

**xTool D1(5W) Materials parameters for reference**

Serial number	Material Code	Material name	Machine	Processing mode	Power %	Speed mm/s	Processing times	Remarks	
1	A008	Clay	D1 5W	Laser vector engraving	30	50	1		
2	A008	Clay	D1 5W	Laser vector engraving	30	50	1		
3	A009	Plasticine	D1 5W	Laser vector engraving	90	50	1		
4	A001	Rubber mat for engraving	D1 5W	Laser vector engraving	90	50	1		
5	A001	Rubber mat for engraving	D1 5W	Laser bitmap engraving	100	20	2		
6	A005	Photosensitive stamp pad	D1 5W	Laser bitmap engraving	50	110	1		
7	A006	Photosensitive stamp pad	D1 5W	Laser bitmap engraving	50	110	1		
8	A008	Rubber magnet	D1 5W	Laser cutting	100	3	1		
9	A008	Rubber magnet	D1 5W	Laser vector engraving	100	80	1		
10	A008	Rubber magnet	D1 5W	Laser bitmap engraving	90	80	1		
11	AF001	Eva foam 1mm	D1 5W	Laser cutting	22	20	1		
12	AF001	Eva foam 2mm	D1 5W	Laser cutting	20	5	1	Shrunked	
13	AF003	Eva foam 3mm	D1 5W	Laser cutting	100	4	1	Shrunked	
14	AF004	Eva foam 4mm	D1 5W	Laser cutting	20	2	1	Shrunked	
15	AF006	Foam cotton 5mm	D1 5W	Laser cutting	100	5	1		
16	AFT001	Nylon	D1 5W	Laser cutting	50	20	1		
17	AFT001	Nylon	D1 5W	Laser vector engraving	25	80	1		
18	AFT002	Flannel	D1 5W	Laser bitmap engraving	90	120	1		
19	AFT003	Flannel	D1 5W	Laser cutting	50	20	1		
20	AFT003	Flannel	D1 5W	Laser vector engraving	40	80	1		
21	AFT003	Flannel	D1 5W	Laser bitmap engraving	40	100	1		
22	AFT005	Red cotton fabric	D1 5W	Laser vector engraving	45	20	1		
23	AFT005	Red cotton fabric	D1 5W	Laser vector engraving	40	80	1		
24	AFT005	Red cotton fabric	D1 5W	Laser bitmap engraving	50	180	1		
25	AFT009	Nonwoven fabric 1mm	D1 5W	Laser cutting	50	20	1		
26	AF014	Denim fabric	D1 5W	Laser vector engraving	90	80	1	Yellowing	
27	AFT011	Denim fabric	D1 5W	Laser vector engraving	90	65	1	Yellowing	
28	AFT011	Denim fabric	D1 5W	Laser bitmap engraving	70	50	1	Yellowing	
29	AFT015	Conductive fabric	D1 5W	Laser cutting	35	20	1		
30	AFT016	Green felt 1.5mm	D1 5W	Laser vector engraving	50	20	1		
31	AFT016	Green felt 1.5mm	D1 5W	Laser vector engraving	35	80	1		
32	AFT016	Green felt 1.5mm	D1 5W	Laser bitmap engraving	50	100	1		
33	AFT017	Tencel-like fabric	D1 5W	Laser cutting	77	20	1		
34	AFT017	Tencel-like fabric	D1 5W	Laser vector engraving	50	80	1		
35	AFT017	Tencel-like fabric	D1 5W	Laser bitmap engraving	90	140	1		
36	AFT018	Blue and white patterned linen	D1 5W	Laser cutting	80	12	1		
37	AFT018	Blue and white patterned linen	D1 5W	Laser bitmap engraving	50	50	1		
38	AFT019	Cork with nonwoven fabric	D1 5W	Laser cutting	85	20	1		
39	AFT019	Cork with nonwoven fabric	D1 5W	Laser vector engraving	40	70	1		
40	AFT020	Cork with nonwoven fabric	D1 5W	Laser bitmap engraving	50	150	1		
41	AFT020	Coarse woven linen	D1 5W	Laser cutting	100	6	1		
42	AFT021	Thin woven fabric	D1 5W	Laser cutting	50	100	1		
43	AFT022	Felt 1mm	D1 5W	Laser vector engraving	100	20	1		
44	AFT022	Felt 1mm	D1 5W	Laser vector engraving	100	80	1		
45	AFT022	Felt 1mm	D1 5W	Laser bitmap engraving	40	100	1		
46	AFT022	Felt 3mm	D1 5W	Laser cutting	100	3	1	For bright colored felt, use the speed of 3 mm/s, and for pink felt, use the speed of 3 mm/s.	
47	AFT023	Felt 3mm	D1 5W	Laser vector engraving	100	80	1		
48	AFT023	Felt 3mm	D1 5W	Laser bitmap engraving	40	100	1		
49	AFT024	Felt 5mm	D1 5W	Laser cutting	100	8	2		
50	AFT024	Felt 5mm	D1 5W	Laser vector engraving	100	80	1		
51	AFT024	Felt 5mm	D1 5W	Laser bitmap engraving	100	120	1		
52	AL001	PU artificial leather	D1 5W	Laser cutting	85	20	4		
53	AL001	PU artificial leather	D1 5W	Laser vector engraving	80	80	1		
54	AL001	PU artificial leather	D1 5W	Laser bitmap engraving	50	50	1		
55	AL002	PVC artificial leather	D1 5W	Laser vector engraving	40	80	1		
56	AL002	PVC artificial leather	D1 5W	Laser bitmap engraving	50	120	1		
57	AL006	Gray top-layer leather	D1 5W	Laser cutting	100	5	4	Burned	
58	AL006	Gray top-layer leather	D1 5W	Laser vector engraving	20	100	1	Your hands are blackened when touching it.	
59	AL006	Gray top-layer leather	D1 5W	Laser bitmap engraving	20	100	1	Your hands are blackened when touching it.	
60	AL006	Gray top-layer leather	D1 5W	Laser vector engraving	30	30	1		
61	AL007	Checkered top-layer leather	D1 5W	Laser vector engraving	50	53	1		
62	AL008	Teal top-layer leather	D1 5W	Laser vector engraving	30	30	1		
63	AL008	Teal top-layer leather	D1 5W	Laser bitmap engraving	60	100	1		
64	AL009	Cow leather	D1 5W	Laser cutting	100	5	4		
65	AL009	Cow leather	D1 5W	Laser vector engraving	90	80	1		
66	AL009	Cow leather	D1 5W	Laser bitmap engraving	70	100	1		
67	AL010	PVC basketball leather	D1 5W	Laser cutting	100	5	1		
68	AL010	PVC basketball leather	D1 5W	Laser bitmap engraving	100	50	1		
69	AL010	PVC basketball leather	D1 5W	Laser vector engraving	90	20	1		
70	AP001	Kraft paper 70g	D1 5W	Laser vector engraving	37	80	1		
71	AP001	Kraft paper 70g	D1 5W	Laser bitmap engraving	50	150	1		
72	AP001	Kraft paper 100g	D1 5W	Laser cutting	40	20	1		
73	AP001	Kraft paper 100g	D1 5W	Laser vector engraving	50	110	1		
74	AP003	Kraft paper 150g	D1 5W	Laser cutting	60	20	1		
75	AP003	Kraft paper 150g	D1 5W	Laser vector engraving	35	80	1		
76	AP003	Kraft paper 150g	D1 5W	Laser bitmap engraving	100	110	1		
77	AP004	Kraft paper (thick)	D1 5W	Laser vector engraving	60	80	1		
78	AP004	Kraft paper (thick)	D1 5W	Laser bitmap engraving	75	80	1		
79	AP004	White cardboard 180g	D1 5W	Laser cutting	72	20	1		
80	AP006	White cardboard 180g	D1 5W	Laser bitmap engraving	65	45	1		
81	AP006	White cardboard 180g	D1 5W	Laser vector engraving	65	45	1		
82	AP007	White cardboard 260g	D1 5W	Laser cutting	100	10	1		
83	AP007	White cardboard 260g	D1 5W	Laser vector engraving	100	50	1		
84	AP007	White cardboard 260g	D1 5W	Laser bitmap engraving	55	20	1		
85	AP008	Marker paper 120g	D1 5W	Laser cutting	60	20	1		
86	AP008	Marker paper 120g	D1 5W	Laser vector engraving	55	40	1		
87	AP008	Marker paper 120g	D1 5W	Laser bitmap engraving	60	80	1		
88	AP009	Round kraft cardboard 250g	D1 5W	Laser cutting	95	20	1		
89	AP009	Round kraft cardboard 250g	D1 5W	Laser vector engraving	55	80	1		
90	AP009	Round kraft cardboard 250g	D1 5W	Laser bitmap engraving	55	80	1		
91	AP010	Round white cardboard 250g	D1 5W	Laser cutting	100	15	1		
92	AP010	Round white cardboard 250g	D1 5W	Laser vector engraving	90	50	1		
93	AP010	Round white cardboard 250g	D1 5W	Laser bitmap engraving	90	50	1		
94	AP011	Round black cardboard 250g	D1 5W	Laser cutting	100	15	1		
95	AP011	Round black cardboard 250g	D1 5W	Laser vector engraving	70	80	1		
96	AP011	Round black cardboard 250g	D1 5W	Laser bitmap engraving	100	80	1		
97	AP012	White cardboard with gray back 1mm	D1 5W	Laser vector engraving	100	80	1		
98	AP012	White cardboard with gray back 1mm	D1 5W	Laser bitmap engraving	100	100	1		
99	AP012	White cardboard with gray back 1mm	D1 5W	Laser cutting	100	20	1		
100	AP013	White cardboard with gray back 2mm	D1 5W	Laser vector engraving	100	80	1		
101	AP013	White cardboard with gray back 2mm	D1 5W	Laser bitmap engraving	100	80	1		
102	AP013	White cardboard with gray back 2mm	D1 5W	Laser cutting	100	6	3		
103	AP014	White cardboard with gray back 3mm	D1 5W	Laser vector engraving	100	80	1		
104	AP014	White cardboard with gray back 3mm	D1 5W	Laser bitmap engraving	100	85	1		
105	AP014	White cardboard with gray back 3mm	D1 5W	Laser cutting	95	4	1		
106	AP015	Corrugated paper 3.5mm	D1 5W	Laser vector engraving	100	100	1		
107	AP015	Corrugated paper 3.5mm	D1 5W	Laser bitmap engraving	100	100	1		
108	AP015	Corrugated paper 3.5mm	D1 5W	Laser cutting	80	20	1		
109	AP016	White self-adhesive material	D1 5W	Laser bitmap engraving	60	70	1		
110	AP016	White self-adhesive material	D1 5W	Laser vector engraving	60	70	1		
111	AP016	White self-adhesive material	D1 5W	Laser cutting	100	10	1		
112	AP017	PVC self-adhesive lettering film	D1 5W	Laser vector engraving	13	80	1		
113	AP018	A corrugated board	D1 5W	Laser cutting	55	6	1		
114	AP018	A corrugated board	D1 5W	Laser vector engraving	65	80	1		
115	AP018	A corrugated board	D1 5W	Laser bitmap engraving	60	100	1		
116	AP019	E corrugated board	D1 5W	Laser cutting	95	8	1		
117	AP019	E corrugated board	D1 5W	Laser vector engraving	60	80	80	1	
118	AP019	E corrugated board	D1 5W	Laser bitmap engraving	50	100	1		
119	AP020	Laser engraver marking paper 90g	D1 5W	Laser cutting	57	20	1		
120	AP020	Laser engraver marking paper 90g	D1 5W	Laser vector engraving	100	65	1		
121	AP021	Laser engraver marking paper 120g	D1 5W	Laser cutting	40	20	1		
122	AP021	Laser engraver marking paper 120g	D1 5W	Laser vector engraving	100	40	1		
123	AP021	Laser engraver marking paper 120g	D1 5W	Laser bitmap engraving	100	60	1		
124	AP022	Testing paper	D1 5W	Laser cutting	55	20	1		
125	AP022	Testing paper	D1 5W	Laser vector engraving	40	50	1		
126	AP022	Testing paper	D1 5W	Laser bitmap engraving	100	50	1		
127	AP023	Laser engraver marking paper	D1 5W	Laser vector engraving	100	50	1		
128	AP023	Laser engraver marking paper	D1 5W	Laser bitmap engraving	100	50	1		
129	AP024	Kraft paper 200g	D1 5W	Laser cutting	100	20	1		
130	AP024	Kraft paper 200g	D1 5W	Laser vector engraving	40	60	1		
131	AP024	Kraft paper 200g	D1 5W	Laser bitmap engraving	60	100	1		
132	AP025	Sandpaper	D1 5W	Laser cutting	100	10	1	The lines are clearer when you cut it on the back than on the front.	
133	AP025	Sandpaper	D1 5W	Laser vector engraving	100	50	1		
134	AP025	Sandpaper	D1 5W	Laser bitmap engraving	30	50	1		
135	AP026	Wood grain sticker	D1 5W	Laser cutting	85	20	1		
136	AP026	Wood grain sticker	D1 5W	Laser vector engraving	80	80	1		
137	AP026	Wood grain sticker	D1 5W	Laser bitmap engraving	50	165	1		
138	AP027	Colored paper 70g	D1 5W	Laser cutting	25	20	1		
139	AP027	Colored paper 70g	D1 5W	Laser vector engraving	23	20	1		
140	AP027	Colored paper 70g	D1 5W	Laser bitmap engraving	50	180	1		
141	AP028	Pearlescent paper	D1 5W	Laser cutting	25	20	1		
142	AP028	Pearlescent paper	D1 5W	Laser vector engraving	50	80	1		
143	AP028	Pearlescent paper	D1 5W	Laser bitmap engraving	50	180	1		
144	AP029	Laser paper	D1 5W	Laser cutting	100	1	1		
145	AP029	Laser paper	D1 5W	Laser vector engraving	15	80	1		
146	AP029	Laser paper	D1 5W	Laser bitmap engraving	25	180	1		
147	AP030	Cardboard 300g	D1 5W	Laser cutting	100	13	1		
148	AP030	Cardboard 300g	D1 5W	Laser vector engraving	35	20	1		
149	AP030	Cardboard 300g	D1 5W	Laser bitmap engraving	30	10	1		
150	AP031	Waxed handmade paper	D1 5W	Laser cutting	30	20	1		
151	AP031	Waxed handmade paper	D1 5W	Laser vector engraving	15	80	1		
152	AP032	Waxed handmade paper	D1 5W	Laser bitmap engraving	100	150	1		
153	AP032	Flash paper sheet	D1 5W	Laser cutting	100	15	1		
154	AP01010	Black acrylic 3.0mm	D1 5W	Laser cutting	100	2	2		
155	AP01010	Black acrylic 3.0mm	D1 5W	Laser vector engraving	100	50	1		
156	AP01010	Black acrylic 3.0mm	D1 5W	Laser bitmap engraving	100	50	1		
157	AP01011	White acrylic 1.5mm	D1 5W	Laser cutting	100	12	1		
158	AP01012	White acrylic 2.5mm	D1 5W	Laser vector engraving	100	10	1		
159	AP01013	White acrylic 3.0mm	D1 5W	Laser vector engraving	100	4	1		
160	AP01023	Mirror acrylic 3mm	D1 5W	Laser vector engraving	50	50	1		
161	AP01023	Mirror acrylic 3mm	D1 5W	Laser bitmap engraving	60	50	1		
162	AP01024	Black acrylic 1mm	D1 5W	Laser cutting	100	4	1		
163	AP01024	Black acrylic 1mm	D1 5W	Laser vector engraving	45	50	1		
164	AP01024	Black acrylic 1mm	D1 5W	Laser bitmap engraving	95	80	1		
165	AP01025	Pink acrylic 1mm	D1 5W						