



- 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.
- 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.
- The minimum cutting speed of the 10W laser module is recommended not to be lower than 200mm/min, otherwise it will easily cause the cutting material to catch fire!
- When the laser engraver is working, the operator must pay close attention and not place it alone to prevent the engraved material from catching fire. Please set up the laser engraver in a fireproof area and ensure good ventilation. If possible, we recommend that you purchase a fire extinguisher and keep it close to the machine.
- Please check the documentation of ortur, find the corresponding software tutorial, and modify the corresponding value.

To Engraving	Material	 ≤ 2.1W LU2-2	 = 5W LU2-4-LF LU2-4-SF	 = 10W LU2-10A
M D F		Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.075 Power Max (%) : 70 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.05 Power Max (%) : 100 Power Min (%) : 0
Plywood		Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.075 Power Max (%) : 70 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 15000mm Interval (mm) : 0.05 Power Max (%) : 100 Power Min (%) : 0
Pine		Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.075 Power Max (%) : 70 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.05 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0
Paulownia		Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.075 Power Max (%) : 70 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.05 Power Max (%) : 70 Power Min (%) : 0
Paperboard (Cardboard Box)		Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.06 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 9000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.05 Power Max (%) : 70 Power Min (%) : 0
A4 Paper (Not White)		Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.06 Power Max (%) : 60 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 9000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.05 Power Max (%) : 15 Power Min (%) : 0
Kraft Paper 250g		Image Mode: Grayscale Speed (mm/m) : 2000mm Interval (mm) : 0.06 Power Max (%) : 60 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 9000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.05 Power Max (%) : 60 Power Min (%) : 0
Leather		Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.05 Power Max (%) : 60 Power Min (%) : 0
Black Acrylic		Image Mode: Grayscale Speed (mm/m) : 2000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.05 Power Max (%) : 100 Power Min (%) : 0
Cobblestone		Image Mode: Grayscale Speed (mm/m) : 100mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 1000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 1000mm Interval (mm) : 0.05 Power Max (%) : 25 Power Min (%) : 0
Ceramics		Image Mode: Grayscale Speed (mm/m) : 500mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 1000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 5000mm Interval (mm) : 0.1 Power Max (%) : 25 Power Min (%) : 0
Coated Metal		Image Mode: Grayscale Speed (mm/m) : 2500mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 6000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.05 Power Max (%) : 100 Power Min (%) : 0
Plated Metal		Image Mode: Grayscale Speed (mm/m) : 100mm Interval (mm) : 0.075 Power Max (%) : 70 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 100mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 1000mm Interval (mm) : 0.05 Power Max (%) : 25 Power Min (%) : 0
Stainless Steel		×	Image Mode: Grayscale Speed (mm/m) : 100mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 2000mm Interval (mm) : 0.05 Power Max (%) : 100 Power Min (%) : 0
Glass		Image Mode: Grayscale Speed (mm/m) : 500mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 1500mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 5000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0
Knit		Image Mode: Grayscale Speed (mm/m) : 4000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0
Cotton		Image Mode: Grayscale Speed (mm/m) : 4000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 20000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0
ABS Plastics		Image Mode: Grayscale Speed (mm/m) : 4000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.1 Power Max (%) : 50 Power Min (%) : 0
Bamboo		Image Mode: Grayscale Speed (mm/m) : 3000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 7000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 15000mm Interval (mm) : 0.1 Power Max (%) : 100 Power Min (%) : 0

To Engraving	Material	 ≤ 2.1W LU2-2	 = 5W LU2-4-LF LU2-4-SF	 = 10W LU2-10A
Silica Gel		Image Mode: Grayscale Speed (mm/m) : 400mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 1000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 2000mm Interval (mm) : 0.1 Power Max (%) : 100 Power Min (%) : 0
Rubber		Image Mode: Grayscale Speed (mm/m) : 2000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 5000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 10000mm Interval (mm) : 0.1 Power Max (%) : 100 Power Min (%) : 0
Ceramic Tile		Image Mode: Grayscale Speed (mm/m) : 2000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 4000mm Interval (mm) : 0.075 Power Max (%) : 100 Power Min (%) : 0	Image Mode: Grayscale Speed (mm/m) : 8000mm Interval (mm) : 0.1 Power Max (%) : 100 Power Min (%) : 0
Tin Lead Ore		×	×	×
Copper		×	×	×
Silver		×	×	×
Gold		×	×	×
Pure Aluminum		×	×	×
Soap		×	×	×
White Foam		×	×	×
Transparent Acrylic		×	×	×

To Cutting	Material	 ≤ 2.1W LU2-2	 = 5W LU2-4-LF LU2-4-SF	 = 10W LU2-10A
M D F 3mm		×	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 4 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 250mm Pass Count : 2 Power Max (%) : 100
5mm		×	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 10 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 250mm Pass Count : 3 Power Max (%) : 100
Plywood 1.6mm		×	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 500mm Pass Count : 1 Power Max (%) : 100
2.8mm		×	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100
5mm		×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100
8mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 1 Power Max (%) : 100
10mm		×	×	Image Mode: Line Speed (mm/m) : 150mm Pass Count : 8 Power Max (%) : 100
Pine 3mm		×	Image Mode: Line Speed (mm/m) : 150mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 500mm Pass Count : 1 Power Max (%) : 100
5mm		×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 2 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 1 Power Max (%) : 100
8mm		×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 3 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 1 Power Max (%) : 100
10mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 2 Power Max (%) : 100
12mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 3 Power Max (%) : 100
15mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 5 Power Max (%) : 100
19mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 8 Power Max (%) : 100
Paulownia 3mm		×	Image Mode: Line Speed (mm/m) : 500mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 800mm Pass Count : 1 Power Max (%) : 100
5mm		×	Image Mode: Line Speed (mm/m) : 150mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100
8mm		×	Image Mode: Line Speed (mm/m) : 250mm Pass Count : 3 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 1 Power Max (%) : 100
10mm		×	Image Mode: Line Speed (mm/m) : 150mm Pass Count : 2 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 4 Power Max (%) : 100
12mm		×	×	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 5 Power Max (%) : 100
15mm		×	×	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 6 Power Max (%) : 100
Cardboard Grey 3mm		×	×	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100
6mm		×	×	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 5 Power Max (%) : 100

To Cutting	Material	 ≤ 2.1W LU2-2	 = 5W LU2-4-LF LU2-4-SF	 = 10W LU2-10A
Cardboard White 3mm		×	Image Mode: Line Speed (mm/m) : 400mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 400mm Pass Count : 1 Power Max (%) : 100
5mm		×	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100
Corrugated Cardboard 3mm		×	Image Mode: Line Speed (mm/m) : 500mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 1000mm Pass Count : 1 Power Max (%) : 100
6mm		×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 800mm Pass Count : 1 Power Max (%) : 100
Black Acrylic 5mm		×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 3 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 3 Power Max (%) : 100
8mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 4 Power Max (%) : 100
20mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 11 Power Max (%) : 100
25mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 15 Power Max (%) : 100
30mm		×	×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 17 Power Max (%) : 100
PVC 3mm		×	Image Mode: Line Speed (mm/m) : 500mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 1000mm Pass Count : 1 Power Max (%) : 100
5mm		×	Image Mode: Line Speed (mm/m) : 100mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 700mm Pass Count : 1 Power Max (%) : 100
7mm		×	×	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 1 Power Max (%) : 100
Leather 2mm		×	×	Image Mode: Line Speed (mm/m) : 300mm Pass Count : 1 Power Max (%) : 100
A4 Paper		Image Mode: Line Speed (mm/m) : 1000mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 2500mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 4500mm Pass Count : 1 Power Max (%) : 100
Knit		×	Image Mode: Line Speed (mm/m) : 500mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 1000mm Pass Count : 1 Power Max (%) : 100
Cotton		×	Image Mode: Line Speed (mm/m) : 500mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 1000mm Pass Count : 1 Power Max (%) : 100
ABS Plastics		×	Image Mode: Line Speed (mm/m) : 500mm Pass Count : 1 Power Max (%) : 100	Image Mode: Line Speed (mm/m) : 1000mm Pass Count : 1 Power Max (%) : 100
Bamboo		×	×	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 10 Power Max (%) : 100
Silica Gel		×	×	Image Mode: Line Speed (mm/m) : 200mm Pass Count : 8 Power Max (%) : 100