



GRAVOTECH

by  BRADY



# ENGRAVING PARAMETERS

## LS900 EDGE

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## SUMMARY

PLASTICS >	Gravoply™ Laser	3
	Gravoply™ Ultra	
	Gravoply™ 2	
ACRYLICS >	Gravoglas™ 1	4
	Acrylic	
FLEXIBLE FOILS >	Rubbalase™	5
	Flexilase™	
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	Durablack®	
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## MACHINE CONFIGURATION



Machine	LS900 EDGE
Source power	CO2: 40 W
Lens	2"

## ENGRAVING EXAMPLES

**RASTER  
ENGRAVING**

**Raster**  
Text engraving

**VECTOR  
ENGRAVING**

**Vector**  
Line engraving

**VECTOR  
CUTTING**

**Vector cutting**  
Cutting

**GRAVOPLY™ LASER**

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster	0,8 mm	30	100	500	0	No	1
	1,3 mm	30	100	500	0	No	1
	1,6 mm	30	100	500	0	No	1
Vector	0,8 mm	10	100	500	0	No	1
	1,3 mm	10	100	500	0	No	1
	1,6 mm	10	100	500	0	No	1
Vector cutting	0,8 mm	60	40	500	0	Yes	1
	1,3 mm	90	30	500	0	Yes	1
	1,6 mm	90	25	500	0	Yes	1

**GRAVOPLY™ ULTRA**

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster	0,5 mm	30	100	500	0	No	1
	1,6 mm	30	100	500	0	No	1
	2,4 mm	30	100	500	0	No	1
Vector	0,5 mm	10	100	500	0	No	1
	1,6 mm	10	100	500	0	No	1
	2,4 mm	7	100	500	0	No	1
Vector cutting	0,5 mm	25	40	500	0	Yes	1
	1,6 mm	100	25	500	0	Yes	1
	2,4 mm	100	10	500	0	Yes	1

**GRAVOPLY™ 2**

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster	-	60	90	500	0	No	1
Vector	-	20	40	500	0	No	1

Gravoply™ 2 is not recommended for laser cutting, which is why no cutting parameters are provided.

## ACRYLICS

### GRAVOGLAS™ 1

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes	Comments
Raster	1,5 mm	60	90	500	0	No	1	Engraving below
	3 mm	60	90	500	0	No	1	Engraving below
	5 mm	60	90	500	0	No	1	Engraving below
Vector	1,5 mm	20	40	500	0	No	1	Engraving below
	3 mm	20	40	500	0	No	1	Engraving below
	5 mm	20	40	500	0	No	1	Engraving below
Vector cutting	1,5 mm	80	18	500	0	Yes	1	Leave a protection film
	3 mm	100	10	500	0	Yes	1	Leave a protection film
	5 mm	100	6	500	0	Yes	1	Leave a protection film

### ACRYLIC

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes	Comments
Raster	3 mm	30	100	500	0	No	1	
	5 mm	30	100	500	0	No	1	
	10 mm	30	100	500	0	No	1	
Vector	3 mm	10	100	500	0	No	1	
	5 mm	10	100	500	0	No	1	
	10 mm	10	100	500	0	No	1	
Vector cutting	3 mm	100	5	500	0	Yes	1	Pin table recommended
	5 mm	100	3	500	0	Yes	1	Pin table recommended
	10 mm	100	0,8	500	0	Yes	1	Pin table recommended

## FLEXIBLE FOILS

### RUBBALASE™

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster	2,2 mm	100	19	500	0	No	1
Vector cutting	2,2 mm	100	10	500	0	Yes	1
Vector Pnt	2,2 mm	100	10	500	0	Yes	1

### FLEXILASE™

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes	Comments
Raster	0,25 mm	28	100	500	0	No	1	Gravogrip use recommended for fixing
Vector	0,25 mm	10	100	500	0	No	1	Gravogrip use recommended for fixing
Vector cutting	0,25 mm	28	35	500	0	Yes	1	Gravogrip use recommended for fixing

### STICKALASE™

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes	Comments
Raster	0,09 mm	24	100	500	0	No	1	Gravogrip use recommended for fixing
Vector	0,09 mm	2	35	500	0	No	1	Gravogrip use recommended for fixing
Vector cutting	0,09 mm	4	35	500	0	Yes	1	Gravogrip use recommended for fixing

GRAVOLASE™ METALLICS

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster	0,5 mm	30	100	500	0	No	1
	1,6 mm	30	100	500	0	No	1
Vector	0,5 mm	10	100	500	0	No	1
	1,6 mm	10	100	500	0	No	1
Vector cutting	0,5 mm	23	40	500	0	Yes	1
	1,6 mm	80	20	500	0	Yes	1

METALLEX™

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster	0,5 mm	30	100	500	0	No	1
	0,8 mm	30	100	500	0	No	1
	1,6 mm	30	100	500	0	No	1
	2,4 mm	30	100	500	0	No	1
Vector	0,5 mm	9	100	500	0	No	1
	0,8 mm	9	100	500	0	No	1
	1,6 mm	9	100	500	0	No	1
	2,4 mm	9	100	500	0	No	1

Metallex™ is not recommended for laser cutting, which is why no cutting parameters are provided.

## METALS

### GRAVOXAL™

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster		100	50	500	0	No	1
Vector		30	100	500	0	No	1

Gravoxal™ is made of anodized aluminum, which makes it impossible to cut with a CO2 laser.

### ALUMAMARK®

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster		28	50	500	0	No	1
Vector		10	50	500	0	No	1

### DURABLACK®

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster		28	50	500	0	No	1
Vector		14	50	500	0	No	1

### GRAVOMETALL™

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster		30	100	500	0	No	1
Vector		20	50	500	0	No	1

Gravometal™ is made of brass, which makes it impossible to be cut with a CO2 laser.

## PHENOLICS

### GRAVOSTRAT™

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Raster		30	30	500	0	No	1
Vector		30	30	500	0	No	1

Gravostrat™ is not recommended for laser cutting, which is why no cutting parameters are provided.

## ADA

### GRAVOTAC™ EXTERIOR

Type	Thickness	Power	Speed	DPI (%)	Focus Offset	Air assist	Passes
Vector cutting	0,8 mm	30	37	500	0	Yes	1
	1,6 mm	100	27	500	0	Yes	1
	3,2 mm	100	9	500	0	Yes	1