

Epilog Fusion M2 CO₂ Laser Cutter: Suggested Material Settings **DRAFT**

Material	Process	DPI	Speed	Power	Frequency
Acrylic					
	Raster Engraving	300	90	40	100
	Vector Engraving	-			100
	Cutting 1/16"(1.5mm)	-			100
	Cutting 1/8"(3mm)	-	10	100	100
	Cutting 1/4"(6mm)	-	3	100	100
Bristol Board					
	Raster Engraving	300 - 400	40	15	15
	Vector Engraving	-	90	7	15
	Cutting 96lb	-	40	20	5
	Cutting 500 series	-	30	10	5
Butter Board					
	Raster Engraving	300 - 400	90	15	50
	Vector Engraving	-	90	20	50
	Cutting 1/32"(.75mm)	-			50
	Cutting 1/16"(1.5mm)	-	30	40	50
	Cutting 1/8"(3mm)	-			50
Chip Board					
	Raster Engraving	300 - 400	90	30	50
	Vector Engraving-Light	-	90	20	50
	Vector Engraving-Dark	-	90	40	50
	Cutting 1/32"(.75mm)	-	30	40	50
	Cutting 1/16"(1.5mm)	-	20	45	50
	Cutting 1/8"(3 mm)	-	10	80	50
	Cutting 1/4"(6 mm)	-			50
Cork					
	Raster Engraving	300			40
	Vector Engraving	-	90	30	40
	Cutting 1/16"(1.5mm)	-			40
	Cutting 1/8"(3mm)	-			40
	Cutting 1/4"(6mm)	-			40

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Material	Process	DPI	Speed	Power	Frequency
Mat Board					
	Raster Engraving	300			50
	Vector Engraving	-			50
	Cutting 1/16"(1.5mm)	-	30	40	50
	Cutting 1/8"(3mm)	-			50
Museum Board					
	Raster Engraving	300			50
	Vector Engraving	-			50
	Cutting 1/16"(1.5mm)	-	30	40	50
	Cutting 1/8"(3mm)	-			50
Plywood					
	Raster Engraving	400 - 600	70	100	10
	Vector Engraving	-	90	20	10
	Cutting 1/32"(.75mm)	-	50	100	10
	Cutting 1/8"(3mm)	-	20	100	10
	Cutting 3/16"(4.5mm)	-	12	100	10
Basswood					
	Raster Engraving	600	70	100	10
	Vector Engraving	-	60	100	10
	Cutting 1/32"(.75mm)	-	50	80	10
	Cutting 1/16"(1.5mm)	-	30	100	10
	Cutting 1/8"(3 mm)	-	20	100	10
	Cutting 3/16"(4.5mm)	-	10	100	10
	Cutting 1/4"(6mm)	-	5	100	10
Definitions					
	Raster Engraving	For text fills or images			
	Vector Engraving	For engraving vector lines for text or details without cutting			
	Cutting ___"(___mm)	For cutting through flat material of specified thickness			
	**These settings may vary depending on manufacturer and quality. If these settings don't produce the desired affect, consult a lab monitor, the TA, or Shop Manager.				