

激光机切割参数表（此数据仅提供参考）

材料	材料厚度	最大功率25W		40W		60W		80W		100W		120W		150W		180W		200W		300W		备注(激光功率为95%)	
		最高速度	最佳速度	最高速度	最佳速度	最高速度	最佳速度	最高速度	最佳速度	最高速度	最佳速度	最高速度	最佳速度	最高速度	最佳速度	最高速度	最佳速度	最高速度	最佳速度	最高速度	最佳速度		
亚克力	3mm	8mm/s	5mm/s	15mm/s	10mm/s	20mm/s	15mm/s	25mm/s	20mm/s	30mm/s	25mm/s	35mm/s	30mm/s	40mm/s	35mm/s	45mm/s	40mm/s	55mm/s	45mm/s	75mm/s	70mm/s	亚克力切割要注意气流控制，材料表面吹气量要小些或侧吹，这样可以保证亚克力的光滑度；材料底面要有空气流动，防止起火。	
	5mm	4mm/s	2mm/s	8mm/s	5mm/s	10mm/s	7mm/s	12mm/s	8mm/s	15mm/s	10mm/s	17mm/s	12mm/s	21mm/s	15mm/s	25mm/s	18mm/s	30mm/s	25mm/s	41mm/s	36mm/s		
	8mm	1mm/s	---	4mm/s	2mm/s	5mm/s	3mm/s	9mm/s	5mm/s	10mm/s	6mm/s	12mm/s	8mm/s	15mm/s	10mm/s	18mm/s	12mm/s	25mm/s	15mm/s	30mm/s	25mm/s		
	1cm	---	---	3mm/s	---	4mm/s	2mm/s	6mm/s	3mm/s	7mm/s	4mm/s	8mm/s	5mm/s	11mm/s	7mm/s	16mm/s	10mm/s	20mm/s	13mm/s	21mm/s	15mm/s		
	15mm	---	---	---	---	2mm/s	0.8mm/s	3mm/s	1.5mm/s	4mm/s	2mm/s	5mm/s	3mm/s	7mm/s	4mm/s	9mm/s	6mm/s	11mm/s	8mm/s	14mm/s	9mm/s		
	20mm	---	---	---	---	1mm/s	0.3mm/s	1mm/s	0.3mm/s	0.7mm/s	0.3mm/s	1mm/s	1mm/s	0.4mm/s	1.5mm/s	1.5mm/s	4.5mm/s	2mm/s	5.5mm/s	3mm/s	6.5mm/s		3.5mm/s
	25mm	---	---	---	---	---	---	0.5mm/s	0.2mm/s	0.8mm/s	0.3mm/s	1mm/s	0.4mm/s	1.8mm/s	0.8mm/s	2.5mm/s	1.2mm/s	3mm/s	1.5mm/s	3.6mm/s	2mm/s		
	30mm	---	---	---	---	---	---	---	---	0.3mm/s	---	0.5mm/s	0.3mm/s	0.8mm/s	0.5mm/s	1.3mm/s	0.8mm/s	2mm/s	1.2mm/s	2.5mm/s	1.8mm/s		
	35mm	---	---	---	---	---	---	---	---	---	---	0.2mm/s	---	0.4mm/s	0.1mm/s	0.6mm/s	0.3mm/s	1mm/s	0.7mm/s	1.4mm/s	1mm/s		
	40mm	---	---	---	---	---	---	---	---	---	---	---	---	0.1mm/s	---	0.2mm/s	0.1mm/s	0.4mm/s	0.3mm/s	0.8mm/s	0.5mm/s		
刀模版	15mm	---	---	---	---	---	---	---	---	---	---	4mm/s	3mm/s	6mm/s	4.5mm/s	8mm/s	6mm/s	11mm/s	9mm/s	12mm/s	10mm/s	刀模版切割主要注意焦距和气流控制，气流量越大切割速度越快，出气孔越小作用在材料单位面积上的力越大；聚焦镜建议使用焦距100mm以上的，这样焦距长，可以更好的达到刀缝精度。	
	18mm	---	---	---	---	---	---	---	---	---	---	2mm/s	1.2mm/s	4mm/s	2.5mm/s	5mm/s	3.5mm/s	8mm/s	6mm/s	9mm/s	8mm/s		
	20mm	---	---	---	---	---	---	---	---	---	---	---	---	2.5mm/s	1.8mm/s	3.5mm/s	2.5mm/s	6mm/s	4.5mm/s	8mm/s	7mm/s		
密度板（高密度板）	3mm	4mm/s	---	7mm/s	5mm/s	12mm/s	10mm/s	15mm/s	13mm/s	18mm/s	15mm/s	22mm/s	18mm/s	21mm/s	18mm/s	25mm/s	20mm/s	30mm/s	25mm/s	50mm/s	45mm/s	密度板切割主要注意气流控制，气流越大，切割速度越快。	
	5mm	---	---	2.5mm/s	---	4mm/s	---	6mm/s	---	8mm/s	7mm/s	12mm/s	10mm/s	13mm/s	10mm/s	15mm/s	12mm/s	17mm/s	14mm/s	30mm/s	27mm/s		
	8mm	---	---	---	---	---	---	---	---	---	---	---	---	---	8mm/s	6mm/s	10mm/s	8mm/s	12mm/s	10mm/s	25mm/s		20mm/s
	10mm	---	---	---	---	---	---	---	---	---	---	---	---	---	5mm/s	---	7mm/s	5mm/s	9mm/s	7mm/s	16mm/s		15mm/s
	12mm	---	---	---	---	---	---	---	---	---	---	---	---	---	---	5mm/s	---	7mm/s	5mm/s	13mm/s	11mm/s		
18mm	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	3mm/s	---	6mm/s	5mm/s	6mm/s	5mm/s		
皮革	单层	6mm/s	5mm/s	15mm/s	12mm/s	20mm/s	17mm/s	25mm/s	20mm/s	30mm/s	25mm/s	40mm/s	35mm/s	45mm/s	40mm/s	50mm/s	45mm/s	60mm/s	55mm/s	85mm/s	75mm/s	皮革切割建议用焦距50的聚焦镜配合60W-100W的激光管和小型空压机使用。	
木板（稀有硬质木材除外）	3mm	4mm/s	---	10mm/s	8mm/s	15mm/s	12mm/s	20mm/s	18mm/s	25mm/s	22mm/s	30mm/s	28mm/s	35mm/s	33mm/s	40mm/s	37mm/s	45mm/s	42mm/s	---	---	木板切割主要注意气流控制，气流量越大，切割速度越快。	
	5mm	---	---	5mm/s	---	10mm/s	8mm/s	15mm/s	10mm/s	20mm/s	18mm/s	25mm/s	22mm/s	30mm/s	28mm/s	35mm/s	32mm/s	40mm/s	36mm/s	---	---		
	10mm	---	---	---	---	4mm/s	---	8mm/s	6mm/s	12mm/s	10mm/s	15mm/s	13mm/s	20mm/s	17mm/s	25mm/s	20mm/s	30mm/s	23mm/s	---	---		
	15mm	---	---	---	---	---	---	---	---	---	8mm/s	5mm/s	11mm/s	8mm/s	15mm/s	13mm/s	18mm/s	15mm/s	20mm/s	17mm/s	---		---
布料	单层	25mm/s	20mm/s	40mm/s	38mm/s	60mm/s	58mm/s	100mm/s	98mm/s	200mm/s	195mm/s	300mm/s	295mm/s	400mm/s	395mm/s	500mm/s	495mm/s	600mm/s	590mm/s	800mm/s	700mm/s	同皮革切割	
PVC	2mm	15mm/s	13mm/s	35mm/s	32mm/s	50mm/s	45mm/s	60mm/s	58mm/s	70mm/s	68mm/s	80mm/s	78mm/s	90mm/s	88mm/s	100mm/s	98mm/s	120mm/s	118mm/s	170mm/s	160mm/s	PVC切割建议使用焦距50的聚焦镜配合60W-100W的激光管，并且功率在50%-70%	
	3mm	12mm/s	10mm/s	30mm/s	27mm/s	40mm/s	38mm/s	50mm/s	48mm/s	60mm/s	58mm/s	70mm/s	68mm/s	80mm/s	78mm/s	90mm/s	88mm/s	110mm/s	108mm/s	160mm/s	150mm/s		
	4mm	---	---	25mm/s	20mm/s	35mm/s	30mm/s	45mm/s	40mm/s	55mm/s	50mm/s	65mm/s	63mm/s	75mm/s	73mm/s	85mm/s	80mm/s	100mm/s	98mm/s	140mm/s	130mm/s		
铁板	2mm	---	---	---	---	---	---	---	---	---	---	---	---	8mm/s	6mm/s	13mm/s	10mm/s	15mm/s	12mm/s	21mm/s	15mm/s	铁板切割需要氧气辅助，氧气压力为0.8mpa	
	3mm	---	---	---	---	---	---	---	---	---	---	---	---	---	---	5mm/s	---	10mm/s	8mm/s	16mm/s	12mm/s		
松木夹板	20mm	---	---	---	---	---	---	---	---	18mm/s	15mm/s	22mm/s	18mm/s	25mm/s	22mm/s	30mm/s	25mm/s	35mm/s	30mm/s	50mm/s	42mm/s	同PVC切割	
双芭板	2mm	10mm/s	7mm/s	15mm/s	13mm/s	25mm/s	20mm/s	35mm/s	30mm/s	40mm/s	35mm/s	45mm/s	40mm/s	55mm/s	50mm/s	65mm/s	60mm/s	80mm/s	75mm/s	100mm/s	95mm/s		
纸张	单层	50mm/s	40mm/s	80mm/s	40mm/s	120mm/s	40mm/s	150mm/s	40mm/s	250mm/s	40mm/s	350mm/s	40mm/s	450mm/s	40mm/s	550mm/s	40mm/s	650mm/s	40mm/s	900mm/s	40mm/s	纸张切割要注意激光功率调节，激光管功率越高激光调节百分比越小。	
橡胶板	4mm	5mm/s	4mm/s	15mm/s	13mm/s	25mm/s	20mm/s	30mm/s	27mm/s	35mm/s	33mm/s	40mm/s	38mm/s	45mm/s	43mm/s	50mm/s	48mm/s	60mm/s	58mm/s	---	---	橡胶板一般为单层切割，表层穿透即可，表格所属为表层切割参数。	
	6mm	2mm/s	1mm/s	10mm/s	8mm/s	15mm/s	10mm/s	18mm/s	15mm/s	20mm/s	18mm/s	25mm/s	23mm/s	30mm/s	28mm/s	35mm/s	33mm/s	45mm/s	43mm/s	---	---		
不锈钢	0.6mm	---	---	---	---	19mm/s	16mm/s	25mm/s	20mm/s	30mm/s	27mm/s	36mm/s	32mm/s	50mm/s	46mm/s	64mm/s	55mm/s	70mm/s	60mm/s	120mm/s	100mm/s	---	
	0.8mm	---	---	---	---	---	---	18mm/s	15mm/s	24mm/s	20mm/s	30mm/s	23mm/s	42mm/s	35mm/s	52mm/s	48mm/s	62mm/s	50mm/s	85mm/s	65mm/s		
	1mm	---	---	---	---	---	---	---	---	10mm/s	8mm/s	15mm/s	10mm/s	28mm/s	24mm/s	35mm/s	32mm/s	40mm/s	38mm/s	60mm/s	50mm/s		
	1.5mm	---	---	---	---	---	---	---	---	---	---	10mm/s	8mm/s	16mm/s	13mm/s	22mm/s	18mm/s	25mm/s	22mm/s	30mm/s	24mm/s		
	2mm	---	---	---	---	---	---	---	---	---	---	---	---	10mm/s	8mm/s	12mm/s	10mm/s	14mm/s	12mm/s	18mm/s	16mm/s		
碳钢	1mm	---	---	---	---	---	---	---	---	---	---	15mm/s	10mm/s	32mm/s	28mm/s	35mm/s	30mm/s	40mm/s	35mm/s	60mm/s	50mm/s	---	
	2mm	---	---	---	---	---	---	---	---	---	---	---	---	11mm/s	8mm/s	13mm/s	10mm/s	15mm/s	12mm/s	21mm/s	15mm/s		
	3mm	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	16mm/s	12mm/s		
铝朔板	2mm	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	---	24mm/s	27mm/s	---		

