

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