

Parameter Table for RAY5 20W Laser Engraver

Material	Action	Thickness	Power for LightBurn	Power for GRBL	Speed mm/min	Cycles	Remarks
Basswood	Engraving	-	20%	200%	4000	1	
Cork Wood			15%	150%	3500	1	
Bamboo		-	20%	200%	4000	1	
Translucent Acrylic			15%	150%	3000	1	
Acrylic		-	20%	200%	4000	1	
Kraft Paper		-	20%	200%	4500	1	
Rubber			50%	500%	3000	1	
High Density Foam			15%	150%	3000	1	
Mirror		-	30%	300%	4500	1	
Leather		-	20%	200%	4500	1	
Carton			15%	150%	3000	1	
Denim		-	25%	250%	4500	1	
Powder Coated Metal		-	100%	1000%	400	1	
PCB Borad		-	60%	600%	1500	1	
Anodized Aluminum		-	60%	600%	500	1	
Rock			60%	600%	3500		
Pebble			60%	600%	3500		
Ceranic		-	70%	700%	1000	1	White color, Color with dark paint.
Glass		-	75%	750%	4000	1	Color with dark paint before engraving.
Stainless Steel		-	75%	750%	1500	1	
Basswood		Cutting	2 mm	100%	1000%	800	1
Basswood	3 mm		100%	1000%	700	1	
Basswood	5 mm		100%	1000%	450	1	
Basswood	6 mm		100%	1000%	300	1	
Basswood	8 mm		100%	1000%	200	1	
Basswood	10 mm		100%	1000%	100	1	
Pine	10mm		100%	1000%	120	1	
Pine	15mm		100%	1000%	100	1	Lower the laser head by 3mm after focusing.
Acrylic	3 mm		100%	1000%	300	1	
Acrylic	8 mm		100%	1000%	100	1	
Kraft Paper	0.1 mm		40%	400%	5000	1	
Leather	0.5mm		70%	700%	2500	1	
Denim	0.5mm		100%	1000%	2000	1	
Acrylic	10mm		100%	1000%	120	2	
Stainless Steel	0.05mm		100%	1000%	120	1	
Acrylic	15mm		70%	700%	100	5	
MDF Middle Density Fiberboard	5mm		100%	1000%	160	1	
MDF Middle Density Fiberboard	10mm		100%	1000%	300	6	Lower the laser head by 3mm after focusing. Be aware that the material is flammable during cutting.
Paulownia Wood	15mm	70%	700%	300	3	Be aware that the material is flammable during cutting.	
Cork Wood	5mm	100%	1000%	500	1		