LBT™
Laser Bonding Technology

Laser Settings for *LaserBond 100* Aerosol Spray

The following table details recommended laser settings for the ***LaserBond 100*** material on most glass, ceramic and metals. These settings are designed to help guide the user to the optimum parameters as quickly as possible. Please note that there will be variations in substrate finish and between different brands of laser. It may still be necessary to perform further refinement of settings to achieve the desired mark.

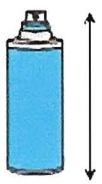
Suggested Laser Settings Used for CO_2 X-Y Laser						
Substrate Material	**Settings 45W laser**		**Settings 30W laser**		**Lens**	**DPI/PPI**
	Power (W)	**Speed (in/sec)**	**Power (W)**	**Speed (in/sec)**		
Glass	11	35	11	35	2"	500/1000
Ceramic	14	28	14	28	2"	500/1000
Stainless Steel	40	100	30	60	2"	600/600
Stainless Steel Bright Annealed	40	60	30	45	2"	600/600
Galvanized Steel	40	100	30	60	2"	600/600
Brass	45	30	30	20	2"	500/1000
Aluminum	45	30	30	20	2"	500/1000
Copper	45	30	30	20	2"	500/1000
Chrome	40	30	30	30	2"	500/1000
Nickel	40	40	30	30	2"	500/1000
Gold	45	20	30	15	2"	500/1000
Silver	45	10	30	7	2"	500/1000
Titanium	40	120	30	100	2"	500/1000
Pewter	40	70	30	50	2"	500/1000

Suggested Laser Settings Used for Beam Steered Nd:YAG, Fiber or DPSS Laser with a 100mm lens				
Substrate Material	**Power (W)**	**Speed (mm/sec)**	**Hatch Spacing (mm)**	**CW Mode or Q-Switch Freq**
Glass	8	300	0.05	CW /≥100KHz
Ceramic	10	100	0.05	CW /≥100KHz
Stainless Steel	20	300	0.05	CW /≥100KHz
Stainless Steel Bright Annealed	20	300	0.05	CW /≥100KHz
Galvanized Steel	20	250	0.05	CW /≥100KHz
Brass	20	100	0.05	CW /≥100KHz
Aluminum	20	100	0.05	CW /≥100KHz
Copper	20	100	0.05	CW /≥100KHz
Chrome	20	100	0.05	CW /≥100KHz
Nickel	20	250	0.05	CW /≥100KHz
Gold	20	150	0.05	CW /≥100KHz
Silver	20	100	0.05	CW /≥100KHz
Titanium	20	300	0.05	CW /≥100KHz
Pewter	20	200	0.05	CW /≥100KHz

Clean up: Wash with water or a wet towel. After use, the can nozzle should be cleaned by inverting the can and spraying until mist becomes clear. Any excess material on the nozzle should be removed with water. Nozzle can be removed and soaked in warm water or alcohol if spraying difficulty is encountered or nozzle becomes clogged.

IMPORTANT

- **Before Spray** - shake can vigorously for at least 1 minute to achieve even mixture of pigment within the ***LaserBond 100*** material.



- **After Spray** - turn can upside down and press nozzle for 3 - 4 seconds to clear ***LaserBond 100*** material in the valve.