layer of Accessories



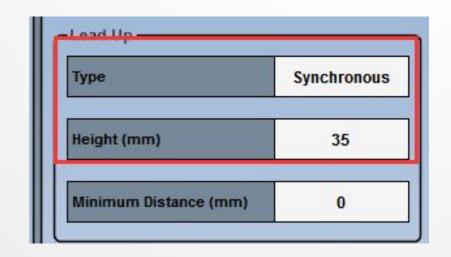






Attentions:

- Nozzle lowest offset;Booster O. 3mm, Normal0. 5mm
- Syncronize Hight recommend to 40





Attentions:

Cutting Gas, Piercing
 Gas, Repositioning
 GAS, lead-in cutting Gas
 should set to be same

