

# XTOOL | F2

## Quick Start Guide



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\* The English version is the original instructions verified by the manufacturer.

## What's in the box



xTool F2



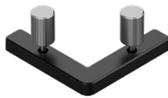
Pipe



Baseplate



Slatted panel



L-shaped positioning piece



Power adapter



Power cable



USB cable



Grease



Key (pre-installed)



Screwdriver



Lint-free cloth



Material pack



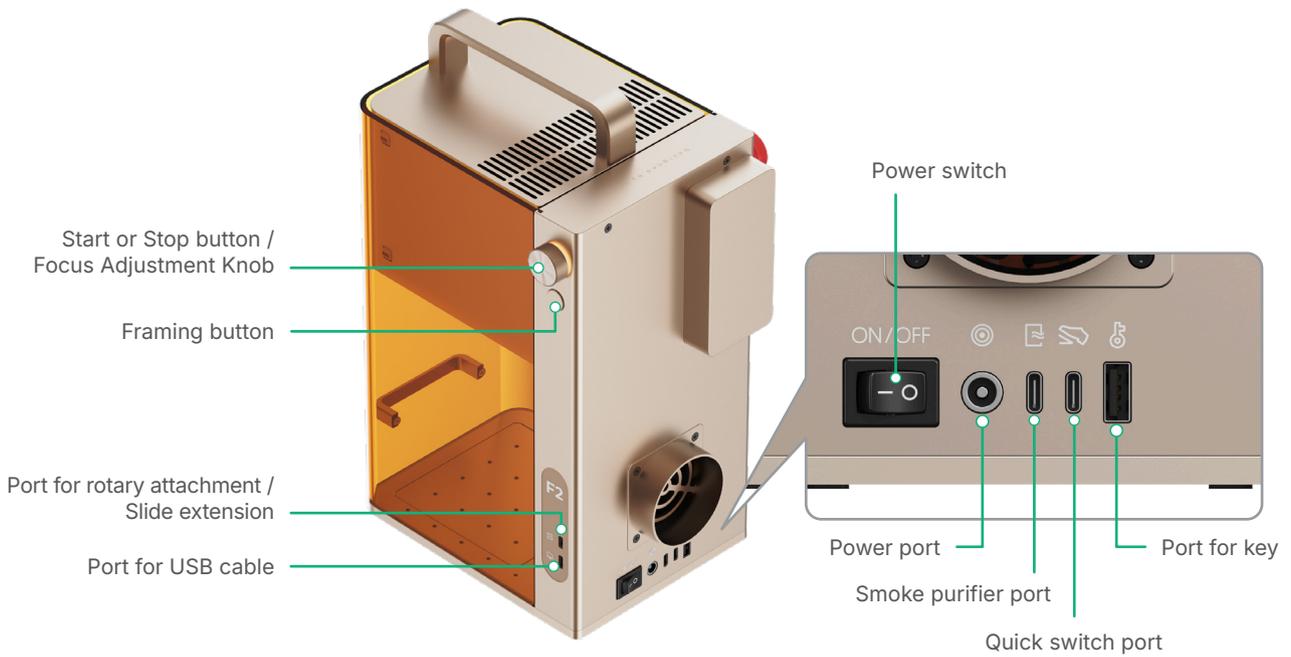
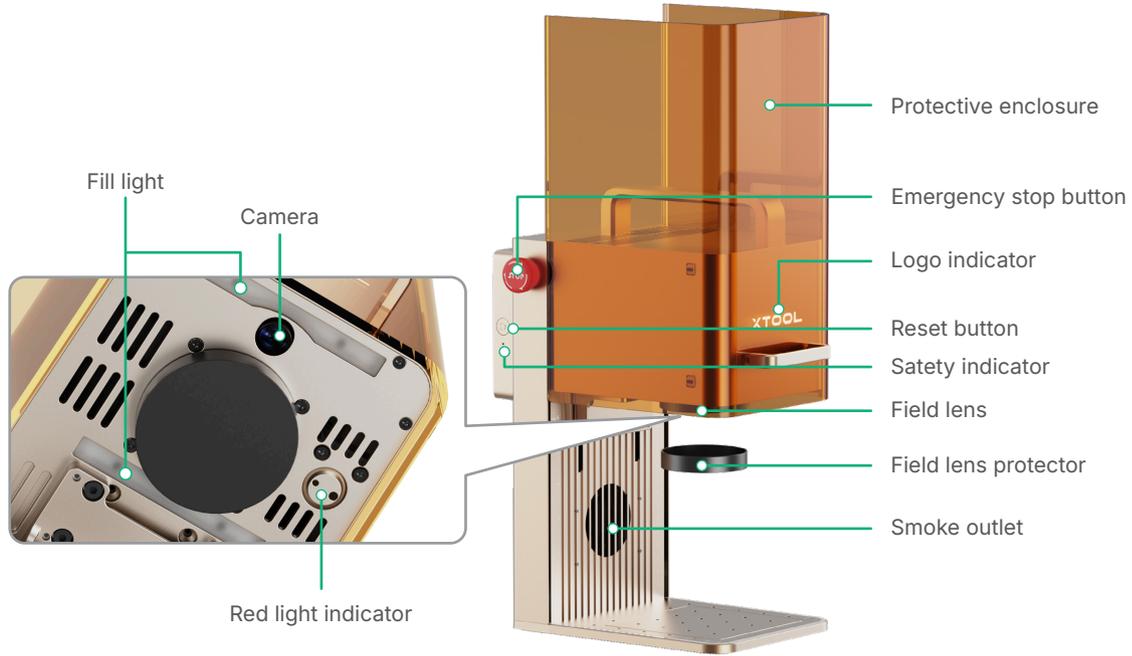
Quick Start Guide



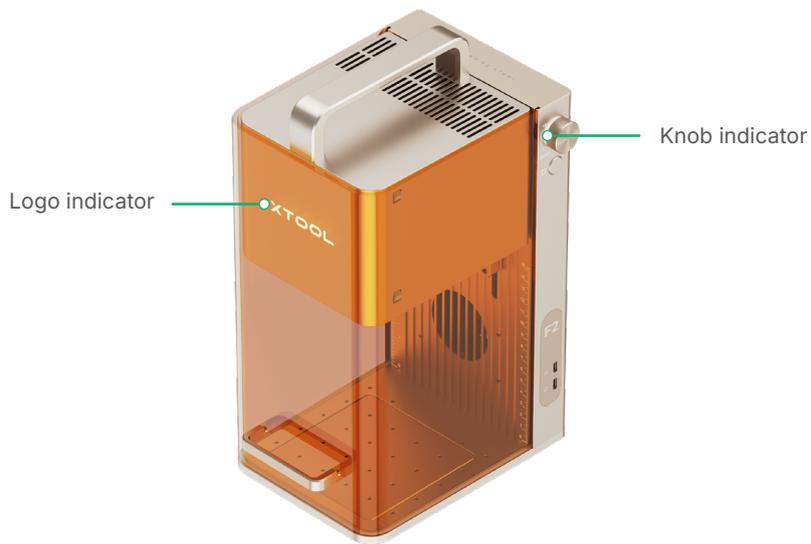
Safety Instructions

# Meet your xTool F2

## Product structure



## Common machine states and indicator display



Logo indicator	Knob indicator	Machine state
Solid on	● Solid white	Not connected to the software
	● Solid yellow	Setting network
	● Solid blue	Connected to the software
	● Solid green	Processing completed
	● Solid purple	Firmware updating
	● Solid red	Exceptions occur
Blinking	● Blinking red for 3 times	Invalid operation
Going off	● Solid blue	Processing
	○ Blinking white slowly	Enters sleep state if no operation is performed within 10 minutes



Indicator display	Machine status
● Solid red	Emergency stop button pressed
○ Solid white	Emergency stop button released, and device reset required
● Solid green	Emergency stop button released, and device ready for operation

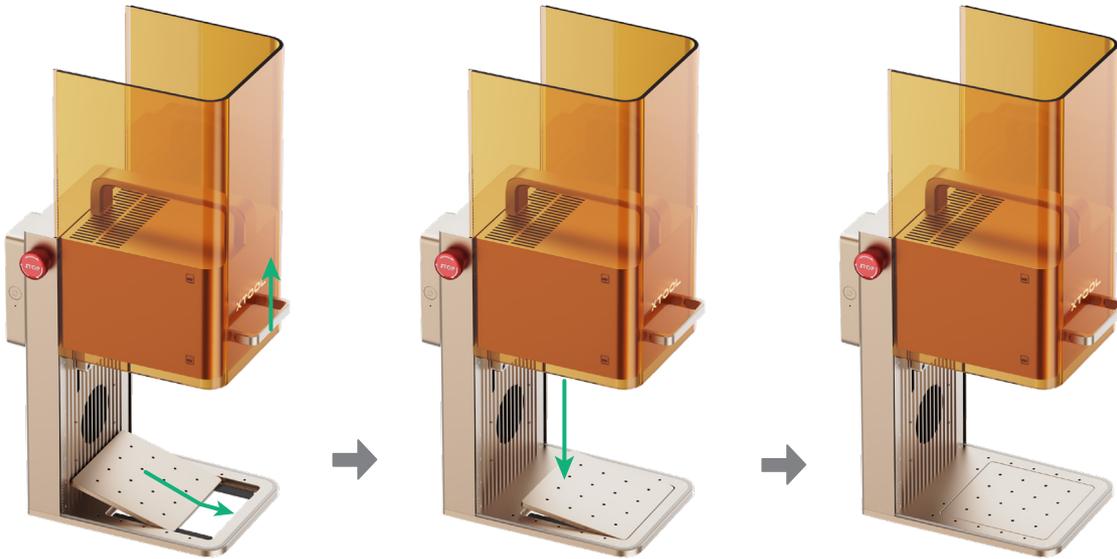
## Specifications

Product name	xTool F2
Model	MXF-K005-003
Connection mode	Wi-Fi, USB, IP
Internal working area	115 mm × 115 mm
Maximum processing speed	6,000 mm/s

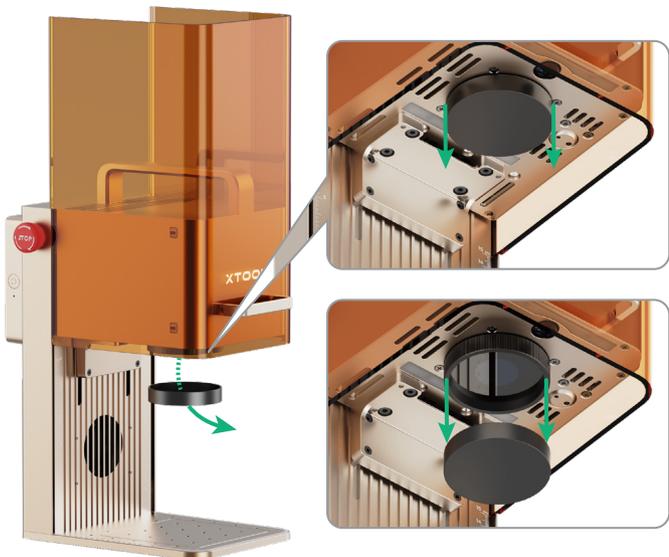
Size (W × D × H)	175 mm × 237 mm × 334 mm
Input power	25 V = 6 A, 150 W
Working laser	15 W blue-light diode laser 5 W infrared laser
Working laser wavelength	Blue-light laser: 445 ± 15 nm Infrared laser: 1064 ± 5 nm
Maximum processing height	120 mm

## Get the machine ready

- 1 Open the protective enclosure, and install the baseplate in the direction indicated by the arrow.



- 2 Pull down the field lens protector to remove it.



Ensure that the protector is removed every time before you use the machine. If you won't use the machine for a long period of time, you can install the protector back to prevent the field lens from getting dusty.

**3** Ensure the key is fully inserted.



You can use the key either as an access-control key or a remote interlock connector.

**Access-control key**

Removing the key can disable the machine's processing and related functions.

**Remote interlock connector**

For detailed instructions, scan the QR code or visit the link.



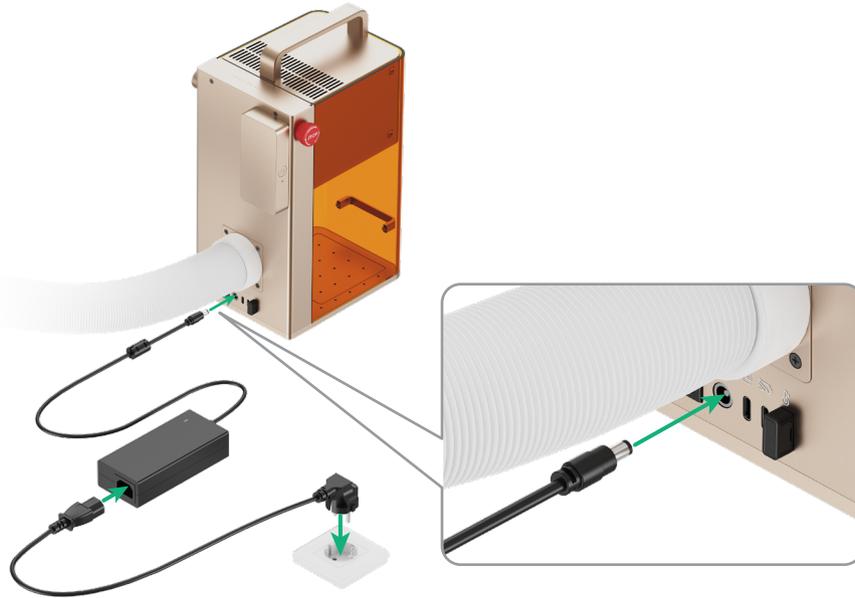
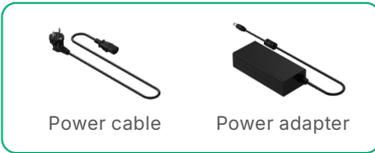
[support.xtool.com/article/1367](https://support.xtool.com/article/1367)

**4** Install the pipe.

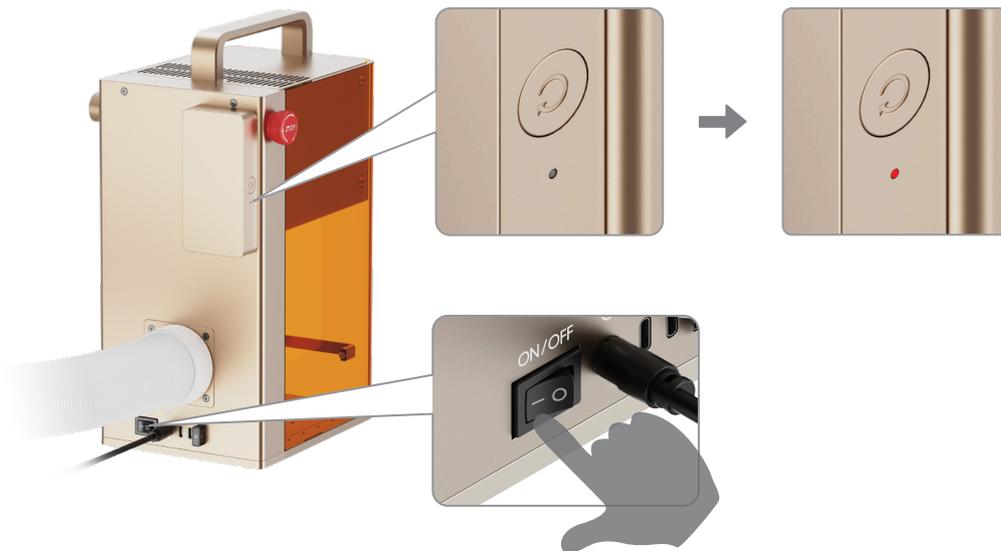


If you need a desktop smoke purifier, purchase one and connect it to xTool F2 as instructed by the user manual.

5 Connect to a power supply.



6 Press the power button to turn on xTool F2. The safety indicator will light up red.

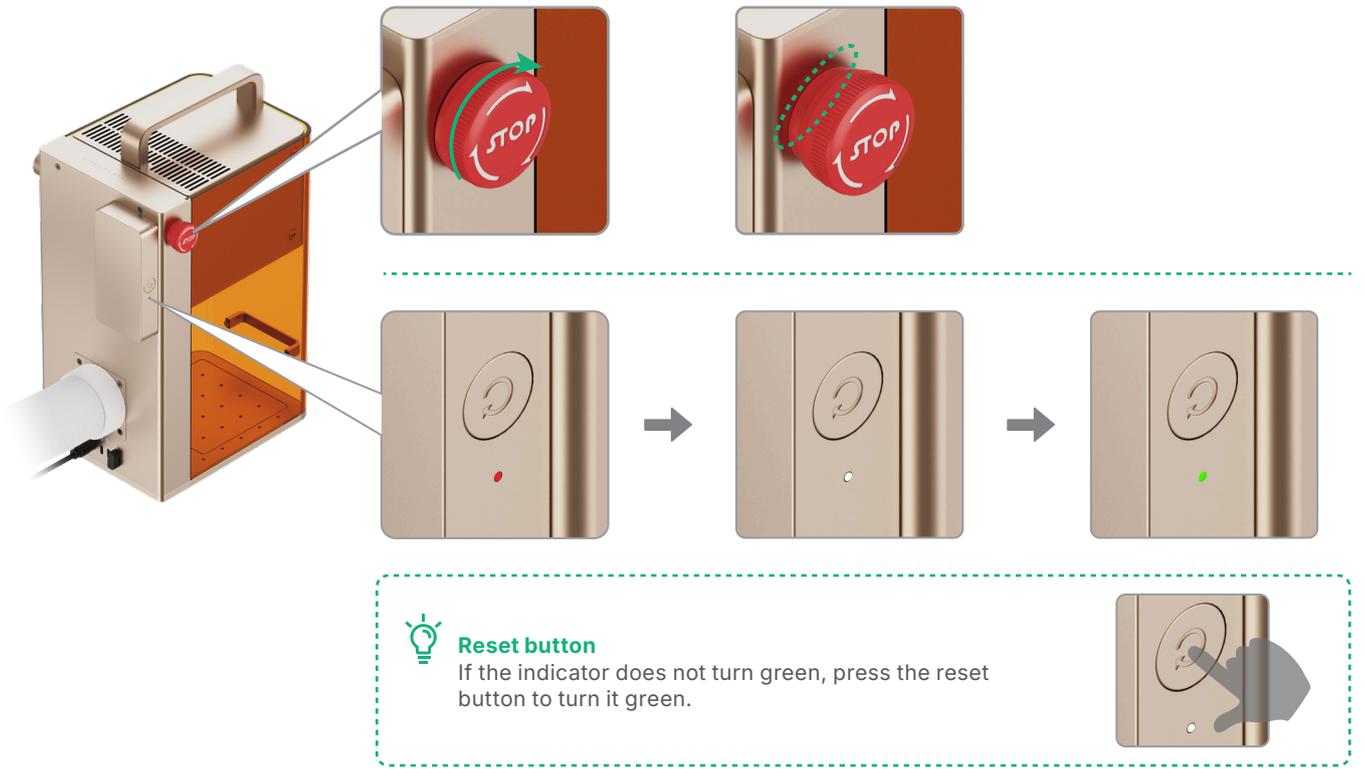


**Never use the emergency stop button as a power button.**

Use the emergency stop button only when an emergency occurs. Using it as a power button to turn on and off the machine may damage it.



**7** Rotate the emergency stop button clockwise to release it. The safety indicator will first turn white and then green.



**Emergency stop button**

If an emergency occurs, press the emergency stop button to shut off the machine. After dealing with the emergency, rotate the emergency stop button to release it.

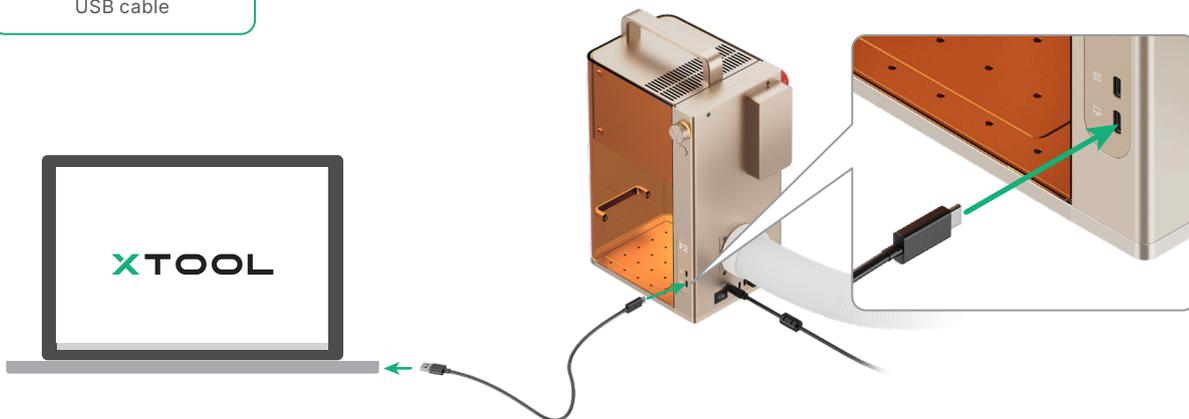


## Use your xTool F2

- 1 Visit [s.xtool.com/software](https://s.xtool.com/software) to download and install the software developed by xTool.



- 2 Use the USB cable to connect xTool F2 to your computer, and then connect xTool F2 in the software.



For details about how to use the software to operate xTool F2 to process materials, scan the QR code or visit the link.

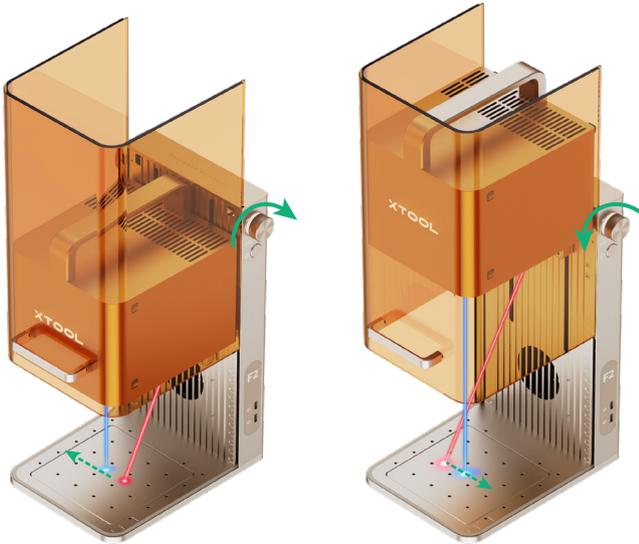


[support.xtool.com/product/60](https://support.xtool.com/product/60)

## More operations

### Manual focus setting

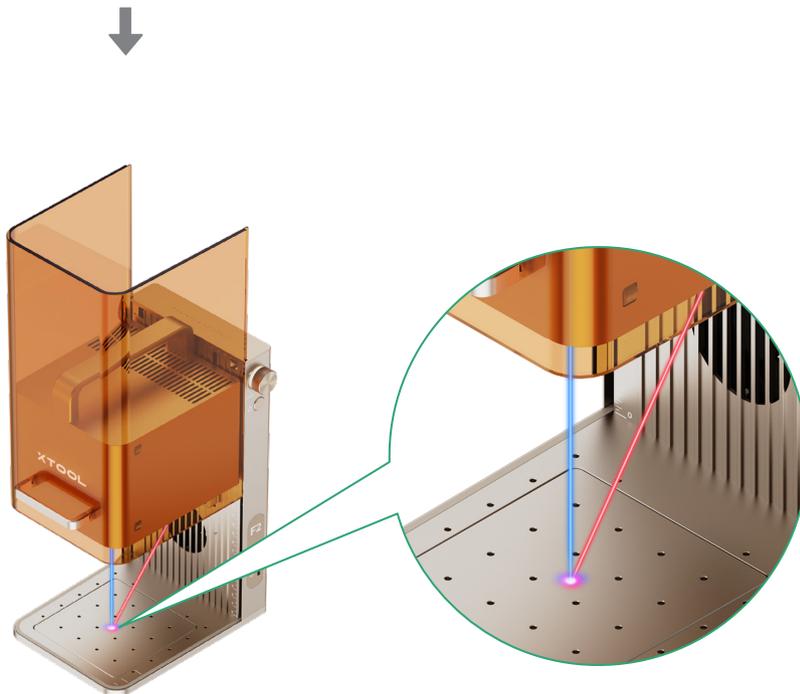
Turn the knob to adjust the height of the laser module. When the red and blue light spots overlap, the focus is successfully set.



If turning the knob cannot overlap the red and blue spots, visit [support.xtool.com/article/2373](https://support.xtool.com/article/2373) or scan the QR code for reference, or you can contact customer support for help.



[support.xtool.com/article/2373](https://support.xtool.com/article/2373)



## Use accessories

### Slatted panel

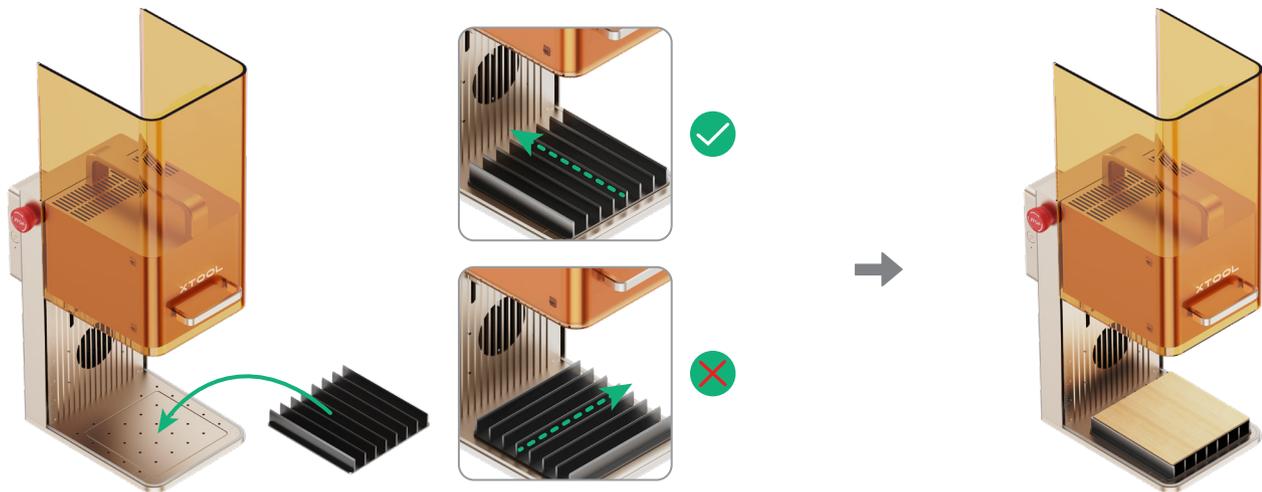
To cut a material, you are advised to use the slatted panel. It can reduce the areas burned and protect the baseplate during material processing.



Slatted panel



For optimal smoke exhausting, orient the slatted panel with its openings facing the machine.

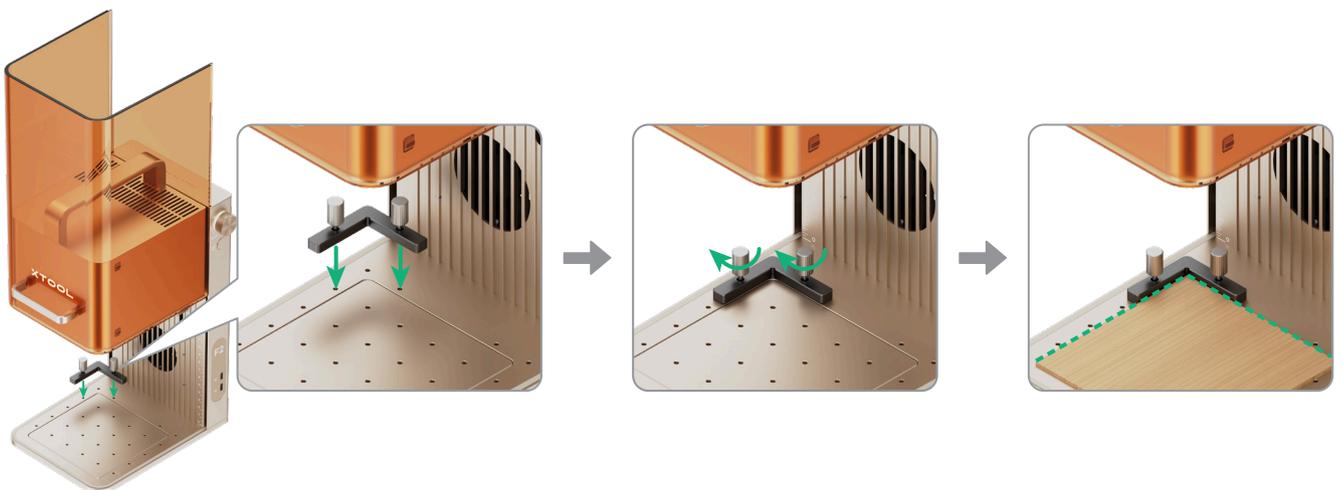


### L-shaped positioning piece

You can use the L-shaped positioning piece for batch processing. It helps you place materials in the same position for each processing task.



L-shaped positioning piece



## Rotary attachment

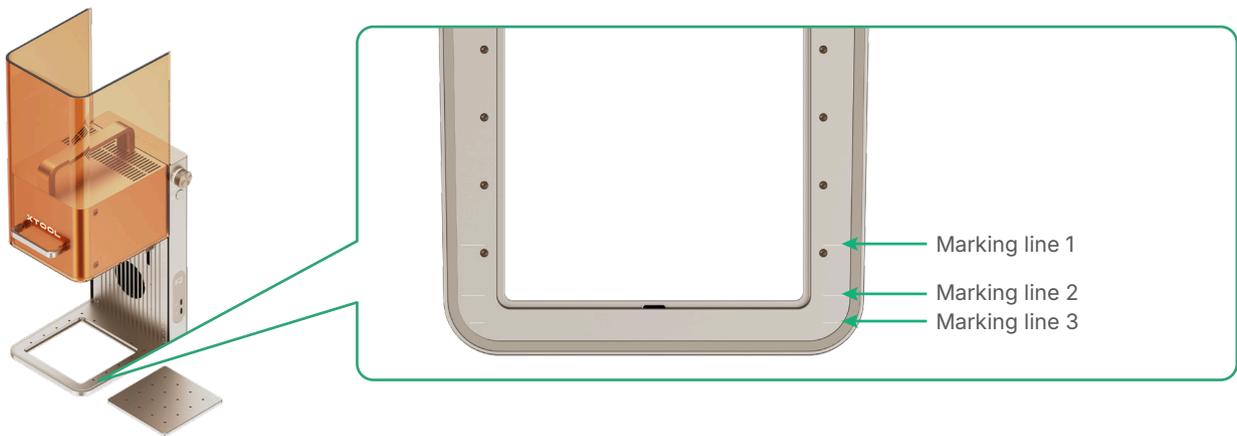


Rotary attachment (not provided)



No rotary attachment is included in the pack.

There are three marking lines on the base of xTool F2. Depending on the working mode and level setting of your rotary attachment, align its front bottom edge to the corresponding marking line.



For details about how to use xTool F2 with the rotary attachment, scan the QR code or visit [support.xtool.com/product/13](https://support.xtool.com/product/13) for reference.



[support.xtool.com/product/13](https://support.xtool.com/product/13)



Strictly follow the safety instructions to use xTool F2 with the rotary attachment. Set up a safety-controlled area under the guidance of the Laser Safety Officer (LSO), and take sufficient personal protective measures against laser risks.

## Maintenance



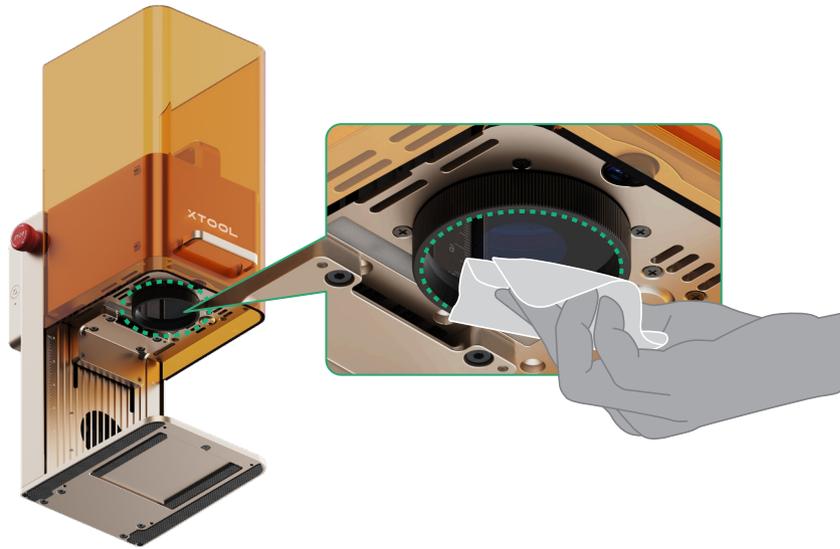
Disconnect power before maintaining the product.

### Clean the field lens

When laser power attenuation occurs, for example, engraved patterns are shallow or materials can't be cut as expected, the field lens may get dirty. Clean it with the lint-free cloth moistened with alcohol.



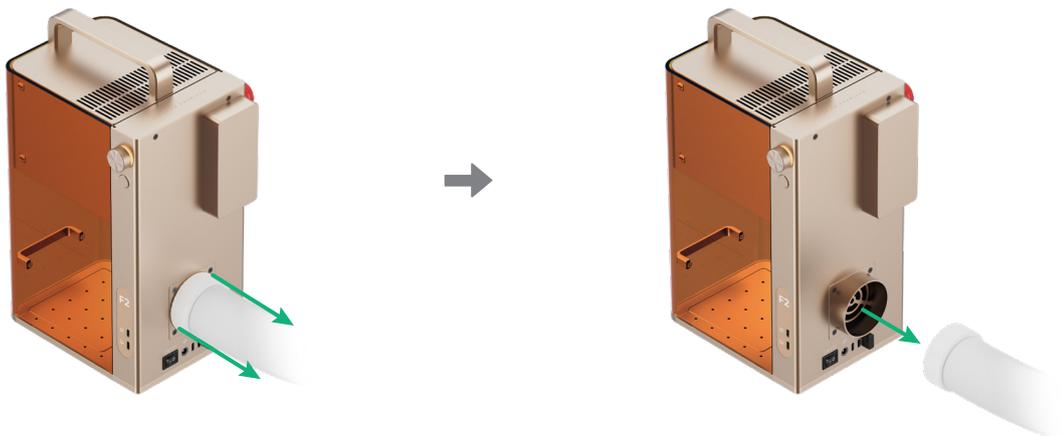
Lint-free cloth



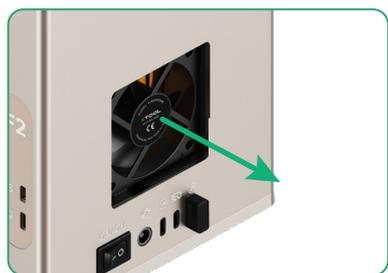
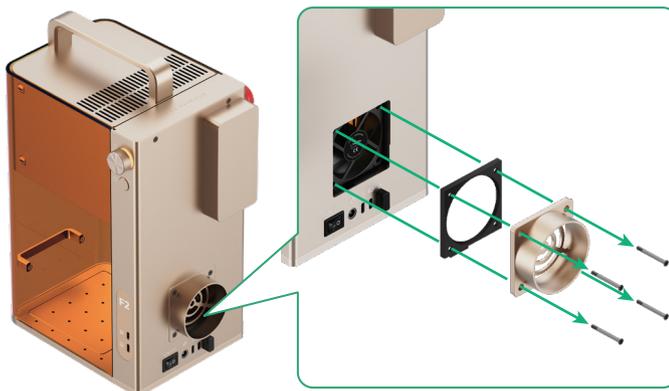
### Clean the fan module

When smoke runs out of the protective enclosure, the fan module may be blocked by dust. Clean it to ensure proper smoke exhausting.

(1) Remove the pipe.



(2) Open the cover, and then take out the fan module.



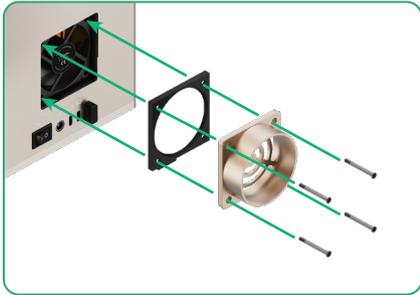
Remove the connector

(3) Use a brush or other tools to clean both sides of the fan module.

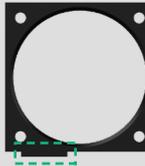


The fan module can be rinsed with water, but do not soak it. Ensure it is completely dry before reinstalling.

(4) Install the fan module back to the main unit.



💡 Ensure the fan logo faces outward when reinstalling.



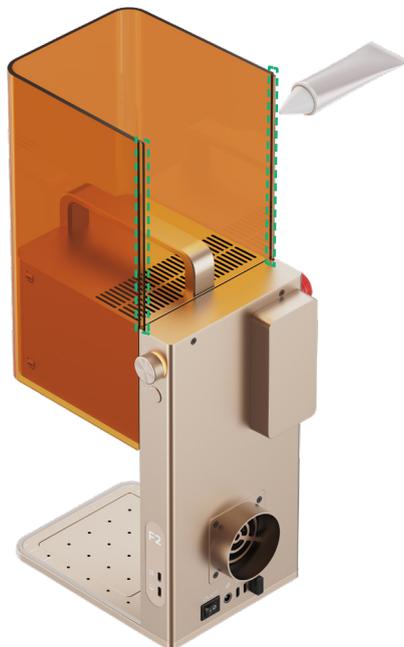
💡 Ensure the locating tab of the fan gasket is positioned at the lower-left corner when reinstalling.

### Lubricate the protective enclosure

If you can't move the protective enclosure up and down smoothly, apply grease to the edges of the two sides.



Grease



💡 For self-purchase, white lithium grease is recommended.

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