

80W First grade laser tube/ on acrylic (cutting effect refers to Picture 4)					
Lens 63.5mm	Speed(mm/s)		Power (%)		Remarks
	Best speed	Speed range	Min. Power	Max. Power	
1mm	60	35-100	75	80	Refer to Picture 1
2mm	50	30-80	75	80	Refer to Picture 1
3mm	20	10-30	75	80	Refer to Picture 2
5mm	8	6-17	75	80	Refer to Picture 2
8mm	4	3-6	75	80	Refer to Picture 3
10mm	4	2-5	75	80	Refer to Picture 3
Lens 100	Speed(mm/s)		Power (%)		Remarks
	Best speed	Speed range	Min. Power	Max. Power	
1mm			75	80	Refer to Picture 1
2mm			75	80	Refer to Picture 1
3mm			75	80	Refer to Picture 2
5mm			75	80	Refer to Picture 2
8mm			75	80	Refer to Picture 3
10mm	4	2-6	75	80	Refer to Picture 3
12mm	2	1-5	75	80	Refer to Picture 3

100W First grade laser tube/ on acrylic (cutting effect refers to Picture 4)					
Lens 63.5mm	Speed(mm/s)		Power (%)		Remarks
	Best speed	Speed range	Min. Power	Max. Power	
1mm	100	40-130	75	80	Refer to Picture 1
2mm	60	30-90	75	80	Refer to Picture 1
3mm	25	10-40	75	80	Refer to Picture 2
5mm	12	8-20	75	80	Refer to Picture 2
8mm	5	2-7	75	80	Refer to Picture 3
10mm	4	2-6	75	80	Refer to Picture 3
	Speed(mm/s)		Power (%)		

Lens 100	Best speed	Speed range	Min. Power	Max. Power	Remarks
1mm	60	30-100	75	80	Refer to Picture 1
2mm	30	20-50	75	80	Refer to Picture 1
3mm	15	10-30	75	80	Refer to Picture 2
5mm	10	7-15	75	80	Refer to Picture 2
8mm	5	2-9	75	80	Refer to Picture 3
10mm	4	2-6	75	80	Refer to Picture 3
12mm	3	2-5	75	80	Refer to Picture 3
15mm	1.5	1-3	75	80	Refer to Picture 3

<b>135W First grade laser tube/ on acrylic (cutting effect refers to Picture 4)</b>					
Lens 63.5mm	Speed(mm/s)		Power (%)		Remarks
	Best speed	Speed range	Min. Power	Max. Power	
1mm	100	40~150	75	80	Refer to Picture 1
2mm	60	30~90	75	80	Refer to Picture 1
3mm	25	10~35	75	80	Refer to Picture 2
5mm	12	8~18	75	80	Refer to Picture 2
8mm	6	3~9	75	80	Refer to Picture 3
10mm	5	3~7	75	80	Refer to Picture 3
Lens 100 mm	Speed(mm/s)		Power (%)		Remarks
	Best speed	Speed range	Min. Power	Max. Power	
1mm	60	40~120	75	80	Refer to Picture 1
2mm	50	30~75	75	80	Refer to Picture 1
3mm	20	10~30	75	80	Refer to Picture 2
5mm	10	8~15	75	80	Refer to Picture 2
8mm	6	3~10	75	80	Refer to Picture 3
10mm	5	3~7	75	80	Refer to Picture 3
12mm	4	2~6	75	80	Refer to Picture 3
15mm	2.5	1~4	75	80	Refer to Picture 3

Work	Output	Doc	User	Test	Transform
<b>Cut parameters</b>					
Idle speed(mm/s)	200.000				
Idle Acc(mm/s <sup>2</sup> )	1000.000				
Start speed(mm/s)	15.000				
Min Acc(mm/s <sup>2</sup> )	800.000				
Max Acc(mm/s <sup>2</sup> )	1000.000				
Cutting mode	Normal Cutting				
Acc Mode	S mode				
<b>Sweep parameters</b>					
x Start Speed(mm/s)	20.000				
y Start Speed(mm/s)	15.000				
x Acc(mm/s <sup>2</sup> )	4000.000				
y Acc(mm/s <sup>2</sup> )	2500.000				
Line Shift Speed (mm/s)	150.000				
Scan Mode	Common Mode				
Facula Size(50~99%)	98.000				
<b>Home para</b>					
Home speed(mm/s)	50.000				
Auto home X	Yes				
Auto home Y	Yes				
Auto home z	No				

Work	Output	Doc	User	Test	Transform
<b>Cut parameters</b>					
Idle speed(mm/s)	200.000				
Idle Acc(mm/s <sup>2</sup> )	1000.000				
Start speed(mm/s)	5.000				
Min Acc(mm/s <sup>2</sup> )	300.000				
Max Acc(mm/s <sup>2</sup> )	500.000				
Cutting mode	Normal Cutting				
Acc Mode	S mode				
<b>Sweep parameters</b>					
x Start Speed(mm/s)	20.000				
y Start Speed(mm/s)	15.000				
x Acc(mm/s <sup>2</sup> )	4000.000				
y Acc(mm/s <sup>2</sup> )	2500.000				
Line Shift Speed (mm/s)	150.000				
Scan Mode	Common Mode				
Facula Size(50~99%)	98.000				
<b>Home para</b>					
Home speed(mm/s)	50.000				
Auto home X	Yes				
Auto home Y	Yes				
Auto home z	No				

Work	Output	Doc	User	Test	Transform
<b>Cut parameters</b>					
Idle speed(mm/s)	200.000				
Idle Acc(mm/s <sup>2</sup> )	1000.000				
Start speed(mm/s)	5.000				
Min Acc(mm/s <sup>2</sup> )	200.000				
Max Acc(mm/s <sup>2</sup> )	300.000				
Cutting mode	Normal Cutting				
Acc Mode	S mode				
<b>Sweep parameters</b>					
x Start Speed(mm/s)	20.000				
y Start Speed(mm/s)	15.000				
x Acc(mm/s <sup>2</sup> )	4000.000				
y Acc(mm/s <sup>2</sup> )	2500.000				
Line Shift Speed (mm/s)	150.000				
Scan Mode	Common Mode				
Facula Size(50~99%)	98.000				
<b>Home para</b>					
Home speed(mm/s)	50.000				
Auto home X	Yes				
Auto home Y	Yes				
Auto home z	No				

加工	输出	文档	用户	调试	变换
<b>切割参数</b>					
空程速度(mm/s)	200.000				
空程加速度(mm/s <sup>2</sup> )	1000.000				
拐弯速度(mm/s)	15.000				
拐弯加速度(mm/s <sup>2</sup> )	800.000				
切割加速度(mm/s <sup>2</sup> )	1000.000				
切割模式	精度切割				
加速方式	S型加速				
<b>扫描参数</b>					
x轴起始速度(mm/s)	20.000				
y轴起始速度(mm/s)	15.000				
x轴加速度(mm/s <sup>2</sup> )	4000.000				
y轴加速度(mm/s <sup>2</sup> )	2500.000				
扫描换行速度(mm/s)	150.000				
扫描模式	一般模式				
光斑大小(50~99%)	98.000				
<b>复位参数</b>					
复位速度(mm/s)	50.000				
X轴开机复位	是				
Y轴开机复位	是				
Z轴开机复位	否				
U轴开机复位	否				

加工	输出	文档	用户	调试	变换
<b>切割参数</b>					
空程速度(mm/s)	200.000				
空程加速度(mm/s <sup>2</sup> )	1000.000				
拐弯速度(mm/s)	5.000				
拐弯加速度(mm/s <sup>2</sup> )	300.000				
切割加速度(mm/s <sup>2</sup> )	500.000				
切割模式	精度切割				
加速方式	S型加速				
<b>扫描参数</b>					
x轴起始速度(mm/s)	20.000				
y轴起始速度(mm/s)	15.000				
x轴加速度(mm/s <sup>2</sup> )	4000.000				
y轴加速度(mm/s <sup>2</sup> )	2500.000				
扫描换行速度(mm/s)	150.000				
扫描模式	一般模式				
光斑大小(50~99%)	98.000				
<b>复位参数</b>					
复位速度(mm/s)	50.000				
X轴开机复位	是				
Y轴开机复位	是				
Z轴开机复位	否				
U轴开机复位	否				

加工	输出	文档	用户	调试	变换
<b>切割参数</b>					
空程速度(mm/s)	200.000				
空程加速度(mm/s <sup>2</sup> )	1000.000				
拐弯速度(mm/s)	5.000				
拐弯加速度(mm/s <sup>2</sup> )	200.000				
切割加速度(mm/s <sup>2</sup> )	300.000				
切割模式	精度切割				
加速方式	S型加速				
<b>扫描参数</b>					
x轴起始速度(mm/s)	20.000				
y轴起始速度(mm/s)	15.000				
x轴加速度(mm/s <sup>2</sup> )	4000.000				
y轴加速度(mm/s <sup>2</sup> )	2500.000				
扫描换行速度(mm/s)	150.000				
扫描模式	一般模式				
光斑大小(50~99%)	98.000				
<b>复位参数</b>					
复位速度(mm/s)	50.000				
X轴开机复位	是				
Y轴开机复位	是				
Z轴开机复位	否				
U轴开机复位	否				

Picture 1

Picture 2

Picture 3



1mm  
Effect from the  
highest speed range



1mm  
Effect from the  
best speed



2mm  
Effect from the  
highest speed range



2mm  
Effect from the  
best speed



3mm  
Effect from the  
highest speed range



3mm  
Effect from the  
best speed



5mm  
Effect from the  
highest speed range



5mm  
Effect from the  
best speed



8mm  
Effect from the  
highest speed range



8mm  
Effect from the  
best speed



10mm  
Effect from the  
highest speed range



10mm  
Effect from the  
best speed



12mm  
Effect from the  
highest speed range



12mm  
Effect from the  
best speed



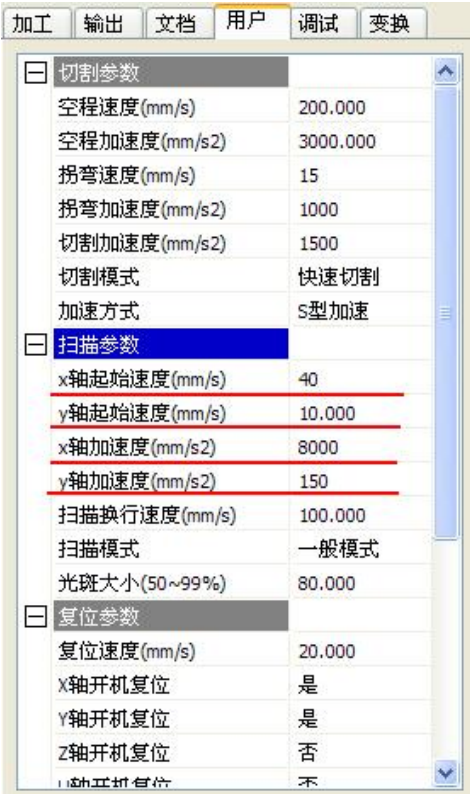
15mm  
Effect from the  
highest speed range



15mm  
Effect from the  
best speed

**Picture 4**

60W laser tube engraving effect (Engraving effect refers to Picture 6)						
Materials	Speed(mm/s) Bigger designs, higher speed		Power (%) Higher power, deeper engraving effect		Engraving interval (mm) Smaller interval, more delicate engraving effect	Remarks
	Best speed	Speed range	Min. Power	Max. Power		
Acrylic	200	10-400	18	18	0.08 (0.05 and above)	Refer to Picture 5
Double-colour board	200	10-400	18	18	0.08 (0.05 and above)	Refer to Picture 5
Plywood	200	10-400	18	18	0.08 (0.05 and above)	Refer to Picture 5
Jeans	200	10-400	18	18	0.25 (0.05 and above)	Refer to Picture 5



Picture 5