

xTool M1(5W) Materials parameters for reference								
Serial number	Material code	Material name	Machine	Processing mode	Power %	Speed mm/s	Processing times	Remarks
1	AE001	Rubber mat for engraving	M1 5W	Laser vector engraving	90	40	1	
2	AE001	Rubber mat for engraving	M1 5W	Laser bitmap engraving	100	20	2	
3	APL0010	Black acrylic 3.0mm	M1 5W	Laser cutting	100	3	2	
4	APL0010	Black acrylic 3.0mm	M1 5W	Laser vector engraving	50	40	1	
5	APL0010	Black acrylic 3.0mm	M1 5W	Laser bitmap engraving	100	15	1	
6	APL058	2358 Yellow opaque	M1 5W	Laser cutting	100	3	4	
7	APL059	237 Yellow opaque	M1 5W	Laser cutting	100	2	4	
8	APL060	235 Yellow opaque	M1 5W	Laser cutting	100	2	4	
9	APL062	238 Yellow opaque	M1 5W	Laser cutting	100	2	4	
10	APL063	215 Yellow opaque	M1 5W	Laser cutting	100	2	4	
11	APL064	236 Yellow opaque	M1 5W	Laser cutting	100	2	4	
12	APL066	M002 Yellow opaque	M1 5W	Laser cutting	100	2	4	
13	APL067	M003 Yellow opaque	M1 5W	Laser cutting	100	2	4	
14	APL070	M006 Red opaque	M1 5W	Laser cutting	100	2	4	
15	APL072	M008 Orange opaque	M1 5W	Laser cutting	100	2	4	
16	APL074	8814 Brown opaque	M1 5W	Laser cutting	100	2	4	
17	APL075	502 Black opaque	M1 5W	Laser cutting	100	2	4	
18	APL076	5028 Black opaque	M1 5W	Laser cutting	100	2	3	
19	APL091	522 Brown translucent material	M1 5W	Laser cutting	100	2	4	
20	APL092	212 Yellow opaque	M1 5W	Laser cutting	100	2	4	
21	APL100	992 Red opaque	M1 5W	Laser cutting	100	2	4	
22	APL102	994 Yellow opaque	M1 5W	Laser cutting	100	2	4	
23	APL106	362 Green opaque	M1 5W	Laser cutting	100	2	4	
24	APL107	584 Brown translucent material	M1 5W	Laser cutting	100	2	4	
25	APL108	5021 Black opaque	M1 5W	Laser cutting	100	2	4	
26	APL109	102 Red opaque	M1 5W	Laser cutting	100	2	4	
27	APL110	2370 Black opaque	M1 5W	Laser cutting	100	2	4	
28	APL111	348 Green opaque	M1 5W	Laser cutting	100	2	4	
29	APL112	347 Green opaque	M1 5W	Laser cutting	100	2	4	
30	APL114	184 Green opaque	M1 5W	Laser cutting	100	2	4	
31	APL115	635 Green opaque	M1 5W	Laser cutting	100	2	4	
32	APL117	115 Red opaque	M1 5W	Laser cutting	100	2	4	
33	APL118	8138 Red opaque	M1 5W	Laser cutting	100	2	4	
34	APL119	136 Red opaque	M1 5W	Laser cutting	100	2	4	
35	APL120	135 Red opaque	M1 5W	Laser cutting	100	2	4	
36	APL122	8266 Orange opaque	M1 5W	Laser cutting	100	2	4	
37	APL128	GST-212 Transparent material	M1 5W	Laser cutting	100	2	4	
38	APL145	814 Brown opaque	M1 5W	Laser cutting	100	2	4	
39	AW050	Basswood plywood 3mm (launched by xTool)	M1 5W	Laser cutting	100	3	1	
40	AW050	Basswood plywood 3mm (launched by xTool)	M1 5W	Laser bitmap engraving	90	150	1	
41	AW051	Black Walnut (launched by xTool)	M1 5W	Laser cutting	100	3	1	
42	AW051	Black Walnut (launched by xTool)	M1 5W	Laser bitmap engraving	90	150	1	
43	AW069	Materials library_Black Walnut plywood (30cm × 30cm) 2pcs	M1 5W	Laser cutting	100	5	1	
44	AW069	Materials library_Black Walnut plywood (30cm × 30cm) 2pcs	M1 5W	Laser vector engraving	100	40	1	
45	AW069	Materials library_Black Walnut plywood (30cm × 30cm) 2pcs	M1 5W	Laser bitmap engraving	100	65	1	
46	AW070	Materials library_Pine plywood (30cm × 30cm) 2pcs	M1 5W	Laser cutting	100	4	2	
47	AW070	Materials library_Pine plywood (30cm × 30cm) 2pcs	M1 5W	Laser vector engraving	100	20	1	
48	AW070	Materials library_Pine plywood (30cm × 30cm) 2pcs	M1 5W	Laser bitmap engraving	100	40	1	
49	AW072	Materials library_Mahogany plywood (30cm × 30cm) 2pcs	M1 5W	Laser cutting	100	4	2	
50	AW072	Materials library_Mahogany plywood (30cm × 30cm) 2pcs	M1 5W	Laser vector engraving	100	15	1	
51	AW072	Materials library_Mahogany plywood (30cm × 30cm) 2pcs	M1 5W	Laser bitmap engraving	100	50	1	
52	AW073	Materials library_Cherry plywood (30cm × 30cm) 2pcs	M1 5W	Laser cutting	100	3	2	
53	AW073	Materials library_Cherry plywood (30cm × 30cm) 2pcs	M1 5W	Laser vector engraving	100	15	1	
54	AW073	Materials library_Cherry plywood (30cm × 30cm) 2pcs	M1 5W	Laser bitmap engraving	80	60	1	
55	BL016	Materials library_Stainless steel manicure set 16 pcs	M1 5W	Laser vector engraving	80	80	1	
56	BL016	Materials library_Stainless steel manicure set 16 pcs	M1 5W	Laser bitmap engraving	50	50	1	
57	BM001	Metal dog tag	M1 5W	Laser bitmap engraving	100	25	1	
58	BM004	Metal business card	M1 5W	Laser vector engraving	85	20	1	
59	BM004	Metal business card	M1 5W	Laser bitmap engraving	85	250	1	
60	BM006	Necklace jewelry	M1 5W	Laser bitmap engraving	100	25	1	
61	BM039	Metal money clip card case	M1 5W	Laser vector engraving	100	1	1	
62	BM039	Metal money clip card case	M1 5W	Laser bitmap engraving	100	10	1	
63	BP004	Color scratch paper	M1 5W	Laser cutting	60	15	1	
64	BP004	Color scratch paper	M1 5W	Laser vector engraving	20	80	1	
65	BP004	Color scratch paper	M1 5W	Laser bitmap engraving	20	100	1	
66	BS004	Rock coaster	M1 5W	Laser vector engraving	100	50	1	
67	BS004	Rock coaster	M1 5W	Laser bitmap engraving	100	80	1	
68	BW056	Materials library_Round bamboo & wood tray of diameter 15.5cm 4pcs	M1 5W	Laser vector engraving	100	50	1	
69	BW056	Materials library_Round bamboo & wood tray of diameter 15.5cm 4pcs	M1 5W	Laser bitmap engraving	100	60	1	
70	BW062	Wooden poster stand	M1 5W	Laser vector engraving	85	80	1	
71	BW062	Wooden poster stand	M1 5W	Laser bitmap engraving	85	100	1	