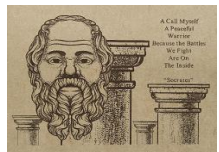


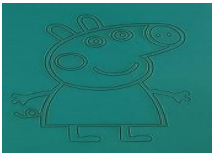
Remark:

Our parameter list is only for the most widely used materials. Customers may need to try other uncommon materials by themselves, or they can contact us to apply for testing.

Engraving Parameter for Common Material

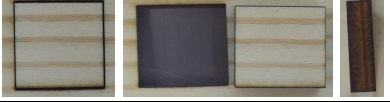
Material	Type	Engraving						Case illustration
		Line Interval	Speed (mm/Min)	Max-Power	Image Mode	Needs to be blackened	Number of passes	
Basswood	Bitmap	0.08	9000	80%	Stucki	NO	1	
	Vector Line	NA	1000	20%	NA	NO	1	
Yellow peach wood	Bitmap	0.08	8000	80%	Stucki	NO	1	
	Vector Line	NA	1000	15%	NA	NO	1	
Pine	Bitmap	0.08	5000	80%	Stucki	NO	1	
	Vector Line	NA	1000	30%	NA	NO	1	
Paulownia wood	Bitmap	0.08	8000	80%	Stucki	NO	1	
	Vector Line	NA	1000	15%	NA	NO	1	
Bamboo	Bitmap	0.08	7000	80%	Stucki	NO	1	

Engraving Parameter for Common Material								
Material	Type	Engraving						Case illustration
		Line Interval	Speed (mmNAM	Max-Power	Image Mode	Needs to be blackened	Number of passes	
Bamboo	Vector Line	NA	1000	20%	NA	NO	1	
Beech	Bitmap	0.08	8000	80%	Stucki	NO	1	
	Vector Line	NA	1000	20%	NA	NO	1	
Kraft Paper	Bitmap	0.08	9000	80%	Stucki	NO	1	
	Vector Line	NA	1000	15%	NA	NO	1	
MDF	Bitmap	0.08	10000	70%	Stucki	NO	1	
	Vector Line	NA	1000	15%	NA	NO	1	
Aluminum card	Bitmap	0.05	100	80%	Stucki	NO	1	
	Vector Line	NA	100	80%	NA	NO	1	
Leather	Bitmap	0.08	6000	80%	Stucki	NO	1	

Engraving Parameter for Common Material								
Material	Type	Engraving						Case illustration
		Line Interval	Speed (mm/min)	Max-Power	Image Mode	Needs to be blackened	Number of passes	
Leather	Vector Line	NA	1000	20%	NA	NO	1	
Plastic	Bitmap	0.08	8000	80%	Threshold	NO	1	
	Vector Line	NA	1000	20%	NA	NO	1	
Rubber	Bitmap	0.08	10000	70%	Stucki	NO	1	
	Vector Line	NA	1000	15%	NA	NO	1	
Denim	Bitmap	0.08	10000	70%	Stucki	NO	1	
ceramics	Bitmap	0.08	200	80%	Stucki	Yes	1	
	Vector Line	NA	100	80%	NA	Yes	1	
Ceramic tile	Bitmap	0.08	800	80%	Stucki	Yes	1	
	Vector Line	NA	300	80%	NA	Yes	1	

Engraving Parameter for Common Material								
Material	Type	Engraving						Case illustration
		Line Interval	Speed (mmNAM	Max-Power	Image Mode	Needs to be blackened	Number of passes	
Black alumina	Bitmap	0.05	1000	80%	Stucki	NO	1	
	Vector Line	NA	1000	80%	NA	NO	1	
Glass	Bitmap	0.08	800	80%	Stucki	Yes	1	
	Vector Line	NA	400	80%	NA	Yes	1	
Black acrylic	Bitmap	0.08	5000	80%	Stucki	NO	1	
	Vector Line	NA	1000	25%	NA	NO	1	
Two color plate	Bitmap	0.08	8000	80%	Stucki	NO	1	
	Vector Line	NA	1000	15%	NA	NO	1	
Carton	Bitmap	0.08	10000	65%	Stucki	NO	1	
	Vector Line	NA	1000	15%	NA	NO	1	

Engraving Parameter for Common Material								
Material	Type	Engraving						Case illustration
		Line Interval	Speed (mmNAM	Max-Power	Image Mode	Needs to be blackened	Number of passes	
Mirrors	Bitmap	0.08	3000	80%	Stucki	NO	1	
	Vector Line	NA	1000	60%	NA	NO	1	
Leaf	Bitmap	0.08	10000	70%	Stucki (Negative engraving)	NO	1	
Leaf	Vector Line	NA	1000	10%	NA	NO	1	
Rock	Bitmap	0.08	6000	80%	Stucki	NO	1	
	Vector Line	NA	1000	30%	NA	NO	1	
Stainless Steel	Bitmap	0.08	1500	80%	Stucki	NO	1	
	Vector Line	NA	100	80%	NA	NO	1	
painted furniture	Bitmap	0.08	6000	80%	Stucki	NO	1	
	Vector Line	NA	1000	20%	NA	NO	1	

Engraving Parameter for Common Material								
Material	Type	Engraving						Case illustration
		Line Interval	Speed (mmNAm	Max-Power	Image Mode	Needs to be blackened	Number of passes	
Laser debugging paper	Bitmap	0.08	10000	10%	Stucki	NO	1	
	Vector Line	NA	1000	15%	NA	NO	1	
Cutting Parameter for Common Material								
Material	Number of cuts	Cutting				Case illustration		
		Thickness (mm)	Speed (mmNAm	S-Max	Number of passes			
Basswood	One cut	3	120	80%	1			
	Multiple cuts	5	120	80%	2			
Pine	Multiple cuts	5	100	80%	2			
Paulownia wood	One cut	4	150	80%	1			
Paulownia wood	Multiple cuts	7	150	80%	3			
Leather	One cut	1	500	80%	1			
Kraft Paper	One cut	0.6	700	80%	1			
Felt cloth	Multiple cuts	3	1000	80%	3			
Woolen Blanket	One cut	2	500	80%	1			
Denim	One cut	0.7	300	80%	1			
Carton	One cut	6	150	80%	1			