

→ **Book of Parameters**
Speedy 100, 40 watt

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1 General information

JobControl[®] features parameters for Trotec laser materials. The book of parameters is offering supplementary advice as to how these new parameters can be used.

Engraving and cutting results always depend on the equipment used, specific applications, as well as the requirements regarding quality and productivity. By providing two different parameter sets "Quality" and "Speed" we are covering a wide range of conditions. Feedback and suggestions will help us to further develop these parameters and are highly appreciated.

1.1 "Quality" vs. "Speed" optimized parameters

"Quality" parameter sets are recommended for applications where fine detail and strong contrast is required.

"Speed" parameters are for time-efficiency orientated applications, where a reduced degree of detail in engraving is acceptable.

1.2 Machinery and job setup used for parameter finding

- Speedy 100
- Atmos Mono exhaust system
- Ferro-magnetic table plus honeycomb
- 2" lens
- Air assist
- Engraving over the whole working area with multiple rectangular engraving jobs
- "Speed" jobs are printed to JobControl[®] with 333 DPI; "Quality" jobs are printed to JobControl[®] with 600 DPI

1.3 General recommendations

- Engraving is recommended to be carried out from the bottom to the top, preventing residue from being pulled over freshly engraved parts on route to the exhaust, resulting in a cleaner engraving.
- Air assist is enabled ("On")
- Laser Correction (LC-value) is set to 10
- Accurate focus is prerequisite for good engraving and cutting results (controlled de-focus through Z-offset). Please make sure the material stays flat over the whole working area.

1.4 Individual parameter fine tuning

Depending on a specific application, minor adjustments of standard settings may allow for improved quality or reduced engraving time. For this, step-by-step adjustments in the range of +/- 10 % are recommended on power, speed and DPI.

→ **Tips:**

- Increasing the Z-Offset (controlled de-focus) can allow for an increased contrast and a darker engraving image. However, this may also result in a decrease of detail engraving.
- Increasing the laser pulse rate (Hz) when cutting can allow for a cleaned, flame polished edge, especially for transparent materials.

2 TroLase

→ Quality	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	60%	60%	600	1	On	+1 mm (0.04 ")
Cut 0,8mm (1/32 ")	40%	1,5%	1000	1	On	0
Cut 1,6mm (1/16 ")	50%	0,8%	1000	1	On	0
Cut 3,2mm (1/8 ")	90%	0,8%	1000	1	On	-1,6mm (1/16 ")

Print DPI: 600

→ Speed	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	90%	100%	500	1	On	+1 mm (0.04 ")
Cut 0,8mm (1/32 ")	80%	4%	1000	1	On	0
Cut 1,6mm (1/16 ")	100%	1,6%	1000	1	On	0
Cut 3,2mm (1/8 ")	100%	1%	1000	1	On	-1,6mm (1/16 ")

Print DPI: 333

3 TroLase Metallic Plus

→ Quality	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	60%	70%	600	1	On	+1 mm (0.04 ")
Cut 0,8mm (1/32 ")	40%	1,5%	1000	1	On	0
Cut 1,6mm (1/16 ")	50%	1%	1000	1	On	0
Cut 3,2mm (1/8 ")	90%	0,7%	1000	1	On	-1,6mm (1/16 ")

Print DPI: 600

→ Speed	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	80%	100%	500	1	On	+1 mm (0.04 ")
Cut 0,8mm (1/32 ")	80%	5%	1000	1	On	0
Cut 1,6mm (1/16 ")	90%	2%	1000	1	On	0
Cut 3,2mm (1/8 ")	90%	0,8%	1000	1	On	-1,6mm (1/16 ")

Print DPI: 333

4 TroLase Metallic

→ Quality	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	80%	80%	600	1	On	+1 mm (0.04 ")
Cut 0,8mm (1/32 ")	40%	1,5%	1000	1	On	0
Cut 1,6mm (1/16 ")	50%	1%	1000	1	On	0
Cut 3,2mm (1/8 ")	90%	0,7%	1000	1	On	-1,6mm (1/16 ")

Print DPI: 600

→ Speed	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	90%	100%	500	1	On	+1 mm (0.04 ")
Cut 0,8mm (1/32 ")	80%	5%	1000	1	On	0
Cut 1,6mm (1/16 ")	90%	2%	1000	1	On	0
Cut 3,2mm (1/8 ")	90%	0,8%	1000	1	On	-1,6mm (1/16 ")

Print DPI: 333

5 TroLase Reverse

→ Quality	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	60%	60%	600	1	On	+2,5mm (0.1 ")
Cut 1,6mm (1/16 ")	90%	1%	1000	1	On	0

Print DPI: 600

→ Speed	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	80%	100%	500	1	On	+2,5mm (0.1 ")
Cut 1,6mm (1/16 ")	90%	1,6%	1000	1	On	0

Print DPI: 333



6 TroLase Thins

→ Quality	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	60%	80%	600	1	On	+1 mm (0.04 ")
Cut 0,5mm (0.02 ")	25%	1,5%	1000	1	On	0

Print DPI: 600

→ Speed	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	60%	90%	500	1	On	+1 mm (0.04 ")
Cut 0,5mm (0.02 ")	25%	2%	1000	1	On	0

Print DPI: 333

7 TroLase ADA Signage

→ Quality	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Cut 0,8mm (1/32 ")	70%	2%	1000	1	On	0
Cut 1,0mm (0,04 ")	90%	2%	1000	1	On	0
Cut 1,6mm (1/16 ")	70%	1%	1000	1	On	0
Cut 3,2mm (1/8 ")	100%	0,5%	1000	1	On	0

Print DPI: 1000

→ Speed	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Cut 0,8mm (1/32 ")	100%	2,5%	1000	1	On	0
Cut 1,0mm (0,04 ")	100%	2%	1000	1	On	0
Cut 1,6mm (1/16 ")	100%	1,5%	1000	1	On	0
Cut 3,2mm (1/8 ")	100%	0,6%	1000	1	On	0

Print DPI: 1000

8 markSolid

→ Quality	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	60%	20%	500	1	On	0

Print DPI: 500

→ Speed	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	100%	30%	500	1	On	0

Print DPI: 500

9 TroGlass

→ Quality	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	36%	20%	500	1	On	0
Cut 3mm (0,118")	100%	0,4%	5000	1	On	0

Print DPI: 500

→ Speed	Power	Speed	PPI / HZ	Passes	Air Assist	Z-Offset
Engrave	38%	20%	500	1	On	0
Cut 3mm (0,118")	100%	0,6%	1000	1	On	0

Print DPI: 333

