



Laser Settings for *LaserBond 100*

The following table details recommended laser settings for the *LaserBond 100* material on most glass, ceramic and metals. 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. Power settings shown are in Watts, to convert to a % divide your laser wattage into the wattage shown in the chart. Speed settings are in in/sec, to convert to a % divide your laser's top speed into the in/sec shown in the chart. To convert in/sec of speed into mm/sec multiply inches shown by 25. 500 – 600 DPI is equivalent to approximately 0.05mm interval.

Suggested Laser Settings 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)		
Glass	10	35	11	35	2"	500/1000
Ceramic	15	20	15	20	2"	500/1000
Stainless Steel	45	60	30	40	2"	600/600
Stainless Steel Bright Annealed	45	40	30	30	2"	600/600
Galvanized Steel	45	60	30	60	2"	600/600
Brass	45	15	30	10	2"	500/1000
Aluminum	45	15	30	10	2"	500/1000
Copper	45	30	30	20	2"	500/1000
Chrome	45	30	30	20	2"	500/1000
Nickel	45	40	30	30	2"	500/1000
Gold	45	15	30	10	2"	500/1000
Silver	45	15	30	10	2"	500/1000
Titanium	45	60	30	40	2"	500/1000
Pewter	45	30	30	20	2"	500/1000

Suggested Laser Settings for Galvo / Beam Steered 20 Watt Nd:YAG, Fiber or DPSS Laser with a 100mm F-Theta Lens

Substrate Material	Power (W)	Speed (mm/sec)	Hatch Spacing (mm)	CW Mode or Q-Switch Freq
Glass	8	200	0.05	CW / 100KHz
Ceramic	12	100	0.05	CW / 100KHz
Stainless Steel	20	500	0.05	CW / 100KHz
Stainless Steel Bright Annealed	20	500	0.05	CW / 100KHz
Galvanized Steel	20	300	0.05	CW / 100KHz
Brass	20	100	0.05	CW / 100KHz
Aluminum	20	100	0.05	CW / 100KHz
Copper	20	100	0.05	CW / 100KHz
Chrome	20	200	0.05	CW / 100KHz
Nickel	20	250	0.05	CW / 100KHz
Gold	20	100	0.05	CW / 100KHz
Silver	20	100	0.05	CW / 100KHz
Titanium	20	500	0.05	CW / 100KHz
Pewter	20	200	0.05	CW / 100KHz

Clean up: After use, *LaserBond 100* may be cleaned up using a damp cloth or paper towel or it can be rinsed under plain tap water and it is safe to let the excess material go down the drain.