

# LMM6018.LF Laser Settings



## Laser Settings for LMM6018.LF Tape



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

The following table details recommended laser settings for LMM6018.LF tape on a range of common substrates. 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.

| LMM6018.LF Suggested Laser Settings Used for CO <sub>2</sub> X-Y Laser |                    |                |                    |                |      |           |
|--|--------------------|----------------|--------------------|----------------|------|-----------|
| Substrate Material   | Settings 45W laser |                | Settings 30W laser |                | Lens | DPI/PPI   |
|  | Power (W)          | Speed (in/sec) | Power (W)          | Speed (in/sec) |      |           |
| Stainless Steel  | 30                 | 25             | 30                 | 25             | 2"   | 1000/1000 |
| Stainless Steel - Bright Annealed                                      | 38                 | 20             | 30                 | 17             | 2"   | 1000/1000 |
| Galvanized Steel   | 30                 | 7              | 30                 | 7              | 2"   | 1000/1000 |
| Brass  | 30                 | 2              | 30                 | 2              | 2"   | 1000/1000 |
| Aluminum   | 43                 | 4              | 30                 | 3              | 2"   | 1000/1000 |
| Anodized Aluminum  | 20                 | 7              | 20                 | 7              | 1.5" | 1000/1000 |
| Chrome plating   | 41                 | 4              | 30                 | 3              | 1.5" | 1000/1000 |
| Nickel Plating   | 38                 | 8              | 30                 | 6              | 2"   | 1000/1000 |
| Gold Plating   | 45                 | 4              | 30                 | 2              | 2"   | 1000/1000 |
| Titanium   | 43                 | 35             | 30                 | 31             | 1.5" | 1000/1000 |
| Pewter   | 45                 | 11             | 30                 | 6              | 1.5" | 1000/1000 |

# LMM6018.LF Laser Settings



## 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 |
|-----------------------------------|-----------|----------------|-----------------|--------------------------|
| Stainless Steel                   | 9         | 3              | .002            | CW / $\geq 50$ KHz       |
| Stainless Steel - Bright Annealed | 10        | 1              | .002            | CW / $\geq 50$ KHz       |
| Galvanized Steel                  | 10        | 4              | .002            | CW / $\geq 50$ KHz       |
| Anodized Aluminum                 | 10        | 1              | .002            | CW / $\geq 50$ KHz       |
| Chrome plating                    | 10        | 1              | .002            | CW / $\geq 50$ KHz       |
| Nickel Plating                    | 10        | 3              | .002            | CW / $\geq 50$ KHz       |
| Gold Plating                      | 10        | 0.4            | .002            | CW / $\geq 50$ KHz       |
| Titanium                          | 10        | 1              | .002            | CW / $\geq 50$ KHz       |
| Pewter                            | 9         | 1              | .002            | CW / $\geq 50$ KHz       |



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