

Recommended Cutting Settings for **Baltic Birch Plywood** of Various Thicknesses

Wattage	Parameter Settings	1/16 in	1/8 in	1/4in	1/2in	3/4in	1in	1.2 in	1.4 in
55w	Speed	17 mm/s	12 mm/s	5 mm/s	3 mm/s	N/A	N/A	N/A	N/A
	Power	20%	25%	35%	46%				
60w	Speed	16 mm/s	12 mm/s	6 mm/s	4 mm/s	2 mm/s	N/A	N/A	N/A
	Power	20%	25%	32%	45%	50%			
80w	Speed	25 mm/s	12 mm/s	7 min/s	5 mm/s	4 min/s	3 min/s	N/A	N/A
	Power	20%	25%	30%	35%	43%	47%		
100w	Speed	30 mm/s	15 mm/s	7 min/s	6 mm/s	5 min/s	4 min/s	2 mm/s	N/A
	Power	20%	25%	28%	35%	40%	45%	55%	
130w	Speed	35 min/s	16 mm/s	8 min/s	7 mm/s	6 min/s	5 min/s	3 inm/s	2 mm/s
	Power	18%	25%	27%	32%	37%	42%	47%	55%
150w	Speed	40 min/s	17 mm/s	9 mm/s	8 mm/s	7 min/s	6 min/s	4 inm/s	2 mm/s
	Power	18%	24%	26%	30%	35%	40%	45%	52%

Recommended Cutting Settings for **Plexiglass/Acrylic** of Various Thicknesses

Wattage	Parameter Settings	1/16 in	1/8 in	1/4in	1/2in	3/4in	1in	1.2 in	1.4 in
55w	Speed	20 mm/s	11 mm/s	4 min/s	2 mm/s	N/A	N/A	N/A	N/A
	Power	20%	25%	44%	49%				
60w	Speed	20 mm/s	11 min/s	5 min/s	3 inm/s	2 min/s	N/A	N/A	N/A
	Power	20%	25%	37%	48%	58%			
80w	Speed	25 min/s	12 mm/s	6 min/s	4 mm/s	3 mm/s	1 mm/s	N/A	N/A
	Power	18%	25%	35%	45%	55%	60%		
100w	Speed	25 min/s	14 mm/s	6 min/s	5 mm/s	4 mm/s	1 mm/s	N/A	N/A
	Power	18%	25%	33%	43%	53%	58%		
130w	Speed	30 mm/s	15 mm/s	7 min/s	6 mm/s	5 mm/s	2 mm/s	1 mm/s	N/A
	Power	17%	25%	30%	37%	42%	55%	58%	
150w	Speed	35 min/s	16 mm/s	8 min/s	7 mm/s	6 mm/s	3 mm/s	2 mm/s	1 min/s
	Power	16%	24%	30%	35%	40%	53%	55%	58%

Recommended Cutting Settings for **Leather** of Various Thicknesses

Wattage	Parameter Settings	1/16 in	1/8 in	1/4in	1/2in
55w	Speed	20inm/s	12 mm/s	3 mm/s	N/A
	Power	23%	30%	32%	
60w	Speed	20inm/s	13 mm/s	4 mm/s	N/A
	Power	20%	28%	35%	
80w	Speed	25 mm/s	18 mm/s	6 mm/s	4 mm/s
	Power	18%	28%	32%	40%
100w	Speed	35 mm/s	23 mm/s	8 min/s	5 mm/s
	Power	18%	25%	30%	38%
130w	Speed	40 mm/s	25 mm/s	9 mm/s	6 mm/s
	Power	17%	24%	28%	37%
150w	Speed	45 mm/s	26 mm/s	10 mm/s	7 mm/s
	Power	17%	23%	27%	35%

Recommended Engraving Settings of Various Materials

Wattage	Parameter Settings	Clear Acrylic	Wood	Glass	Leather	Faux Leather	Tile/Stones
55w	Speed	275 mm/s	150 mm/s	175 mm/s	350 min/s	375 inm/s	125 mm/s
	Power	22%	21%	19%	19%	18%	20%
60w	Speed	300 mm/s	180 mm/s	200 mm/s	375 mm/s	400 mm/s	145 mm/s
	Power	20%	20%	19%	17%	16%	19%
80w	Speed	325 mm/s	200 mm/s	225 mm/s	400 min/s	425 mm/s	145 mm/s
	Power	18%	19%	18%	16%	15%	18%
100w	Speed	350 mm/s	200 mm/s	250 mm/s	425 min/s	450 mm/s	165 mm/s
	Power	15%	18%	18%	16%	15%	18%
130w	Speed	375 min/s	225 mm/s	275 mm/s	450 min/s	475 mm/s	185 mm/s
	Power	15%	18%	16%	16%	15%	18%
150w	Speed	375 min/s	225 mm/s	275 mm/s	450 min/s	475 mm/s	185 mm/s
	Power	15%	18%	16%	16%	15%	18%