

Parameter Table for B1 30W Laser Engraver

Material	Action	Thicknes s	Power for Lightburn	Power for LaserGRB	Speed mm/min	Cycles	Cycles
Bamboo	Engraving	-	55%	550%	7000	1	
Cardboard (carton)		-	15%	150%	3000	1	
Hardwood		-	30%	300%	4500	1	
Eraser		-	65%	650%	3000	1	
Ceramic		-	80%	800%	1000	1	
Pine wood		-	45%	450%	7000	1	
Leather		-	30%	300%	6000	1	
Denim		-	20%	200%	6000	1	
Kraft paper		-	5%	50%	1300	1	
Mirror		-	40%	400%	5000	1	
High density foam		-	4%	40%	1000	1	
Powder Coated Metal(black)		-	90%	900%	500	1	
Cobblestone		-	60%	600%	4000	1	
Basswood		-	20%	200%	5000	1	
Electroplated aluminum (purple pink)		-	50%	500%	2000	1	
Stainless Steel		-	80%	800%	1500	1	
Glass		-	30%	300%	1500	1	painting blue
black acrylic		-	25%	250%	4500	1	
Translucent Acrylic (Orange)		-	25%	250%	2500	1	
PCB copper plate		-	60%	600%	4000	1	
MDF	-	17%	170%	4000	1		
Cardboard (carton)	Cutting	3mm	100%	1000%	3000	1	
Acrylic		10mm	100%	1000%	100	1	Defocus 2mm
Acrylic acid		3mm	100%	1000%	360	1	
Non-woven fabric		0.18mm	100%	1000%	3200	1	
Pine wood		15mm	100%	1000%	100	1	Defocus 2mm
Leather		0.5mm	100%	1000%	4000	1	
Paulownia wood		20mm	100%	1000%	120	1	Defocus 2mm
Denim		0.5mm	100%	1000%	2100	1	
Kraft paper		0.1mm	100%	1000%	9000	1	
Basswood		2mm	100%	1000%	1000	1	
Basswood		3mm	100%	1000%	800	1	
Basswood		5mm	100%	1000%	480	1	
Basswood		6mm	100%	1000%	320	1	
Basswood		8mm	100%	1000%	210	1	
Basswood		10mm	100%	1000%	160	1	
Hardwood		11mm	100%	1000%	100	1	
Stainless Steel		0.05mm	100%	1000%	1800	1	
Stainless Steel		0.1mm	100%	1000%	400	1	
MDF		5mm	100%	1000%	360	1	
MDF		8.5mm	100%	1000%	160	3	
MDF		10mm	100%	1000%	320	7	
MDF		12mm	100%	1000%	240	10	
Acrylic		10mm	100%	1000%	140	2	
Acrylic		15mm	100%	1000%	100	3	
Basswood		25mm	100%	1000%	240	10	Defocus 10mm
Acrylic	50mm	100%	1000%	240	25	Defocus 10mm	

Parameter Table for B1 20W Laser Engraver

Material	Action	Thicknes s	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	2mm	100%	1000%	800	1		
Basswood		3mm	100%	1000%	700	1		
Basswood		5mm	100%	1000%	450	1		
Basswood		6mm	100%	1000%	300	1		
Basswood		8mm	100%	1000%	200	1		
Basswood		10mm	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		3mm	100%	1000%	300	1		
Acrylic		8mm	100%	1000%	100	1		
Kraft Paper		0.1mm	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		