

20W Engraving Parameters					
Material	Line Interval	Speed（mm/min）	Power（%）	Note	
Basswood	0.11mm	20000	80		
Leather	0.11mm	20000	50		
Kraft paper	0.11mm	20000	70		
MDF	0.11mm	20000	70		
Stainless Steel	0.09mm	2000	100	It is recommended to choose a thicker stainless steel.	
Anodized aluminum	0.09mm	10000	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		
20W Cutting Parameters					
Material	Thickness	Speed（mm/min）	Power（%）	Passes	Note
Basswood	4mm	400	100	1	
Basswood	6mm	300	100	1	
Basswood	8mm	200	100	1	
Basswood	10mm	150	100	1	
Cork Wood	10mm	100	100	1	

Leather	1mm	3000	1000	1	
Kraft paper	1mm	3000	1000	1	
MDF	2mm	500	100	1	
MDF	3mm	400	100	1	
Acrylic	2mm	300	100	1	Must be black non-transparent acrylic to be cut.
Acrylic	4mm	200	100	1	Must be black non-transparent acrylic to be cut.
Warm Tip	<p>1. Please note the above units of speed and power and convert them in Lightburn and LaserGRBL by yourself.</p> <p>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!</p> <p>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.</p> <p>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.</p>				