ACMER

P3-24W
Engraving Parameter

Parameter / Material	Speed (mm/min)	Max Power (%)	Min Power (%)	Line Interval	Effect	TIP
Basswood Plywood	28000	100	0	0.1		
Leather	30000	60	0	0.1		
Kraft Paper	30000	100	0	0.1		
MDF	30000	60	0	0.1		
Stainless Steel	3000	100	0	0.1		It is recommended to choose a thicker stainless steel.
Anodized Aluminum	20000	100	0	0.1		
Glass	5000	100	0	0.1		The engraving is done after the color paper is applied to the surface of the material.
Ceramics	5000	100	0	0.1		The engraving is done after the color paper is applied to the surface of the material.
Black Acrylic	30000	60	0	0.1		

Notice:

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, to have better effect.
4. Can't engrave or cut directly on glossy metal plates, transparent materials, reflective materials, some white or translucent materials, etc. You need to blacken it with a marker or use the color paper to cover the surface to carve.

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P3-24W
Cutting Parameter

Material \ Parameter	Speed (mm/min)	Max Power (%)	Mode	Pass Count	Effect
3mm Basswood Plywood	800	100	Line	1	
4mm Basswood Plywood	600	100	Line	1	
6mm Basswood Plywood	300	100	Line	1	
8mm Basswood Plywood	150	100	Line	1	
10mm Basswood Plywood	100	100	Line	1	
12mm Basswood Plywood	300	100	Line	3	
3mm Black Acrylic	300	100	Line	1	
4mm Black Acrylic	300	100	Line	2	
6mm Black Acrylic	300	100	Line	4	
3mm MDF	500	100	Line	1	
8mm MDF	300	100	Line	8	

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