

EPILOG LASERCUTTER SETTINGS

- Each of our Epilog Lasercutters at Pier 9 require custom settings for a successful cut or etch operation.
- As the lasertubes degrade over time, the ideal settings for a material change.
- Use the tabs below to find recommended settings for your laser!

Note:

This is a User-Run Google Doc. If you find a new setting that works well on one of the machines, please update the machine's tab and add the date when you make this improvement.

Epilog Approved Materials		
Material	Engrave	Cut
Wood	X	X
Acrylic	X	X
Fabric	X	X
Cloth	X	X
Ceramic	X	
Delrin	X	X
Linoleum	X	X
Leather	X	X
Marble	X	
Matte Board	X	X
Coated Metals	X	
Paper	X	
Cork	X	X
Tile	X	X
Glass	X	
Chocolate	X	X

Epilog Forbidden Materials		
Material	Danger	Consequence
PVC (Polyvinyl Chloride)	Emits Pure Chlorine Gas	Gas will ruin lense, corrode Metal, and ruin motion control system.
Pleather / Artificial Leather	Emits Pure Chlorine Gas	Gas will ruin lense, corrode Metal, and ruin motion control system.
Moleskin Notebooks	Emits Pure Chlorine Gas	Gas will ruin lense, corrode Metal, and ruin motion control system.
Polycarbonate / Lexan	Cuts poorly, Discolors, Fire	This Material absorbs infrared Radiation so the laser is very ineffective.
ABS	Emits cyanide gas and melts	ABS tends to melt, making a mess. It also has a higher chance of catching fire.
HDPE / Milk Bottle Plastic	Catches fire and melts	It melts, tending to make a mess and ruin the material tray.
Polystyrene Foam	Catches Fire	It catches Fire and melts. #1 material to cause laser fire.
Fiberglass		Like Polystyrene, it melts, catches fire and the melted drops continue to burn and turn into rock-hard drips and pebbles.
Coated Carbon Fiber	Emits Noxious Fumes	A mix of two materials. Thin carbon fiber can be cut, with some fraying - but not when coated.
Any Powder		Compressed Air will blow it away.
Butane Lighters	Explode / Catch Fire	
Gasoline or other Liquids	Explode / Catch Fire	
People	XX	
Animals	XX	

Speedycut Rubber	X	X				
Melamine	X	X				
Neoprene	X	X				
PDF Charts for Reference	<u>120 Watt Manufacturer Settings</u>	<u>75 Watt Manufacturer Settings</u>		<u>Approved Epilog Materials</u>	<u>Forbidden Epilog Materials</u>	

120 Watt Laser Cutter	User Tested Settings						Factory Standard Settings			
	Note : These Settings have been User tested for the Water Laser cutter. Please Update if you find a better setting.						Note : These are the Factory Standard Settings for a 120 watt epilop. They should only be used as a starting point when testing your material.			
	Material	Thickness	600 DPI Raster Speed / Power	Vector Cutting Speed/Power/Frequency	Notes	Date	Tested By	Raster 300 DPI Speed / Power	Raster 400 DPI Speed / Power	Raster 600 DPI Speed / Power
Ply Wood	1/8 Inch 3 MM	100 / 70	20/90/500		4/19/2016	WF/Gabe	90 / 100	100 / 90	100 / 70	50 / 40 / 500
Ply Wood	3/16 Inch 4.7 MM						90 / 100	100 / 90	100 / 70	20 / 50 / 500
Ply Wood	1/4 Inch 6 MM	100 / 80	10 / 95 / 500		4/3/2016	Purin P	90 / 100	100 / 90	100 / 70	20 / 50 / 500
Acrylic	1/8 Inch 3 MM		45 / 80 / 5000		7/13/2016	MEY	100 / 30	100 / 25	100 / 20	50 / 70 / 5,000
Acrylic	3/16 Inch 4.7 MM						100 / 30	100 / 25	100 / 20	20 / 70 / 5,000
Acrylic	1/4 Inch 6 MM		8 / 95 / 5000		6/21/2016	Mike Koehle	100 / 30	100 / 25	100 / 20	4 / 95 / 5,000
AlumaMark							100/20	100 / 25	100 / 20	Do not cut
Anodized Aluminum		95 / 25					100 / 30	100 / 25	100 / 20	Do not cut
Painted Brass							100 / 35	100 / 20	100 / 25	Do not cut
Marbleized Painted Brass							100 / 40	100 / 35	100 / 30	Do not cut
Corian or Avonite	1/8 Inch 3 MM						75 / 100	80 / 100	85 / 100	15 / 95 / 5,000
Delrin Seals							100 / 25	100 / 30	100 / 35	50 / 20 / 1000
Glass							100 / 95	100 / 80	100 / 60	Do not cut
Leather	1/8 Inch 3 MM						100 / 25	100 / 20	100 / 15	30 / 10 / 5,000
Marbleized Painted Brass							100 / 65	100 / 55	100 / 45	Do not cut
Mat Board							100 / 25	100 / 20	100 / 15	50 / 15 / 500
Melamine							100 / 70	100 / 65	100 / 60	Do not cut
Stainless Steel with Cerdec Coating							60 / 95	60 / 80	60 / 60	Do not cut
Rubber and Rubber Stamps							60 / 100	70 / 100	80 / 100	45 / 95 / 100
Cermark on Steel		40 / 90	Do not Vector Cut							
Card Stock	1/4 inch	n/a	40/12/450			Renee				
Paper		n/a	100/25/0500	Bristol board		Renee				
Leather										
Cork	1/4 inch	100/20	50/30/500	12x12 material	2/29/2016	EK				
Cardboard			50/25/500			JHR				
acrylic	1/16 inch		75/45/5000		6/22/2016	mike koehle				
cotton muslin			75/25/500		5/11/2016	Lara Grant				