

## Laser Settings for LMM6018.LF Tape



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



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