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PARAMETERS FOR 130WAT 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	35	60	60	
mdf	3.8	15	60	60	
mdf	10.0	2	60	60	
acr	3.0	30	60	60	
acr	5.0	15	60	60	
acr	10.0	5	60	60	
acr	20.0	1.5	60	60	
foam	17.0	11	60	60	
plywood	2.0	140	40	40	
plywood	4.5	40	60	60	
plywood	7.5	13	60	60	
plywood	10.0	11	60	60	
cardboard	6.0	22	50	50	
non-dust cloth	0.4	250	60	60	
leather	1.5	80	60	60	
rubber	4.5	9	60	60	
double color boards	1.5	50	60	60	
bamboo	7.0	12	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	10.0	3	60	60	
acr	10.0	5	60	60	
acr	20.0	1.5	60	60	
foam	17.0	12	60	60	
plywood	10.0	12	60	60	
plywood	13.0	5	60	60	
plywood	15.0	5	80	80	
plywood	18.0	4	80	80	
rubber	4.0	10	60	60	
cherry wood	12.0	8	60	60	
cherry wood	15.0	5	60	60	
peach wood	20.0	4	60	60	
bamboo	7.0	15	60	60	
paper	0.1	300	20	20	
Kraft paper	0.5	300	45	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	10	/	0.06
acr	/	300	11	/	0.04
bamboo	/	500	10	/	0.06
plywood	/	500	10	/	0.06
cardboard	/	500	10	/	0.05
painted aluminum	/	500	15	/	0.06
cherry wood	/	500	10	/	0.06
anodized aluminum	/	500	10	/	0.05
plastaic	/	500	18	/	0.06
glass	/	500	25	/	0.06
Kraft paper	/	500	20	/	0.06
leather	/	500	13	/	0.06
cloth	/	500	15	/	0.06
rubber	/	450	35	15	0.06
metal	/	/	/	/	/
double color boards	/	500	11	/	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	

image invert	image dither
no	0.25
yes	0.2
no	0.25
yes	0.25
yes	0.25