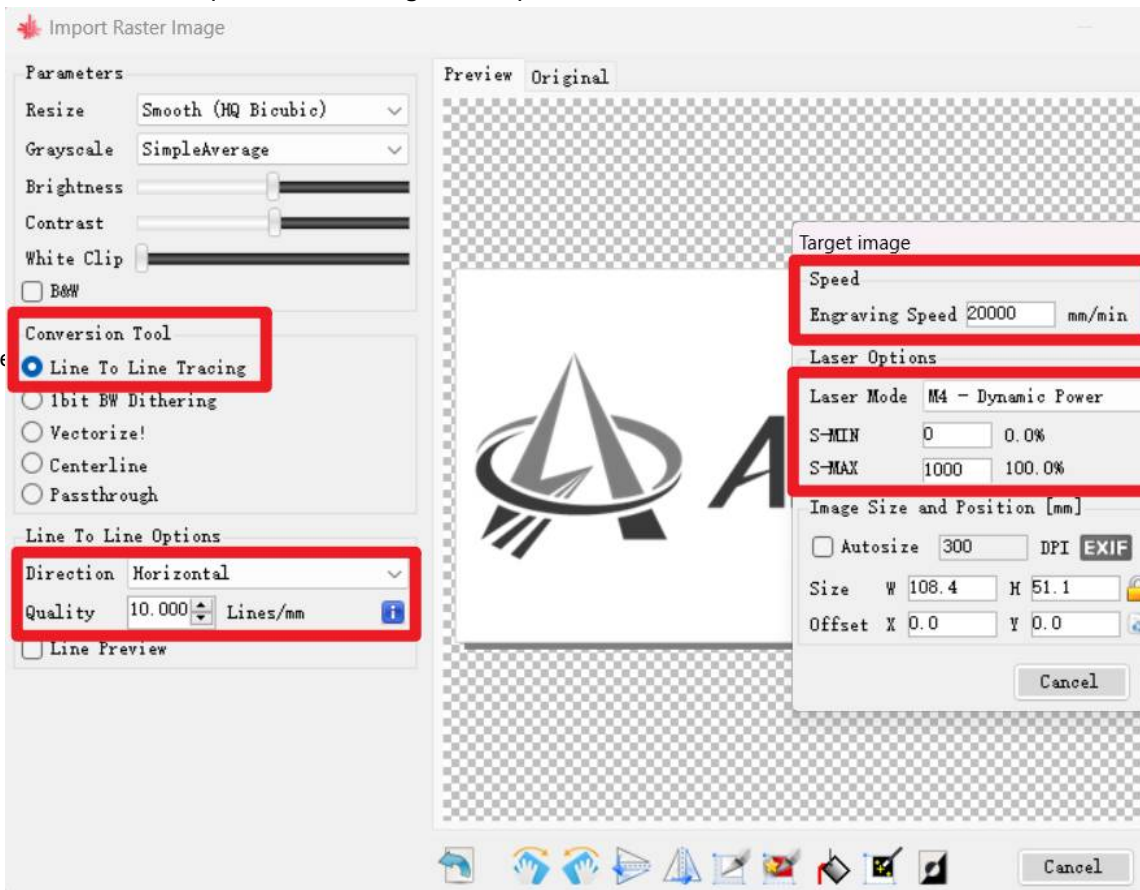


Material Parameter Reference of AlgoLaser_Delta for 20W for LaserGRBL									
Material	Conversion Tool	Direction	Quality	Speed (mm/min)	Laser Mode	S-MIN (Laser Power %)	S-MAX (Laser Power %)	Remark	Reference Picture(Parameter setting location)
Birch Plywood	Line To Line Tracing	Horizontal	20	25000	M4	0%	100%		
Basswood Plywood	Line To Line Tracing	Horizontal	20	25000	M4	0%	100%		
Eucalyptus plywood	Line To Line Tracing	Horizontal	20	15000	M4	0%	100%		
Pine Board	Line To Line Tracing	Horizontal	10	25000	M4	0%	100%		
Paulownia Plank	Line To Line Tracing	Horizontal	20	15000	M4	0%	100%		
MDF	Line To Line Tracing	Horizontal	20	40000	M4	0%	100%		
Black Acrylic	Line To Line Tracing	Horizontal	10	20000	M4	0%	100%		
Green Acrylic	Line To Line Tracing	Horizontal	20	20000	M4	0%	100%		
Orange Acrylic	Line To Line Tracing	Horizontal	20	20000	M4	0%	100%		
Blue Acrylic	/	/	/	/	/	/	/	Blue Light is Absorbed	
Yellow Acrylic	Line To Line Tracing	Horizontal	20	20000	M4	0%	100%		
Red Acrylic	Line To Line Tracing	Horizontal	20	20000	M4	0%	100%		
PolyVinyl Chloride (雪弗板)	Line To Line Tracing	Horizontal	20	30000	M4	0%	100%		
Gray Cardboard	Line To Line Tracing	Horizontal	20	40000	M4	0%	100%		
White Cardboard	Line To Line Tracing	Horizontal	20	15000	M4	0%	100%		
Black Cardboard	Line To Line Tracing	Horizontal	20	30000	M4	0%	100%		
Coated Duplex Board (牛卡纸)	Line To Line Tracing	Horizontal	10	30000	M4	0%	100%		
Leather	Line To Line Tracing	Horizontal	20	50000	M4	0%	100%		
colored paper	Line To Line Tracing	Horizontal	20	50000	M4	0%	100%		
Navy Blue canvas	Line To Line Tracing	Horizontal	10	20000	M4	0%	100%		
denim	Line To Line Tracing	Horizontal	20	20000	M4	0%	100%		
rubber	Line To Line Tracing	Horizontal	10	30000	M4	0%	100%		
white ABS sheet	/	/	/	/	/	/	/		
black ABS sheet	Line To Line Tracing	Horizontal	20	30000	M4	0%	100%		
bamboo	Line To Line Tracing	Horizontal	20	20000	M4	0%	100%		
Stainless steel	Line To Line Tracing	Horizontal	20	3000	M4	0%	100%		
cold rolled sheet	Line To Line Tracing	Horizontal	20	2000	M4	0%	100%		
coated metal	Line To Line Tracing	Horizontal	10	20000	M4	0%	100%		
dry leaves	Line To Line Tracing	Horizontal	10	30000	M4	0%	100%		
clear acrylic	Laser Color Paper								
copper	/	/	/	/	/	/	/		
gold	/	/	/	/	/	/	/		
Pure aluminum	/	/	/	/	/	/	/		
pure iron	/	/	/	/	/	/	/		

Notice:

1、The results would be different in even same material with different finishing or different colors, So you need to adjust the speed and power rate based on different objects. Also, please adjust the focal length to be the best, make the focal spot to be the smallest.

2、It couldn't engrave or cut directly: Glossy metal plate, Transparent materials, Reflecting materials, Some materials in white color or pervious to light, etc. Then, you need to use the marker pen to black it to engrave.

