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PARAMETERS FOR 100WAT LASER TUBE

suggested paramters for some materials.(the parameters might be a bit different according to different machines

CUTTING

Laser head type: standard laser head

materials	thickness	speed	max power	power in corners	
mdf	2.5	50	90	90	
acr	2.5	40	90	90	
acr	5.0	18	90	90	
acr	10.0	5	90	90	
acr	20.0	1	90	90	
foam	17.0	8	90	90	
plywood	2.0	100	70	70	
plywood	4.5	35	90	90	
cardboard	1.9	200	75	75	
non-dust cloth	0.4	300	90	90	
leather	1.5	65	90	90	
rubber	4.0	8	90	90	
double color boards	1.5	60	90	90	
bamboo	7.0	15	90	90	
paper	0.1	300	30	30	
Kraft paper	0.5	300	60	60	
cherry wood	15.0	4	90	90	
plastics	/	/	90	90	
glass	/	/	/	/	
granite	/	/	/	/	
marble	/	/	/	/	
ceramic cup	/	/	/	/	
rostone	/	/	/	/	
anodized aluminum	/	/	/	/	
grip tape	/	/	/	/	

ENGRAVING

Laser head type: standard laser head

materials	thickness	speed	max power	min power	scan gap
MDF	/	500	20	/	0.08
acr	/	500	20	/	0.08
bamboo	/	500	20	/	0.08
plywood	/	500	20	/	0.08

cardboard	/	500	20	/	0.08
paper	/	500	12	/	0.08
painted aluminum	/	500	30	/	0.08
cherry wood	/	500	25	/	0.08
anodized aluminum	/	500	30	/	0.08
plastaic	/	500	20	/	0.08
glass	/	500	25	/	0.08
Kraft paper	/	500	20	/	0.08
leather	/	500	20	/	0.08
cloth	/	500	15	/	0.08
rubber	/	500	60	10	0.06
metal	/	500	/	/	0.08
double color boards	/	500	18	/	0.08
granite	/	500	25	/	0.08
marble	/	500	25	/	0.08
ceramic cup	/	500	25	/	0.08
rostone	/	500	25	/	0.08
grip tape	/	500	20	/	0.08
foam	/	/	/	/	/

CUTTING

Laser head type: 4 inches laser head

materials	thickness	speed	max power	power in corners	
mdf	2.5	35	90	60	
acr	10.0	4.5	90	60	
acr	20.0	1	90	60	
foam	17.0	10	90	60	
plywood	4.5	35	90	60	
plywood	11.0	5	90	60	
cardboard	6.2	40	90	60	
non-dust cloth	0.4	300	90	60	
leather	1.5	35	90	60	
rubber	4.0	7	90	60	
cherry wood	12.0	7	90	60	
peach wood	19.0	4	90	60	
double color boards	1.5	45	90	60	
bamboo	7.0	13	90	60	
paper	0.1	300	30	20	
Kraft paper	0.5	300	70	45	
plastics	/	/	/	/	
granite	/	/	/	/	
marble	/	/	/	/	
ceramic cup	/	/	/	/	
rostone	/	/	/	/	
anodized aluminum	/	/	/	/	
grip tape	/	/	/	/	

ENGRAVING

Laser head type: high resolution laser head

materials	thickness	speed	max power	min power	scan gap
MDF	/	400	15	/	0.06
acr	/	500	18	/	0.04
bamboo	/	500	16	/	0.06
plywood	/	400	15	/	0.06
cardboard	/	500	14	/	0.05
painted aluminum	/	400	20	/	0.05
cherry wood	/	400	15	/	0.06
anodized aluminum	/	500	16	/	0.06
plastaic	/	400	15	/	0.06
glass	/	500	30	/	0.06
Kraft paper	/	500	24	/	0.06
leather	/	500	15	/	0.06
cloth	/	500	18	/	0.06
rubber	/	300	50	10	0.06
metal	/	500	/	/	0.06
double color boards	/	500	15	/	0.06
granite	/	500	30	/	0.06
marble	/	500	30	/	0.06
ceramic cup	/	500	30	/	0.06
rostone	/	500	30	/	0.06
grip tape	/	500	20	/	0.06
foam	/	/	/	/	/

Cutting and Engraving a variety of plastaic

Material	Abbreviation		Trade name	
Polyamide	PA		Kevlar®, Nylon®	
Polyoxymethylene	POM		Delrin®	
Polyester	PES		Thermolite®, Polarguard®	
Polyethylene terephthalate	PET		Mylar®	
Polyimide	PI		Kapton®	
Polystyrene	PS			
Polymethyl-methacrylate	PMMA		Plexiglas®	
Polycarbonate	PC		Lexan®, Makrolon®	
Polypropylene	PP			
Acrylonitrile butadiene styrene co-polymerisate	ABS			

image invert	
no	
yes	
no	
yes	
yes	

	image dither
	0.25
	0.2
	0.25
	0.25
	0.25