

TECH TIP

Laser Engraver Settings

We have provided some baseline settings for engraving and cutting various materials. Today's advanced laser systems provide crisp, clean quality and offer a consistency that is extraordinary.

However, each laser tube output varies slightly so the settings shown may need adjustment for your system. Clean laser optics also makes a difference in the transmitted laser energy. Take the time to maintain the lens and mirrors on your system to obtain repeatability.

When adjusting settings, a good rule is to adjust either the power or the speed. Having less variables will help to find the optimum settings faster. Also, keep the power setting as low as possible. Power settings that are too high can melt and distort many materials. All settings noted use the default resolution which is 500 or 600 depending on the make of your laser system.

A special note when using CerMark Metal Marking Solution: not all metals use the same speed setting. Metals that are thick will require more heat energy and a slower speed setting. Softer metals like aluminum and pewter also require more heat energy and a slower engraving speed setting. If the engraving washes off, slow the speed setting until the engraving bonds to the metal.

Engraving Settings - 35 Watt System

	Power	Speed
CerMark		
Metal Marking Solution	100	30
CerMark		
Tile Marking Solution	100	24
Alder Wood	100	65
Walnut Wood	100	60
Maple Wood	100	65
RowMarkLaserMAX/LASERmag	40	100
RowMarkLaserLIGHTS/FlexiBrass	35	100
Acrylic Cast		
Awards & Sheet	45	100
Painted Acrylic Awards and Mirrored Sheet	50	100
Marble – Soft	25	100
Marble – Hard	75	80
AlumaMark	35	100
Coated Metals	80	100
Glass/Crystal	100	30
Onyx	25	100
Premium Laser Rubber	100	20
Delrin	100	30

Cutting Settings - 35 Watt System

	Power	Speed
Alder Wood -1/8	90	20
Wood Thins	5	20
Rowmark LaserMAX/LASERmag	45	20
Rowmark LaserLIGHTS/FlexiBrass	30	20
Acrylic Cast/Extruded – 1/8 in.	100	10
Stencil	20	20
Laser Foil	5	20
Shell Laminate	25	20
Premium Laser Rubber	100	10



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