

White Laser Settings

Default Engraving Settings: 50/33/[PPI of Material]

*Use [RAST] for solids and Images, [VECT] for lines **All settings listed are recommended settings, test cut each material for best results.

	THICKNESS	MATERIAL	POWER	SPEED	PPI	
Plastics	.04 mm	Polyester	50	4	100	
	1/16"	Polyester Felt	20	10	600	
	1/16 in	G&G Art Sup. "Acrylic"	100	2.5	100	
	3/64 in	SIG Plastic (G&G Art)	80	7	200	
	ONLY 1/32 in	Styrene	50	9	300	
	1/16 in	Acrylic	100	4.5	100	
	3/32 in	Acrylic	100	3.5	300	
	1/8 in	Acrylic	100	3	100	
	1/4 in	Acrylic	100	1	100	
	1/32 in	Acetate	100	4	100	
	Woods	1/32 in	Walnut	100	20	300
		1/16 in	Walnut	100	10	300
1/32 in		Mahogany	60	12	300	
1/32 in		Basswood	100	30	300	
1/16 in		Basswood	100	8	300	
3/32 in		Basswood	100	10	300	
1/8 in		Basswood	100	8	300	
3/16 in		Basswood	80	5	300	
1/4 in		Basswood	100	3	300	
1/8 in		Cherry Wood	100	10	400	
1/64 in		3 ply Birch Plywood	100	15	500	
1/16 in		3 ply Birch Plywood	100	6	500	
1/8 in		3 ply Birch Plywood	100	4	500	
		* Plywood must be flat				
1/8 in		Balsa	100	10	300	
3/32 in		Balsa	100	20	300	
		Etch ONLY MDF - DO NOT CUT				
Boards	3/16 in	Foam Core	100	10	100	
	1/8 in	Foam Core	100	12	300	
	1/16 in	Mat Board	100	12	400	
	1/32 in	2 ply Chipboard	100	12	400	
	3/32 in	4 ply Chipboard	100	4.5	400	
	1/32 in	2 ply Museum Board	70	15	400	
	1/16 in	4 ply Museum Board	60	5	400	
	3/16 in	Cardboard	100	12	300	
	1/8 in	Cardboard	100	15	300	
	3/64 in	Illustration Board	70	10	400	
Papers	110lb	Vellum/Translucent Paper	60	30	100	
	100lb	Bristol Paper	65	15	600	
	Etch	Bristol Paper	15	100	500	
Naturals	1/8 in	Leather	50	4.1	200	

Red Laser Settings

Default Engraving Settings: 50/100/[PPI of Material]

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	THICKNESS	MATERIAL	POWER	SPEED	PPI	
Plastics	.04 mm	Polyester	70	10	100	
	1/16"	Polyester Felt	40	40	100	
	1/16 in	G&G Art Sup. "Acrylic"	100	2.5	100	
	3/64 in	SIG Plastic (G&G Art)	70	10	100	
	ONLY 1/32 in	Styrene	60	25	300	
	1/16 in	Acrylic	100	8.5	100	
	3/32 in	Acrylic	90	5	100	
	1/8 in	Acrylic	100	4	100	
	1/4 in	Acrylic	100	2	100	
	1/32 in	Acetate	75	8	100	
	Woods	1/32 in	Walnut	100	65	300
		1/16 in	Walnut	100	20	300
1/32 in		Mahogany	100	40	300	
1/32 in		Basswood	100	100	300	
1/16 in		Basswood	100	40	300	
3/32 in		Basswood	100	15	300	
1/8 in		Basswood	100	12	300	
3/16 in		Basswood	100	8	300	
1/4 in		Basswood	100	5.5	300	
1/8 in		Cherry Wood	100	12	300	
1/64 in		3 ply Birch Plywood	100	13	400	
1/16 in		3 ply Birch Plywood	100	5	500	
1/8 in		3 ply Birch Plywood	100	4	500	
		* Plywood must be flat				
1/8 in		Balsa	100	70	300	
3/32 in		Balsa	100	50	300	
Etch ONLY		MDF - DO NOT CUT	50	100	400	
Boards		3/16 in	Foam Core	100	15	200
	1/8 in	Foam Core	100	20	100	
	1/16 in	Mat Board	100	12	400	
	1/32 in	2 ply Chipboard	100	40	400	
	3/32 in	4 ply Chipboard	100	9	400	
	1/32 in	2 ply Museum Board	80	40	400	
	1/16 in	4 ply Museum Board	80	11	400	
	3/16 in	Cardboard	100	20	200	
	1/8 in	Cardboard	100	25	200	
	3/64 in	Illustration Board	70	20	500	
Papers	110lb	Vellum/Translucent Paper	70	100	500	
	100lb	Bristol Paper	50	100	500	
	Etch	Bristol Paper	15	100	500	
Naturals	1/8 in	Leather	50	10	200	

Red Laser Settings

Default Engraving Settings: 50/100/[PPI of Material]

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Type	THICKNESS	MATERIAL	POWER	SPEED	PPI	LASER	
Plastics	.04 mm	Polyester	50	4	100	top/bot	
	3/64 in	SIG Plastic (G&G Art)	70	10	100	top/bot	
	ONLY 1/32 in	Styrene	60	25	100	top/bot	
	1/16 in	Acrylic	100	10	100	top/bot	
	3/32 in	Acrylic	100	15	300	both	
	1/8 in	Acrylic	100	8	100	both	
	1/4 in	Acrylic	100	5	100	both	
	1/32 in	Acetate	50	4	100	top/bot	
	Woods	1/32 in	Walnut	100	40	300	top/bot
1/16 in		Walnut	100	15	400	both	
1/32 in		Mahogany	100	35	300	top/bot	
1/32 in		Basswood	100	50	300	top/bot	
1/16 in		Basswood	100	15	300	top/bot	
3/32 in		Basswood	100	30	300	both	
1/8 in		Basswood	100	10	400	top/bot	
3/16 in		Basswood	80	8	400	both	
1/4 in		Basswood	100	30	300	both	
1/8 in		Cherry Wood	100	10	400	top/bot	
1/64 in		3 ply Birch Plywood	100	50	600	top/bot	
1/16 in		3 ply Birch Plywood	100	8.5	600	both	
1/8 in		3 ply Birch Plywood	100	7.5	600	both	
		* Plywood must be flat					
		1/8 in	Balsa	100	45	400	top/bot
		3/32 in	Balsa	100	50	400	top/bot
		Etch ONLY	MDF - DO NOT CUT				
Boards	3/16 in	Foam Core	100	15	100	top/bot	
	1/8 in	Foam Core	100	20	100	top/bot	
	1/16 in	Mat Board	100	10	500	top/bot	
	1/32 in	2 ply Chipboard	80	50	500	both	
	3/32 in	4 ply Chipboard	100	30	400	both	
	1/32 in	2 ply Museum Board	70	40	400	both	
	1/16 in	4 ply Museum Board	100	16	300	top/bot	
	3/16 in	Cardboard	100	80	300	both	
	3/64 in	Illustration Board Vellum/	90	20	600	top/bot	
Papers	110lb	Translucent Paper Bristol	70	100	500	top/bot	
	100lb	Paper	50	100	500	top/bot	
	Etch	Bristol Paper	15	100	500	top/bot	
Naturals	1/8 in	Leather	50	10	200	top/bot	