

### 3.04.3D Footplate Lasercutter Settings

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Manufacturing instruction	GJM Tuijthof	3D Footplate
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### Document change history

BY	DATE	VERSION	SUMMARY OF CHANGES
E. Masih	02-09-2024	01	Text spelling check, update images
GJM Tuijthof	24-08-2025	01	Added front page, optimized layout, changed telescopic clamp
GJM Tuijthof	10-09-2025	01	Added parts to be made



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**WARNING: THIS PRODUCT IS TO BE MANUFACTURED BY QUALIFIED AND TRAINED PROFESSIONALS**

# Laser cutting Protocol

## Material

Polypropylene (PP) 6mm. See 3.03.3D Footplate Bill of Materials v1.2, worksheet 'Custom made' for all parts to be lasercut.

## Lasercutter and settings

Laser cutter Trotec Speedy 300 (<https://www.troteclaser.com/static/pdf/speedy-300/operating-manual-Speedy-300-8066-en-us.pdf>). Lens: red 1.5inch

Polypropylene (PP) 6mm is a difficult material to laser cut, because the settings to cut all the way through cause the material to "melt". It has been experimentally determined that PP should be cut with the 1-pass-twice method. The settings for the first and second round are slightly different.

### Settings first round

Power	90%
Speed	0.09
PPI/Hz	Auto
Auto	On
Passes	1
Air Assist	On
Z Offset	-
Direction	-
Advanced	-



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### 3.04.3D Footplate Lasercutter Settings

#### Settings second round

Power	85%
Speed	0.09
PPI/Hz	Auto
Auto	On
Passes	1
Air Assist	On
Z Offset	-
Direction	-
Advanced	-



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