

# 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)

### 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)

### Double Sticky Tape

25% power, 3 ips

Gore Teflon Foam 1/16" 15% power, 0.5% speed, 1000 Hz (DB 7/9/15)

Silicone Rubber sheet, 1/8" 100% power, 0.1% speed, 2000 Hz - use Nitrogen gas (DB 7/9/15)

## Guideline Cutting Recipes

### Acrylic

1. 1/8 acrylic

	Color	Power	Speed	PPI/Hz	Passes	Air Assist	Correction	Z-Offset
<b>Engrave</b>	Black	25	20	PPI	-	on	0	0

	Color	Power	Speed	PPI/Hz	Passes	Air Assist	Correction	Z-Offset
<b>Cut</b>	Red	25	0.4	Hz	1	on	10	0
<b>Cut</b>	Blue	100	0.4	PPI	1	on	10	0

-1/10 acrylic

	Color	Power	Speed	PPI/Hz	Passes	Air Assist	Correction	Z-Offset
<b>Skip</b>	Black	-	-	-	-	on	-	-
<b>Cut</b>	Red	2	0.1	Hz	1	Hz	1	0
<b>Cut</b>	Blue	15	0.5	Hz	5	Gas 1	0	0

	Color	Power	Speed	PPI/Hz	Passes	Air Assist	Correction	Z-Offset
<b>Engrave</b>	Row 1 Col 2	Row 1 Col 3						
<b>Cut</b>	no colspan this time							
<b>Cut</b>	Row 2 Col 2	Row 2 Col 3						

- Recipes from Vincent

	Heading 1	Heading 2
<b>Heading 3</b>	Row 1 Col 2	Row 1 Col 3
<b>Heading 4</b>	no colspan this time	
<b>Heading 5</b>	Row 2 Col 2	Row 2 Col 3

- Recipes from Rachel

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<b>Heading 3</b>	Row 1 Col 2	Row 1 Col 3
<b>Heading 4</b>	no colspan this time	
<b>Heading 5</b>	Row 2 Col 2	Row 2 Col 3

- Recipes from Ola

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<b>Heading 3</b>	Row 1 Col 2	Row 1 Col 3
<b>Heading 4</b>	no colspan this time	
<b>Heading 5</b>	Row 2 Col 2	Row 2 Col 3

- Recipes from Beach

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