

Approximate cutting parameters for 150W CO2 laser

Acrylic						
Thickness		Approximate Cutting Speed		Power		Air Assist
mm	inch	mm/s	inch/min	Max %	Corner %	
1.5	0.059	20	47.24	30	30	Med.
2	0.079	20	47.24	30	30	Med.
2.5	0.098	20	47.24	30	30	Med.
3	0.118	20	47.24	30	30	Med.
4	0.157	30	70.87	70	70	Med.
5	0.197	15	35.43	45	40	Med.
5.7	0.224	7	16.54	60	60	Med.
7.6	0.299	5	11.81	60	60	Med.
9.2	0.362	7	16.54	60	60	Med.

MDF						
Thickness		Approximate Cutting Speed		Power		Air Assist
mm	inch	mm/s	inch/min	Max %	Corner %	
1.5	0.059	20	47.24	30	30	Max
2.3	0.091	20	47.24	30	30	Max
2.5	0.098	45	106.30	60	60	Max
3	0.118	45	106.30	70	70	Max
3.2	0.126	20	47.24	30	30	Max
4	0.157	40	94.49	70	60	Max
5	0.197	15	35.43	40	35	Max
6	0.236	15	35.43	70	70	Max
8	0.315	10	23.62	75	75	Max
9.5	0.374	7	16.54	80	80	Max
10	0.394	5	11.81	80	80	Max
12	0.472	5	11.81	85	85	Max

Plywood						
Thickness		Approximate Cutting Speed		Power		Air Assist
mm	inch	mm/s	inch/min	Max %	Corner %	
2	0.079	780	1842.52	70	70	Med.
4.5	0.177	26	61.42	70	70	Med.
10	0.394	4.5	10.63	70	70	Med.

Paper/PaperBoard/Cardstock/Cardboard						
Thickness		Approximate Cutting Speed		Power		Air Assist
mm	inch	mm/s	inch/min	Max %	Corner %	
0.1	0.004	300	708.66	24	24	Med.
0.2	0.008	60	141.73	11	11	Max
0.5	0.020	300	708.66	24	24	Med.
0.9	0.035	60	141.73	12	10	Max
3	0.118	100	236.22	30	30	Min.
4	0.157	80	188.98	80	75	Max