

# Camcode Laser Marking Materials - Settings Guide

The following information provides guidelines to help achieve consistent and high quality marks on DuraBlack<sup>®</sup>, AlumaMark<sup>®</sup> Natural, AlumaMark BlackPLUS<sup>™</sup> and Stainless Steel.

Optimal marking results are based on a combination of the power and speed settings. The goal is to achieve a high contrast and consistent mark. Too much power delivered at the point of contact will typically “bleed” the image. Too little power will result in a dark brown/streaky mark.

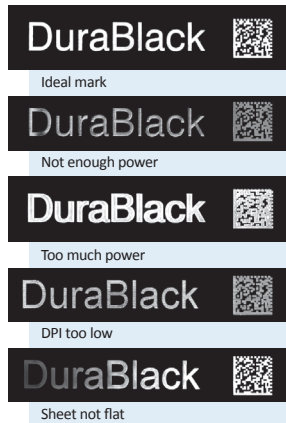
Expect some trial and error in order to achieve an optimal mark.



## CO<sub>2</sub> Laser Starting Point

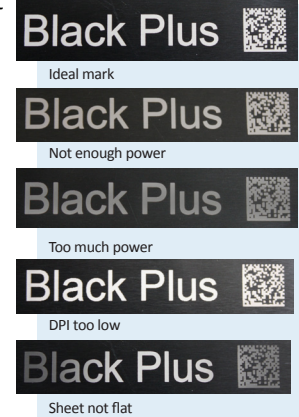
- Make sure sheet is lying flat during the lasing process.
- **Speed** - between 60-80%. Some dwell time is needed to create a good mark.
- **Power** - about 15-20 watts (50watt laser should be set at about 35%)
- **DPI** - set at 600dpi or higher
- **PPI** - set as high as possible (at least 1000).

Note - After marking, clean DuraBlack with soapy water to eliminate the blotchy appearance.



## YAG/Fiber Laser Starting Point

- Make sure sheet is lying flat during the lasing process.
- **Speed** - between 20-30%. Some dwell time is needed to create a good mark.
- **Power** - about 50 watts (50watt laser should be set at about 100%)
- **DPI** - set at 600dpi or higher
- **PPI** - set as high as possible (at least 1000).
- **Wavelength** - 80,000 Hz



## CO<sub>2</sub> Laser Starting Point

- Make sure sheet is lying flat during the lasing process.
- **Speed** - between 60-80%. Some dwell time is needed to create a good mark.
- **Power** - about 5-10 watts (50watt laser should be set at about 15%)
- **DPI** - set at 600dpi or higher
- **PPI** - set as high as possible (at least 1000).

Note - Lowering the bed of the laser about 1/8" (0.125") may help to achieve a more consistent and black mark.



## Satinless Steel

### CO<sub>2</sub> Laser Starting Point

- Make sure sheet is lying flat during the lasing process.
- **Speed** - between 30-40%. Some dwell time is needed to create a good mark.
- **Power** - about 35-40 watts (50watt laser should be set at about 70%)
- **DPI** - set at 600dpi or higher
- **PPI** - set as high as possible (at least 1000).

Note - After marking, soapy water will help to wash off excess coating.

