Learning by doing, through trial and error, can facilitate comprehension of laser parameters and understanding of materials. This can allow for unexpected outcomes, not limited by potential handbook parameters.
It is important to understand how fabric properties affect laser output.

Cotton; Burns, vaporises.

Polyester; Melts, re-fuses, changes structure.

Knowledge of materials must be individually established in order to inform creative work.
Each fabric can have slightly different properties.
Laser processing affecting the shine of a satin weave
Manipulating fabric handle and drape by laser processing