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Vivak Transparent								
Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1	CUT/Schneiden	40	1.1	5000				

polystyrol weiß / polystyrene white								
Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
0.3	CUT/Schneiden	50	5	5000	2.5 Bar / Gas 1			
0.5	CUT/Schneiden	50	4.25	5000	2.5 Bar / Gas 1	10		
0.75	CUT/Schneiden	50	2.5	6500	2.5 Bar / Gas 1			
1	CUT/Schneiden	40	2	5000	2.5 Bar / Gas 1			
1.5	CUT/Schneiden	55	1.3	5000	2.5 Bar / Gas 1	10		
2	CUT/Schneiden	77	1.2	5000	2.5 Bar / Gas 1	10		
3	CUT/Schneiden	87	0.7	5000	2.5 Bar / Gas 1			
4								does not work
	carve / ritzen	40	15	2000		5		

polystyrol schwarz / polystyrene black								
Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
0.5	CUT/Schneiden	29	3	3500	2.5 Bar / Gas 1			
1	CUT/Schneiden	35	2.5	3500	2.5 Bar / Gas 1			
	carve / ritzen	20	30	1100				

PLEXIGLAS / PLEXIGLASS								
Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
0.4	CUT/Schneiden	30	5	5000	1 Bar / GAS 1			
0.5	CUT/Schneiden	30	3	5000	1 Bar / GAS 1			
0.75	CUT/Schneiden	40	1.5	5000	1 Bar / GAS 1			
1	CUT/Schneiden	40	1.1	5000	1 Bar / GAS 1			
1.5	CUT/Schneiden	40	1	5000	1 Bar / GAS 1	10		
2	CUT/Schneiden	40	0.8	5000	1 Bar / GAS 1			
2.5	CUT/Schneiden	40	0.45	5000	1 Bar / GAS 1			
3	CUT/Schneiden	90	1.15	5000	1 Bar / GAS 1			
3.5	CUT/Schneiden	90	1	5000	1 Bar / GAS 1			
4	CUT/Schneiden	90	0.6	5000	1 Bar / GAS 1			
4.5	CUT/Schneiden	90	0.7	5000	1 Bar / GAS 1			
5	CUT/Schneiden	95	0.5	5000	1 Bar / GAS 1			
6	CUT/Schneiden	90	0.5	5000	1 Bar / GAS 1	10		
6.5	CUT/Schneiden	90	0.55	5000	1 Bar / GAS 1			
8	CUT/Schneiden	90	0.3	5000	1 Bar / GAS 1			
9	CUT/Schneiden	90	0.35	5000	1 Bar / GAS 1			
10	CUT/Schneiden	90	0.22	5000	1 Bar / GAS 1			
12	CUT/Schneiden	90	0.15	5000	1 Bar / GAS 1	10		
15	CUT/Schneiden	90	0.12	5000	1 Bar / GAS 1	10		
16	CUT/Schneiden	90	0.1	5000	1 Bar / GAS 1			
	carve / ritzen	20	12	2000				very good value
	carve / ritzen	40	4	5000				very deep
	carve / ritzen	30	70	2000		10		super carve
	carve / ritzen	20	6	1000				fine carve

schwarze Plexiglas / Black Plexiglass								
Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
4	carve / ritzen	90	10	2000			10	1mm wide and deeply carved

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Lindenholz / Lime Tree, Basswood, Tilia

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
0.5	CUT/Schneiden	90	18	1000	2 Bar / Gas 1	5		
1	CUT/Schneiden	90	12	1000	2 Bar / Gas 1	5		
1.2	CUT/Schneiden	90	10	1000	2 Bar / Gas 1	5		
2	CUT/Schneiden	90	3.5	1000	2 Bar / Gas 1	5		
	carve / ritzen	70	30	1000				
	carve / ritzen	70	30	1000			5 mm	Strong Line

Balsa Holz / Balsa wood - Ochroma

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1	CUT/Schneiden	80	35	1000	2 Bar / Gas 1			
2	CUT/Schneiden	80	9.5	1000	2 Bar / Gas 1			
	carve / ritzen	60	50	1000	2 Bar / Gas 1			

Birkensperrholz / Birch Plywood

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1	CUT/Schneiden	100	8	1000	2 Bar / Gas 1			
2	CUT/Schneiden	100	1	1000	2 Bar / Gas 1			
4	CUT/Schneiden	100	0.5	1000	2 Bar / Gas 1			
	carve / ritzen	60	50	1000		15		

Pappelsperrholz / Poplar Plywood

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
3	CUT/Schneiden	100	3	1000	2 Bar / Gas 1			
4	CUT/Schneiden	100	2.5	1000	2 Bar / Gas 1			
6	CUT/Schneiden	100	1.5	1000	2 Bar / Gas 1			
8	CUT/Schneiden	100	0.5	1000	2 Bar / Gas 1			
	carve / ritzen	70	30	1000		5		

Furnier / Veneer

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Type
0.7	CUT/Schneiden	90	10	1000				Ahorn / Maple
0.5	CUT/Schneiden	90	15	1000				Nußbaum - Walnut
1	CUT/Schneiden	90	12	1000				Kirschbaum - Cherry Tree
1	CUT/Schneiden	90	10	1000				Birnbaum / Pear Tree
1.5	CUT/Schneiden	90	7	1000				Mahagoni / Mahogoni

Buchenholzmassive / Solid Beech

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
7.7	CUT/Schneiden	100	0.5	1000				

Flugzeugsperrholz / Aircraft Plywood

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
0.6	CUT/Schneiden	70	4.7	3000				
0.8	CUT/Schneiden	70	4.2	3000				
1	CUT/Schneiden	70	2.5	3000				
1.5	CUT/Schneiden	70	1.8	3000				
2	CUT/Schneiden	80	1.5	3000		20		
2.5	CUT/Schneiden	80	1	3000				
3	CUT/Schneiden	70	0.5	3000				

Please note that the following paper/cellulose base materials could be also cut/engraved with the Zund Cutter machine. It is faster, more environmentally friendly, and less hazardous to work with the Zund cutter. We suggest using the Zund Cutter unless you specifically need the quality or aesthetics of the Laser Engraver machine.

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Graukarton / Greyboard

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
0.5	CUT/Schneiden	70	3.8	5000				
1	CUT/Schneiden	70	3	5000				
1.5	CUT/Schneiden	70	2	5000				
2	CUT/Schneiden	70	1.5	5000				
2.7	CUT/Schneiden	80	1.25	5000				
3	CUT/Schneiden	80	1.2	5000				
3.8	CUT/Schneiden	80	1.1	5000				
4	CUT/Schneiden	80	0.8	5000				
	carve / ritzen	60	90	1000		5		heavily scratched
	carve / ritzen	33	80	1000				very finely carved

weißpappe / White Cardboard

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1	CUT/Schneiden	40	3.9	2000				
2	CUT/Schneiden	50	2.5	3000				
	carve / ritzen	40	60	2000				

schwarzer karton glatt / Black Cardboard smooth

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1	CUT/Schneiden	70	3	5000				
2	CUT/Schneiden	75	1.3	5000				

Wellpappe / corrugated cardboard

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1.5	CUT/Schneiden	70	2	2000				
3	CUT/Schneiden	90	3.5	2000				
4	CUT/Schneiden	90	3.25	2000				
5	CUT/Schneiden	100	3	2000				
6.5	CUT/Schneiden	100	3.1	2000				
	carve / ritzen	70	60	1000				

Finnpappe (hell) / Finnboard (bright)

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1	CUT/Schneiden	50	2	5000				
1.5	CUT/Schneiden	55	3.5	5000		5		
2	CUT/Schneiden	65	3.25	5000				
3	CUT/Schneiden	65	3	5000				
4	CUT/Schneiden	60	3.1	5000				
	carve / ritzen	40	90	2000		5		

Siebdruckkarton / Screen Printing Carton

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1	CUT/Schneiden	45	4.5	3000				
1.5	CUT/Schneiden	45	3.3	3000				
2	CUT/Schneiden	40	2	1000				
	carve / ritzen	30	70	1000		5		

Sandwichplatte (weiß) / Sandwich Board (white)

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
1.5	CUT/Schneiden	40	4	1000				
3	CUT/Schneiden	60	4	1000				
5	CUT/Schneiden	80	4	1000				
10	CUT/Schneiden	80	1.25	1000				

Sandwichplatte (schwarz) / Sandwich Board (Black)

Cut Thickness (mm)	Operation	P	V	PPI/Hz	Air Assist	Correction	offset	Notes
5	CUT/Schneiden	19	1	1500				