


**Engraving Parameter**

Parameter Material	Mode	Speed (mm/min)	Max Power (%)	Min Power (%)	Line Interval	Effect	TIP
Basswood Plywood	Diode	15000	100	0	0.08		
Leather	Diode	20000	100	0	0.08		
Kraft Paper	Diode	20000	100	0	0.08		
MDF	Diode	20000	100	0	0.08		
Anodized Aluminum	Diode	8000	100	0	0.08		
Glass	Diode	2000	100	0	0.08		The engraving is done after the color paper is applied to the surface of the material.
Ceramics	Diode	2000	100	0	0.08		The engraving is done after the color paper is applied to the surface of the material.
Black Acrylic	Diode	5000	100	0	0.08		
Anodized Aluminum	IR	30000	100	0	0.02		
Anthracite Aluminum	IR	30000	100	0	0.02		
Stainless Steel	IR	10000	100	0	0.02		
White ABS	IR	20000	100	0	0.02		
Black ABS	IR	20000	100	0	0.02		
Black Acrylic	IR	15000	100	0	0.02		
ROCK	IR	20000	100	0	0.02		
Leather	IR	20000	100	0	0.02		
Black Rubber	IR	30000	100	0	0.02		
Yellow Copper	IR	30000	100	0	0.02		
Purple Copper	IR	30000	100	0	0.02		

**Notice:**

- Please note the above units of speed and power and convert them in Lightburn and LaserGRBL by yourself.
- 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!
- 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, to have better effect.
- Can't engrave or cut directly on glossy metal plates, transparent materials, reflective materials, some white translucent materials, etc. You need to blacken it with a marker or use the color paper to cover the surface to carve.

Parameter Material	Speed (mm/min)	Max Power (%)	Mode	Pass Count	Effect	TIP
2mm Basswood Plywood	400	100	Line	1		
3mm Basswood Plywood	300	100	Line	1		
4mm Basswood Plywood	200	100	Line	1		
6mm Basswood Plywood	100	100	Line	1		
3mm Black Acrylic	100	100	Line	1		
4mm Black Acrylic	300	100	Line	4		
2mm Black Paperboard	1500	100	Line	1		
2mm Leather	500	100	Line	1		
3mm Felt	500	100	Line	1		
3mm MDF	300	100	Line	3		

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