

### 130-Watt Laser Parameters

#### CUTTING

<b>Laser head: Standard Head (2")</b>			
<b>Materials</b>	<b>Thickness (mm)</b>	<b>Speed (mm/s)</b>	<b>Max Power</b>
MDF	2.5	40	90
MDF	3.8	17	90
MDF	10.0	3	90
Acrylic	2.8	35	90
Acrylic	5.0	16	90
Acrylic	10.0	5	90
Acrylic	20.0	2	90
Foam	17.0	10	90
Plywood	2.0	150	60
Plywood	4.5	45	90
Plywood	7.5	15	90
Plywood	10.0	12	90
Cardboard	6.0	25	75
Cloth	0.4	300	90
Leather	1.5	90	90
Rubber	4.5	10	90
Double Color Boards	1.5	55	90
Bamboo	7.0	15	90
Paper	0.1	300	30
Kraft paper	0.5	300	60
Cherry Wood	15.0	4	90
Plastics	/	/	90
Glass	/	/	/
Granite	/	/	/
Marble	/	/	/
Ceramic Cup	/	/	/
Rostone	/	/	/
Anodized Aluminum	/	/	/
Grip Tape	/	/	/

#### ENGRAVING

<b>Laser head: Standard Head (2")</b>			
<b>Materials</b>	<b>Speed (mm/s)</b>	<b>Max Power</b>	<b>Interval (mm)</b>
MDF	500	20	0.08
Acrylic	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
Anodoized Aluminum	500	30	0.08
Plastic	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	50	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

## CUTTING

### Laser head: 4" Laser Head

Materials	Thickness (mm)	Speed (mm/s)	Max Power
MDF	10.0	3	90
Acrylic	10.0	5	90
Acrylic	20.0	1.5	90
Foam	17.0	12	90
Plywood	10.0	15	90
Plywood	13.0	6	90
Plywood	15.0	5	100
Plywood	18.0	4	100
Rubber	4.0	12	90
Cherry Wood	12.0	9	90
Cherry Wood	15.0	6	90
Peach Wood	20.0	4	90
Bamboo	7.0	16	90

## ENGRAVING

### Laser head: HR laser head

Materials	Speed (mm/s)	Max Power	Interval (mm)
MDF	400	12	0.06
Acrylic	300	13	0.04
Bamboo	500	12	0.06
Plywood	500	12	0.06
Cardboard	500	12	0.05
Painted Aluminum	500	18	0.06
Cherry Wood	500	12	0.06
Anodized Aluminum	500	12	0.05
Plastic	500	20	0.06
Glass	500	30	0.06
Kraft paper	500	22	0.06
Leather	500	15	0.06
Cloth	500	18	0.06
Rubber	450	15	0.06
Metal	/	/	/
Double Color Boards	500	13	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	22	0.06

### Cutting and Engraving a variety of plastic

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	

Please note: All materials are different. These are general suggestions and starting places