

Raw material processing settings

| Method | Raw material | Details | Macheine | Settings |
|---------------|--------------------------|---------------------------------------------------------------|--------------------------------------|--------------------------------------------------------------|
| Laser cutting | TPU | Thickness 0.1 mm | Universal Laser Systems' Ultra X6000 | Mode Vect, Power 100, Speed 70 Ppi 500, Z-axis 0.125 |
| | Acrylic, Thickness: 3 mm | for engraving the resistor channel | | Mode Vect, Power 100%, Speed 15%, PPI 500, Z-Axis 0.125 |
| | | for engraving the capacitor channel and switch bottom channel | | Mode Rast/Vect, Power 100%, Speed 5%, PPI 1000, Z-Axis 0.125 |
| | | for cutting through (components) | | ModeVect, Power100%, Speed 3.4%, PPI 1000, Z-Axis 0.125 |
| | Acrylic Thickness: 6 mm | for cutting through (mold) | | ModeVect, Power100%, Speed 1.5%, PPI 1000, Z-Axis 0.125 |
| | VHB tape | 3M 4905 | | Mode Vect, Power 100, Speed 7, PPI 500, Z-axis 0.125 |
| 3D print | Clear Resin | for printing the connectors | FormLabs | resolution 0.1mm |