

The following tables recommended laser settings for CerMark LMM 6018 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 powered lasers. These settings have been specifically developed for a range of commonly used Epilog Lasers. It may still be necessary to perform further refinement of settings to achieve the desired mark.

LMM6018 Suggested Laser Settings Used for Epilog CO₂ X-Y Lasers						
Substrate Material	Settings EXT 60-75W laser 600DPI 2" Lens		Settings Helix / Mini 35-45W laser 600DPI 2" Lens		Settings Zing 25W laser 500DPI 2" Lens	
	Power (W)	Speed (%)	Power (W)	Speed (%)	Power (W)	Speed (%)
Stainless Steel	60W	15-25%	35W	10-15%	25W	25-30%
Stainless Steel - Bright Annealed	60W	10-15%	35W	5-10%	25W	20-25%
Galvanized Steel	60W	10-15%	35W	3-5%	25W	10-15%
Brass	60W	3-5%	35W	1-2%	25W	1-2%
Aluminum	60W	5%	35W	1%	25W	2%
Anodized Aluminum	60W	15-20%	30W	10%	25W	15-20%
Nickel Plating	60W	25%	30W	15%	25W	20-25%
Pewter	60W	20%	30W	10%	25W	15-20%



Suggested Laser Settings Used for Epilog FiberMark Laser @ 600DPI				
Substrate Material	Power (W)	Speed (%)	Focus	Freq
Stainless Steel	18W	3%	- 0.05"	20KHz
Stainless Steel - Bright Annealed	20W	3%	- 0.05"	20KHz
Anodized Aluminum	16W	2%	- 0.05"	20KHz
Galvanized Steel	18W	4%	- 0.05"	20KHz
Nickel Plating	18W	3%	- 0.05"	20KHz