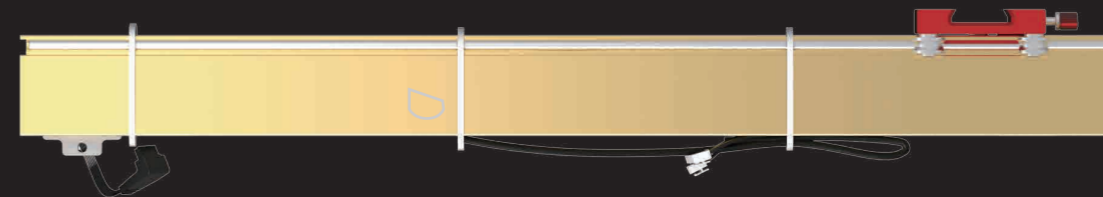


**XTOOL**

**XTOOL**

**xTool D1 Pro 40 W  
Laser Module Kit**



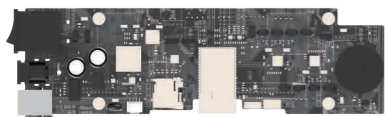
KD010553000

List of items	03
Modify your xTool D1 Pro	06
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Clean the laser module	46
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xTool D1 Pro 40 W laser module kit provides two color options. This user manual uses the golden red version to describe how to modify and set up your machine.

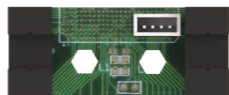
## List of items



Main control board



Laser module



Position limit control board



Power adapter



Cable tie pack



Parts storage box



Position limit piece A



Position limit piece B



Middle plate



Screwdriver



Cylindrical head screw M3\*6



Focal length setting piece



Screw M4\*16



Screw M4\*25



Hex key



Round head  
screw M3\*10



Cylindrical head  
screw M3\*8



Flat head  
screw M3\*8



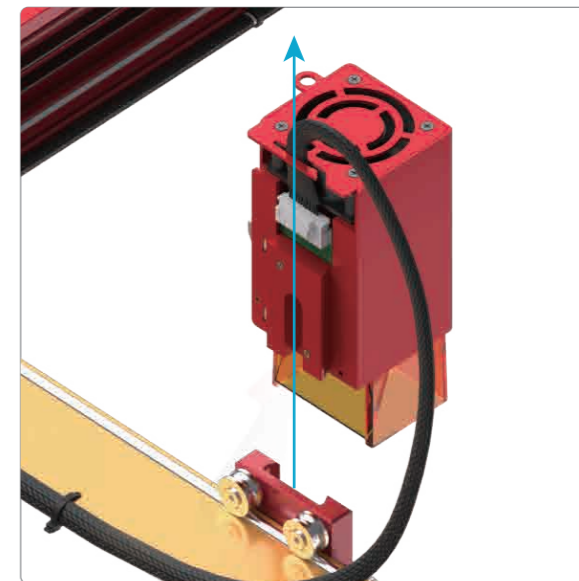
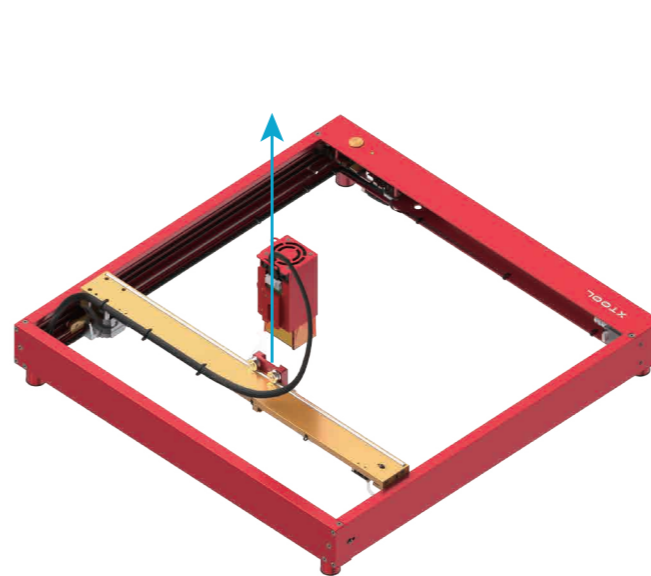
Sharp-nose pliers

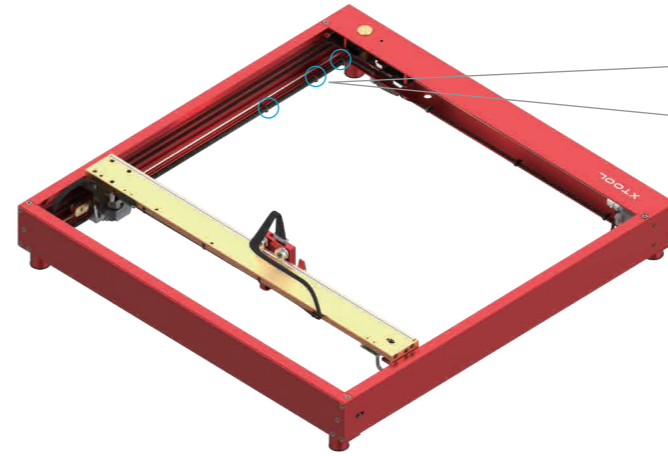
## Modify your xTool D1 Pro

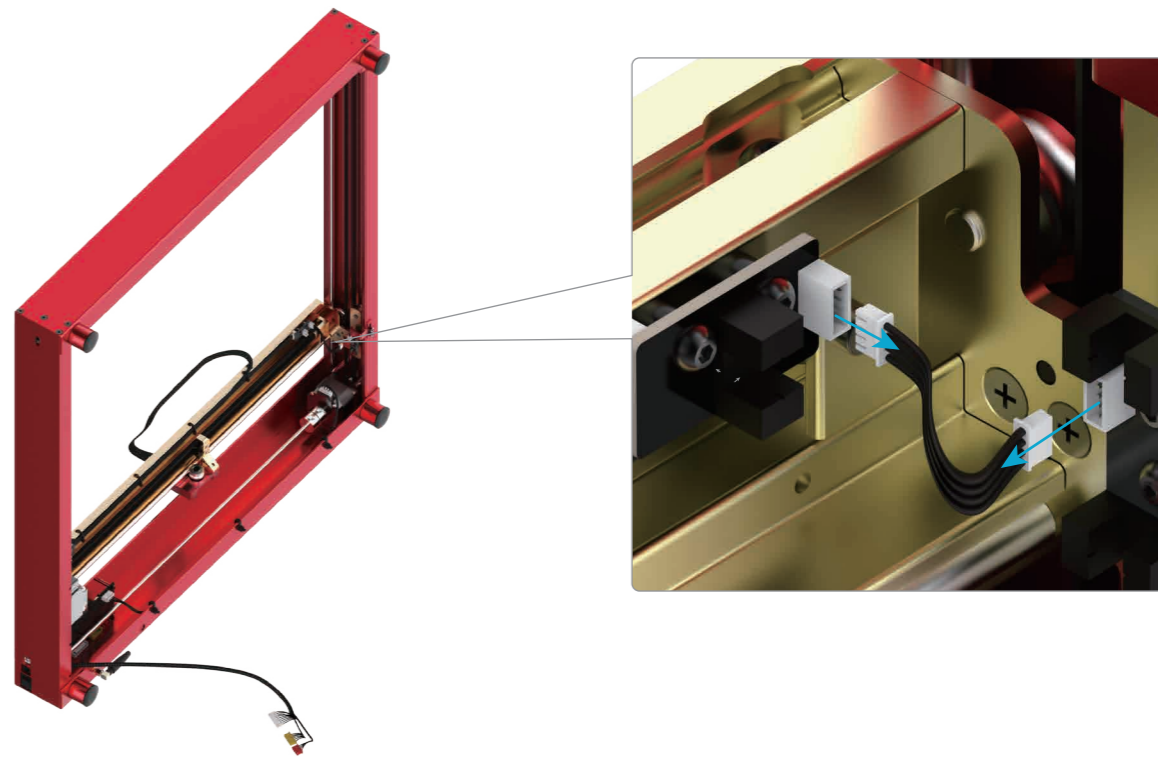
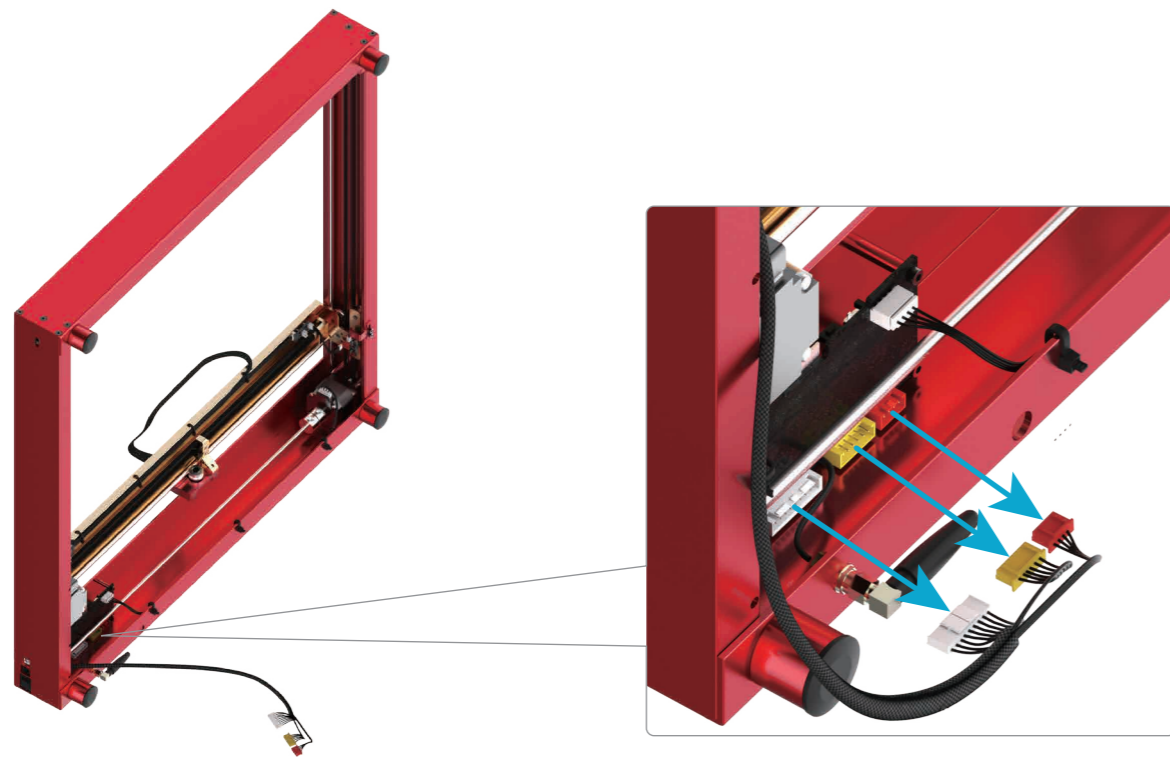


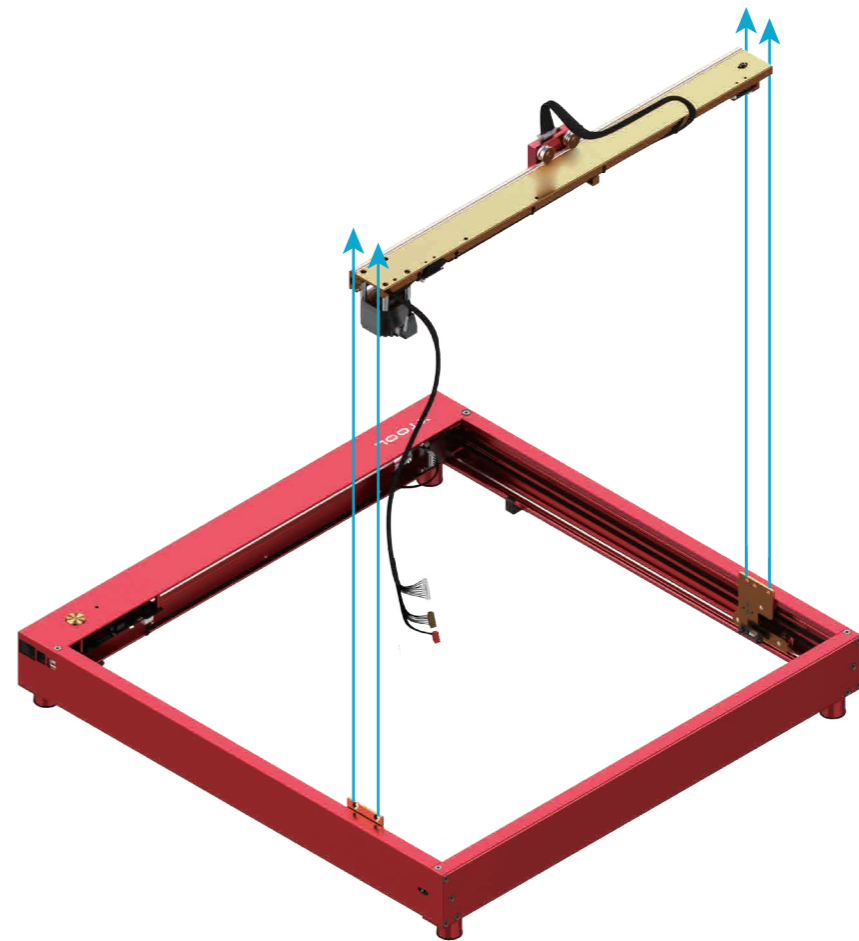
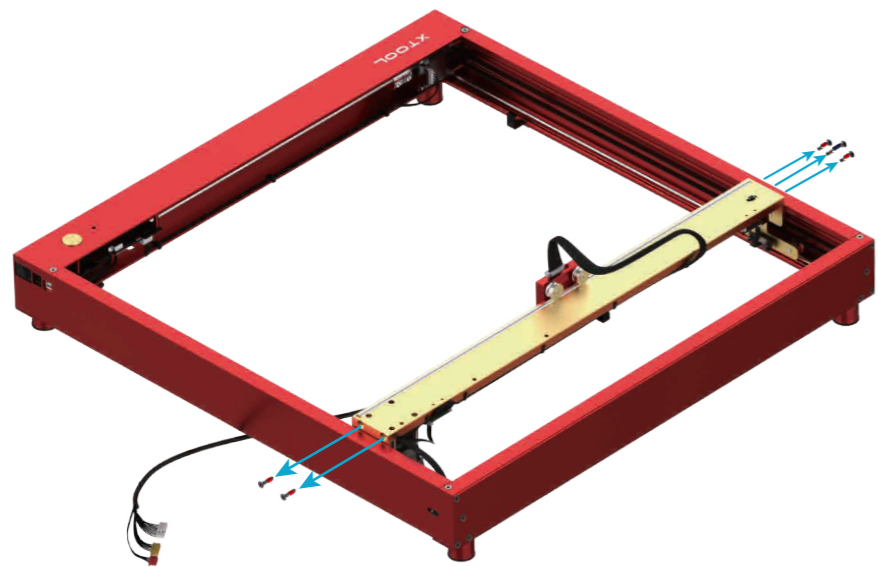
With this xTool D1 Pro 40 W laser module kit, you can modify your xTool D1 Pro into a 40 W one.

### 1. Remove the original middle plate

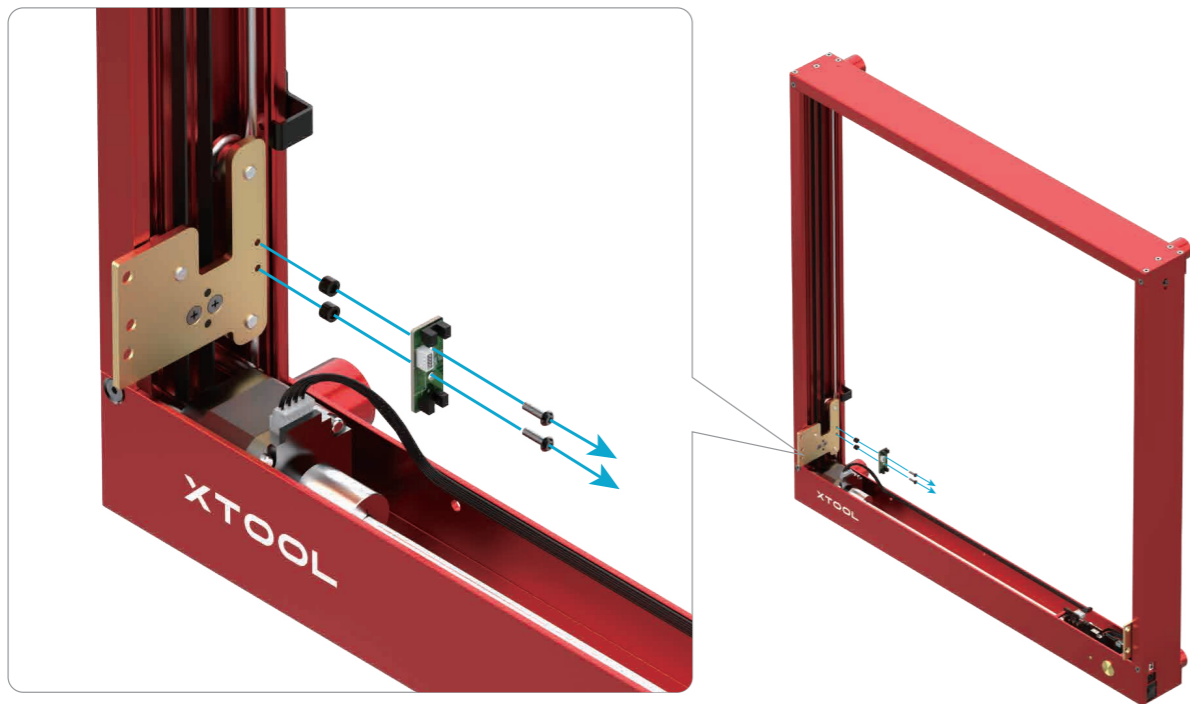
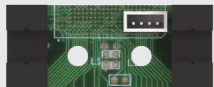




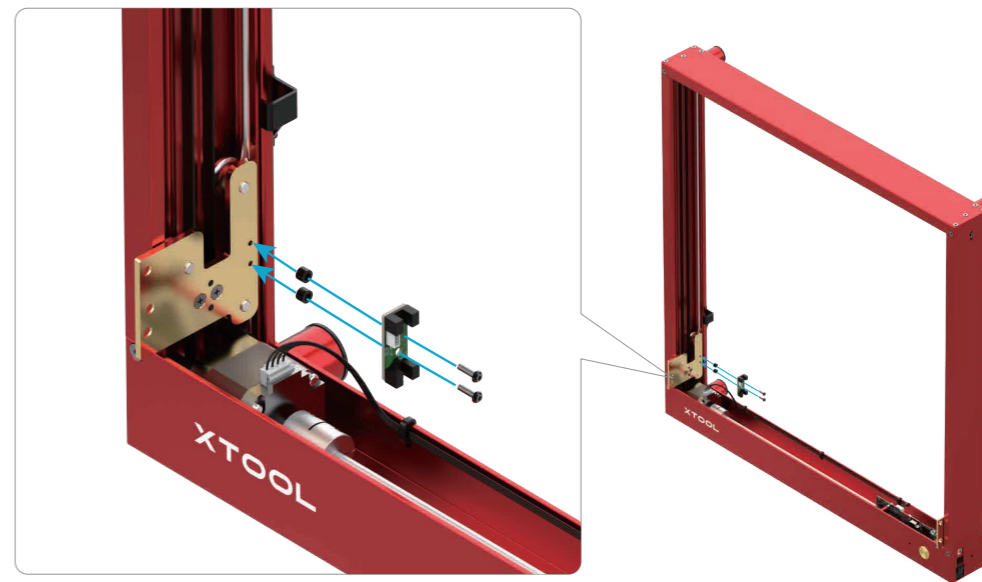




## 2. Replace the position limit control board

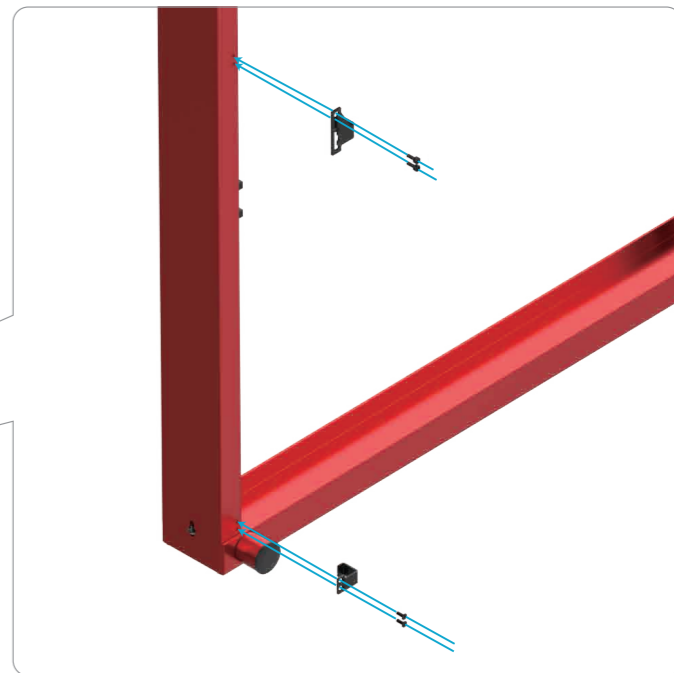
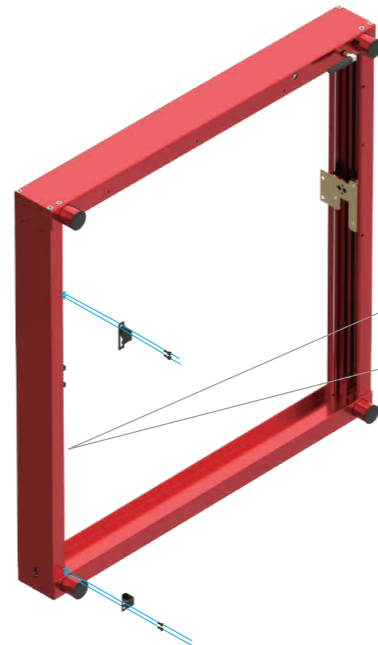
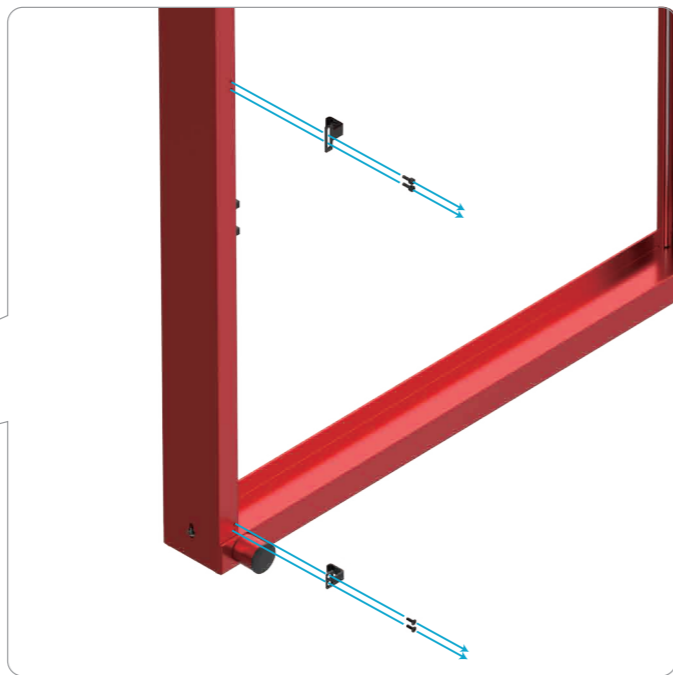
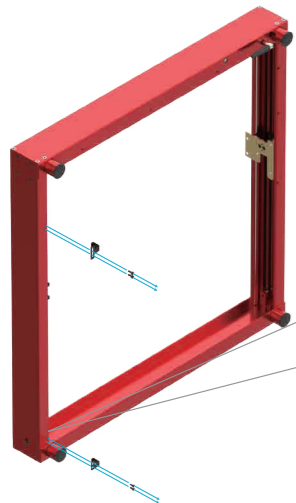


If the position limit control board cannot be removed due to screw slipping, use the sharp-nose pliers to remove it. Exercise caution when doing this, protecting yourself from hurt.





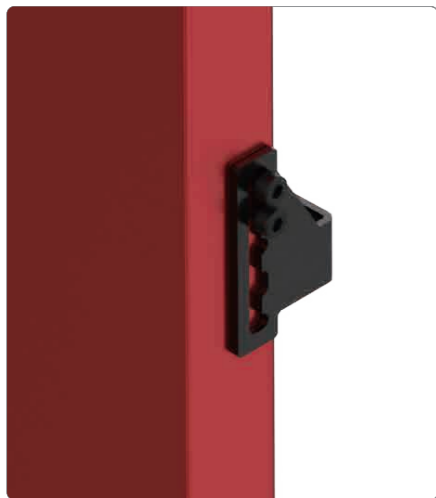
### 3. Replace the position limit pieces





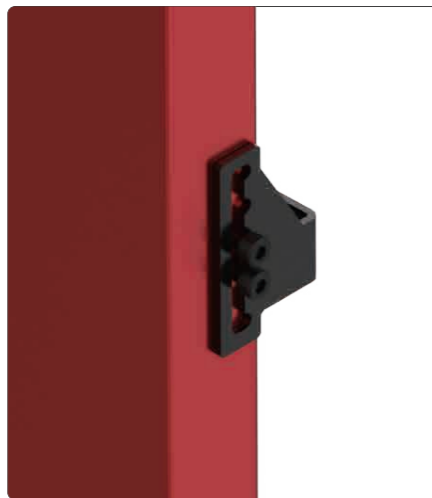
The largest processing area varies according to laser module. You need to set the position of position limit piece A, accordingly.

(1)



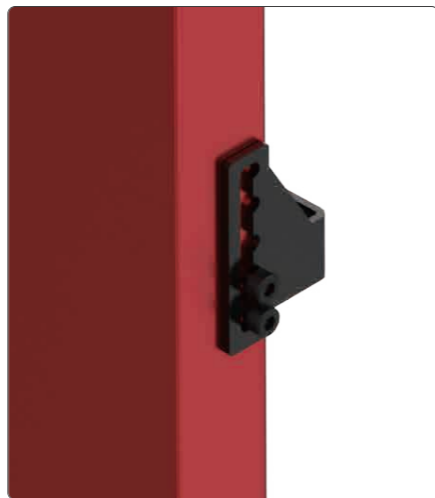
For laser module 40 W

(2)



For laser module 20 W

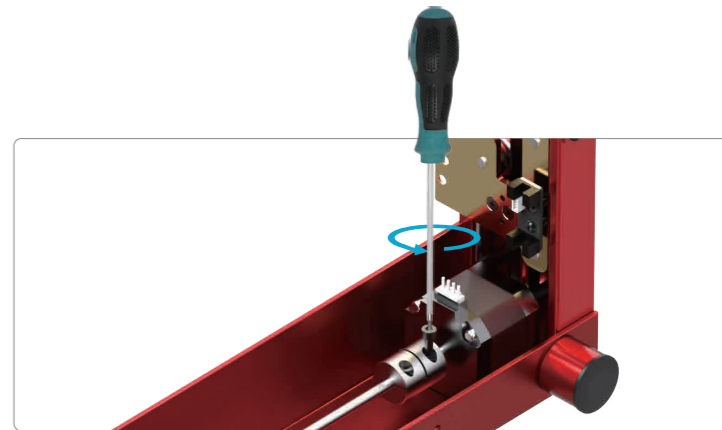
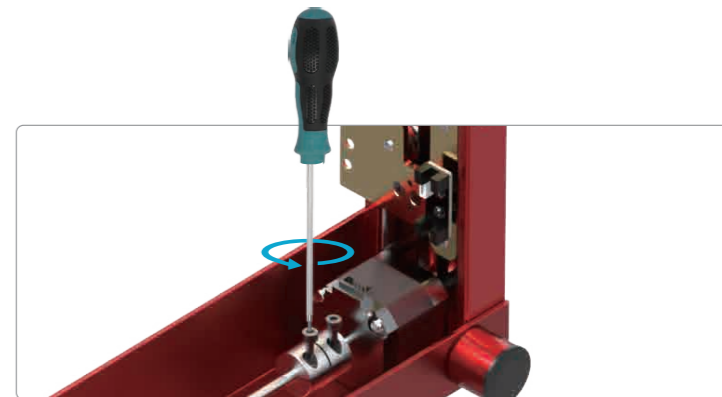
(3)

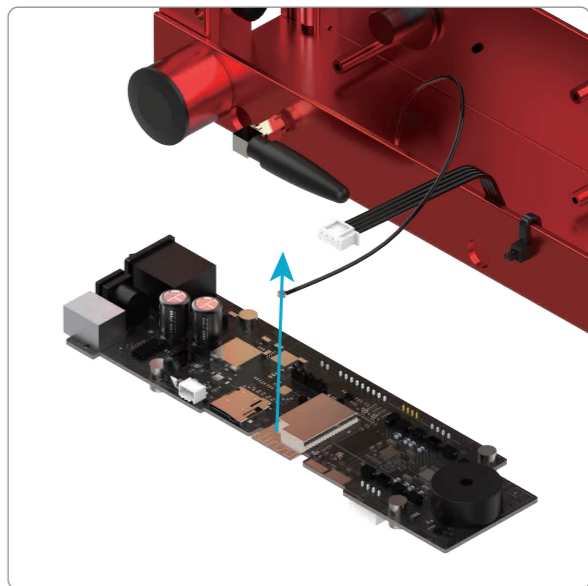
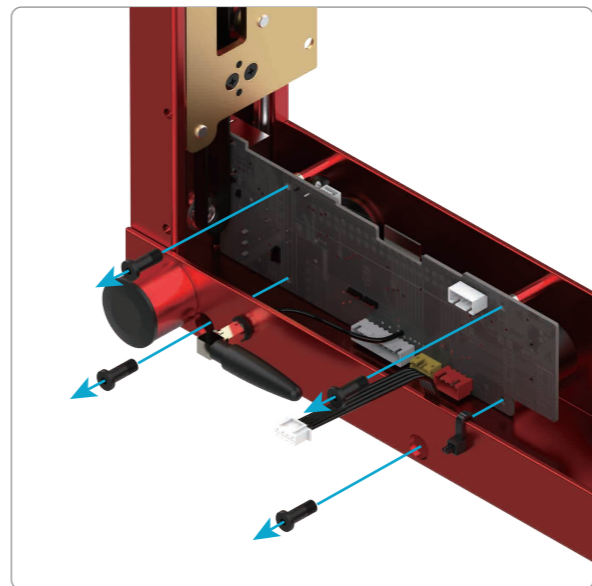
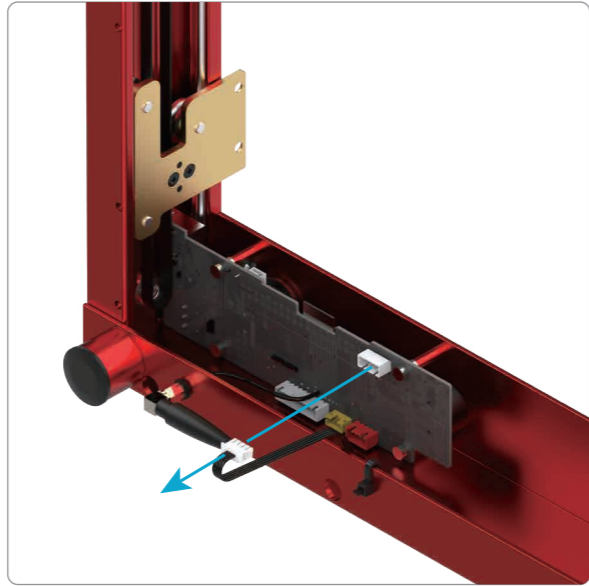
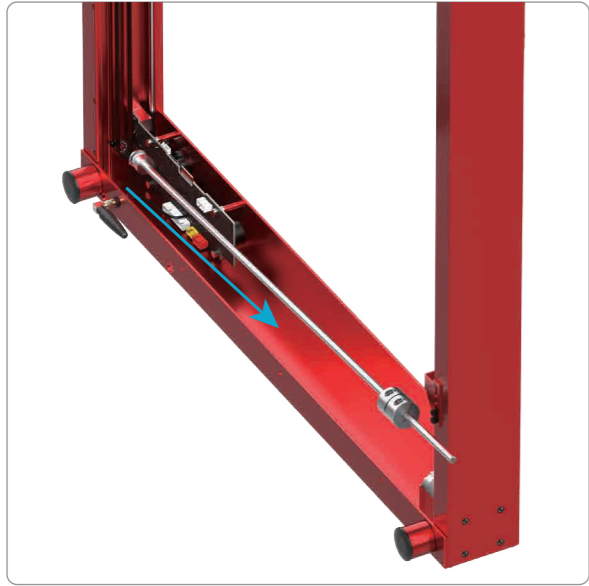


For laser module 10 W & 5 W

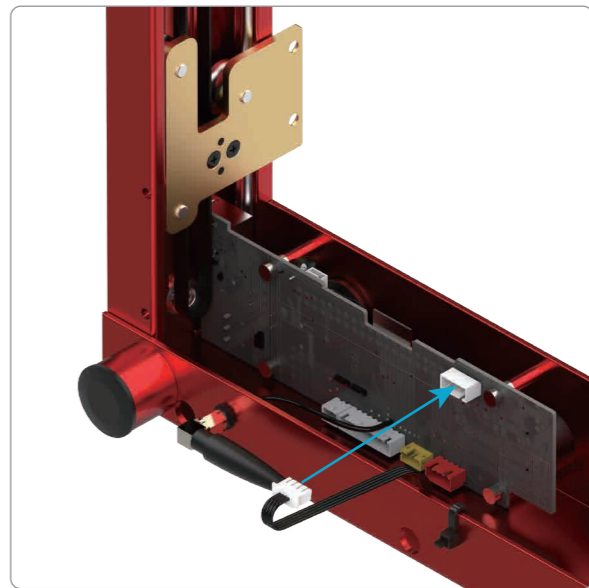
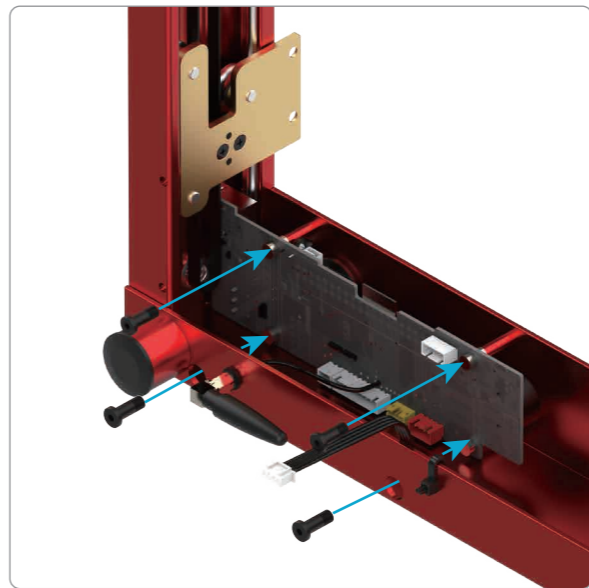
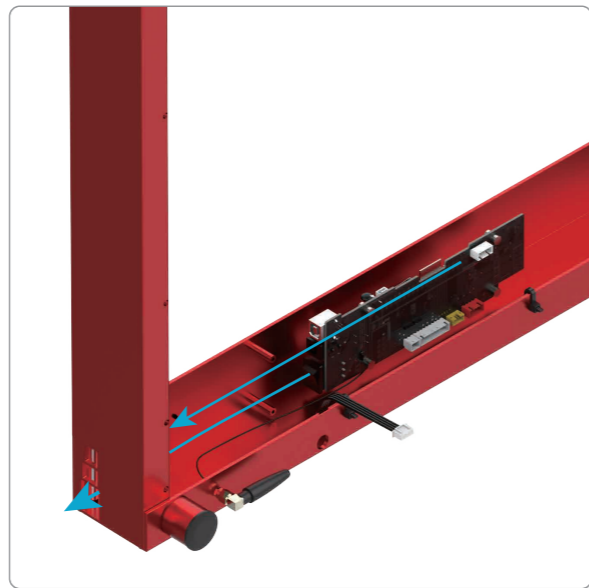
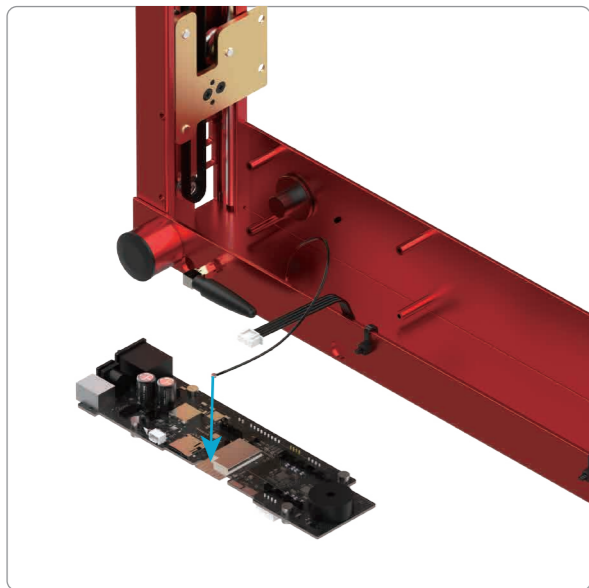
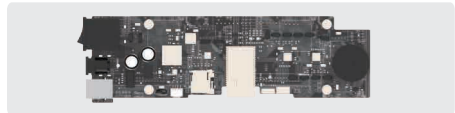
#### 4. Replace the main control board

(1) Remove the original main control board





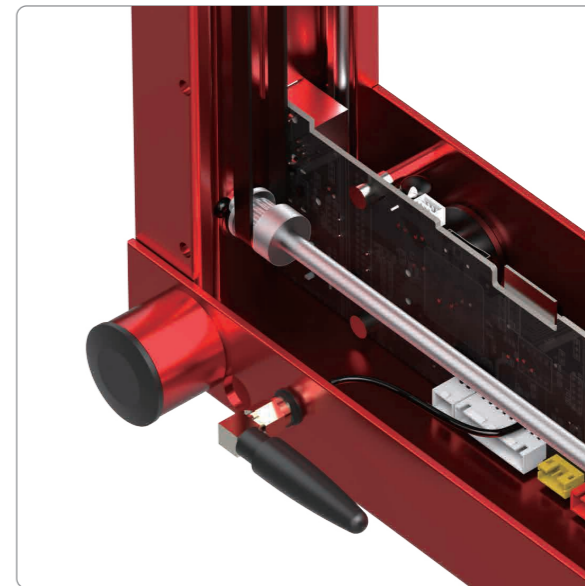
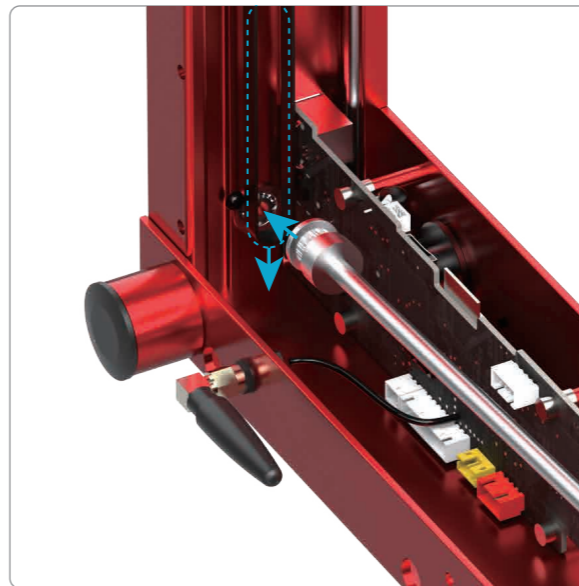
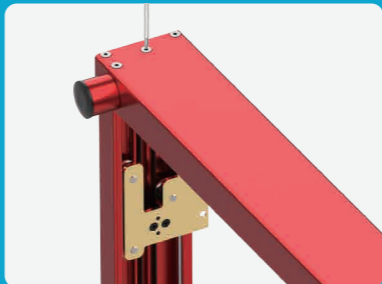
(2) Install the new main control board

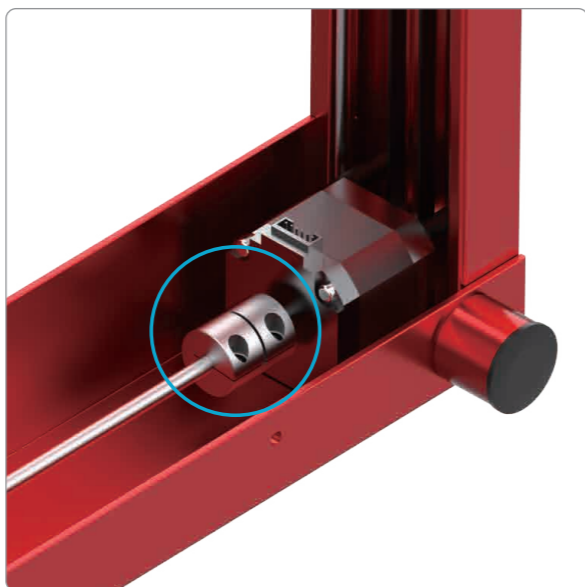
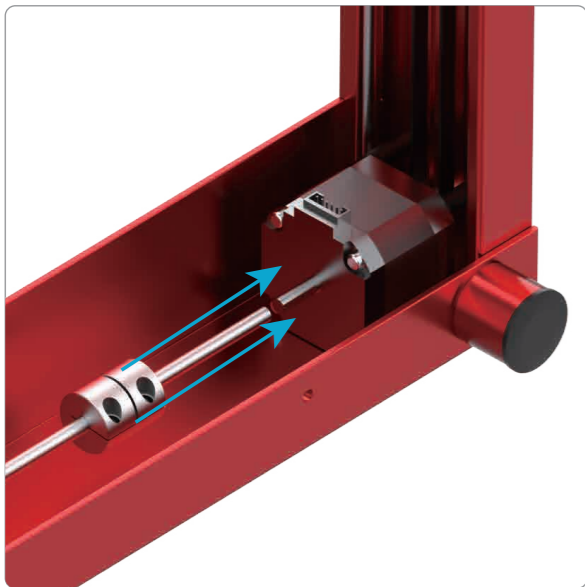


## 5. Install the shaft and coupling back to the machine

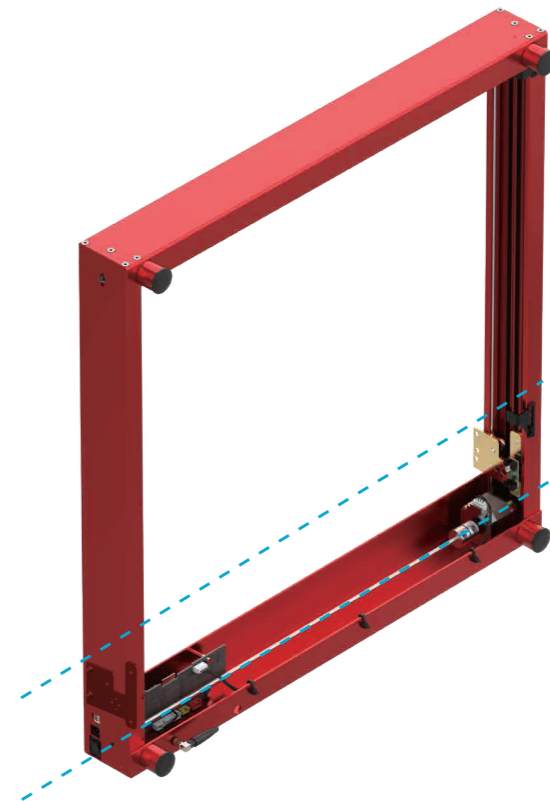


If you can't put the shaft through the timing belt, the possible cause is that the timing belt is set too tight. You can adjust its tension by turning the screw.

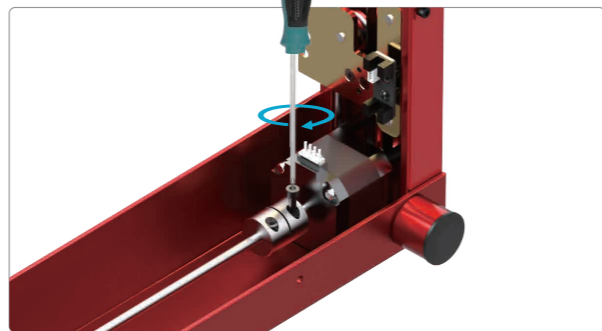
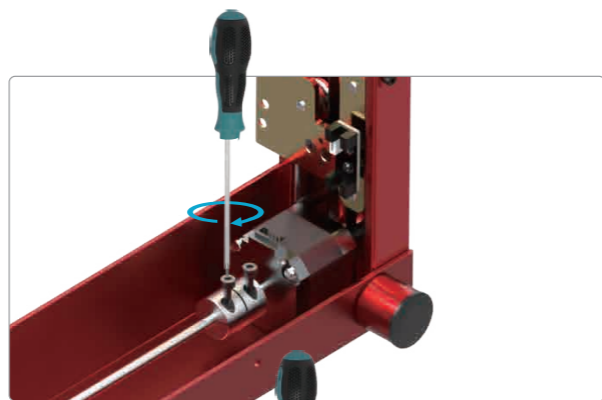




Keep a small distance between the coupling and motor, or the coupling can't rotate properly.  
Do not tighten the screws here.

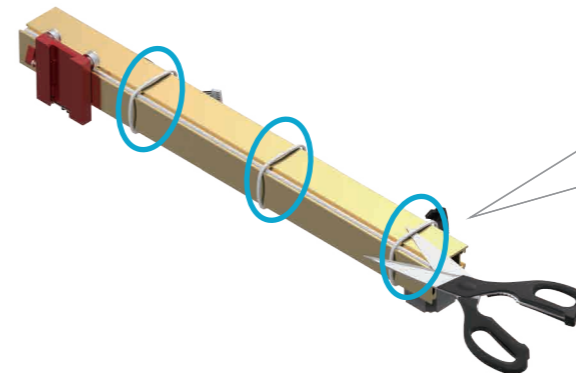
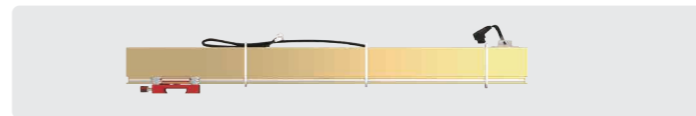


Slide the two sliders down against the front plate.

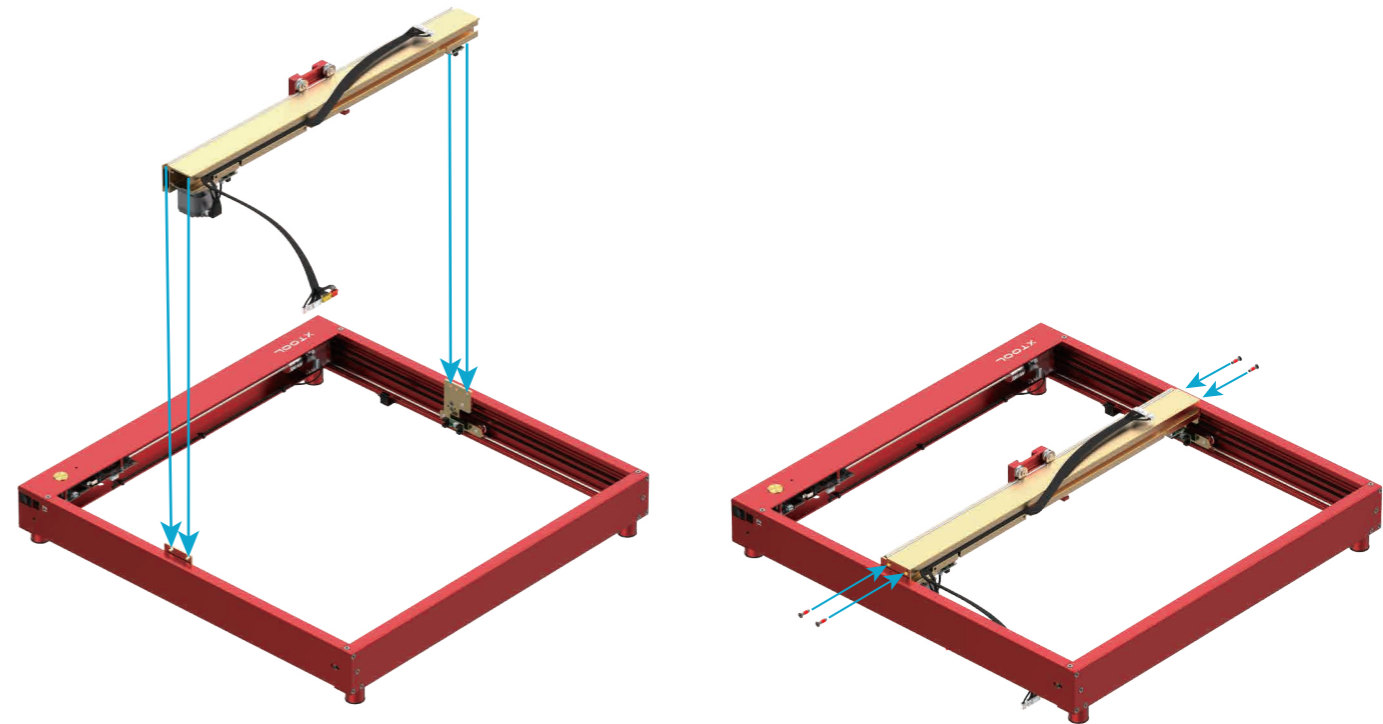
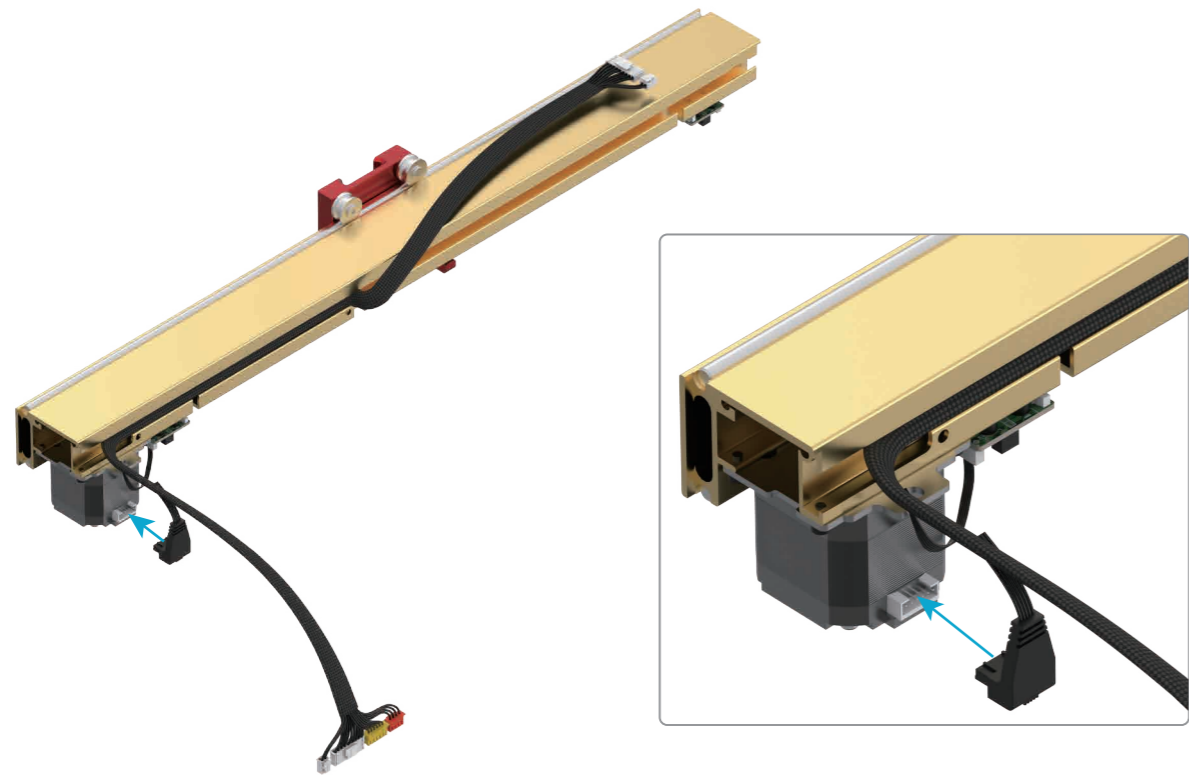


Fully tighten the two screws.

## 6. Install the new middle plate



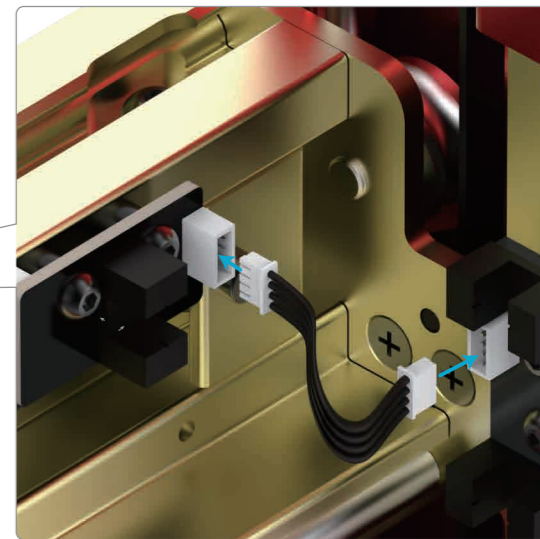
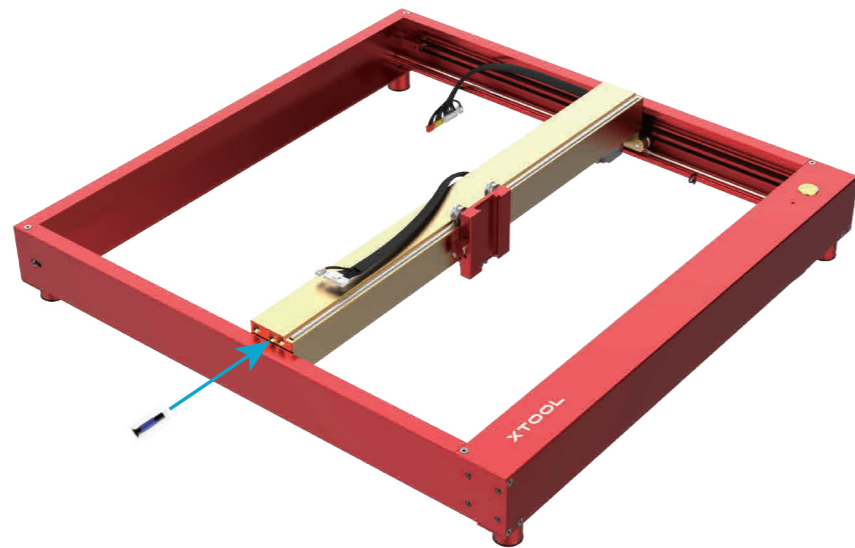
Cut off the white cable ties, and keep the black ones.

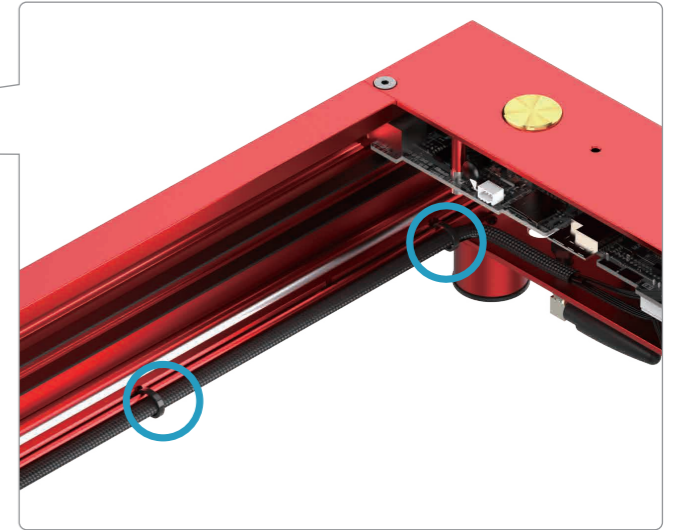
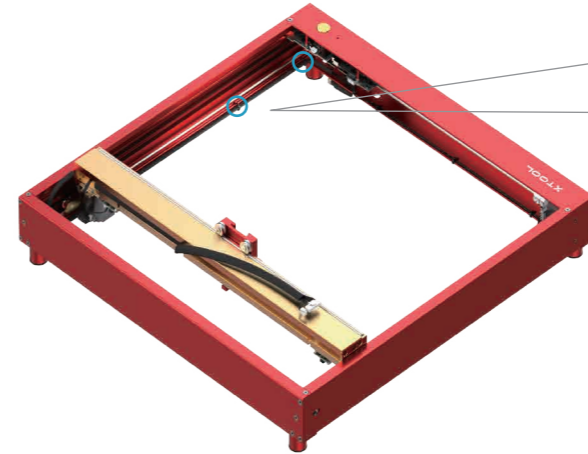
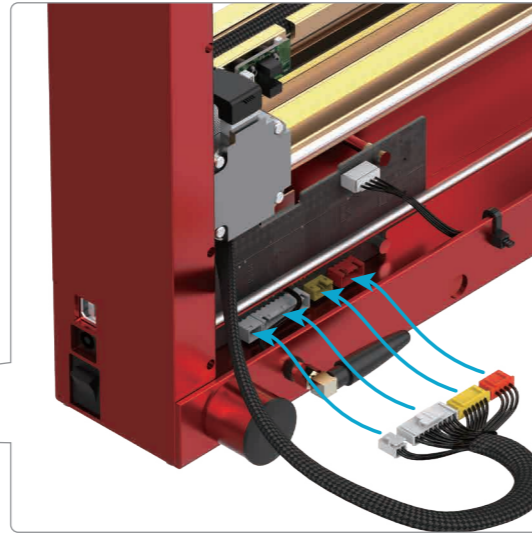
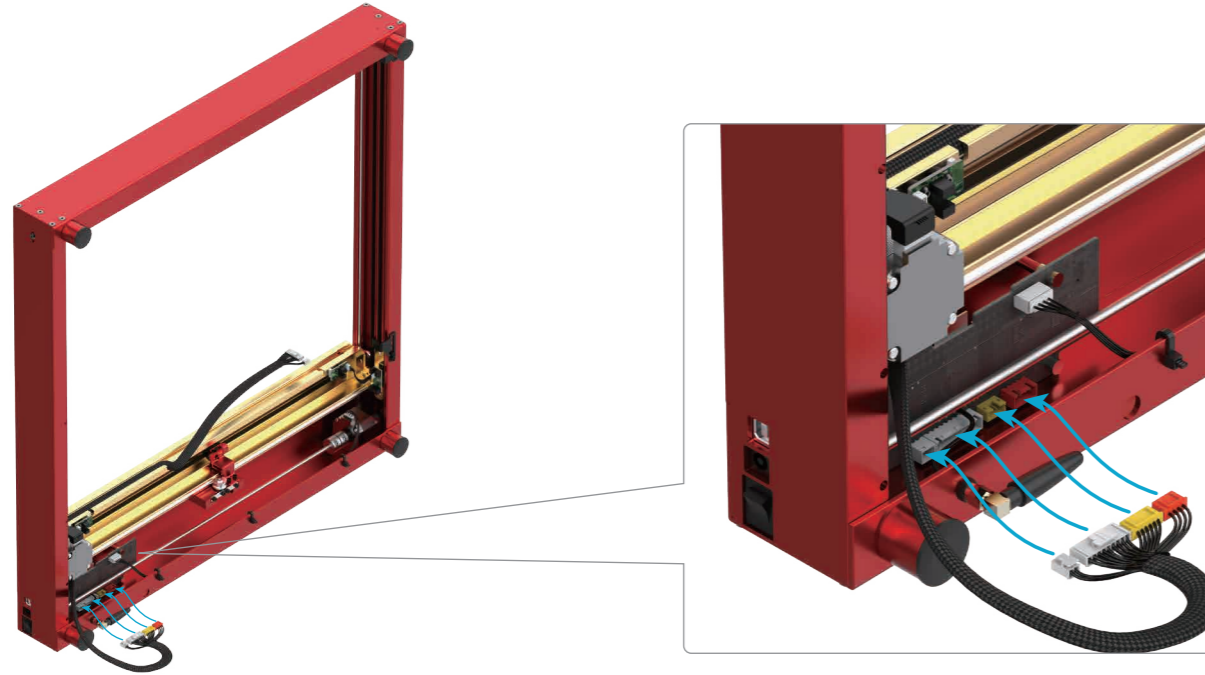






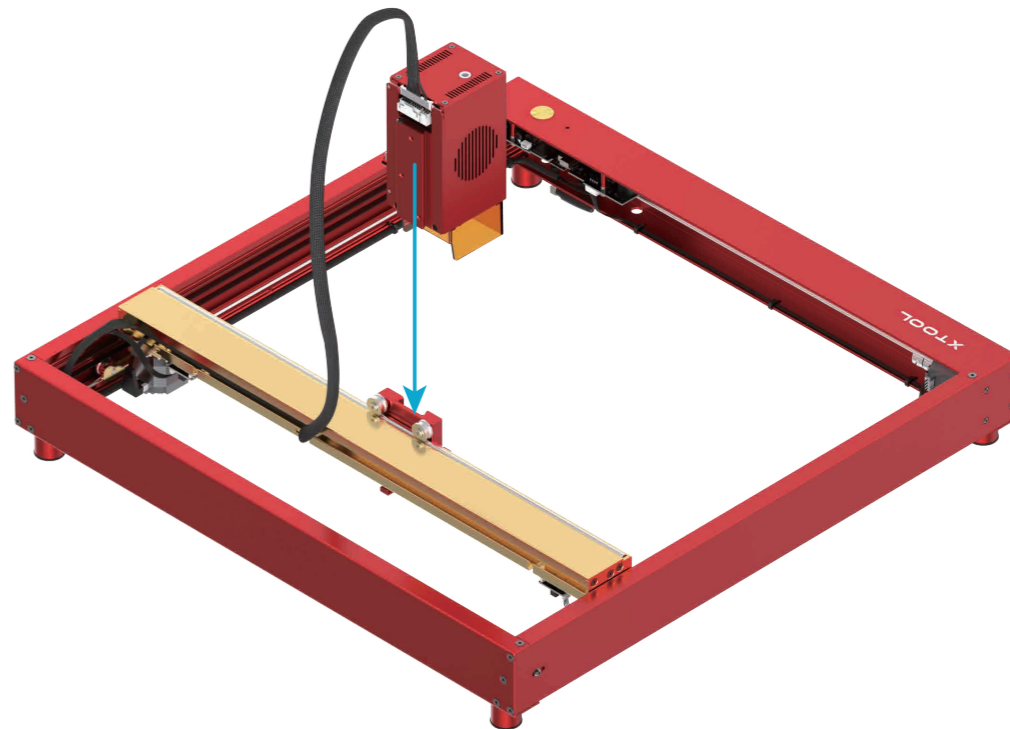
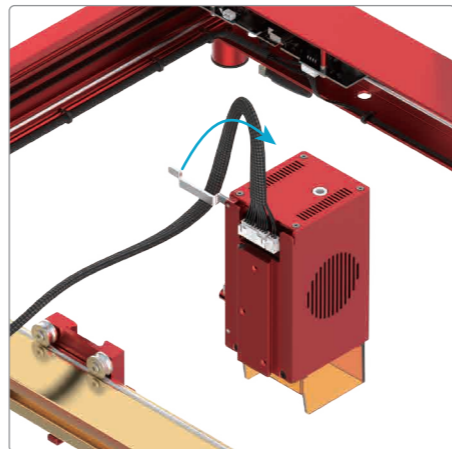
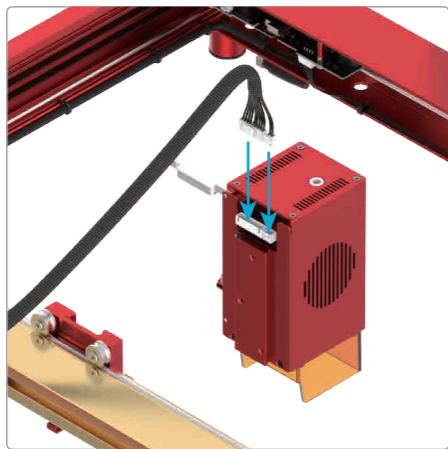
The screw is used to set the tension of the timing belt. Do not fully tighten it. Otherwise, the timing belt may be damaged.

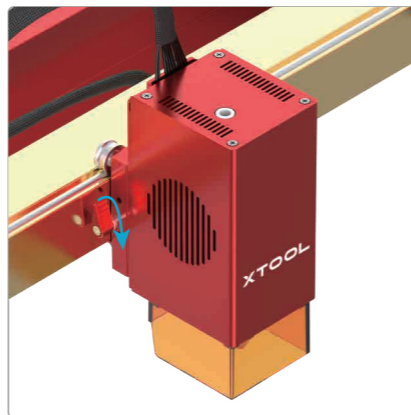
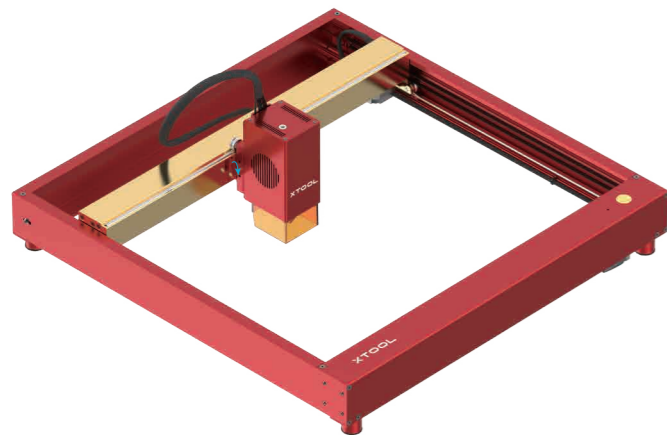




There are three holes designed for cable ties on the right plate. Do not attach a cable tie in the middle hole. It may interfere with the moving of the laser module.

## 7. Install the new laser module

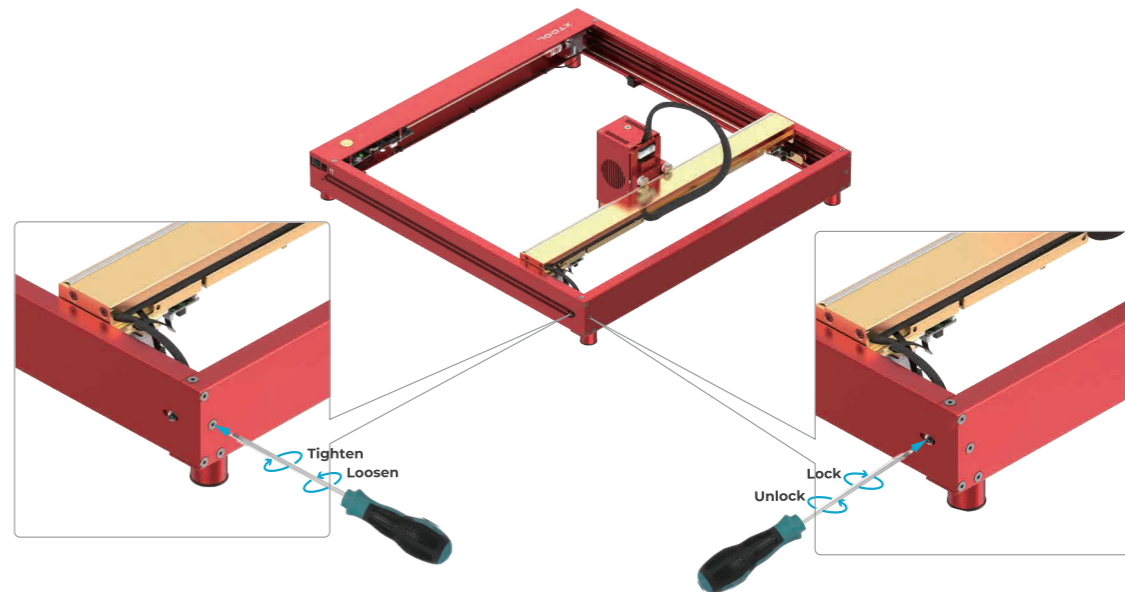




Modification completed!

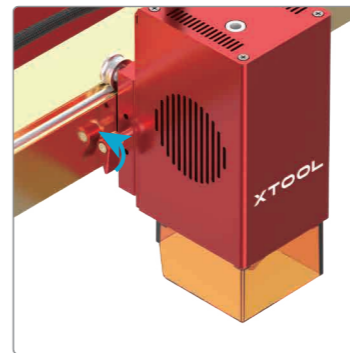
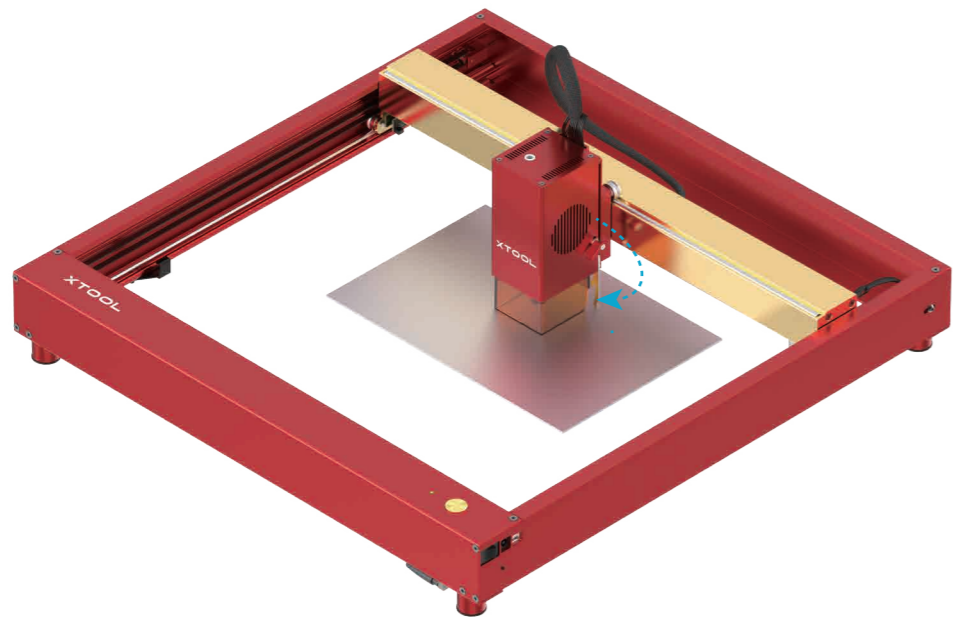
## Set up the machine

### 1. Adjust the tension of the timing belt on the right plate

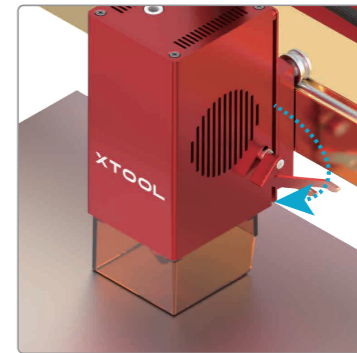


Try to set the tension of the timing belt on the right plate to be the same as that of the timing belt on the left plate to ensure better engraving and cutting results.

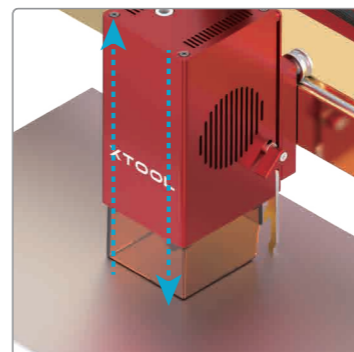
## 2. Set the position of the laser module



Loosen the thumb screw



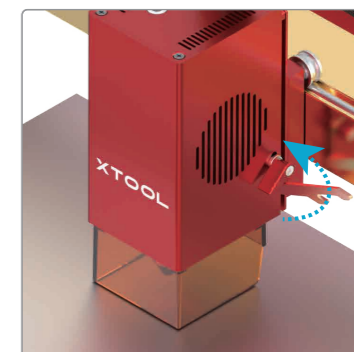
Put the focal length setting bar down



Slide the laser module up or down to allow the bottom of the focal length setting bar to just touch the surface of the material



Tighten the thumb screw

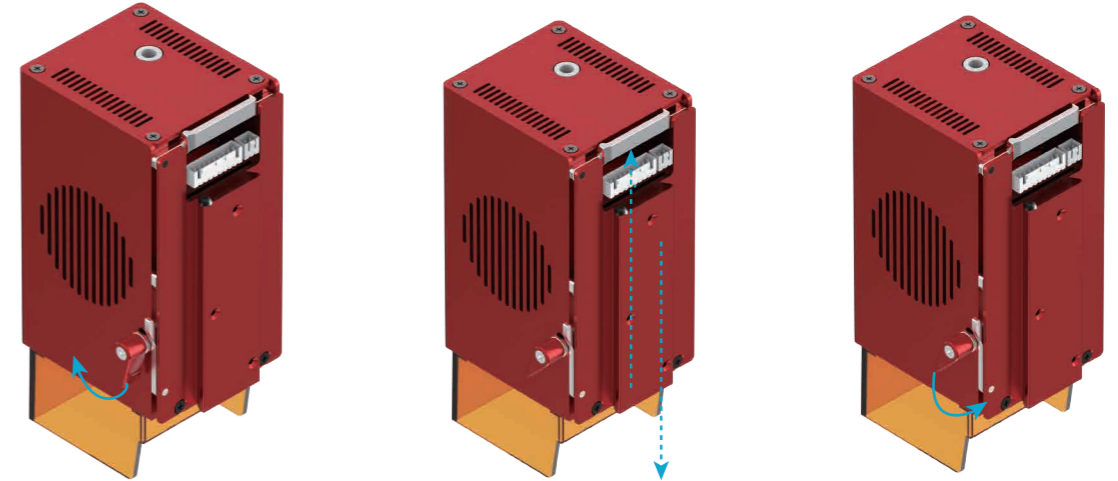
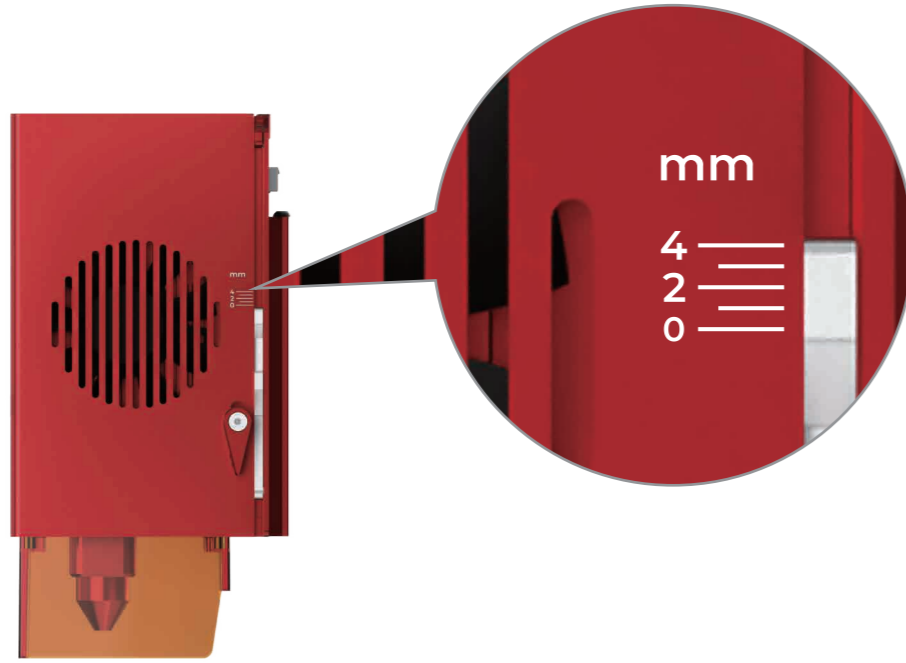


Put the focal length setting bar back

### 3. Set the position of the rear plate on the laser module



To cut thicker materials, you can adjust the position of the rear plate of the laser module to ensure better cutting results.

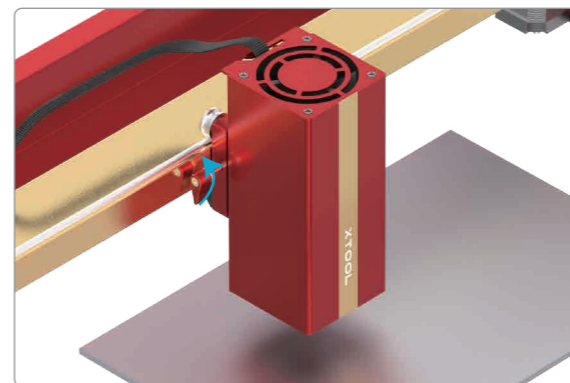
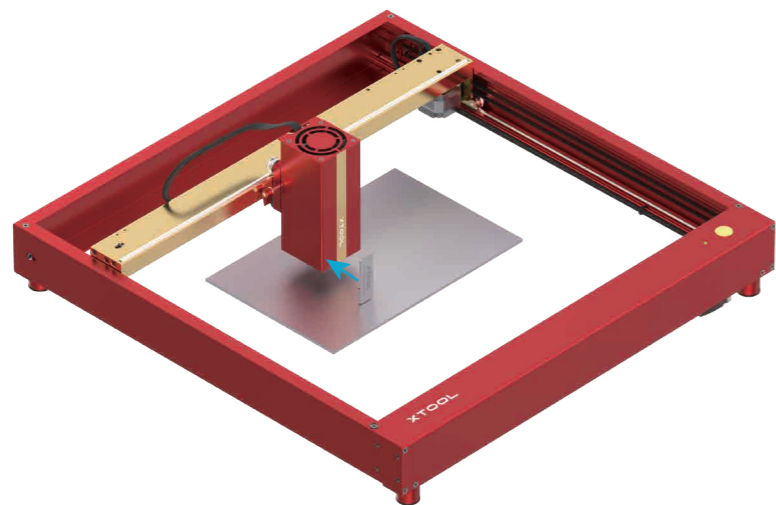


After adjusting the position of the rear plate, you can still use the focal length setting bar to set the position of the laser module.

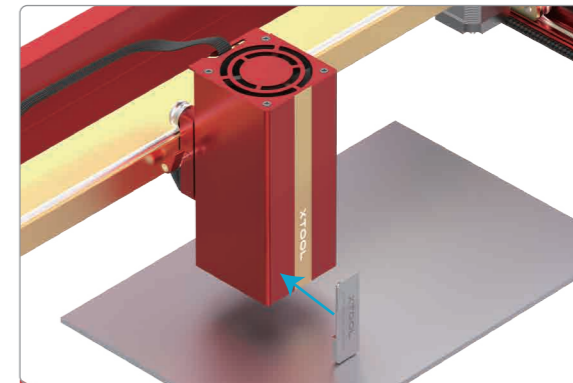
## Use the focal length setting piece for the infrared laser module



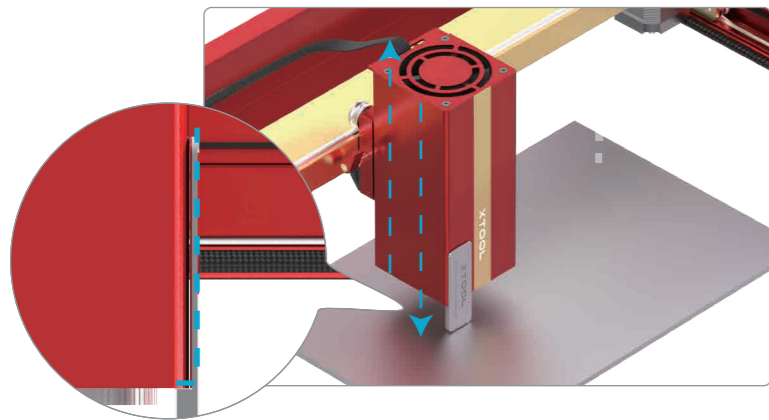
If you use the infrared laser module on the machine, use the focal length setting piece delivered with the machine to set the position of the infrared laser module.



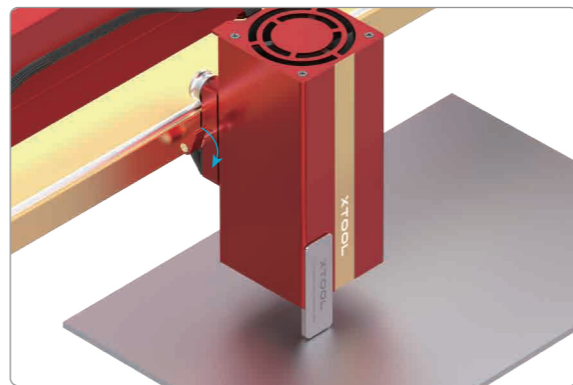
Loosen the thumb screw



Place the piece close to the bottom of the laser module



Slide the laser module up or down to allow its bottom edge to rest on the step of the piece and the bottom of the piece to touch the surface of the material



Tighten the thumb screw

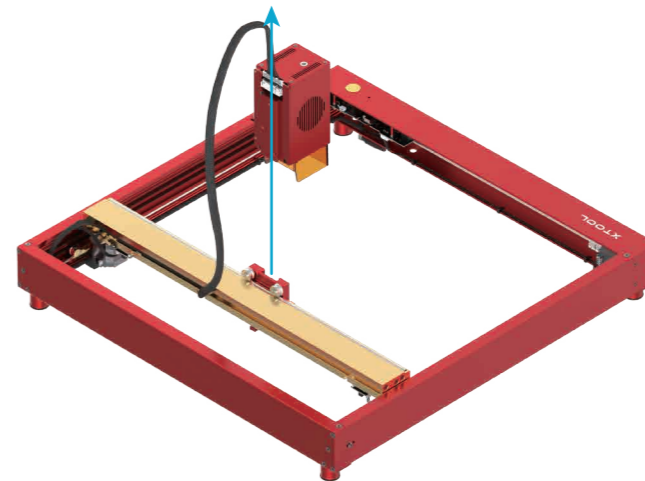
## Clean the laser module



For the 40 W laser module, you are advised to clean it, including the inner and outer frames of the light shield, lens, and red light outlet, every time after it has been used for one consecutive hour.

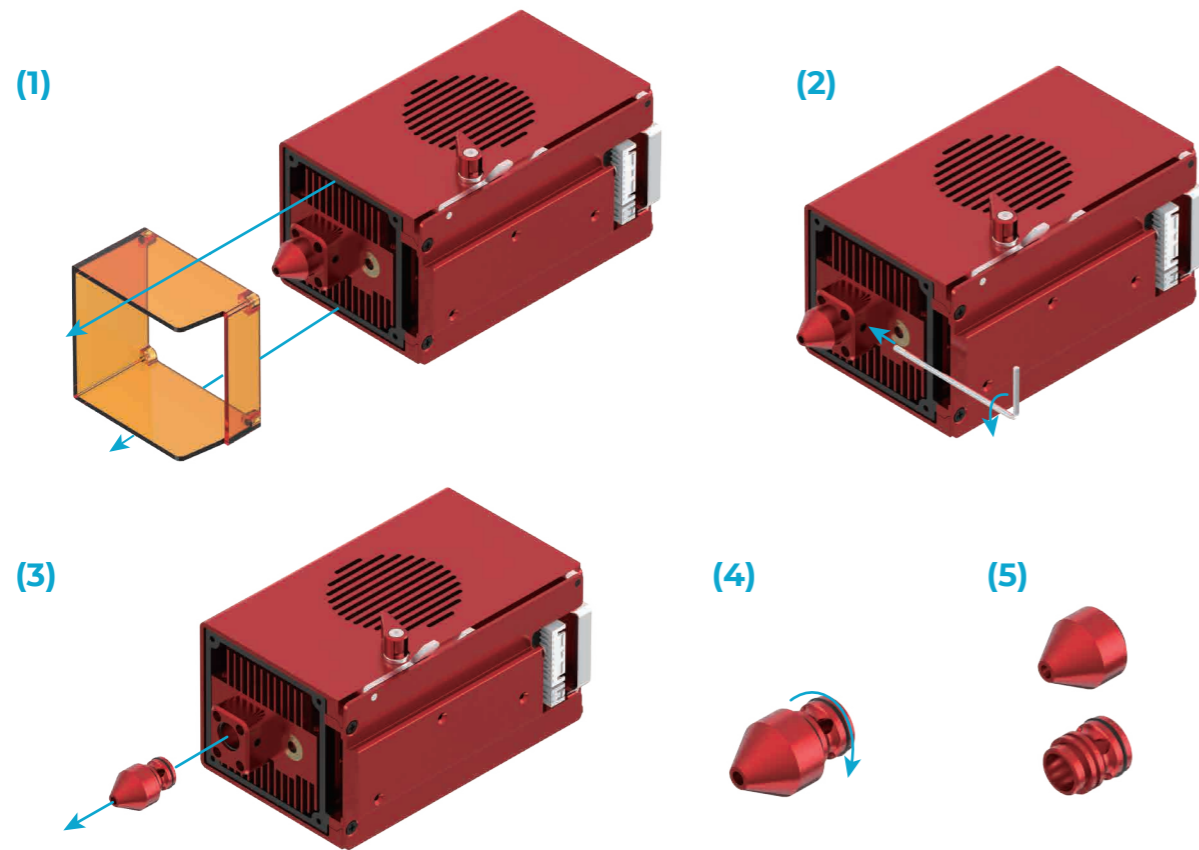
When the light shield is dirty or laser beams can't cut a material, you need to clean the laser module.

**1. Turn off the device and remove the laser module from it.**

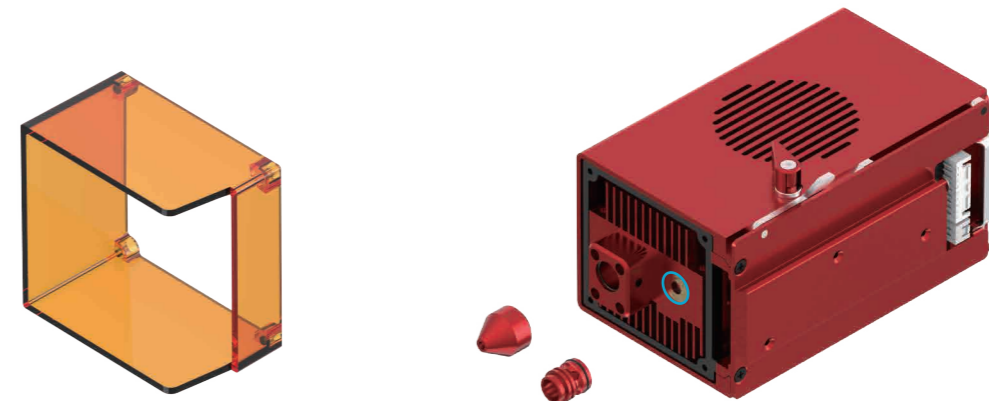




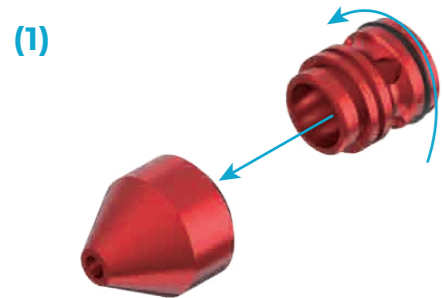
2. Take the lens out of the laser module.



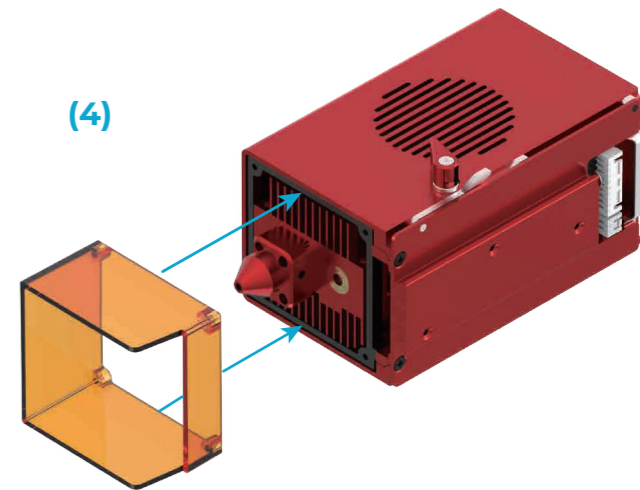
3. Clean the inner and outer frames of the light shield with tissues or dust-free cloth moistened with alcohol; and clean the laser lens, nozzle, and red light outlet with a cotton swab moistened with alcohol.



4. Put the lens back to the laser module.



5. If you find the lens difficult to clean, you can replace it with a new one.



# Instructions | Anweisungen | Instrucciones | Instructions | Istruzioni | Instructies | Instruções | 使用説明 | 지침 | 使用説明 | 使用说明

## Statement | Erklärung | Informe | Déclaration | Dichiarazione | Verklaring | Declaração | 声明 | 스테이트먼트 | 聲明 | 声明

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### ES

¡Bienvenido al uso de los productos xTool!

Si está utilizando este producto por primera vez, lea cuidadosamente todo el material que lo acompaña para mejorar la experiencia con el producto. Si no utiliza este producto de acuerdo con las instrucciones y requisitos del Manual u opera el producto de manera errónea, etc., la empresa no se hará responsable de ningún daño.

La empresa ha cotejado el contenido del manual de manera rigurosa; sin embargo, pueden llegar a quedar algunos errores u omisiones.

La empresa se compromete a seguir mejorando las funciones de sus productos y la calidad de sus servicios y, por lo tanto, se reserva el derecho de cambiar cualquier producto o software descrito en el Manual, así como también el contenido del Manual en cualquier momento.

La función de este Manual es la de ayudarlo a utilizar este producto de manera apropiada y no incluye ninguna descripción de la configuración del hardware o software. Para ver la configuración del producto, revise el contrato relacionado (si existe) y la lista de embalaje, o consulte al distribuidor. Las imágenes en el Manual son únicamente de referencia y pueden variar con respecto al producto real.

El manual está protegido por las leyes y reglamentos sobre derechos de autor y no podrá reproducirse ni transcribirse en ningún modo, ni transmitirse por ninguna red alámbrica o inalámbrica de ninguna forma, ni traducirse a ningún idioma, ni modificarse en modo alguno en su contenido, imagen o maquetación, sin la autorización previa por escrito de la empresa.

### FR

Bienvenue sur les produits xTool !

En cas de première utilisation du produit, lisez attentivement tous les documents d'accompagnement du produit afin d'améliorer votre expérience avec celui-ci. La société ne sera pas responsable des pertes qui résulteront d'une utilisation incorrecte du produit selon les instructions et les exigences du manuel, ou d'une mauvaise utilisation du produit en raison d'un malentendu de votre part.

La société a rassemblé le contenu du manuel avec rigueur et attention, mais il est possible qu'il subsiste des erreurs ou des omissions.

La société s'engage à améliorer continuellement les fonctions des produits et la qualité du service, et se réserve donc le droit de modification de tout produit ou logiciel décrit dans le manuel et le contenu du manuel à tout moment.

Le manuel est destiné à vous aider à utiliser le produit correctement et ne comprend aucune description de la configuration matérielle et logicielle. Reportez-vous au contrat correspondant (le cas échéant) et à la liste de colisage pour la configuration du produit, ou consultez votre distributeur. Les images du manuel sont fournies à titre de référence uniquement et le produit réel peut varier.

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## IT

Benvenuti all'utilizzo dei prodotti xTool!

Se utilizzi il prodotto per la prima volta, leggi attentamente tutti i documenti forniti per un'esperienza migliore. Se non si utilizza il prodotto secondo le istruzioni e i requisiti del manuale, o se si utilizza il prodotto in modo errato a causa di incomprensioni, ecc., la azienda non puo' assumersi alcuna responsabilità per eventuali perdite derivate.

La azienda ha redatto questo Manuale con rigore e attenzione, ma possono comunque essere presenti errori o omissioni.

La azienda si impegna a migliorare continuamente le funzioni del prodotto e la qualità del servizio, e pertanto si riserva il diritto di modificare qualsiasi prodotto o software descritto nel Manuale e il contenuto dello stesso in qualsiasi momento.

Il Manuale ha lo scopo di aiutare l'utente a utilizzare correttamente il prodotto e non include alcuna descrizione della configurazione hardware e software. Per la configurazione del prodotto, fare riferimento al relativo contratto (se presente) e all'elenco di imballaggio oppure rivolgersi al distributore. Le immagini nel Manuale sono solo di riferimento e il prodotto reale può variare.

Secondo le leggi e le norme sul diritto d'autore, non è consentito riprodurre o trascrivere il manuale in nessun modo, né trasferirlo in nessuna forma in una rete via cavo o wireless, né tradurlo in qualsiasi lingua, né modificarlo in alcun modo, ad esempio nel contenuto, nelle immagini o nel layout senza previa autorizzazione scritta dell'azienda.

## NL

Welkom bij xTool producten!

Als u het product voor de eerste keer gebruikt, lees dan zorgvuldig alle begeleidende materialen van het product om uw ervaring met het product te verbeteren. Als u het product niet volgens de instructies en eisen van de handleiding gebruikt, of het product verkeerd gebruikt door een misverstand, etc., zal het Bedrijf geen verantwoordelijkheid dragen voor enig verlies dat hieruit voortvloeit.

Het Bedrijf heeft de inhoud van de handleiding zorgvuldig verzameld, maar er kunnen fouten of omissies in voorkomen.

Het Bedrijf streeft naar een voortdurende verbetering van de productfuncties en de kwaliteit van de service, en behoudt zich daarom het recht voor om elk product of software beschreven in de Handleiding en de inhoud van de Handleiding op elk moment te wijzigen.

De handleiding is bedoeld om u te helpen het product correct te gebruiken en bevat geen beschrijving van de hardware- en softwareconfiguratie. Raadpleeg voor de productconfiguratie het (eventuele) bijbehorende contract en de paklijst, of neem contact op met uw distributeur. Afbeeldingen in de handleiding dienen alleen ter referentie en het werkelijke product kan afwijken.

Deze handleiding wordt auteursrechtelijk beschermd en mag, zonder voorafgaande schriftelijke toestemming van het Bedrijf, op geen enkele wijze worden gereproduceerd of getranscribeerd. Tevens mag deze niet worden verzonden via een bekabeld of draadloos netwerk, naar enige taal worden vertaald, en deze mag op geen enkele wijze waar het bijvoorbeeld de content, afbeeldingen of lay-out betreft, worden gewijzigd.

## PT

Muito obrigado por escolher a xTool!

Se estiver a usar o produto pela primeira vez, leia atentamente todos os materiais que acompanham o produto para melhorar a sua experiência com ele. Se não usar o produto de acordo com as instruções e exigências do Manual, ou operar o produto de forma incorreta devido à má compreensão etc., a Empresa não se responsabilizará por qualquer prejuízo resultante.

A Empresa compilou o conteúdo do Manual rigorosa e cuidadosamente, mas podem existir erros ou omissões.

A Empresa compromete-se a melhorar continuamente as funções do produto e a qualidade do serviço e, portanto, reserva-se o direito de alterar qualquer produto ou software descrito no Manual e o conteúdo do Manual a qualquer momento.

O Manual destina-se a ajudá-lo a usar o produto corretamente e não inclui qualquer descrição de configuração de hardware e software. Para a configuração do produto, consulte o contrato relacionado (se houver) e a lista da embalagem ou consulte o seu distribuidor. As imagens no Manual são somente para referência e o produto real pode variar.

Protegido pelas leis e regulações de direito de autor, o Manual não deve ser reproduzido ou transcrito de nenhuma forma, ou ser transmitido em nenhuma rede com ou sem fio de qualquer maneira, ou ser traduzido em qualquer idioma, ou ser modificado de qualquer forma, tais como modificação de conteúdo, imagem, ou layout, sem a autorização prévia por escrito da Empresa.

## JP

xTool製品へようこそ!

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## KO

xTool 제품을 구입해 주셔서 감사합니다!

본 제품을 처음 사용하는 경우 제품과 함께 제공되는 모든 자료를 주의 깊게 읽으시면 더 나은 사용 경험을 즐기실 수 있습니다. 본 사용설명서의 지시 및 요구사항에 따라 본 제품을 사용하지 않거나, 이해 부족 등으로 제품을 오작동 시킨 경우, 그 회사 손실 대해 일체의 책임을 지지 않습니다.

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## TC

感謝您選擇使用 xTool 產品!

若您初次使用此產品，請仔細閱讀此產品的所有隨附材料，以提高您的使用體驗。若您未按照本手冊的說明和要求條件使用產品，或因誤解等原因誤操作產品而造成的損失，公司不承擔任何責任。

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本手冊旨在幫助您正確使用產品，不包括任何硬體和軟體組態說明。關於產品組態，請參考相關合同（如有）和打包清單，或諮詢經銷商。手冊中的影像僅供參考，實際產品可能會有所不同。

本手冊受著作權法保護。未經公司事先書面授權，不得以任何方式複製或抄錄本手冊、不得以任何形式在任何有線或無線網路中傳送本手冊、不得將本手冊翻譯成任何語言，也不得對本手冊的任何內容、圖片、編排等進行修改。

## ZH

欢迎使用 xTool 产品!

首次使用本产品，请先仔细阅读随产品配送的所有资料，以便更好地使用本产品。若未能依照说明和要求使用产品，或由于理解错误等原因误操作本产品，公司将不对由此导致的任何损失承担任何责任。

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## Declaration of conformity | Konformitätserklärung | Declaración de conformidad | Déclaration de conformité | Dichiarazione di conformità | CONFORMITEITSVERKLARING | Declaração de conformidade

### Frequentes

#### EN

Hereby, Makeblock Co., Ltd., declares that this product is in compliance with the essential requirements and other relevant provisions of Directive RED 2014/53/EU and the RoHS directive 2011/65/EU.

#### DE

Hiermit erklärt Makeblock Co., Ltd., dass dieses Produkt die grundlegenden Anforderungen und anderen relevanten Vorschriften der Richtlinie RED 2014/53/EU und der RoHS-Richtlinie 2011/65/EU & (EU) 2015/863 einhält.

#### ES

Makeblock Co. Ltd. declara por la presente que este producto cumple los requisitos esenciales y otras disposiciones pertinentes de la directiva RED 2014/53/UE y la directiva RoHS 2011/65/UE & (EU) 2015/863.

#### FR

Makeblock Co., Ltd. déclare par la présente que ce produit est conforme aux principales exigences et autres dispositions pertinentes de la directive Directive RED 2014/53/UE et de la directive RoHS 2011/65/UE & (EU) 2015/863.

#### IT

la Makeblock Co., Ltd., con la presente dichiara che questo prodotto è conforme ai requisiti essenziali ed alle altre disposizioni pertinenti alla direttiva RED 2014/53/UE e della direttiva RoHS 2011/65/UE & (EU) 2015/863.

#### NL

Hierbij verklaart Makeblock Co., Ltd., dat dit product in overeenstemming is met de essentiële eisen en andere relevante bepalingen van Richtlijn RED 2014/53/EU en de RoHS-richtlijn 2011/65/EU & (EU) 2015/863.

#### PT

Pelo presente, a Makeblock Co., Ltd., declara que este produto está em conformidade com os requisitos essenciais e outras disposições relevantes da Diretiva RED 2014/53/UE e da Diretiva RoHS 2011/65/UE & (EU) 2015/863.

## FCC statement

This device complies with Part 15 of the FCC Rules. Operation is subject to the following two conditions:

(1) This device may not cause harmful interference, and (2) This device must accept any interference received, including interference that may cause undesired operation.

Warning: Changes or modifications not expressly approved by the party responsible for compliance could void the user's authority to operate the equipment.

NOTE: This equipment has been tested and found to comply with the limits for a Class B digital device, pursuant to Part 15 of the FCC Rules. These limits are designed to provide reasonable protection against harmful interference in a residential installation. This equipment generates uses and can radiate radio frequency energy and, if not installed and used in accordance with the instructions, may cause harmful interference to radio communications. However, there is no guarantee that interference will not occur in a particular installation. If this equipment does cause harmful interference to radio or television reception, which can be determined by turning the equipment off and on, the user is encouraged to try to correct the interference by one or more of the following measures:

- Reorient or relocate the receiving antenna.
- Increase the separation between the equipment and receiver.
- Connect the equipment to an outlet on a circuit different from that to which the receiver is connected.
- Consult the dealer or an experienced radio/TV technician for help.

#### FCC radiation exposure statement

This equipment complies with FCC radiation exposure limits set forth for an uncontrolled environment. This equipment should be installed and operated with a minimum distance of 20 cm between the radiator and your body.

产品有毒有害物质或元素的名称及含量表

部件名称	有毒有害物质或元素					
	铅 (Pb)	汞 (Hg)	镉 (Cd)	六价铬 Cr(VI)	多溴联苯 (PBB)	多溴二苯醚 (PBDE)
PCB	○	○	○	○	○	○
线材	○	○	○	○	○	○
焊锡	○	○	○	○	○	○
金属件	×	○	○	○	○	○
电子元器件	○	○	○	○	○	○

○：表示该有毒有害物质在该部件所有均质材料中的含量均在SJ/T11363-2006 标准规定的限量要求以下。

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备注：以上“×”的部件中，部分含有有害物质超标是由于目前行业水平有限，暂时无法实现替代或减量化。



本标识内数字表示自产品组装出厂之日算起，产品在正常使用状态下的环保使用期限为10年。

After-sales services | Kundendienst | Servicio de posventa | Services après-vente | Servizi post-vendita | Dienst na verkoop | Serviços de pós-vendas | アフターサービス | 애프터 서비스 | 售後服務 | 售后服务

**EN**

For technical support, contact us through [support@xtool.com](mailto:support@xtool.com).  
For more information about after-sales services, visit [support.xtool.com](http://support.xtool.com).

**DE**

Für technische Unterstützung kontaktieren Sie uns bitte unter [support@xtool.com](mailto:support@xtool.com).  
Weitere Informationen über Kundendienstleistungen finden Sie unter [support.xtool.com](http://support.xtool.com).

**ES**

Para soporte técnico, contáctese con nosotros a través de [support@xtool.com](mailto:support@xtool.com).  
Para más información acerca de los servicios posventa, visite [support.xtool.com](http://support.xtool.com).

**FR**

Pour obtenir une assistance technique, contactez-nous à l'adresse [support@xtool.com](mailto:support@xtool.com).  
Pour plus d'informations sur les services après-vente, visitez [support.xtool.com](http://support.xtool.com).

**IT**

Per assistenza tecnica, contattateci per email: [support@xtool.com](mailto:support@xtool.com).  
Per ulteriori informazioni sui servizi post-vendita, visitare [support.xtool.com](http://support.xtool.com).

**NL**

Voor technische ondersteuning kunt u contact met ons opnemen via [support@xtool.com](mailto:support@xtool.com).  
Voor meer informatie over de dienst na verkoop, bezoek [support.xtool.com](http://support.xtool.com).

**PT**

Para suporte técnico, entre em contato através do e-mail [support@xtool.com](mailto:support@xtool.com).  
Para maiores informações sobre os serviços de pós-vendas, visite [support.xtool.com](http://support.xtool.com).

**JP**

テクニカルサポートについては、[support@xtool.com](mailto:support@xtool.com)までお問い合わせください。  
アフターサービスの詳細については、[jp@xtool.com](http://jp@xtool.com)にアクセスしてください。

**KO**

기술 지원이 필요한 경우 [support@xtool.com](mailto:support@xtool.com) 으로 문의하십시오.  
애프터 서비스에 대한 자세한 내용은 [support.xtool.com](http://support.xtool.com)을 방문하십시오.

**TC**

如需技術支持，請前往 [support@xtool.com](mailto:support@xtool.com) 聯繫我們。  
更多售後資訊，請前往 [support.xtool.com](http://support.xtool.com)。

**ZH**

更多产品信息，可访问 [makeblock.com/cn/docs](http://makeblock.com/cn/docs)  
如需技术支持，可通过以下方式联系我们：  
• QQ 技术支持：[800182013](https://www.qq.com)  
• 技术支持热线：[400-893-0004](tel:400-893-0004)  
• 微信公众号：童心制物售后



## EN

**When I set the bitmap processing speed to a large value, the laser module jitters when it is working, causing poor engraving results. Why and what can I do?**

During material processing, your computer generates data while transmitting the data to the machine. Therefore, a high-performance computer is required. Processing may get stuck or jitters may be caused due to the performance of your computer.

You are advised to:

- use a high-performance computer or use the offline processing way to ensure that the processing is not affected by the transmission of GCode files.
- use the machine on a flat surface, such as the ground, to ensure that it doesn't shake during material processing.
- not use risers. Risers raise the center of gravity of the machine and therefore reduce the stability of the machine.
- reduce the processing speed to ensure better engraving results.

## DE

**Wenn ich die Bitmap-Verarbeitungsgeschwindigkeit auf einen hohen Wert einstelle, tritt beim Lasermodul während der Bearbeitung Jitter auf, sodass ich mangelhafte Gravurergebnisse erhalte. Warum ist das so und was kann ich tun?**

Während der Materialbearbeitung generiert Ihr Computer während der Datenübertragung zur Maschine Daten. Deshalb wird ein Hochleistungscomputer benötigt. Aufgrund der unzureichenden Leistungsfähigkeit Ihres Computers kann die Bearbeitung ins Stocken geraten oder es kann Jitter auftreten.

Deshalb sollten Sie Folgendes beachten:

- Verwenden Sie einen Hochleistungscomputer oder nutzen Sie eine Offline-Bearbeitungsform, um sicherzustellen, dass die Bearbeitung nicht durch die Übertragung von GCode-Dateien beeinträchtigt wird.
- Stellen Sie die Maschine auf eine ebene Oberfläche, beispielsweise auf den Boden, damit sie während der Materialbearbeitung stabil steht und nicht wackelt.
- Stellen Sie sie nicht auf eine erhöhte Unterlage, z. B. auf Riser. Diese können den Schwerpunkt der Maschine anheben und dadurch ihre Stabilität beeinträchtigen.
- Verringern Sie die Bearbeitungsgeschwindigkeit, um bessere Gravurergebnisse zu gewährleisten.

## ES

**Cuando ajusto la velocidad de procesamiento del mapa de bits a un valor grande, el módulo láser tiembla cuando está funcionando, provocando malos resultados de grabado. ¿Por qué sucede y qué puedo hacer?**

Durante el procesamiento del material, su ordenador genera datos a la vez que los transmite a la máquina. Por lo tanto, se requiere un ordenador de alto rendimiento. Es posible que el procesamiento se atasque o que se produzcan vibraciones debido al rendimiento de su ordenador.

Le aconsejamos que:

- Utilice un ordenador de alto rendimiento o utilice el modo de procesamiento fuera de línea para asegurarse de que el procesamiento no se ve afectado por la transmisión de archivos GCode.
- Utilice la máquina sobre una superficie plana, como el suelo, para asegurarse de que no tiemble durante el procesamiento del material.
- No utilice elevadores. Los elevadores elevan el centro de gravedad de la máquina y, por tanto, reducen su estabilidad.
- Reduzca la velocidad de procesamiento para garantizar mejores resultados de grabado.

## FR

**Lorsque je définis la valeur de traitement bitmap sur une valeur élevée, le module laser vibre lors du fonctionnement, ce qui provoque de mauvais résultats de gravure. Pourquoi et comment corriger ce problème ?**

Au cours du traitement du matériau, votre ordinateur génère des données tout en les transmettant à la machine. Un ordinateur hautes performances est donc requis. Le traitement peut se bloquer ou des vibrations peuvent avoir lieu en raison des performances de votre ordinateur.

Il est conseillé :

- d'utiliser un ordinateur hautes performances ou une méthode de traitement hors ligne afin de s'assurer que le traitement ne soit pas affecté par la transmission des fichiers GCode ;
- d'utiliser la machine sur une surface plane, par exemple sur le sol, pour s'assurer qu'elle ne tremble pas au cours du traitement de matériau ;
- de ne pas utiliser de cales. Les cales font monter le centre de gravité de la machine et réduisent donc sa stabilité ;
- de réduire la vitesse de traitement afin d'assurer de meilleurs résultats de gravure.



## IT

**Durante il funzionamento, se imposto la velocità di elaborazione bitmap su un valore elevato, il modulo laser trema, causando scarsi risultati di incisione. Perché e cosa posso fare?**

Durante la lavorazione del materiale, il computer genera dati e li trasmette alla macchina per l'elaborazione. Pertanto, è necessario un computer ad alte prestazioni, poiché l'utilizzo di un computer a prestazioni ridotte potrebbe causare il blocco dell'elaborazione o la vibrazione del modulo laser.

Si consiglia di:

- Utilizzare un computer ad alte prestazioni o la modalità di elaborazione offline per garantire che l'elaborazione non sia influenzata dalla trasmissione di file GCode.

- Utilizzare la macchina su una superficie piana, come il pavimento, per assicurarsi che non si verifichino vibrazioni durante la lavorazione del materiale.

- Non utilizzare piedini di rialzo, poiché alzando il baricentro della macchina viene ridotta la sua stabilità.

- Ridurre la velocità di elaborazione per ottenere migliori risultati di incisione.

## NL

**Wanneer ik de verwerkingssnelheid van de bitmap op een hoge waarde instel, maakt de lasermodule tijdens het werken onregelmatige bewegingen. Met slechte graveerresultaten als gevolg. Waarom is dat en wat kan ik doen?**

Tijdens het verwerken van materiaal genereert uw computer gegevens terwijl deze de gegevens doorstuurt naar de machine. Daar is een krachtige computer voor nodig. De verwerking kan vastlopen of er kunnen onregelmatige bewegingen ontstaan doordat de computer niet afdoende presteert.

U wordt geadviseerd om:

- een krachtige computer te gebruiken of om de offline verwerkingsmethode toe te passen. Zo zorgt u ervoor om dat de verwerking niet wordt beïnvloed door de overdracht van GCode-bestanden.

- de machine op een vlakke ondergrond gebruiken, zoals de grond, zodat de machine tijdens de verwerking van het materiaal niet schudt.

- gebruik geen verhoogblokken. Verhoogblokken verhogen het zwaartepunt van de machine, dit vermindert de stabiliteit van de machine.

- de verwerkingssnelheid verlagen voor betere graveerresultaten.

## PT

**Quando ajusto a velocidade de processamento do bitmap para um valor grande, o módulo de laser tremula em funcionamento causando resultados de gravura ruins. Porquê e o que posso fazer?**

Durante o processamento do material, o seu computador gera dados enquanto transmite dados para a máquina. Por isso, é necessário um computador de alto-desempenho. O processamento pode ficar congestionado ou pode ocorrer tremulação devido ao desempenho do seu computador.

É recomendado:

- utilizar um computador de alto-desempenho ou utilizar a via de processamento offline para assegurar que o processamento não seja afetado pela transmissão de ficheiros GCode.

- utilizar a máquina sobre uma superfície plana, como o solo, para assegurar que ela não sacode durante o processamento do material.

- não utilizar calços elevadores. Calços elevadores elevam o centro de gravidade da máquina e, com isso, reduzem a estabilidade da máquina.

- reduzir a velocidade de processamento para assegurar melhores resultados de gravura.

## JP

**「ビットマップを加工する際、処理速度を大きい値に設定すると、レーザーヘッドが振動し、彫刻効果が低下します。その理由と対処法は？」**

ユーザーごとにパソコンの性能が異なるため、D1 Proではパソコンがデータを生成しながら、D1 Proに送信して処理する方式を採用しているため、コンピュータの性能によっては処理が滞ったり、ジッタが発生したりする場合があります。

推奨される方法は次のとおりです。

- 高性能コンピューターを使用するかオフラインで処理します。転送Gcodeファイル時の効率を確保します。
- 揺れない作業台 (地面など) での作業: フレームが安定していることを確保してください。
- 柱を高くしない: 重心を下げ、ラックの安定性をさらに向上。
- 加工速度を適切に下げ、より完璧な彫刻効果を実現します。

## KO

비트맵 처리 속도를 높이면 레이저 모듈에서 떨림이 발생해 각인 품질이 나빠집니다. 원인과 해결 방법이 궁금합니다.

소재 가공 시 컴퓨터에서는 데이터를 생성하여 기계로 전송하게 됩니다. 따라서 고성능 컴퓨터가 필요합니다. 컴퓨터 성능 문제로 인해 작동이 중단되거나 떨림 현상이 발생할 수도 있습니다.

다음 사항을 유념해 주십시오.

- GCode 파일 전송으로 인해 가공 시 문제가 생길 수 있으므로 고성능 컴퓨터를 사용하거나 오프라인 상태에서 가공 작업을 진행해 주십시오.

- 기계는 반드시 땅바닥 등 평평한 곳에서 사용하여 소재 가공 시 떨림이 발생하지 않도록 합니다.

- 레이저는 사용을 금합니다. 레이저를 사용하면 기계의 무게 중심이 높아져 안정성이 떨어지게 됩니다.

- 각인 품질이 나빠질 우려가 있으므로 가공 속도를 줄여 주십시오.

## TC

加工點陣圖時，為什麼只要使用高速加工，雷射頭就會抖動，導致雕刻效果變差？如何解決？

因為每個使用者使用的電腦效能有所差異，而 D1 Pro 採用的方式是電腦一邊產生資料，一邊傳輸給 D1 Pro 加工，因此如果使用的電腦效能較低，就會出現連線加工卡頓、抖動的現象。

建議方式如下：

- 使用高效能的電腦或離線加工：確保電腦傳輸 Gcode 文件的效率不會拖慢速度。
- 在不會晃動的平台上加工（例如地面）：確保機架穩固。
- 不增加墊高柱：降低重心，進一步提升機架的穩固性。
- 適當減緩加工速度，以達到更完美的雕刻效果。

## ZH

加工位图时，一旦使用高速加工，激光头会发生抖动，导致雕刻效果变差，为什么，怎么处理？

由于每个用户使用的电脑性能有差异，xTool D1 Pro采用的是电脑一边生成数据，一边传输给xTool D1 Pro 加工的方法，所以在使用性能较低的电脑时，就会出现在线加工卡顿、抖动的现象。

推荐方式如下：

- 使用高性能的电脑或离线加工：确保电脑的传输Gcode文件的效率不拖后腿。
- 在不会晃动的平台上加工（例如地面）：确保机架稳固。
- 不增加垫高柱：降低重心，进一步提升机架的稳固性。
- 适当降低加工速度，以达到更完美的雕刻效果。