

1. Laser power should be controled around 95% of the total power. Such as when use 100W laser tube, set the working laser as 100W*95%

2. The cutting thickness and speed are just the approximate datas. There are may have measurement error actually. So, the most suitable cutting thickness and speed still need to be adjust by users themselves according to their own materials

Material	Thickness	25W		40W		60W		80W		100W		130W		150W		180W		200W	
		Max Spe	Suitable	Max Spe	Suitable	Max Spe	Suitable	Max Spe	Suitable	Max Spe	Suitable	Max Spe	Suitable	Max Spe	Suitable	Max Spe	Suitable	Max Spe	Suitable
Acrylic	3mm	8mm/s	5mm/s	15mm/s	10mm/s	20mm/s	15mm/s	25mm/s	20mm/s	30mm/s	25mm/s	35mm/s	30mm/s	40mm/s	35mm/s	45mm/s	40mm/s	55mm/s	50mm/s
	5mm	4	2	8	5	10	7	12	8	15	10	17	12	21	15	25	18	30	25
	8mm			4	2	5	3	9	5	10	6	12	8	15	10	18	12	25	15
	10mm					4	2	6	3	7	4	8	5	14	7	16	10	20	13
	15mm					2	0,8	3	1,5	4	2	5	3	7	4	8	6	11	8
	20mm					1	0,3	1,5	0,5	2	0,7	3	1	4	1,5	5	2	7	4
	25mm							0,5	0,2	0,8	0,3	1	0,4	1,8	0,8	2,5	1,2	5	3
	30mm									0,3	0,1	0,5	0,3	0,8	0,5	1,3	0,8	3	1,5
	35mm													0,4	0,1	0,6	0,3	1	0,7
	40mm															0,2	0,1	0,5	0,3

Attention: when cutting acrylic, should be careful for air flow controlling: for material surface, with small air flow and keep a little slant in order to keep the cutting smoothness; keep some air flow beside of the material, to avoid catching fire

Die Board	15mm											4	3	6	4,5	8	6	11	9
	18mm											2	1,2	4	2,5	5	3,5	8	6
	20mm													2,5	1,8	3,5	2,5	6	4,5

Attention: Suggest choose 100mm (focal length) focus lens: with longer focal length, can get higher precision

MDF	3mm	5	3,5	9	7	15	12	20	15	23	18	25	20	30	25	33	28	40	35
	5mm			5	3,5	10	8	13	10	15	13	18	15	21	18	25	21	30	25
	10mm							5	3,5	7	5	9	6,5	12	9	14	11	18	15
	15mm											4	3	7	5,5	9	7	12	10
	18mm															5	4	8	7

Attention: When cutting MDF,should control air flow well, big air flow, higher cutting speed

Wood	3mm			10	8	15	12	20	18	25	22	30	28	35	33	40	37	50	48
	5mm					10	8	15	10	20	18	25	22	30	28	35	32	45	42
	10mm							8	6	12	10	15	13	20	17	25	20	35	30
	15mm									8	5	11	8	15	13	18	15	25	22

Same with MDF, When cutting Wood,should control air flow well, big air flow, higher cutting speed

Leather (single)		6	5	15	12	20	17	25	20	30	25	40	35	45	40	50	45	60	55
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Attention: When cut leather, we suggest use 50mm (focal lenth) focus lens, to match with 60W-100W laser power and small air compressor

Cloth	2-3mm	25	20	40	38	60	58	100	98	200	195	300	295	400	395	500	495	600	595
	3mm	12	10	30	27	40	38	50	48	60	58	70	68	80	78	90	88	110	108
	4mm			25	20	35	30	45	40	55	50	65	63	75	73	85	80	100	98

Attention: When cut Cloth, we suggest use 50mm (focal lenth) focus lens, to match with 60W-100W laser power and small air compressor, and keep laser power around 50%-70%.

Dual-color sheet	2mm	10	7	15	13	25	20	35	30	40	35	45	40	55	50	65	60	80	75
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Paper	Single	50	40	80	40	120	40	150	40	250	40	350	40	450	40	550	40	650	40
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Attention: When cutting paper, should pay attention to controlling laser power, when laser is stronger, percent should be smaller

Rubber	4mm	5	4	15	13	25	20	30	27	35	33	40	38	45	43	50	48	60	58
	6mm	2	1	10	8	15	10	18	15	20	18	25	23	30	28	35	33	45	43

Attention: Usually suggest cut single layer rubber