

# CNSI Microfluidics Laser Cutting Data

## Material Vendors

Acrylic sheet, optically clear, from McMaster Carr: part number 8560K239  
<http://www.mcmaster.com/#catalog/119/3558/=molz4w>

## Cutting Parameters

### Acrylic Sheet

Cutting 1/8", 100% power, 0.4 ipm, 2000 Hz, (Dave Bothman, 5/5/13 - clean cut)

Cutting 1/4", 100% power, 0.15 ipm, 1000 Hz, z offset -.125, (Dave Bothman, 5/5/13 - clean cut)

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### PDMS

250um PDMS with mylar backing on back side and removed from front

Cutting 42% power, 2.0 ips, 5000Hz (Peter Mage, 5/9/13 - some flash and soot - recipe needs to be refined)

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### Double Sticky Tape

25% power, 3 ips

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### Guideline Cutting Recipes

Heading 1	Heading 2	Heading 3
Row 1 Col 1	Row 1 Col 2	Row 1 Col 3
Row 2 Col 1	some colspan (note the double pipe)	
Row 3 Col 1	Row 3 Col 2	Row 3 Col 3

- Recipes from Vincent
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Last update: **2014/07/16 21:23**

