

Suggested Settings – Quick Reference

Laser Cutter

For all laser cutting and engraving, these settings are only starting points. They have worked in some tests, but may not work for your specific material – always test in an inconspicuous place on your material first, as there may be trial and error required.

Substrate	Mode	Power %	Speed mm/s	Pass	Notes
Bamboo	Engrave	50	300	1	
Wood Slice (Dollar Store)	Engrave	30	225	1-2	Varies by wood species, test first
Basswood 3mm (xTool brand)	Engrave Cut	20 100	250 15	1 1	To minimize scorch marks: Try increasing the # of passes and lowering the power
Basswood 3mm (Amazon brand)	Engrave Cut	30 100	200 15	1 1	To minimize scorch marks: Try increasing the # of passes and lowering the power
Laserable Leatherette (FourKeys brand)	Engrave Cut	20 12	355 10	1 1	
Slate Rock	Engrave	30	240	1	
Cork	Engrave	23	350	1	
Stainless Steel Coloured Tumbler (Other Brand)	Engrave	8-15	80-120	1	Test in an inconspicuous place first to fine tune settings. These settings are just a starting point. 15% @ 80mm/s worked well in a test, 8% @80mm/s recommended by xTool for their brand of tumblers.
Stainless Steel Powder Coated Tumbler (Yeti)	Engrave	30	300	1	These settings are just a starting point. Increase lines/cm for more detail. This test used 300 lines/cm.
Stainless Steel (uncoated)	Engrave	60	240	1	

Cricut

Most materials will come with suggested settings for use with a Cricut machine. Make sure you are looking at the settings for a Cricut Maker 3. If you are ever unsure of the settings for a material, you can always search the internet for the answer.

Material Name	Material Type	Print Settings	Cut Settings	Notes
Siser Easyweed HTV	Solid Colour Heat Transfer Vinyl		Vinyl, (non-Cricut)	Mirror ON, cut with shiny side down
Siser EasyColor DTV	Printable Heat Transfer Vinyl	Standard print quality, high quality will oversaturate colours. Allow to dry for 5 minutes before heat pressing.	Vinyl (non-Cricut)	Print Then Cut function in Cricut – print from inkjet printer first, then load into Cricut for cut
Zicoto Matte Printable Adhesive Vinyl	Matte Sticker Sheet	High quality print settings	Printable Vinyl, White (Gray Liner Printing)	For kiss cut, you will need gentler pressure than this – you will need to do tests
Zicoto Glossy Printable Adhesive Vinyl	Glossy Sticker Sheet	High quality print settings	Printable Waterproof Sticker Set – White	Set pressure to “Less”
IModeur Permanent Adhesive Vinyl	Solid Colour Sticky Vinyl		Everyday Iron On	

Heat Press

In general, for rougher, stiffer materials, multiple presses may be required for maximum adhesion. Softer materials should adhere better.

Substrate	Material	Temperature	Time	Notes
100% Cotton T Shirt	Siser Easyweed HTV	305	20s	Preheat fabric for 5s. Cover design with parchment paper before pressing. Hot peel.
100% Cotton T Shirt	Cricut Everyday Iron On	315	40s	Preheat fabric for 5s. Cover design with parchment paper before pressing. Cool peel.
100% Cotton T Shirt	Siser Printable DTV	310	15s	Preheat fabric for 5s. Cover design with parchment paper before pressing. Hot peel.
Cotton Blend Tea Towel	Cricut Smart Iron On	315	50s	Preheat fabric for 5s. May have to press multiple times for full adhesion. Test hot and cool peel in inconspicuous area for best results.
Cotton Blend Tea Towel	Cricut Sportflex HTV	315	15s	Preheat 5s. 1 press is enough, this material adheres very easily. Hot peel.
Cotton Blend Apron	Cricut Smart Iron On	315	50s	Preheat 5s. May require multiple presses to adhere properly. Test hot vs. cool peel.
Wood (Smooth, flat)	Cricut Glitter Iron On	330	40	Place cotton cloth between wood & hot plate when pressing. Preheat 5s. 1 press. Hot peel.
Wood (smooth, flat)	Siser Easyweed HTV	305	15	Preheat for 3s. Cover design with parchment paper before pressing. Hot peel.

This chart is just a small sample of examples. If you do not see your substrate or material listed here, search for: “heat press settings for _____ on _____” on the internet. You will need settings for temperature, time, and pressure. The Cricut Heat Guide is helpful when using Cricut brand materials, otherwise whichever brand you are using will usually have settings suggestions somewhere on their product page.

Ex. I searched “heat press settings for Siser Easyweed HTV on wood” and found the suggestion of a temperature of 305 with a time of 15 seconds. I tested it, and it worked!