



SHANDONG WAMIT CNC TECHNOLOGY CO.LTD

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WAMIT WATERJET CUTTING SPEED

2019-12-19

Material	Thickness (mm)	Cutting Speed of direct drive pump (mm/min)	Cutting Speed of 420MPa (mm/min)
Marble	25	1000	800
	30	800	600
Microcrystal stone	16	1200	900
Ceramic tile	12	2000	1500
	14	1400	900
Glass	5	2000	1600
	8	1800	1400
	10	1500	1100
	12	1200	900

	14	1000	700
Carbon Steel plate	10	330	270
	12	280	220
	14	240	180
	16	200	140
	20	170	110
	22	140	85
	Aluminum	12	800
30		200	160

1. The cutting speed is the speed of cutting off the material, if you need the cutting edge is smooth, please make the speed slower.
2. The above data is for reference.
3. In our experience, when cutting 20mm granite, we usually use 350mm/min speed, and you can cut 21m one hour, if work 8 hours per day, the one day cutting capacity is 168m. In fact, our machine can work longer time according to customer's demand.

CUTTING COST (420MPA)

ITEM		NAME	PRICE (USD)	LIFE	COST PER HOUR (USD)
POWER	1	water		22L/hour	0.1(this depend on your country water cost)

	2	electric		22 degree/hour	3(this depend on your country electricity cost)	
	3	abrasive	190.00 /mt	20-25kg/H	3.8-4.75	
WEAR PARTS	4	Orifice(imported)	10.00 /per	50H	0.2	
	5	nozzle (imported)	100.00 /per	150-200H	0.67-0.5	
	6	on-off valve assemblies(one set)	70.00/set	200H	0.35	
	7	cutting head	75.00/per	500H	0.15	
	8	High pressure water seal(1 set) (imported)	100.00/set	200H	0.5	
	9	High pressure assemblies	12.00/set	200H	0.06	
	10	Low pressure valve pad	12.00/set	200H	0.06	
	11	Low-pressure service package	70.00/set	200H	0.35	
	12	Other (labor cost, factory rent cost and others) this is depend on your country's labor cost and workhouse cost				1
	USD10.07/H, but if consider cutting time and cutting efficiency, 420Mpa pump cost will be lower. And now we have fast speed function which can make the machine moving speed to 20-30m/min, the cutting cost will be lower					