

LASER ENGRAVING ALUMAMARK

What is AlumaMark?

AlumaMark is a form of Laser Engraveable Aluminum. It consists of 3 different layers. The first layer, which is the bottom layer, is made of regular Aluminum. The second/ middle layer is comprised of laser sensitive coating that makes up the engraved part of AlumaMark. The third/top layer is a clear coat to protect the AlumaMark sheet. Correctly processed, it results in a dark black engraving.

Notes:

- Sheets are markable on one side only. Peel off the protective layer.
- Satin Silver, Red, Blue, Green, Yellow & Orange use less power than other finishes.
- The goal is to achieve a dark black mark – not to etch the material.
- Expect some trial & error to compensate for your laser tube.
- Wipe away any engraving residue.

Using AlumaMark

Power and Speed Settings (all settings assume a DPI and PPI of at least 600)

Laser (in watts)	Speed	Gold/Bronze Power	Silver/Colored Power
Epilog 35w	30	10	8
Epilog 40w	30	25	22
Epilog 75w	30	25	22
GCC / LaserPro 12.5w	70	35	31
GCC / LaserPro 35w	70	12	10
GCC / LaserPro 50w	100	30	27
Trotec 30w	15	15	13
Trotec 45w	20	13	11
Universal 25w	80	45	40
Universal 30w	80	36	32
Universal 35w	80	30	27
Universal 50w	80	17	15
Universal 100w	80	6	4
Xenotech 30w	80	56	50

****These are common settings. Use these as a starting point and trial & error to get settings for your laser.**

Universal Laser users: settings for Gold/Bronze AlumaMark have been included with the current Materials Database.

Reduce 'Intensity' slider for Silver/Colored AlumaMark.

Troubleshooting

If the image you have engraved is a dense black color, then you have successfully engraved your design onto AlumaMark. You have reached optimal results and maximized contrast, resolution, and durability performance.

Optimal

The engraved area is shiny and dense black.



Over Mark

The result is a grayish mark with slight etching or relief. The marked area can look “flat” or matte especially when viewing at an angle. This is usually caused by an insufficient speed setting or a power setting that is too high.



Under Mark

Under marking results in a brownish or faint image. Under marking can also cause inconsistency in the image as power is delivered unevenly to the AlumaMark. This is caused by too little power. These sheets can be lasered again with slightly more power until optimal is reached.



JOHNSONPLASTICS
PLUS

Phone: (800) 869-7800 • Email: service@johnsonplastics.com

Connect with us: [f](#) [in](#) [t](#) [u](#)