

Fusion: Speed and Power Recommendations

30 Watt

	300 DPI RASTER ENGRAVING	400 DPI RASTER ENGRAVING	600 DPI RASTER ENGRAVING	VECTOR CUTTING
	SPEED/POWER	SPEED/POWER	SPEED/POWER	SPEED/POWER/FREQUENCY
Wood Cherry – Alder - Walnut	20/100	25/100	30/100	1/8" (3 mm) – 12/100/50 1/4" (6 mm) – 6/100/50 (multiple passes may allow cutting of thicker materials)
Acrylic	100/80	100/70	100/60	1/8" (3 mm) – 7/100/100 1/4" (6 mm) – 2/100/100 (two passes may produce better results) Adjusting the standard focus distance so your material is closer to the lens by about .030" will produce better edge quality on 1/4" and thicker acrylic.
AlumaMark	100/60	100/50	100/40	N/A
Anodized Aluminum	100/70	100/65	100/60	N/A
Painted Brass	100/80	100/70	100/60	N/A
Marbleized Painted Brass	100/100	100/90	100/80	N/A
Corian Or Avonite	15/100	20/100	25/100	1/8" (3 mm) – 6/100/100
Delrin Seals	100/90	100/80	100/70	30/100/50
Glass	15/100	20/100	25/100	N/A
Laserable Plastic	100/80	100/70	100/60	15/100/100
Leather	100/65	100/55	100/45	1/8" (3 mm) - 10/100/50
Marble	10/100	15/100	20/100	N/A
Mat board	100/75	100/65	100/55	20/50/50
Melamine	30/100	40/100	50/100	N/A
Stainless Steel With Cerdec Coating	N/A	20/100	25/100	N/A
Rubber & Rubber Stamps	N/A	10/100	20/100	10/100/100

Section 12: Speed and Power Recommendations

40 Watt

	300 DPI RASTER ENGRAVING	400 DPI RASTER ENGRAVING	600 DPI RASTER ENGRAVING	VECTOR CUTTING
	SPEED/POWER	SPEED/POWER	SPEED/POWER	SPEED/POWER/FREQUENCY
Wood Cherry – Alder - Walnut	25/100	30/100	40/100	1/8" (3 mm) – 15/100/50 1/4" (6 mm) – 8/100/50 (multiple passes may allow cutting of thicker materials)
Acrylic	100/70	100/60	100/50	1/8" (3 mm) – 9/100/100 1/4" (6 mm) – 3/100/100 (two passes may produce better results) Adjusting the standard focus distance so it is closer to the lens by about .030" will produce better edge quality on 1/4" and thicker acrylic.
AlumaMark	80/30	80/25	80/20	N/A
Anodized Aluminum	100/60	100/55	100/50	N/A
Painted Brass	100/65	100/55	100/45	N/A
Marbleized Painted Brass	100/75	100/65	100/55	N/A
Corian Or Avonite	20/100	25/100	30/100	1/8" (3 mm) – 20/100/100
Delrin Seals	100/70	100/60	100/50	50/100/500
Glass	25/100	35/100	45/100	N/A
Laserable Plastic	100/60	100/55	100/50	20/100/100
Leather	100/40	100/35	100/30	1/8" (3 mm) - 15/100/50
Marble	20/100	25/100	30/100	N/A
Mat board	100/65	100/55	100/45	30/40/500
Melamine	40/100	50/100	60/100	N/A
Stainless Steel With Cerdec Coating	N/A	40/100	50/100	N/A
Rubber & Rubber Stamps	10/100	20/100	30/100	15/100/100

Section 12: Speed and Power Recommendations

50 Watt

	300 DPI RASTER ENGRAVING	400 DPI RASTER ENGRAVING	600 DPI RASTER ENGRAVING	VECTOR CUTTING
	SPEED/POWER	SPEED/POWER	SPEED/POWER	SPEED/POWER/FREQUENCY
Wood Cherry – Alder - Walnut	35/100	40/100	50/100	1/8" (3 mm) – 20/100/50 1/4" (6 mm) – 10/100/50 3/8" (9.5 mm) – 5/100/50 (two passes may produce better results)
Acrylic	100/60	100/50	100/40	1/8" (3 mm) – 10/100/100 1/4" (6 mm) – 3/100/100 (two passes may produce better results) Adjusting the standard focus distance so it is closer to the lens by about .030" will produce better edge quality on 1/4" and thicker acrylic.
AlumaMark	100/40	100/35	100/30	N/A
Anodized Aluminum	100/60	100/50	100/40	N/A
Painted Brass	100/35	100/30	100/25	N/A
Marbleized Painted Brass	100/45	100/40	100/35	N/A
Corian Or Avonite	20/100	30/100	40/100	1/8" (3 mm) – 50/100/100
Delrin Seals	100/60	100/50	100/40	60/100/100
Glass	30/100	40/100	50/100	N/A
Laserable Plastic	100/55	100/50	100/45	30/100/100
Leather	100/50	100/40	100/30	1/8" (3 mm) - 20/100/50
Marble	20/100	40/100	60/100	N/A
Mat board	100/65	100/55	100/45	50/50/500
Melamine	100/80	100/70	100/60	N/A
Stainless Steel With Cerdec Coating	N/A	50/100	60/100	N/A
Rubber & Rubber Stamps	15/100	20/100	30/100	20/100/100

Section 12: Speed and Power Recommendations

60 Watt

	300 DPI RASTER ENGRAVING	400 DPI RASTER ENGRAVING	600 DPI RASTER ENGRAVING	VECTOR CUTTING
	SPEED/POWER	SPEED/POWER	SPEED/POWER	SPEED/POWER/FREQUENCY
Wood Cherry – Alder - Walnut	60/100	70/100	80/100	1/8" (3 mm) – 30/60/500 1/4" (6.4 mm) – 15/100/500 3/8" (9.5 mm) – 8/100/500 (two passes may produce better results)
Acrylic	100/50	100/40	100/30	1/8" (3 mm) – 12/100/100 1/4" (6 mm) – 4/100/100 3/8" (9.5 mm) – 2/100/100 (two passes may produce better results) Adjusting the standard focus distance so it is closer to the lens by about .030" will produce better edge quality on 1/4" and thicker acrylic.
AlumaMark	100/30	100/25	100/20	N/A
Anodized Aluminum	100/45	100/35	100/30	N/A
Painted Brass	100/30	100/25	100/20	N/A
Marbleized Painted Brass	100/40	100/35	100/30	N/A
Corian Or Avonite	25/100	35/100	45/100	1/8" (3 mm) – 50/80/100
Delrin Seals	100/40	100/30	100/20	60/85/100
Glass	40/100	50/100	60/100	N/A
Laserable Plastic	100/45	100/35	100/30	30/85/100
Leather	100/40	100/30	100/20	1/8" (3 mm) - 25/100/50
Marble	100/100	100/90	100/80	N/A
Mat board	100/65	100/55	100/45	50/40/50
Melamine	100/60	100/70	100/80	N/A
Stainless Steel With Cerdec Coating	N/A	80/100	70/100	N/A
Rubber & Rubber Stamps	20/100	30/100	40/100	25/100/100

Section 12: Speed and Power Recommendations

75 Watt

	300 DPI RASTER ENGRAVING	400 DPI RASTER ENGRAVING	600 DPI RASTER ENGRAVING	VECTOR CUTTING
	SPEED/POWER	SPEED/POWER	SPEED/POWER	SPEED/POWER/FREQUENCY
Wood Cherry – Alder - Walnut	80/100	90/100	100/100	1/8" (3 mm) – 40/100/50 1/4" (6 mm) – 20/100/50 3/8" (9.5 mm) – 12/100/50 (two passes may produce better results)
Acrylic	100/35	100/30	100/25	1/8" (3 mm) – 15/100/100 1/4" (6 mm) – 6/100/100 3/8" (9.5 mm) – 4/100/100 (two passes may produce better results) Adjusting the standard focus distance so it is closer to the lens by about .030" will produce better edge quality on 1/4" and thicker acrylic.
AlumaMark	100/25	100/20	100/15	N/A
Anodized Aluminum	100/45	100/35	100/25	N/A
Painted Brass	100/40	100/30	100/20	N/A
Marbleized Painted Brass	100/35	100/30	100/25	N/A
Corian Or Avonite	65/100	75/100	85/100	1/8" (3 mm) – 50/80/100
Delrin Seals	100/30	100/25	100/20	60/75/50
Glass	75/100	80/100	85/100	N/A
Laserable Plastic	100/40	100/30	100/25	30/70/100
Leather	100/30	100/20	100/15	1/8" (3 mm) - 30/100/50
Marble	100/85	100/75	100/65	N/A
Mat board	100/40	100/30	100/20	50/30/50
Melamine	100/80	85/70	100/60	N/A
Stainless Steel With Cerdec Coating	N/A	70/100	80/100	N/A
Rubber & Rubber Stamps	40/100	50/100	60/100	40/100/100