ACMER P2-20W Engraving Parameters

Material	Line Interval	Speed （mm/min）	Power （%）	Note
Basswood	0.11mm	10000	100	
Leather	0.11mm	20000	50	
Kraft Paper	0.11mm	20000	80	
MDF	0.11mm	20000	80	
Carton	0.11mm	20000	75	
Stainless Steel	0.09mm	2000	100	It is recommended to choose a thicker stainless steel.
Anodized Aluminum	0.09mm	10000	100	
Wrench (galvanized iron)	0.09mm	2000	100	
Glass	0.11mm	20000	100	Engraving is done after the material is blackened or color paper is applied to the surface.
Ceramics	0.11mm	20000	100	The engraving is done after the color paper is applied to the surface of the material.
Acrylic	0.11mm	20000	60	

ACMER P2-20W Cutting Parameters

Material	Thickness	Speed （mm/min）	Power （%）	Passes	Note
Plywood	4mm	300	100	1	
Plywood	6mm	200	100	1	
Plywood	8mm	200	100	1	
Plywood	10mm	200	100	2	

Plywood	12mm	200	100	2	
Bamboo	4mm	300	100	1	
Paulownia wood	15mm	150	100	1	Focal length reduced to 2mm
Paulownia wood	20mm	100	100	1	Focal length reduced to 2mm
Pine wood	5mm	300	100	1	
Pine wood	10mm	100	100	1	Focal length reduced to 2mm
Leather	1mm	3000	1000	1	
Kraft Paper	1mm	3000	1000	1	
EPE foam board	10mm	1200	60	1	
MDF	2mm	500	100	1	
MDF	3mm	300	100	1	
Acrylic	2mm	200	100	1	Must be black non-transparent acrylic to be cut.
Acrylic	4mm	100	100	1	
Acrylic	6mm	200	100	3	
Acrylic	10mm	200	100	5	
Acrylic	15mm	200	100	8	
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.				