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PARAMETERS FOR 40WAT 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	2.3	3	90	90
acr	5.0	5	60	60
acr	10.0	1	60	60
foam	17.0	5	40	40
plywood	2.0	35	60	60
plywood	4.5	11	60	60
cardboard	6.0	15	60	60
non-dust cloth	0.2	300	50	50
leather	1.5	6	60	60
rubber	4.0	2.0	80	80
double color boards	1.5	18	60	60
bamboo	/	/	50	50
paper	0.1	300	17	17
Kraft paper	1.0	85	50	50
peach wood	5.0	9	80	80
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	25	/	0.08
acr	/	450	30	/	0.08
bamboo	/	500	30	/	0.08
plywood	/	500	35	/	0.08

cardboard	/	500	15	/	0.08
paper	/	500	13	/	0.08
painted aluminum	/	450	35	/	0.08
cherry wood	/	500	25	/	0.08
anodized aluminum	/	400	30	/	0.08
plastaic	/	500	17	/	0.08
glass	/	200	20	/	0.08
Kraft paper	/	500	20	/	0.08
leather	/	500	20	/	0.08
cloth	/	500	18	/	0.08
rubber	/	300	40	15	0.06
metal	/	500	/	/	0.08
double color boards	/	500	20	/	0.08
granite	/	500	30	/	0.08
marble	/	500	30	/	0.08
ceramic cup	/	500	30	/	0.08
rostone	/	500	30	/	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	2.3	3	90	90	
acr	5.0	6	60	60	
acr	10.0	2	60	60	
foam	17.0	6	60	60	
plywood	2.0	26	60	60	
plywood	4.5	11	60	60	
cardboard	3.0	13	60	60	
non-dust cloth	0.2	300	50	50	
leather	1.5	4	60	60	
rubber	4.5	2.0	80	80	
double color boards	1.5	16	60	60	
bamboo	6.7	2.5	60	60	
paper	0.1	300	20	20	
Kraft paper	1.0	85	50	50	
plastics	/	/	/	/	
glass	/	/	/	/	
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	12	/	0.06
acr	/	350	18	/	0.04
bamboo	/	400	15	/	0.06
plywood	/	400	18	/	0.06
cardboard	/	400	13	/	0.06
painted aluminum	/	400	18	/	0.05
cherry wood	/	500	15	/	0.06
anodized aluminum	/	500	20	/	0.05
plastaic	/	500	20	/	0.06
leather	/	500	15	/	0.06
cloth	/	500	17	/	0.06
rubber	/	500	50	15	0.06
double color boards	/	400	15	/	0.06
granite	/	500	28	/	0.06
marble	/	500	28	/	0.06
ceramic cup	/	500	28	/	0.06
rostone	/	500	28	/	0.06
grip tape	/	500	18	/	0.06

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			