



# THUNDER LASER TECH CO.,LTD

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## PARAMETERS FOR 80WAT 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	25	60	60
acr	5.0	10	60	60
acr	10.0	3	60	60
acr	20.0	0.8	80	80
foam	17.0	10	60	60
plywood	2.0	160	60	60
plywood	4.5	30	60	60
cardboard	6.0	60	60	60
non-dust cloth	1.0	300	33	33
leather	1.5	50	60	60
rubber	4.5	6	60	60
double color boards	1.5	40	60	60
bamboo	7.0	9	60	60
paper	0.2	300	60	60
Kraft paper	1.0	300	20	20
plastics	/	/	/	/
composite wood	7.0	10	60	60
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	15	/	0.08
bamboo	/	500	20	/	0.08
plywood	/	500	13	/	0.08

cardboard	/	500	15	/	0.08
paper	/	500	13	/	0.08
painted aluminum	/	500	25	/	0.08
cherry wood	/	500	15	/	0.08
anodized aluminum	/	500	20	/	0.08
plastaic	/	500	18	/	0.08
glass	/	500	15	/	0.08
Kraft paper	/	500	18	/	0.08
leather	/	500	15	/	0.08
cloth	/	500	13	/	0.08
rubber	/	500	30	15	0.06
metal	/	/	/	/	/
double color boards	/	500	15	/	0.08
granite	/	500	15	/	0.08
marble	/	500	40	/	0.08
ceramic cup	/	500	22	/	0.08
rostone	/	500	25	/	0.08
grip tape	/	500	18	/	0.08
foam	/	/	/	/	/

## CUTTING

### Laser head type: 4 inches laser head

materials	thickness	speed	max power	power in corners	
mdf	2.5	23.0	60	60	
acr	10.0	3	60	60	
acr	20.0	0.9	60	60	
foam	17.0	10	60	60	
plywood	4.5	20	60	60	
plywood	10.0	4.0	60	60	
mahogany wood	18.5	2	80	80	
leather	1.5	35.0	60	60	
rubber	4.5	6.0	60	60	
cherry wood	12.0	5	60	60	
bamboo	7.0	13.0	60	60	
taekwondo wood	8.0	16	60	60	
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	13	/	0.06
acr	/	400	15	/	0.04
bamboo	/	500	15	/	0.06
plywood	/	500	15	/	0.06
cardboard	/	500	14	/	0.06
paper	/	/	/	/	0.06
painted aluminum	/	500	15	/	0.06
cherry wood	/	500	15	/	0.06
anodized aluminum	/	500	15	/	0.05
plastaic	/	500	15	/	0.06
glass	/	500	15	/	0.06
Kraft paper	/	500	14	/	0.06
leather	/	500	14	/	0.06
cloth	/	500	14	/	0.06
rubber	/	500	40	15	0.06
metal	/	/	/	/	/
double color boards	/	500	15	/	0.06
granite	/	500	15	/	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			