

Kern Laser Settings (150 W)

| Material | Speed (in/s) | Power % | Laser Start % | Assist Type | Assist Pressure (psi) | Frequency |
|-------------------------------|--------------|-------------------------|---------------|-------------|-----------------------|-----------|
| Vector (Cutting) | | | | | | |
| 0.001" Mild Steel | 0.1 | 20% | 20% | Ambient Air | 110 | 500 |
| .020" Mild Steel | 0.1 | 30% | 20% | Ambient Air | 110 | 500 |
| .040" Mild Steel | 0.1 | 60% | 40% | Ambient Air | 80 | 500 |
| 0.025" Stainless Steel | 0.1 | 60% | 20% | Ambient Air | 110 | 500 |
| 0.006" Stainless Steel | 1 | 60% | 20% | Ambient Air | 110 | 500 |
| Raster (Engraving) | | | | | | |
| Mild Steel | 10 | Black = 80 White = 0 | 4 | Ambient Air | 80 | 600 DPI |
| Stainless Steel | 10 | Black = 70 White = 0 | 4 | Ambient Air | 80 | 600 DPI |

Note: These settings are approximations meant to give a good starting point. Please watch your cut carefully and stop your process if you see sparks/notice any issues. Vectors are classified as being hairline in width. Raster occurs when the lines are thicker than hairline or filled in (please scale color gradient accordingly)