

ACMER P2-10W Engraving Parameters

Material	Line Interval	Speed (mm/min)	Power (%)	Note
Basswood	0.09mm	8000	100	
Leather	0.09mm	20000	80	
Kraft Paper	0.09mm	20000	100	
MDF	0.09mm	20000	100	
Carton	0.09mm	20000	100	
Stainless Steel	0.08mm	800	100	It is recommended to choose a thicker stainless steel.
Anodized Aluminum	0.08mm	6000	100	
Glass	0.09mm	10000	100	Engraving is done after the material is blackened or color paper is applied to the surface.
Ceramics	0.09mm	10000	100	The engraving is done after the color paper is applied to the surface of the material.
Acrylic	0.09mm	20000	100	

ACMER P2-10W Cutting Parameters

Material	Thickness	Speed (mm/min)	Power (%)	Passes	Note
Plywood	4mm	200	100	1	
Plywood	6mm	120	100	1	
Plywood	8mm	150	100	2	
Plywood	10mm	150	100	8	Focal length reduced to 2mm
Bamboo	4mm	100	100	1	
Pine wood	5mm	200	100	1	
Pine wood	10mm	200	100	3	

Leather	1mm	1500	100	1	
Kraft paper	1mm	1500	100	1	
EPE foam board	10mm	800	70	1	
MDF	2mm	200	100	1	
MDF	3mm	180	100	2	
Acrylic	2mm	150	100	1	Must be black non-transparent acrylic to be cut.
Acrylic	4mm	150	100	2	
Acrylic	6mm	150	100	4	
Warm Tip	<p>1. Please note the above units of speed and power and convert them in Lightburn and LaserGRBL by yourself.</p> <p>2. For some materials with low burning point, it is not recommended to set the cutting speed below 100mm/min, otherwise there may be a risk of burning!</p> <p>3. Even for the same material, the effect will be different for different surface treatment or different colors, so you need to adjust the speed and power according to different objects. In addition, please adjust the focal length to the best, so that the focal length is minimal.</p> <p>4. Can't engrave or cut directly: glossy metal plates, transparent materials, reflective materials, some white or translucent materials, etc. Then you need to blacken it with a marker to carve.</p>				