

LMC12 Black for Plastic Laser Settings



USA Tel: (336) 288-1613 Toll Free (866) 288-1613
sales@jorlink.com or support@jorlink.com

Laser Settings for LMC12 Materials

The following table details recommended laser settings for LMC12 materials on various plastics. These settings are designed to help guide the user to the optimum parameters as quickly as possible. Please note that there will be variations in substrate finish and between different brands of laser. It may still be necessary to perform further refinement of settings to achieve the desired mark.

LMC12 Suggested Laser Settings Used for CO ₂ X-Y Laser						
Substrate Material	Settings 45W laser		Settings 30W laser		Lens	DPI/PPI
	Power (W)	Speed (in/sec)	Power (W)	Speed (in/sec)		
Nylon	7	38	7	38	2.5"	500/1000
Polyurethane	5	37	5	37	2.5"	600/600
HDPE	14	56	14	56	2.5"	600/600
Polycarbonate	18	28	18	28	4.0"	600/600
PVC	5	31	5	31	2.5"	600/1000

Suggested Laser Settings Used for Beam Steered ND:YAG or Fiber Laser with a 100mm lens				
Material	Power (W)	Speed (cm/sec)	Hatch Spacing "	CW Mode or Q-Switch Freq
Nylon	1	20	0.002	CW / ≥50KHz
Polyurethane	2	25	0.002	CW / ≥50KHz
HDPE	1	20	0.002	CW / ≥50KHz
Polycarbonate	N/A	N/A	N/A	N/A
PVC	0.25	10	0.002	CW / ≥50KHz



USA Tel: (336) 288-1613 Toll Free (866) 288-1613
sales@jorlink.com or support@jorlink.com