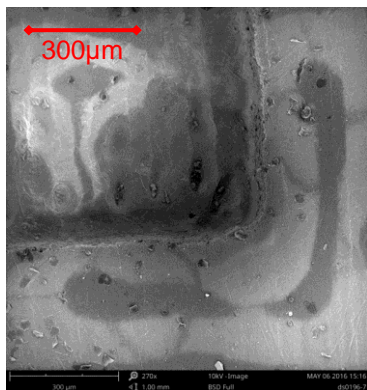
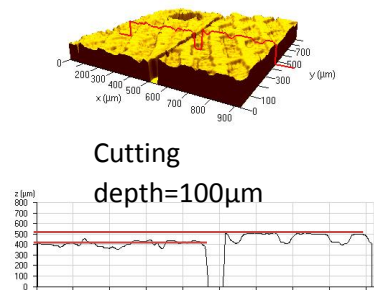
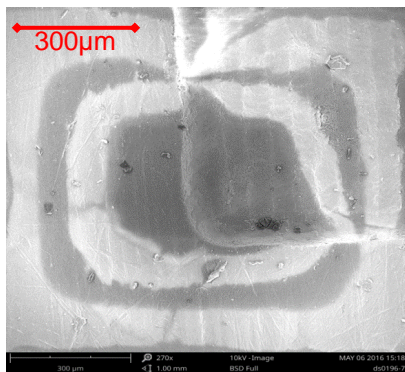
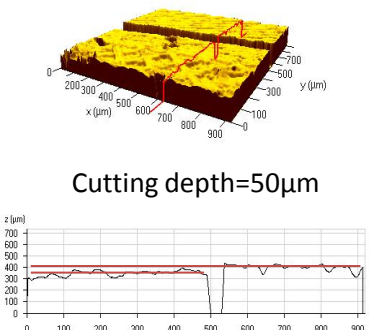


(a) Power: 25%, cutting speed: 10mm/s, pulse width: 3μs, frequency: 6900Hz, **passes:100**



(a) Power: 25%, cutting speed: 10mm/s, pulse width: 3μs, frequency: 6900Hz, **passes:85**



(a) Power: 25%, cutting speed: 10mm/s, pulse width: 3μs, frequency: 6900Hz, **passes:70**