

Abrasivejet Cutting Parameters

Material	Thick/ inch	Orifice Dia.	Nozzle Dia.	Press. ksi	Abras. lb/min	Feed Rate (inches/min)				
						Quality Level				
						1	2	3	4	5
A36 Steel	0.25	0.010	0.030	55	0.6	19.3	12.1	8.8	6.9	5.7
A36 Steel	0.375	0.010	0.030	55	0.6	12.1	7.2	5.2	4.0	3.3
A36 Steel	0.5	0.010	0.030	55	0.6	8.7	5.0	3.5	2.7	2.2
A36 Steel	0.75	0.010	0.030	55	0.6	5.4	3.0	2.1	1.6	1.3
A36 Steel	1	0.010	0.030	55	0.6	3.9	2.1	1.4	1.1	0.9
A36 Steel	1.5	0.010	0.030	55	0.6	2.5	1.2	0.8	0.6	0.5
A36 Steel	2	0.010	0.030	55	0.6	1.8	0.9	0.6	0.5	0.4
A36 Steel	0.25	0.013	0.040	55	1	25.8	16.2	11.8	9.2	7.6
A36 Steel	0.375	0.013	0.040	55	1	16.1	9.7	6.9	5.4	4.4
A36 Steel	0.5	0.013	0.040	55	1	11.6	6.7	4.7	3.6	3.0
A36 Steel	0.75	0.013	0.040	55	1	7.2	4.0	2.8	2.1	1.7
A36 Steel	1	0.013	0.040	55	1	5.2	2.8	1.9	1.4	1.2
A36 Steel	1.5	0.013	0.040	55	1	3.3	1.7	1.1	0.9	0.7
A36 Steel	2	0.013	0.040	55	1	2.4	1.2	0.8	0.6	0.5
A36 Steel	0.25	0.015	0.045	55	1.5	32.4	20.1	14.6	11.5	9.5
A36 Steel	0.375	0.015	0.045	55	1.5	20.1	12.0	8.6	6.7	5.5
A36 Steel	0.5	0.015	0.045	55	1.5	14.4	8.3	5.9	4.5	3.7
A36 Steel	0.75	0.015	0.045	55	1.5	9.0	5.0	3.4	2.6	2.1
A36 Steel	1	0.015	0.045	55	1.5	6.5	3.4	2.3	1.8	1.5
A36 Steel	1.5	0.015	0.045	55	1.5	4.1	2.1	1.4	1.0	0.8
A36 Steel	2	0.015	0.045	55	1.5	2.9	1.4	1.0	0.7	0.6
304 SST	0.25	0.010	0.030	55	0.6	17.4	10.9	7.9	6.2	5.1
304 SST	0.375	0.010	0.030	55	0.6	10.9	6.5	4.2	3.6	3.0
304 SST	0.5	0.010	0.030	55	0.6	7.8	4.5	3.2	2.5	2.0
304 SST	0.75	0.010	0.030	55	0.6	4.9	2.7	1.9	1.4	1.2
304 SST	1	0.010	0.030	55	0.6	3.5	1.9	1.3	1.0	0.8
304 SST	1.5	0.010	0.030	55	0.6	2.2	1.1	0.8	0.6	0.5
304 SST	2	0.010	0.030	55	0.6	1.5	0.8	0.5	0.4	0.3
304 SST	0.25	0.013	0.040	55	1	23.2	14.5	10.6	8.3	6.9
304 SST	0.375	0.013	0.040	55	1	14.5	8.7	6.2	4.8	4.0
304 SST	0.5	0.013	0.040	55	1	10.4	6.0	4.3	3.3	2.7
304 SST	0.75	0.013	0.040	55	1	6.5	3.6	2.5	1.9	1.5
304 SST	1	0.013	0.040	55	1	4.7	2.5	1.7	1.3	1.1
304 SST	1.5	0.013	0.040	55	1	2.9	1.5	1.0	0.8	0.6
304 SST	2	0.013	0.040	55	1	2.1	1.1	0.7	0.5	0.4
304 SST	0.25	0.015	0.045	55	1.5	28.9	18.1	13.2	10.4	8.5
304 SST	0.375	0.015	0.045	55	1.5	18.1	10.8	7.7	6.0	4.9
304 SST	0.5	0.015	0.045	55	1.5	13.0	7.5	5.3	4.1	3.3
304 SST	0.75	0.015	0.045	55	1.5	8.1	4.5	3.1	2.4	1.9
304 SST	1	0.015	0.045	55	1.5	5.8	3.1	2.1	1.6	1.3
304 SST	1.5	0.015	0.045	55	1.5	3.7	1.9	1.2	0.9	0.8
304 SST	2	0.015	0.045	55	1.5	2.6	1.3	0.9	0.7	0.5

Quality Level 1 is a separation cut.

Quality Level 3 to 4 is a quality cut.

Quality Level 5 is high quality cut.

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						Quality Level				
						1	2	3	4	5
6061T6 Al	0.25	0.010	0.030	55	0.6	53.9	33.8	24.6	19.3	15.9
6061T6 Al	0.375	0.010	0.030	55	0.6	33.7	20.2	14.4	11.2	9.2
6061T6 Al	0.5	0.010	0.030	55	0.6	24.2	14.0	9.8	7.6	6.2
6061T6 Al	0.75	0.010	0.030	55	0.6	15.1	8.3	5.7	4.4	3.5
6061T6 Al	1	0.010	0.030	55	0.6	10.9	5.7	3.9	3.0	2.4
6061T6 Al	1.5	0.010	0.030	55	0.6	6.8	3.4	2.3	1.7	1.4
6061T6 Al	2	0.010	0.030	55	0.6	4.9	2.4	1.6	1.2	1.0
6061T6 Al	0.25	0.013	0.040	55	1	72.2	45.1	33.0	25.8	21.3
6061T6 Al	0.375	0.013	0.040	55	1	45.8	27.0	19.3	15.0	12.3
6061T6 Al	0.5	0.013	0.040	55	1	32.3	18.7	13.1	10.1	8.3
6061T6 Al	0.75	0.013	0.040	55	1	20.2	11.1	7.6	5.8	4.7
6061T6 Al	1	0.013	0.040	55	1	14.5	7.7	5.2	4.0	3.2
6061T6 Al	1.5	0.013	0.040	55	1	9.1	4.6	3.1	2.3	1.9
6061T6 Al	2	0.013	0.040	55	1	6.5	3.2	2.1	1.6	1.3
6061T6 Al	0.25	0.015	0.045	55	1.5	90.0	56.2	40.9	32.1	26.5
6061T6 Al	0.375	0.015	0.045	55	1.5	56.2	33.6	24.0	18.7	15.3
6061T6 Al	0.5	0.015	0.045	55	1.5	40.3	23.2	16.3	12.6	10.3
6061T6 Al	0.75	0.015	0.045	55	1.5	25.2	13.8	9.5	7.3	5.9
6061T6 Al	1	0.015	0.045	55	1.5	18.0	9.5	6.5	4.9	4.0
6061T6 Al	1.5	0.015	0.045	55	1.5	11.3	5.7	3.8	2.9	2.3
6061T6 Al	2	0.015	0.045	55	1.5	8.1	4.0	2.6	2.0	1.6
Copper	0.25	0.010	0.030	55	0.6	25.1	15.2	11.4	9.0	7.4
Copper	0.375	0.010	0.030	55	0.6	15.7	9.4	6.7	5.2	4.3
Copper	0.5	0.010	0.030	55	0.6	11.2	6.5	4.6	3.5	2.9
Copper	0.75	0.010	0.030	55	0.6	7.0	3.9	2.7	2.1	1.7
Copper	1	0.010	0.030	55	0.6	5.1	2.7	1.8	1.4	1.1
Copper	1.5	0.010	0.030	55	0.6	3.2	1.6	1.1	0.8	0.7
Copper	2	0.010	0.030	55	0.6	2.3	1.1	0.8	0.6	0.5
Copper	0.25	0.013	0.040	55	1	33.5	21.0	15.3	12.0	9.9
Copper	0.375	0.013	0.040	55	1	21.0	13.6	9.0	7.0	5.8
Copper	0.5	0.013	0.040	55	1	15.0	8.7	6.1	4.7	3.9
Copper	0.75	0.013	0.040	55	1	9.4	5.2	3.6	2.7	2.2
Copper	1	0.013	0.040	55	1	6.8	3.6	2.4	1.9	1.5
Copper	1.5	0.013	0.040	55	1	4.2	2.1	1.4	1.1	0.9
Copper	2	0.013	0.040	55	1	3.0	1.5	1.0	0.8	0.6
Copper	0.25	0.015	0.045	55	1.5	41.8	26.1	19.0	15.0	12.3
Copper	0.375	0.015	0.045	55	1.5	26.1	15.6	11.2	8.7	7.1
Copper	0.5	0.015	0.045	55	1.5	18.2	10.8	7.6	5.9	4.8
Copper	0.75	0.015	0.045	55	1.5	11.7	6.4	4.4	3.4	2.7
Copper	1	0.015	0.045	55	1.5	8.4	4.4	3.0	2.3	1.9
Copper	1.5	0.015	0.045	55	1.5	5.3	2.7	1.8	1.3	1.1
Copper	2	0.015	0.045	55	1.5	3.8	1.9	1.2	0.9	0.8

Quality Level 1 is a separation cut.
 Quality Level 3 to 4 is a quality cut.
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