

The Lasering Procedure

1. When your graphic is completed and proofed in CorelDraw, AutoCAD, or Adobe Illustrator, send the graphic to the laser by choosing **FILE**, then **PRINT**; or choose the printer icon in the menu.
2. If you wish to only engrave a selection look for **PRINT RANGE**: find **SELECTION** and click it, if you wish to print all then print the **CURRENT DOCUMENT**.
3. Make sure that your laser is chosen, now select **PROPERTIES**.
4. This will open the **Universal Laser Materials Data Base**.
5. Click onto the tab **MATERIALS DATABASE**.
6. Choose the material category, **NATURAL**, now choose the **CATEGORY** you wish to engrave, example **WOOD**.
7. Choose under **Wood**, the type you are using, example **Medium Wood, Alder**.
8. Enter the **Material Thickness measured with a digital caliper or micrometer**.
9. Choose nothing else on this tab. Click on to **APPLY**.
10. Now click the **MANUAL CONTROL TAB**.
11. Under this tab you will be able to adjust the **POWER, SPEED** and **PPI** settings if you wish to make improvements.
12. If you are not sure, use these settings on a piece of scrap material of the same selection. For this memo, we are going to use these settings, no changes at this time.
13. Click **APPLY**, then **OK**, click **PRINT**
14. Place your material into the laser, nested into the upper left corner (**X0, Y0**)
15. Now find the **RED ICON** for the **Laser Control Panel..... (**LCP**)**
16. When it is open you should see you're graphic.
17. Turn on your laser using the **RED START** button. Your laser will begin the homing process.
18. Find **FOCUS VIEW**. Pass your cursor over the icons on the right until you find focus view and **CLICK**.

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19. Your cursor will change to cross hairs, as you move your cursor over your graphic now click.
20. The laser carriage will move to that position. **Now use the FOCUS TOOL** and use the **UP or DOWN** arrow buttons on your laser to focus your work piece to the lens carriage. Place your **FOCUS TOOL** back into its storage area.
21. Open your exhaust **VENT** and **TURN ON YOUR EXHAUST**.
22. Lower the **TOP DOOR**.
23. Push the **GREEN START BUTTON**. Your laser will begin to engrave.
24. When the engraving ends, open the top door, and remove your work, and any scrap material.
25. If the Power and Speed settings are good, go with this setting for your engraving.
26. If your engraving is too deep, lower your power OR increase your speed. (But Not Both)
27. If a change in power or speed is necessary, find **SETTINGS BUTTON** and click.
28. Now adjust the **POWER** or the **SPEED**. Click **SET**.
29. If another color needs adjustment do the same as above.
30. Click **Apply** then click **Ok**.
31. Place your work piece into the laser and begin the laser process again.
32. **Remember:**
 - Any changes that you make will be saved for future engravings when you select them at a later time in the print job folder.
 - If you wish to keep it and not loose it accidentally, that is if you purge files, by clicking on to permanent, will the file from being deleted.
 - Any changes made to material placement in the Universal Control Panel will not be changed in your original drawing.