

## DURABLACK LASER SETTINGS GUIDE

The following information provides guidelines to help achieve consistent and high quality marks on DuraBlack. Optimal marking results are based on a combination of the power and speed settings.

The goal is to achieve a consistent white-metallic mark. Too much power delivered at the point of contact will "bleed" the image. Too little power will result in a dark brown/streaky black mark. Expect some trial and error in order to achieve an optimal mark.

Marking sheets can result in some tacky residue on the surface of the lased area. Wipe the sheet with isopropyl alcohol to remove residue.

### Settings 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).



DuraBlack



Ideal mark

DuraBlack

Not enough power

DuraBlack



Too much power

DuraBlack

DPI too low

DuraBlack

Sheet not flat

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