

ACMER P2-33W Engraving Parameters

Material	Line Interval	Speed (mm/min)	Power (%)	Note
Basswood	0.12mm	13000	100	
Leather	0.12mm	20000	40	
Kraft paper	0.12mm	20000	65	
MDF	0.12mm	20000	65	
Carton	0.12mm	20000	60	
Stainless Steel	0.09mm	3000	100	It is recommended to choose a thicker stainless steel.
Anodized aluminum	0.09mm	15000	100	
Wrench (galvanized iron)	0.09mm	4000	100	
Glass	0.12mm	20000	70	Engraving is done after the material is blackened or color paper is applied to the surface.
Ceramics	0.12mm	20000	70	The engraving is done after the color paper is applied to the surface of the material.
Acrylic	0.12mm	20000	40	

ACMER P2-33W Cutting Parameters

Material	Thickness	Speed (mm/min)	Power (%)	Passes	Note
Plywood	4mm	500	100	1	
Plywood	6mm	400	100	1	
Plywood	8mm	300	100	1	
Plywood	10mm	200	100	1	Focal length reduced to 2mm
Plywood	12mm	100	100	1	

Bamboo	4mm	400	100	1	
Bamboo	8mm	200	100	1	Focal length reduced to 2mm
Paulownia wood	15mm	200	100	1	
Paulownia wood	20mm	150	100	1	
Pine wood	5mm	500	100	1	
Pine wood	10mm	200	100	1	
Leather	1mm	4500	100	1	
Kraft paper	1mm	4500	100	1	
EPE foam board	10mm	1000	40	1	
MDF	2mm	800	100	1	
MDF	3mm	700	100	1	
MDF	5mm	200	100	1	
Acrylic	2mm	400	100	1	Must be black non-transparent acrylic to be cut.
Acrylic	4mm	200	100	1	
Acrylic	6mm	200	100	2	
Acrylic	10mm	200	100	4	
Acrylic	15mm	200	100	6	
Warm Tip	1. Please note the above units of speed and power and convert them in Lightburn and LaserGRBL by yourself. 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! 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. 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.				