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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	30	60	60
acr	3.0	25	60	60
acr	5.0	12	60	60
acr	10.0	4	60	60
acr	20.0	1	60	60
foam	17.0	8	60	60
plywood	2.0	180	60	60
plywood	4.5	32	60	60
cardboard	2.0	150	50	50
non-dust cloth	0.4	300	60	60
leather	1.5	60	60	60
rubber	4.0	8	60	60
double color boards	1.5	55	60	60
bamboo	7.0	13	60	60
paper	0.1	300	18	18
Kraft paper	0.5	300	40	40
cherry wood	15.0	3	60	60
plastics	/	/	/	/
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	14	/	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	40	15	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	30	60	60	
acr	10.0	4	60	60	
acr	20.0	1	60	60	
foam	17.0	10	60	60	
plywood	4.5	32	60	60	
cardboard	6.0	35	60	60	
non-dust cloth	0.4	300	60	60	
leather	1.5	32	60	60	
rubber	4.0	6	60	60	
cherry wood	12.0	6	60	60	
peach wood	20.0	3.5	60	60	
double color boards	1.5	40	60	60	
bamboo	7.0	15	60	60	
paper	0.1	300	20	20	
Kraft paper	0.5	300	45	45	
plastics	/	/	60	60	
glass	/	/	/	/	
granite	/	/	/	/	
marble	/	/	/	/	
ceramic cup	/	/	/	/	
rostone	/	/	/	/	
anodized aluminum	/	/	/	/	

grip tape	/	/	/	/	
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ENGRAVING

Laser head type: high resolution laser head

materials	thickness	speed	max power	min power	scan gap
MDF	/	400	12	/	0.06
acr	/	500	15	/	0.04
bamboo	/	500	14	/	0.06
plywood	/	400	13	/	0.06
cardboard	/	500	12	/	0.05
painted aluminum	/	400	18	/	0.05
cherry wood	/	400	13	/	0.06
anodized aluminum	/	500	14	/	0.06
plastaic	/	400	13	/	0.06
glass	/	500	25	/	0.06
Kraft paper	/	500	20	/	0.06
leather	/	500	13	/	0.06
cloth	/	500	15	/	0.06
rubber	/	300	40	15	0.06
metal	/	500	/	/	0.06
double color boards	/	500	13	/	0.06
granite	/	500	25	/	0.06
marble	/	500	25	/	0.06
ceramic cup	/	500	25	/	0.06
rostone	/	500	25	/	0.06
grip tape	/	500	18	/	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	