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- Import Import Applicable Format
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- Layer Parameter Layer Parameter-Cut Layer Parameter-Scan Layer Parameter-Dot
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- How to choose different size focus lens
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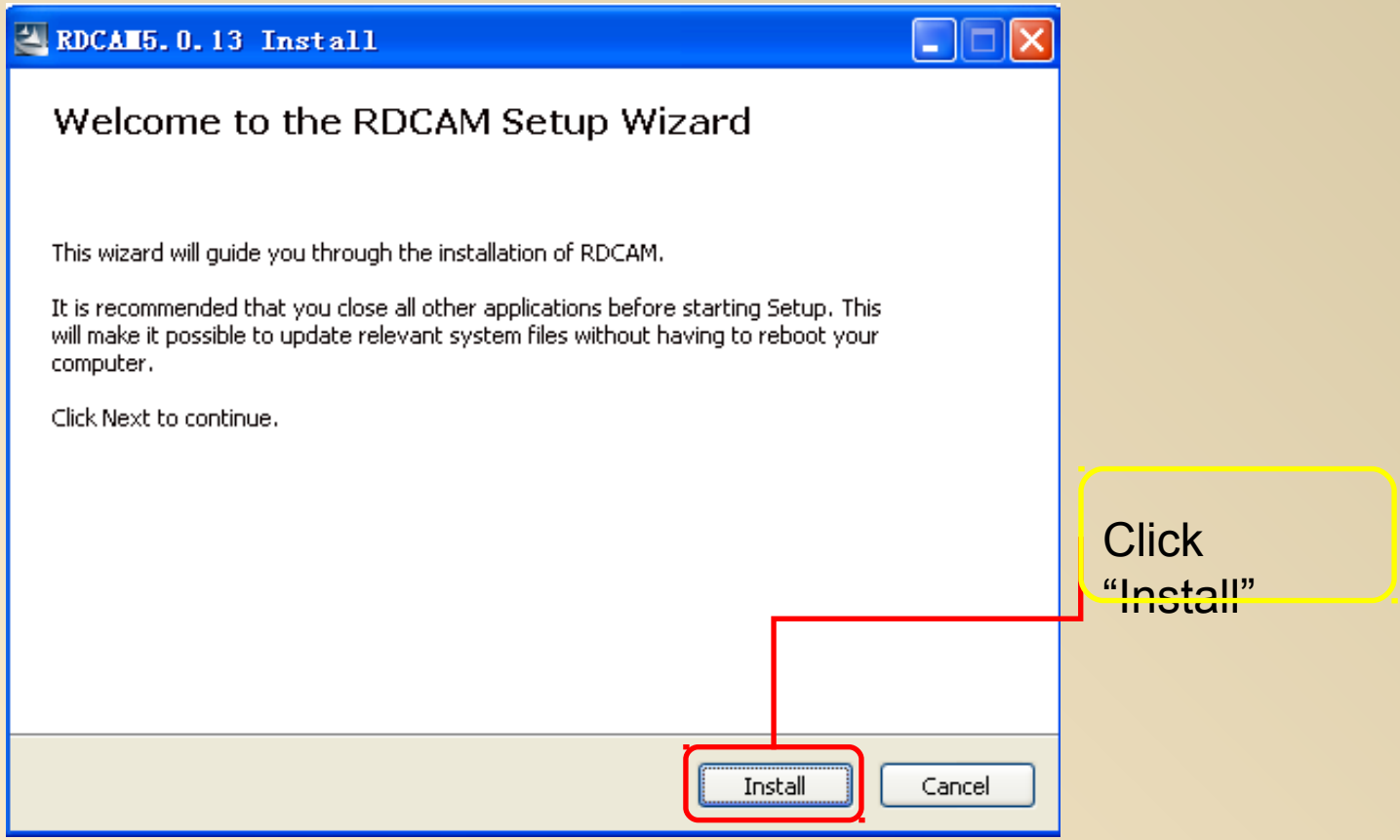
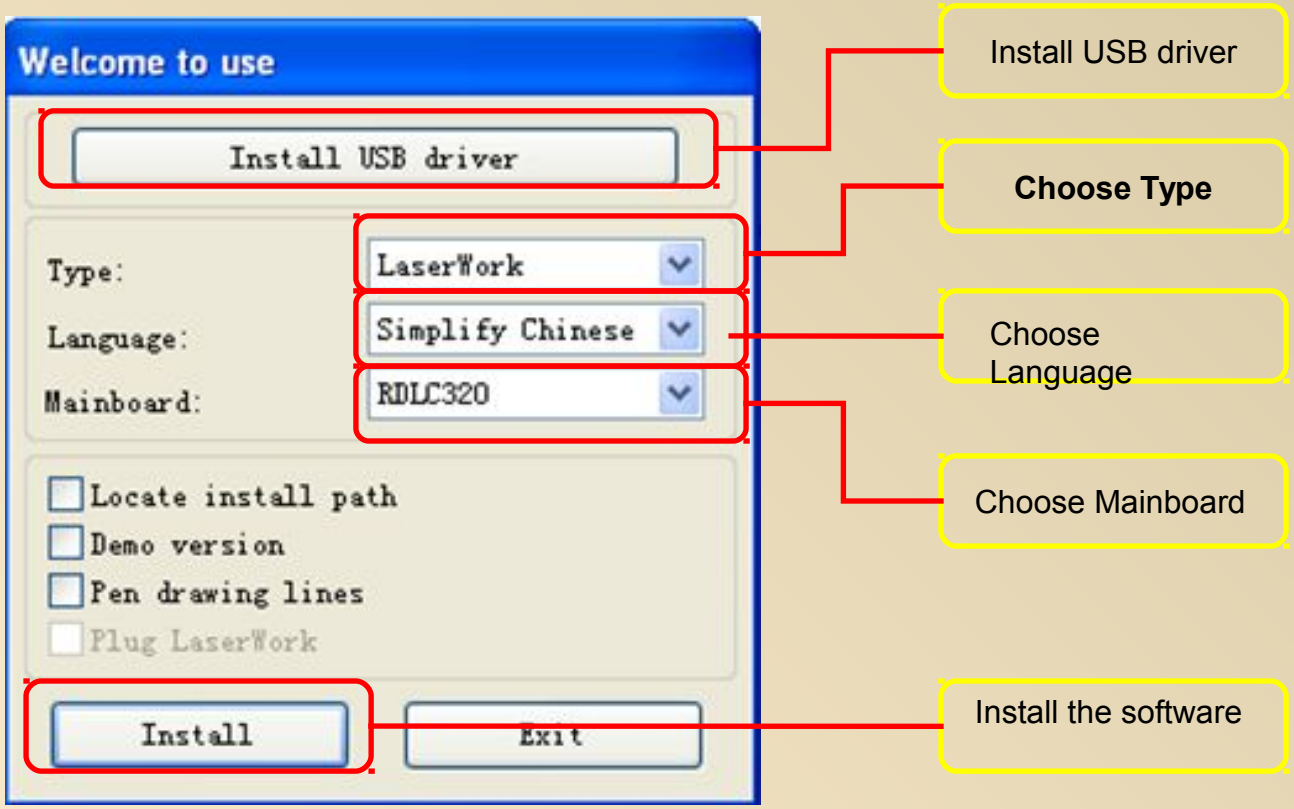
- 300W Acrylic Cutting Parameter
- 60W Engraving Parameter
- 60W Half-cutting Parameter and remarks
- 135 W Glass Tube Plywood Cutting Parameter

Software Installation

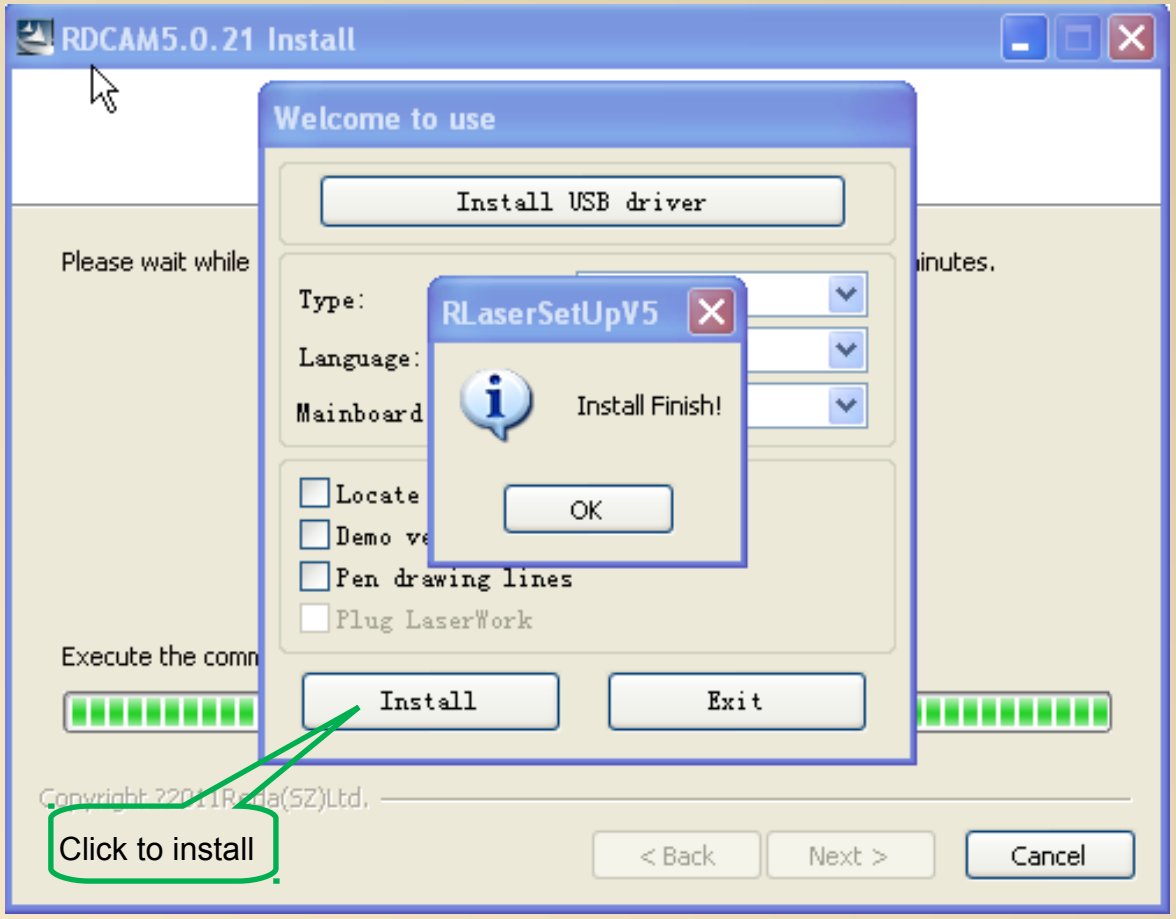
- Double click , here comes out software installation window :



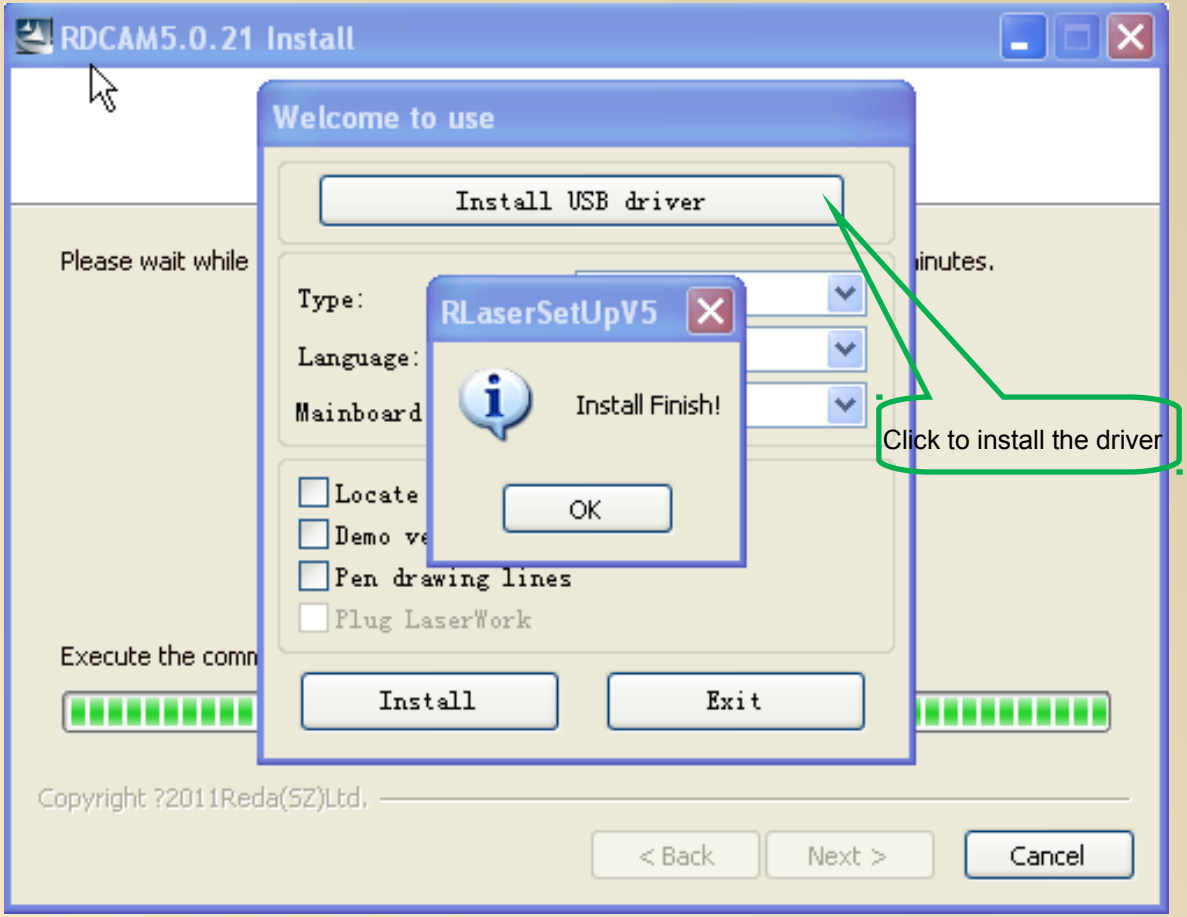
Choose Software Version, Language and Mother Board ：



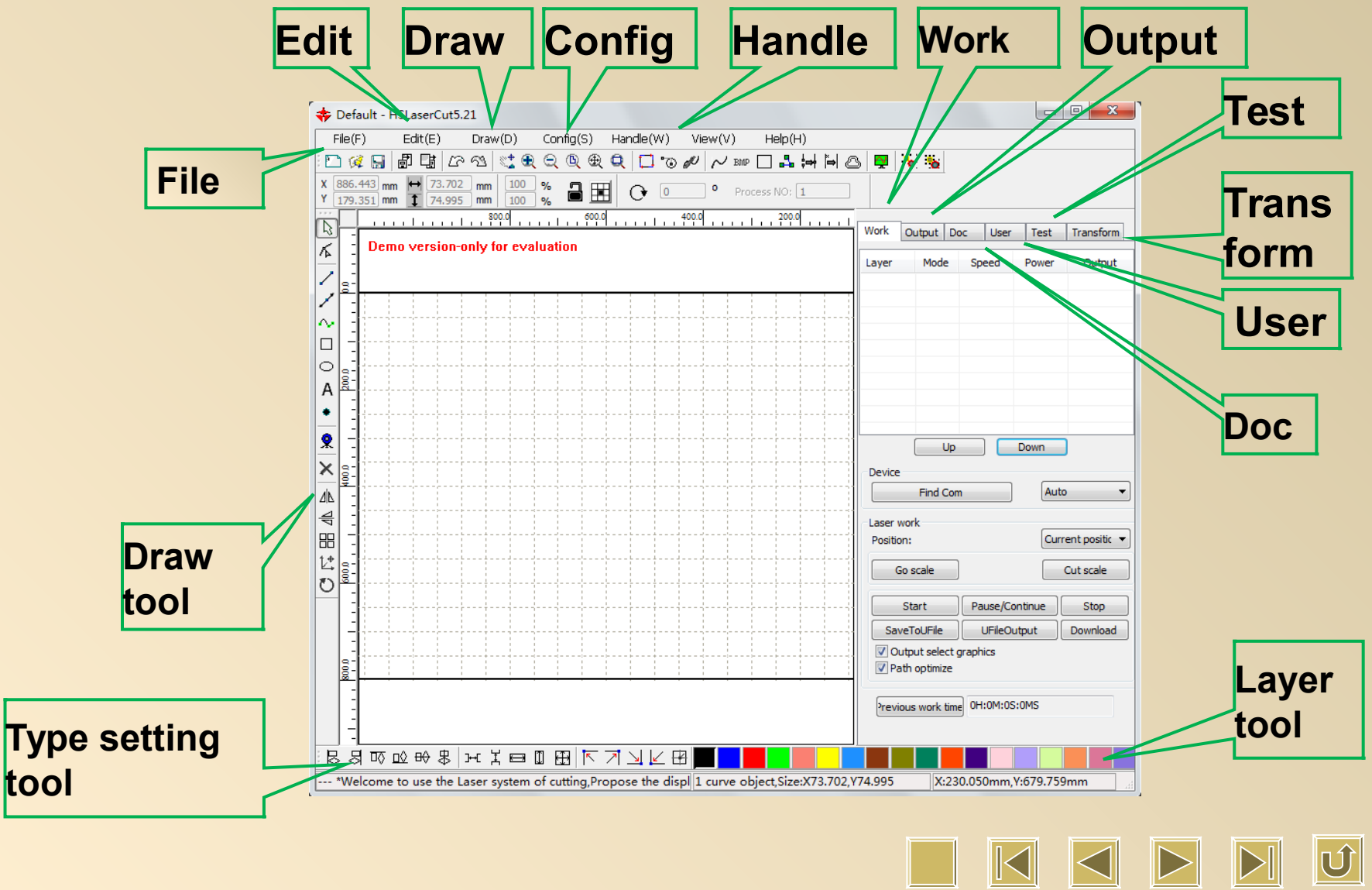
Finished Installation Interface

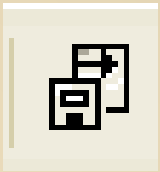


Finished Driver Installation Interface

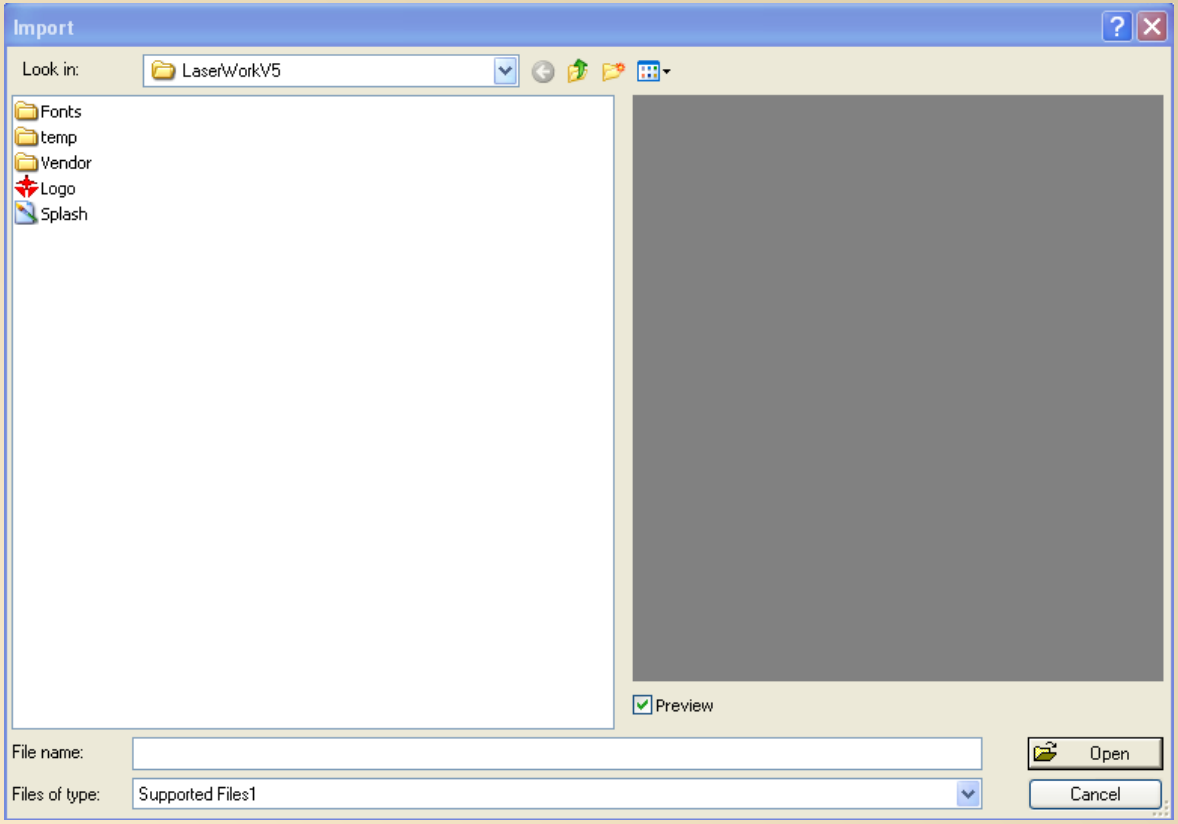


Software Interface



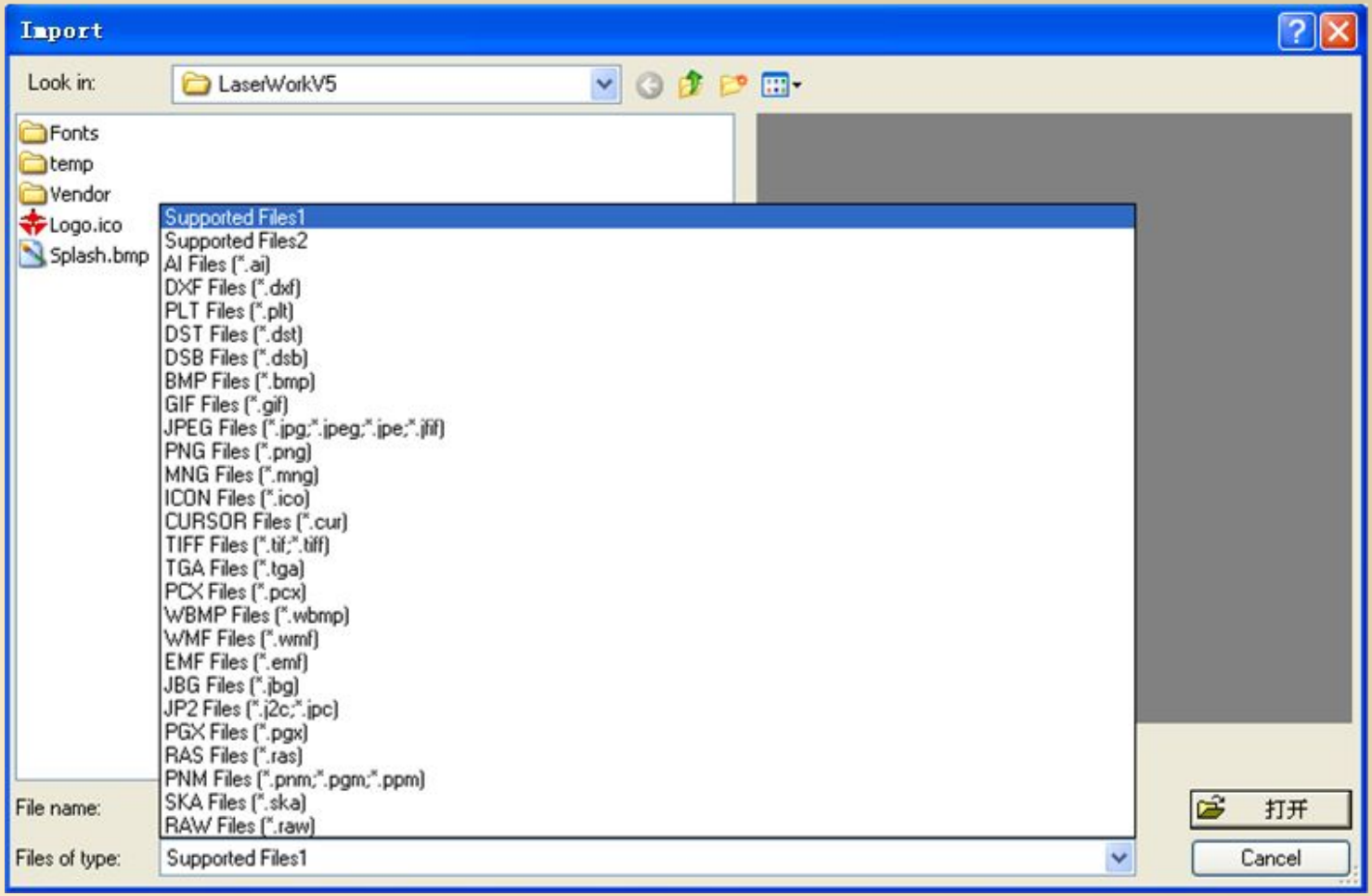
Import 

Click one time  to import our design shown in the following. Choose proper file and click [Open].



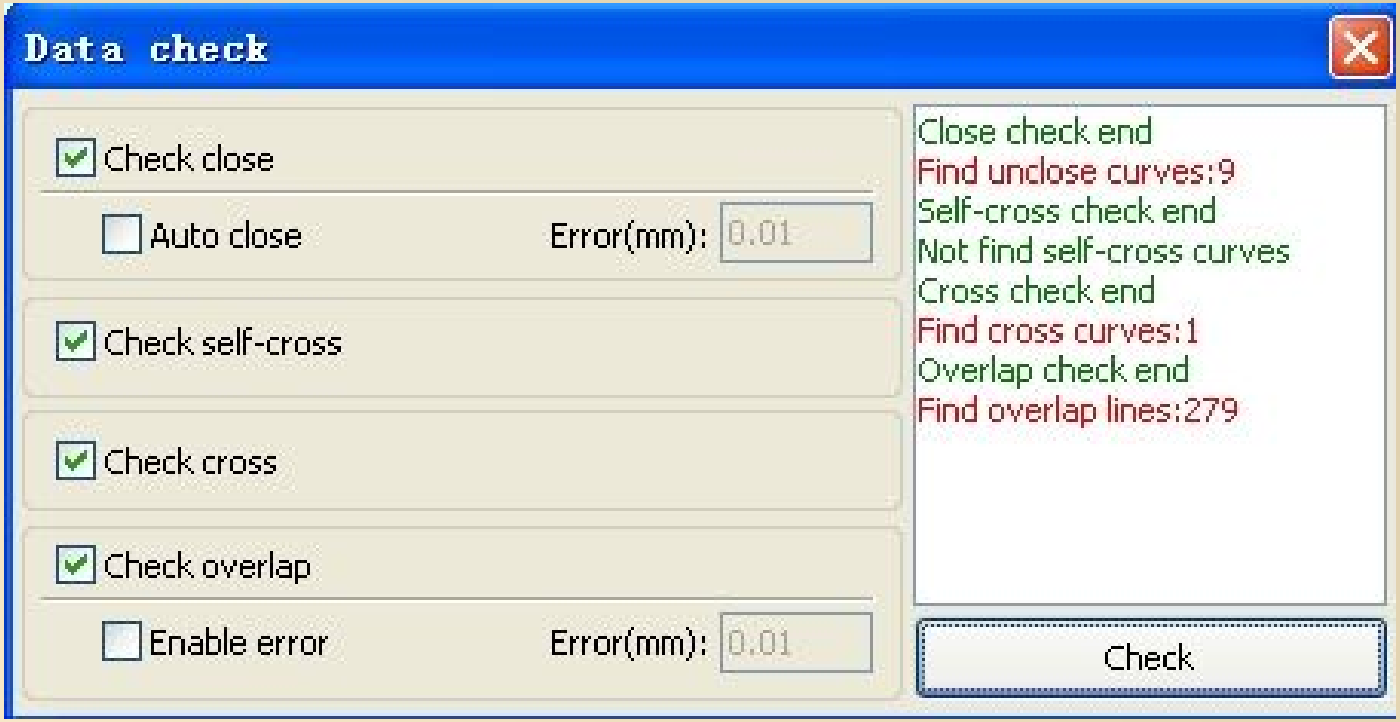
Import Applicable Format

.ai / .dxf / .plt etc are applicable

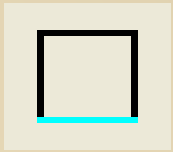


Data Check

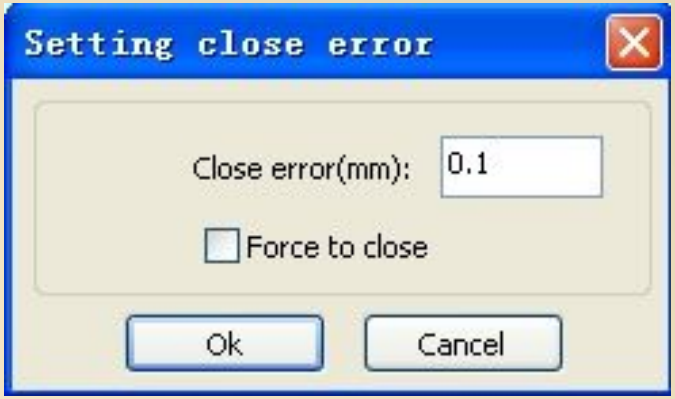
Click , then we will see the following:

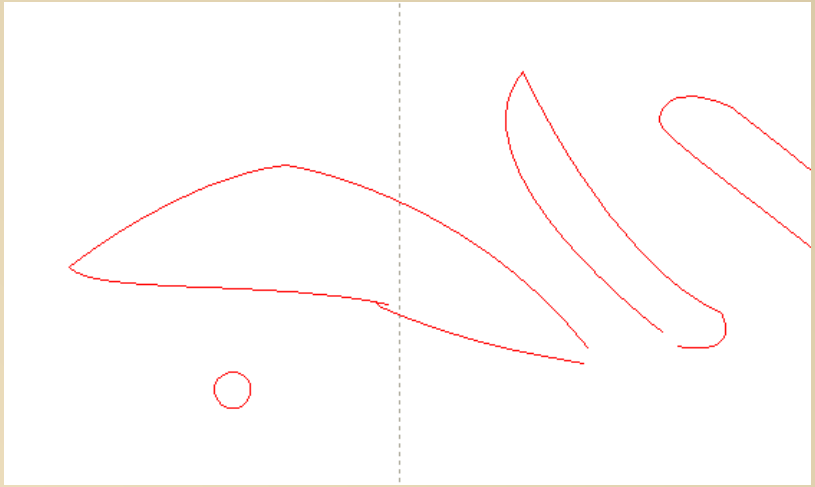


Curve auto close

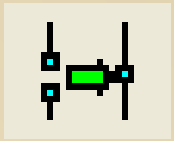


Click  so we will see the following:

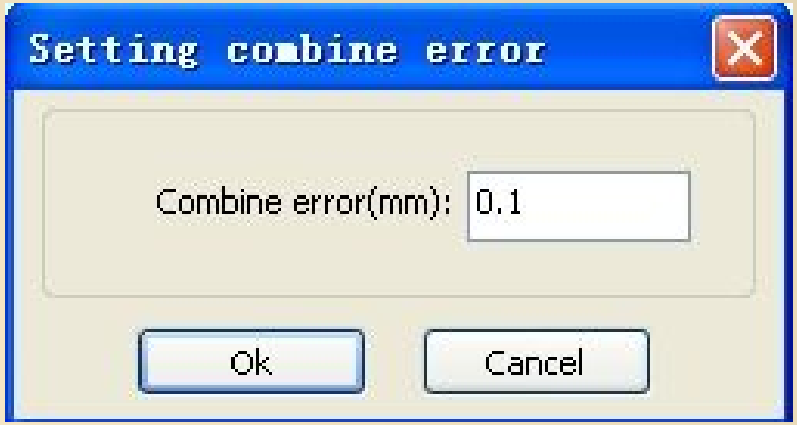


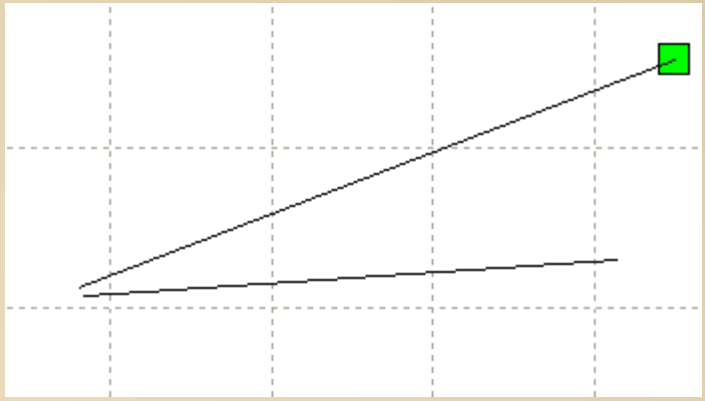


Closing Allowance: Curve will close automatically when the allowance is smaller than the number we type into.
Compulsory Closing: Tick this function for compulsory closing.

Combine curve 

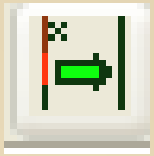
Click , there is a new interface coming out as follows.

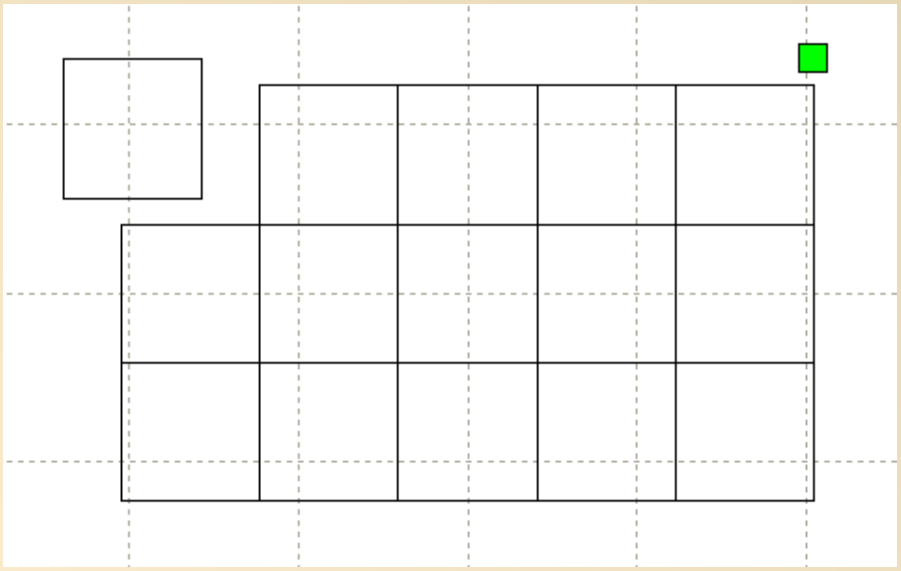


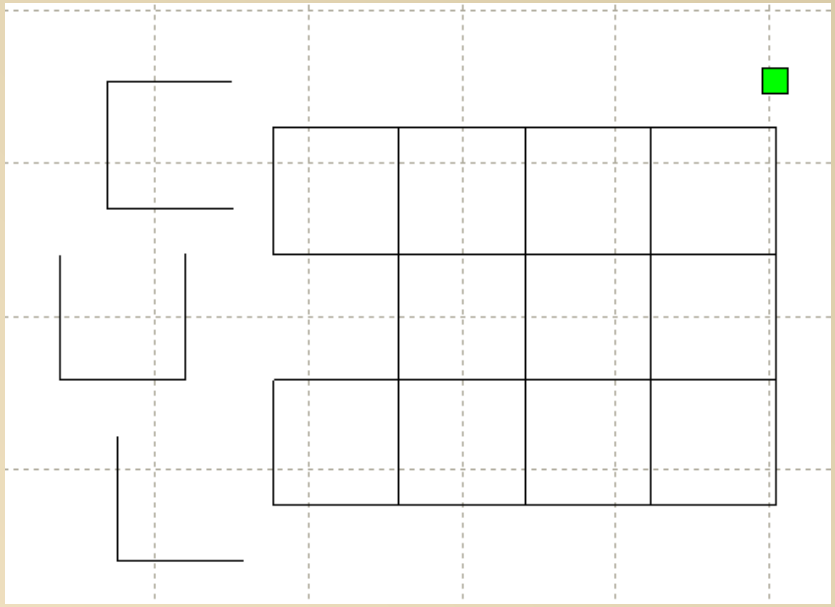


New curve will be seen according to the above setting for combination allowance. Max. is 5mm.

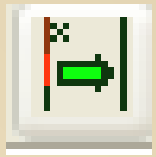
Delete overlap

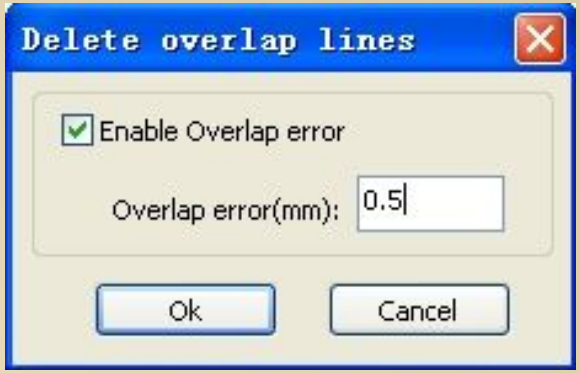


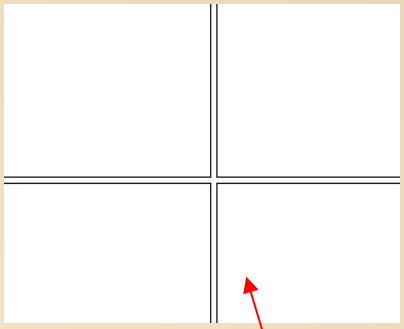


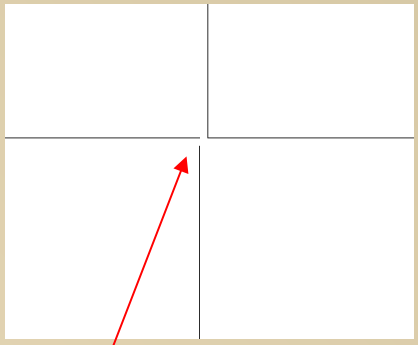


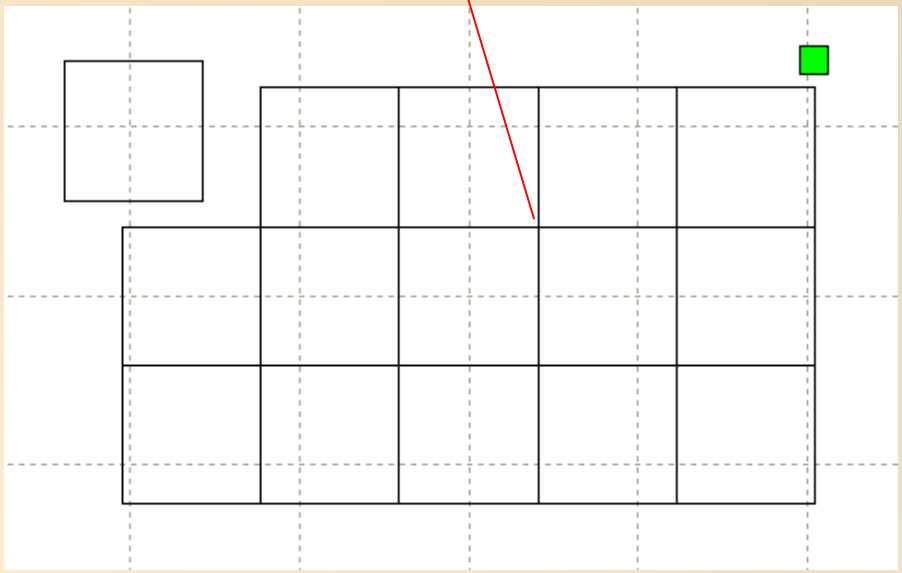
Delete overlap

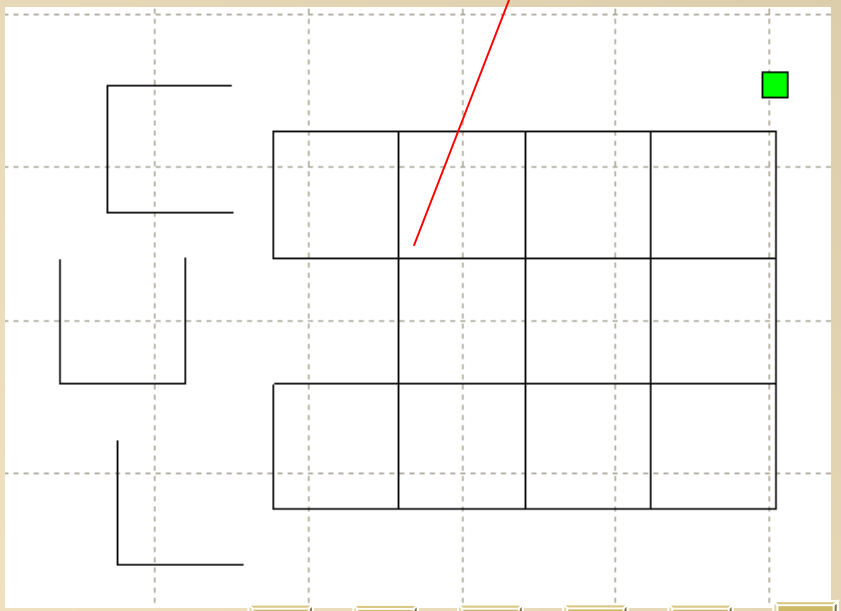






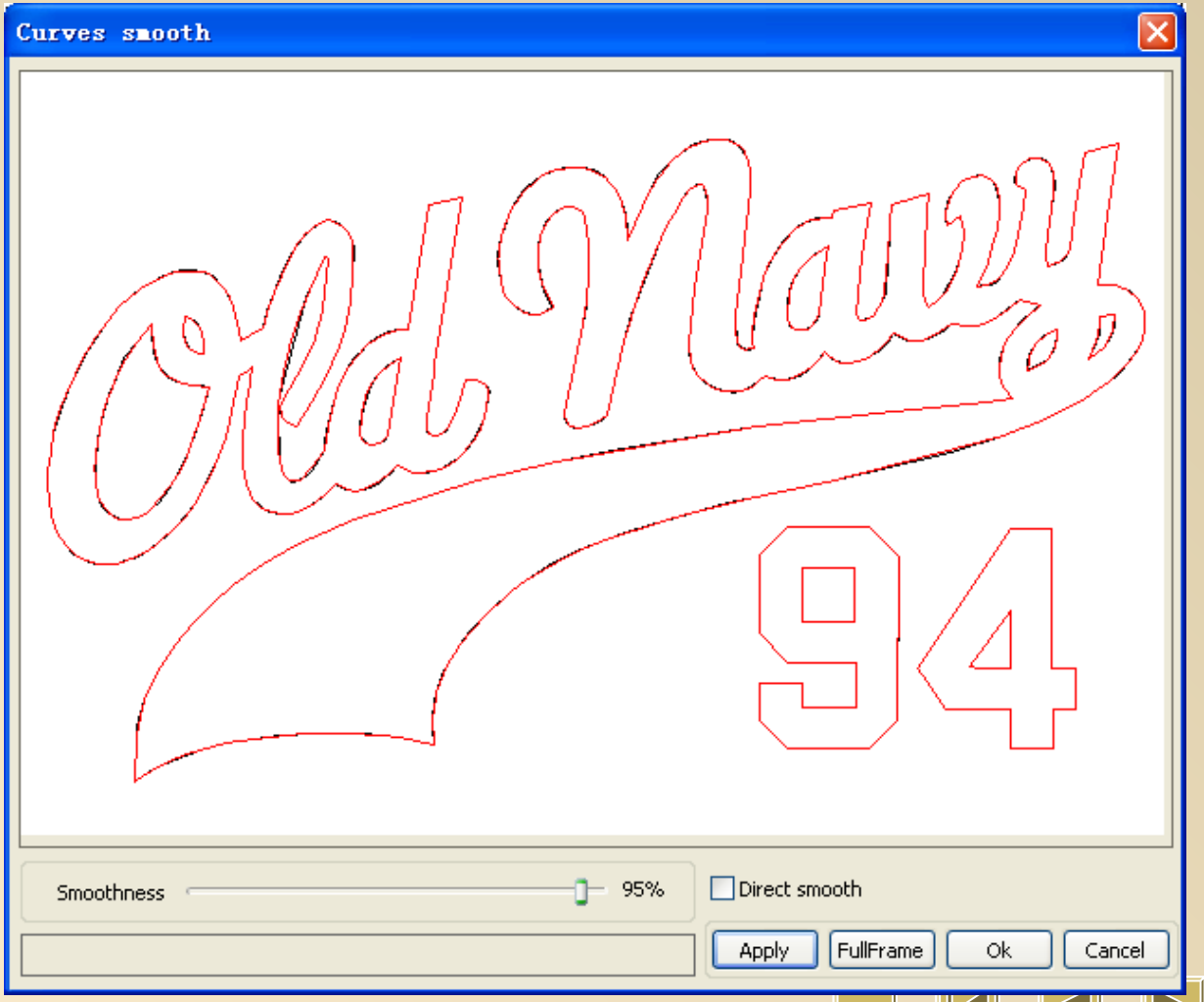






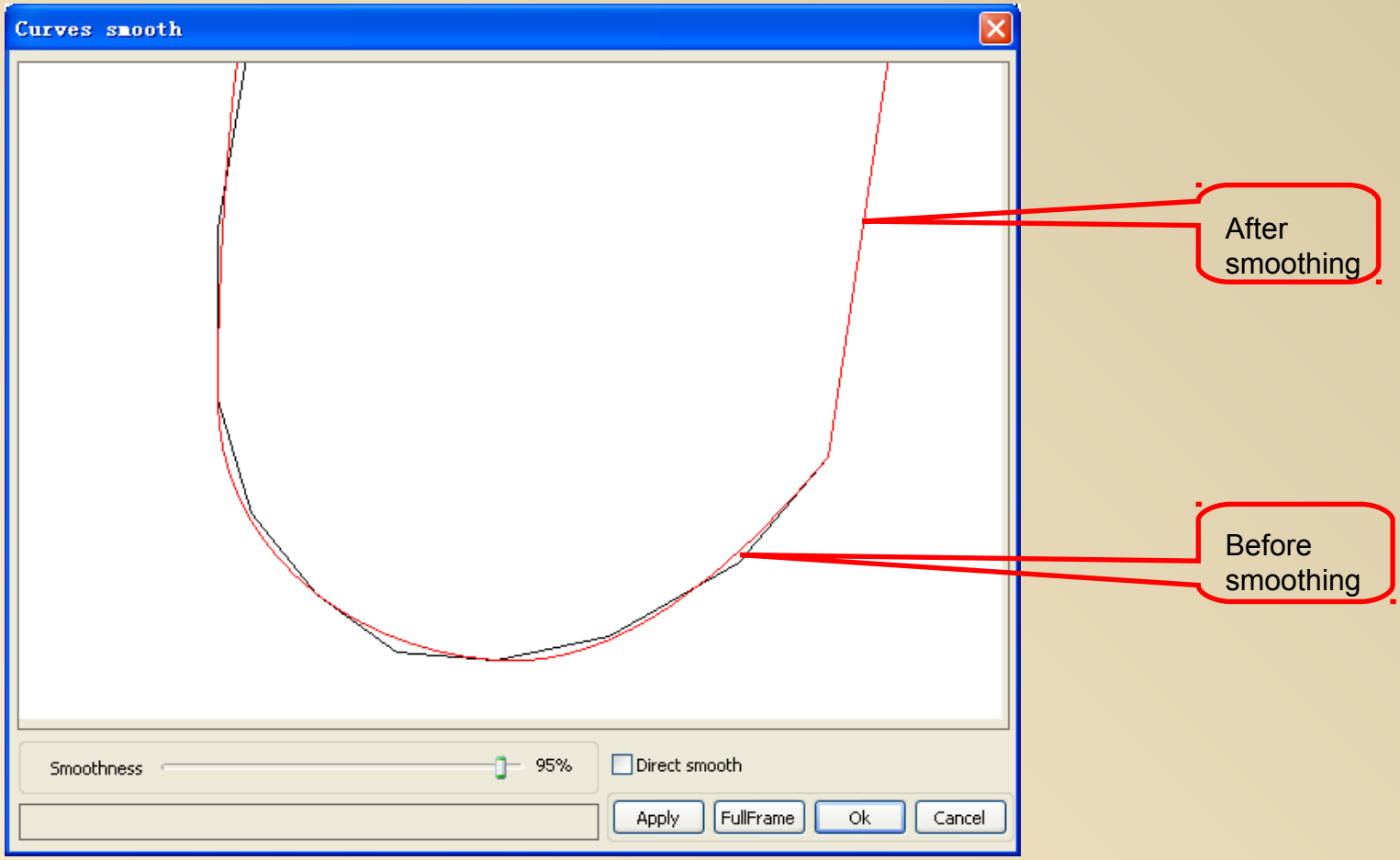
Curve Smooth

Click so as to smoothen curve with the following way:

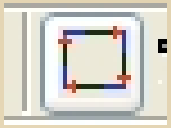


Curve Smoot

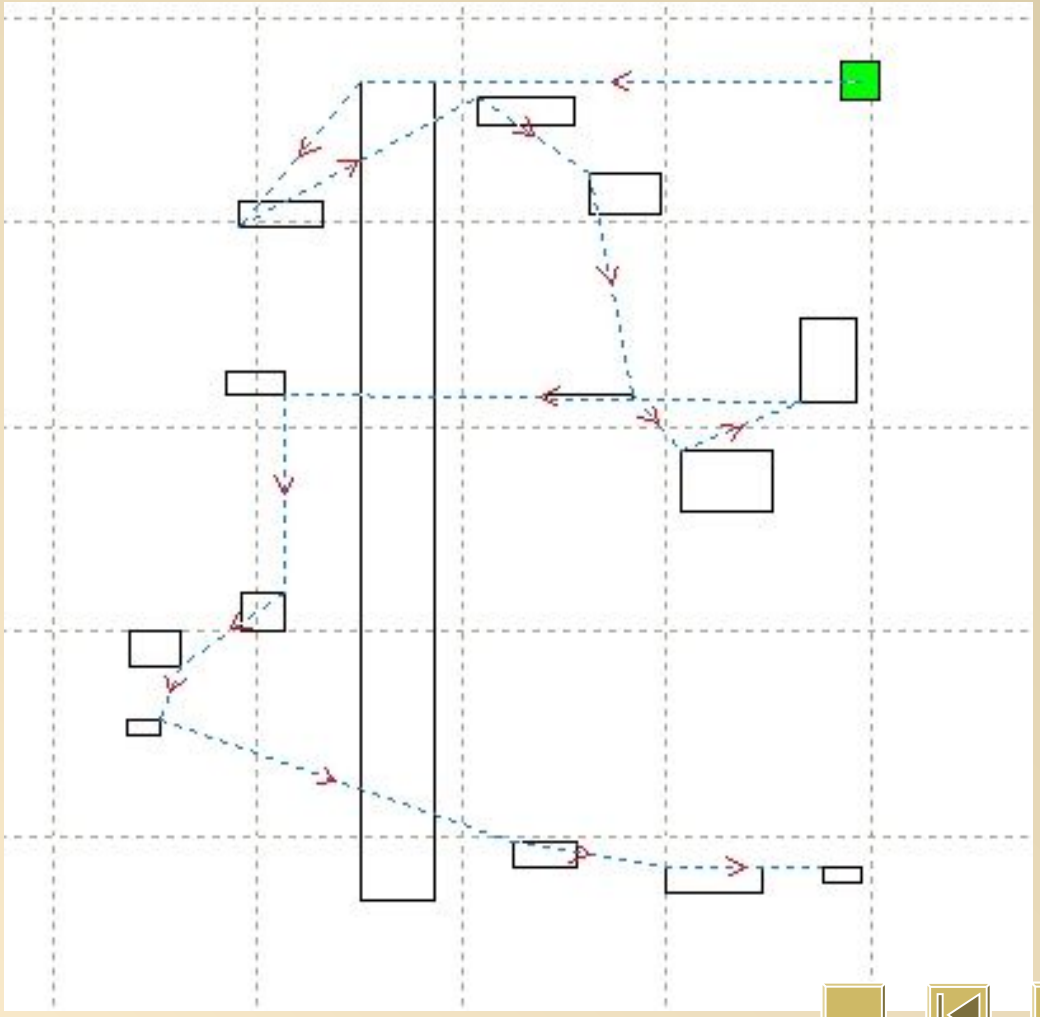
Adjusting smooth rate then we will see the previous and after changing result. Black line is before smoothening, and after smoothening is red line.



Show path

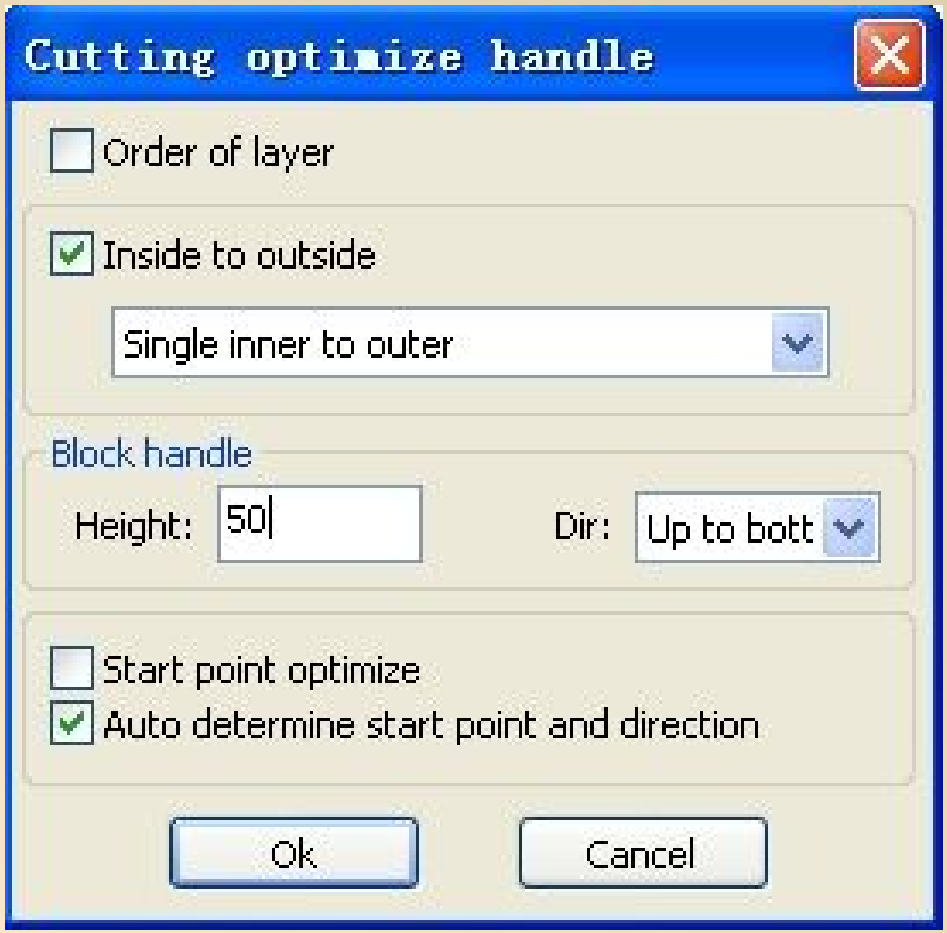


Tick “path displaying” so we will see the order and direction.

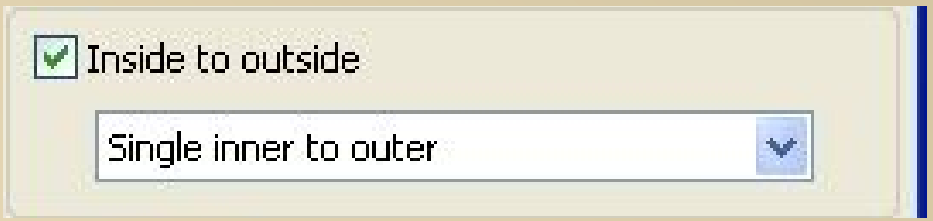


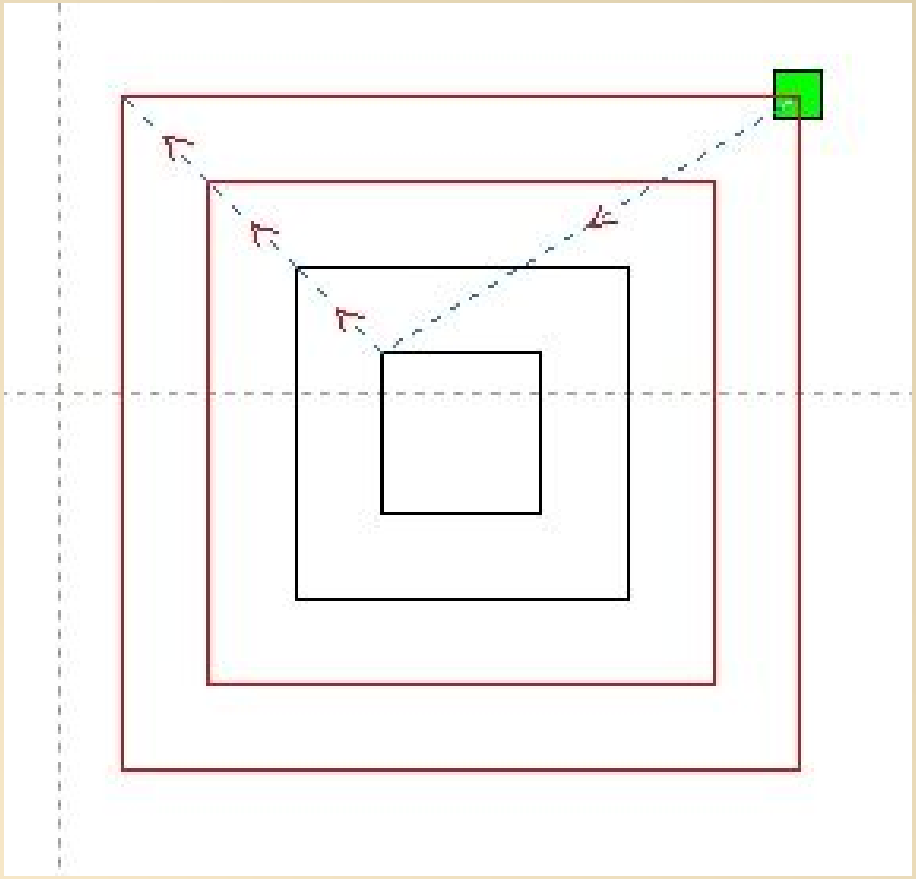
Cut Optimize

To optimize order for outputting, we have to use this function.

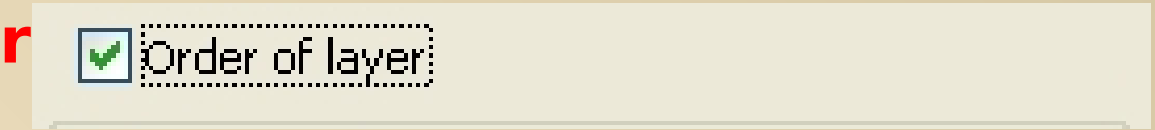


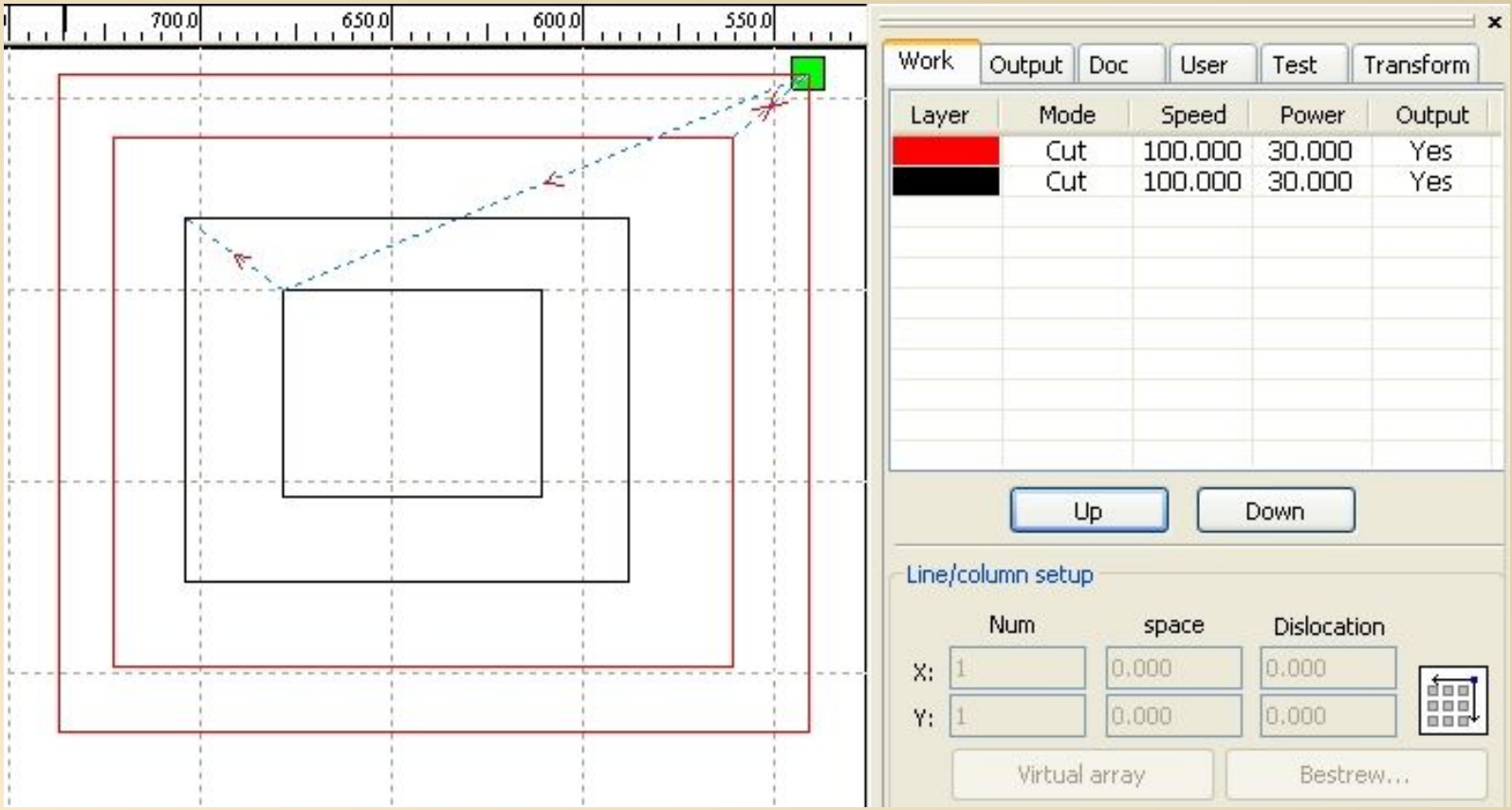
Inside to outside



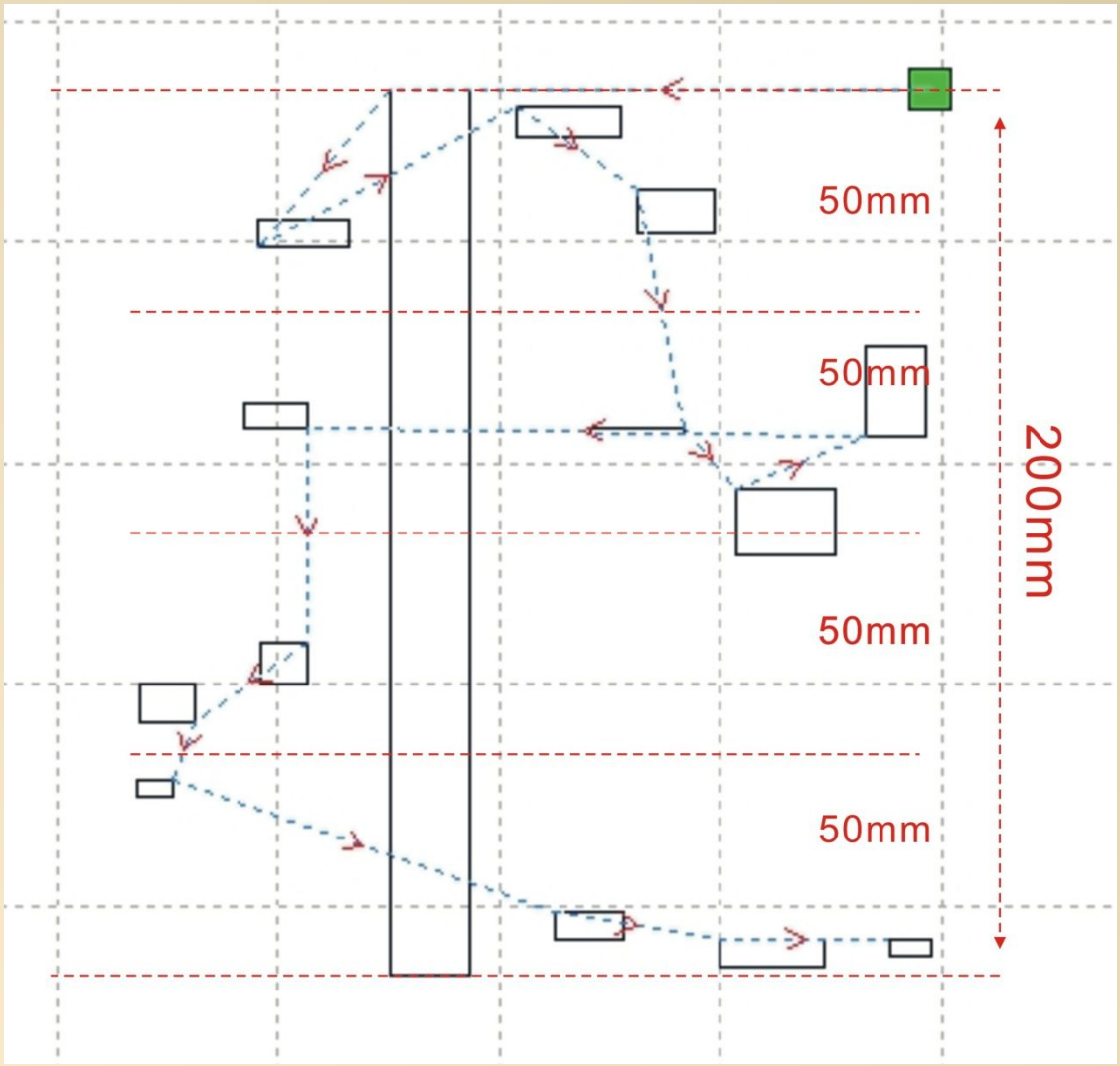


Order of layer

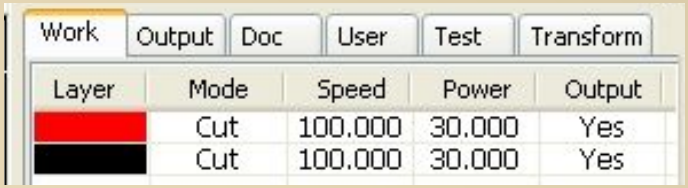




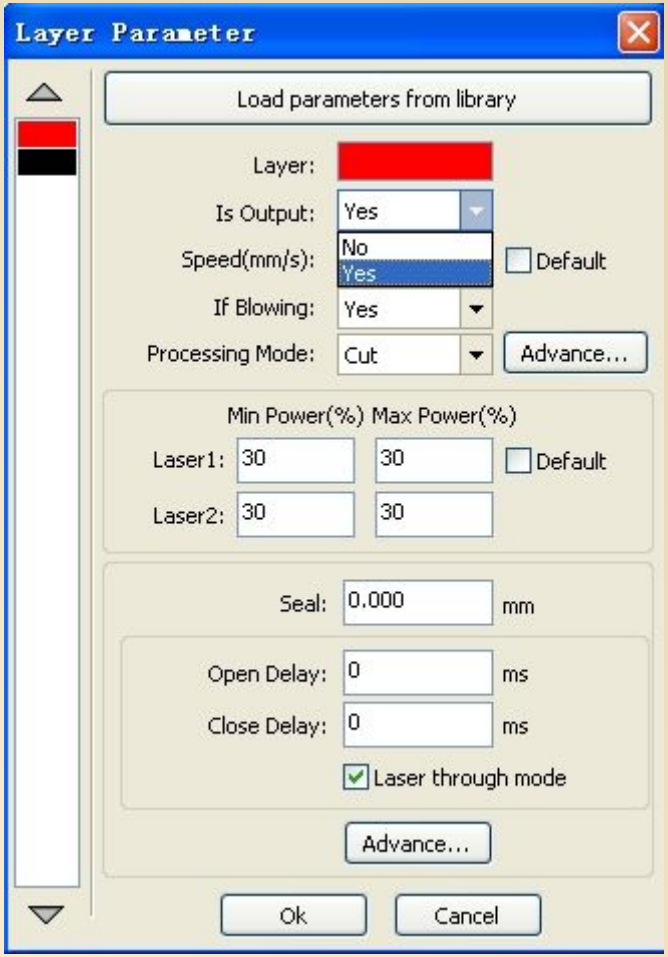
Block handle

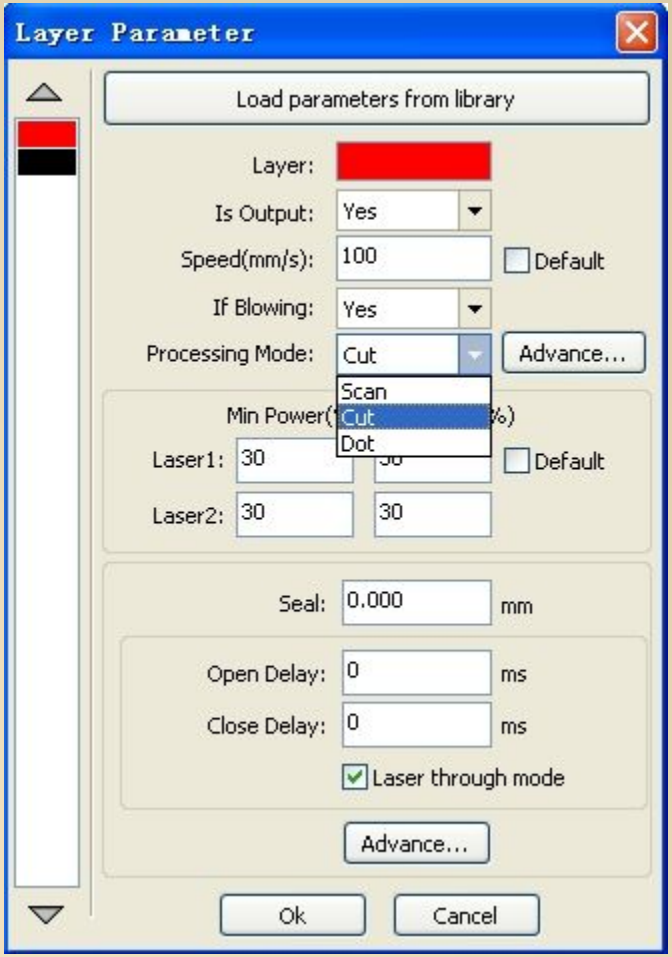


Layer Parameter

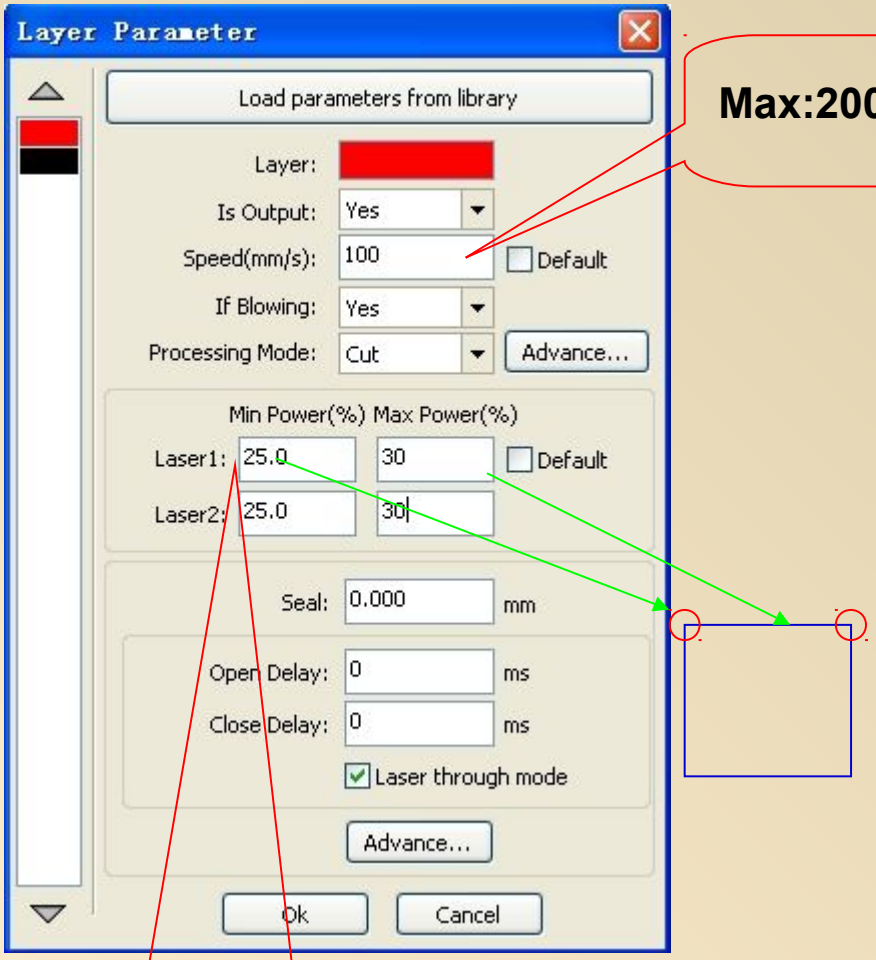


Click 2 times on different color to get layer setting interface





Layer Parameter-Cut



Max:200mm/s

Power Range ： 2%-98%

1mm 10-15mm/s

2mm 15-35mm/s

3mm 25-50mm/s

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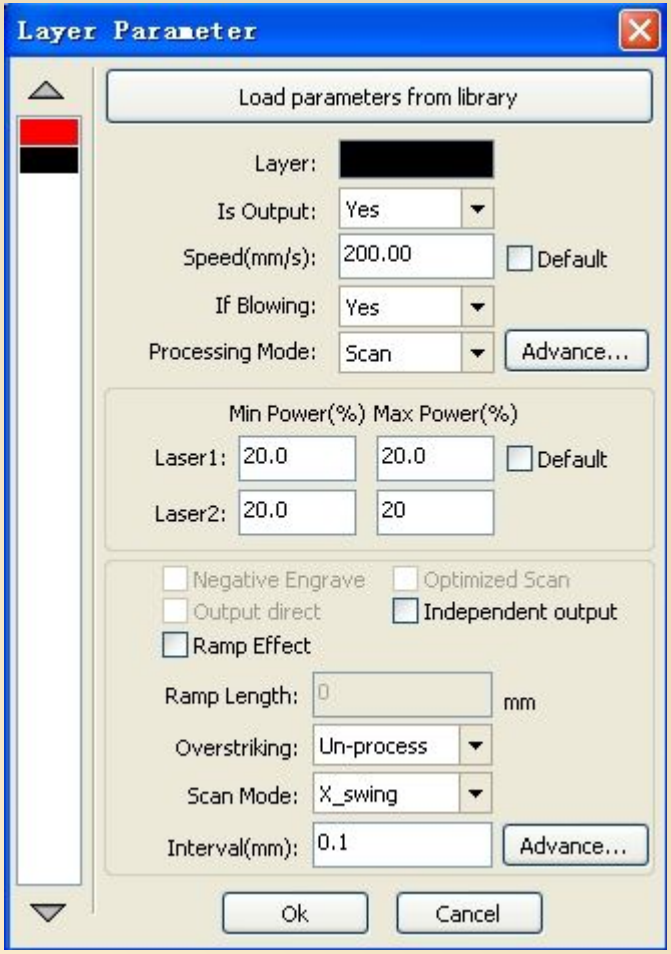
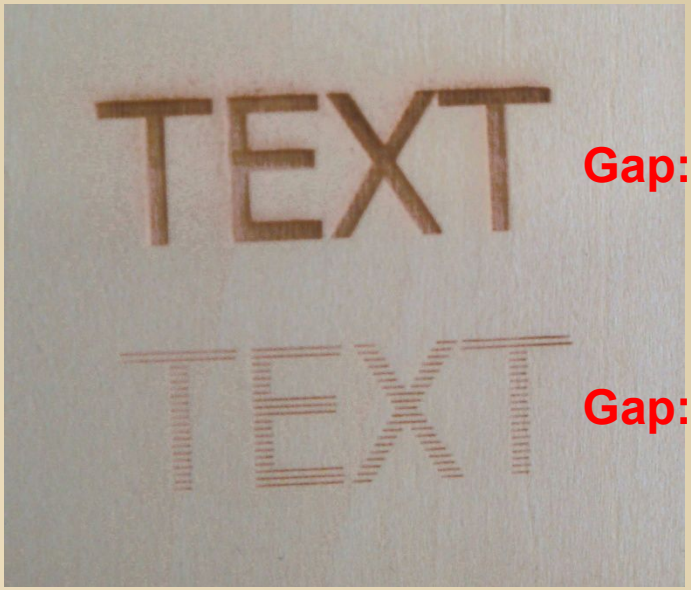
The larger the photo is, the faster the speed is.

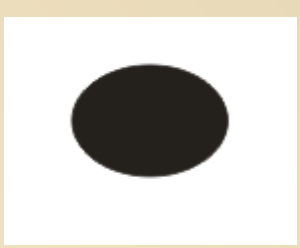
Layer Parameter-Scan





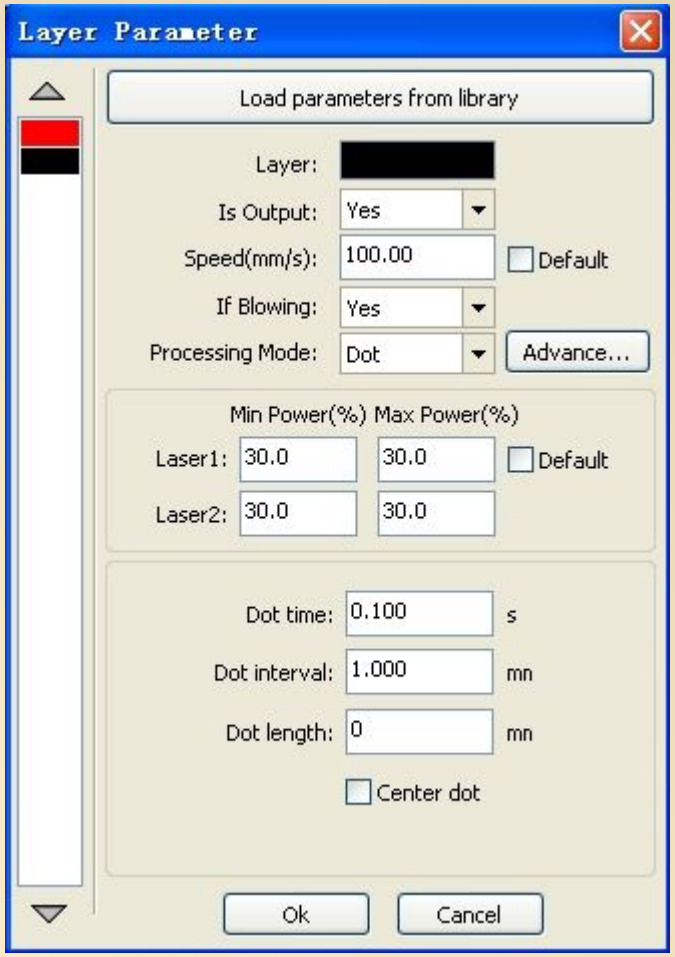
Gap:0.1

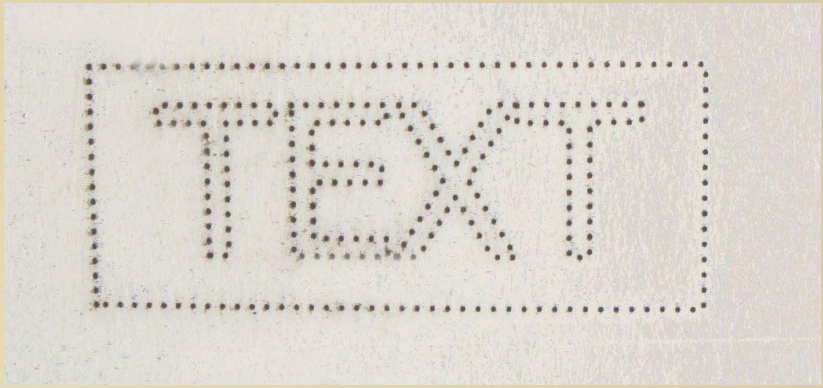
Gap:0.5



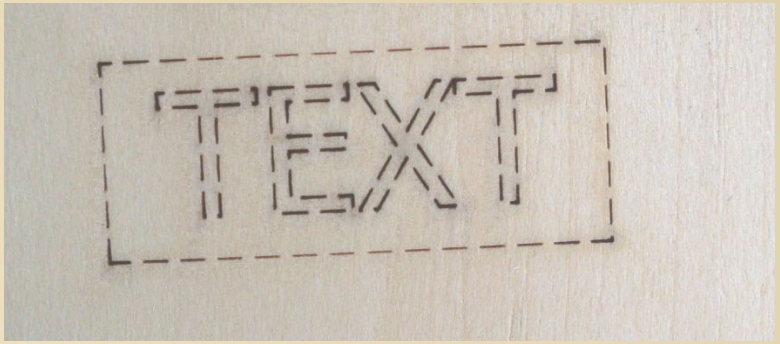
Attention: It must be closed design.

Layer Parameter-Dot



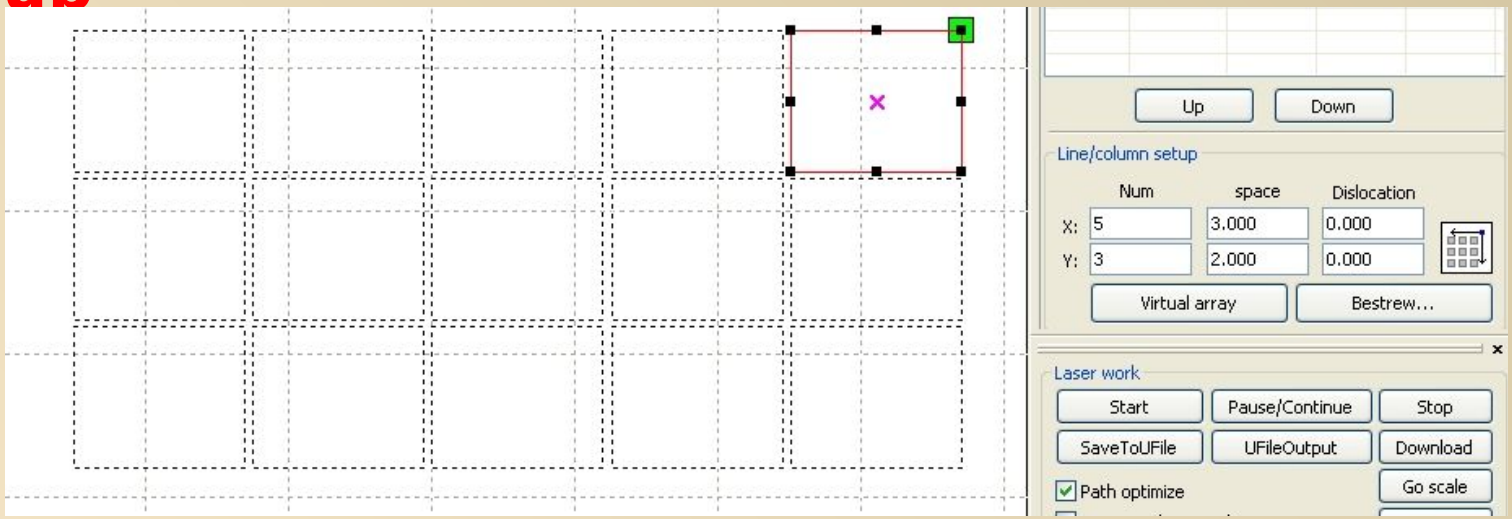


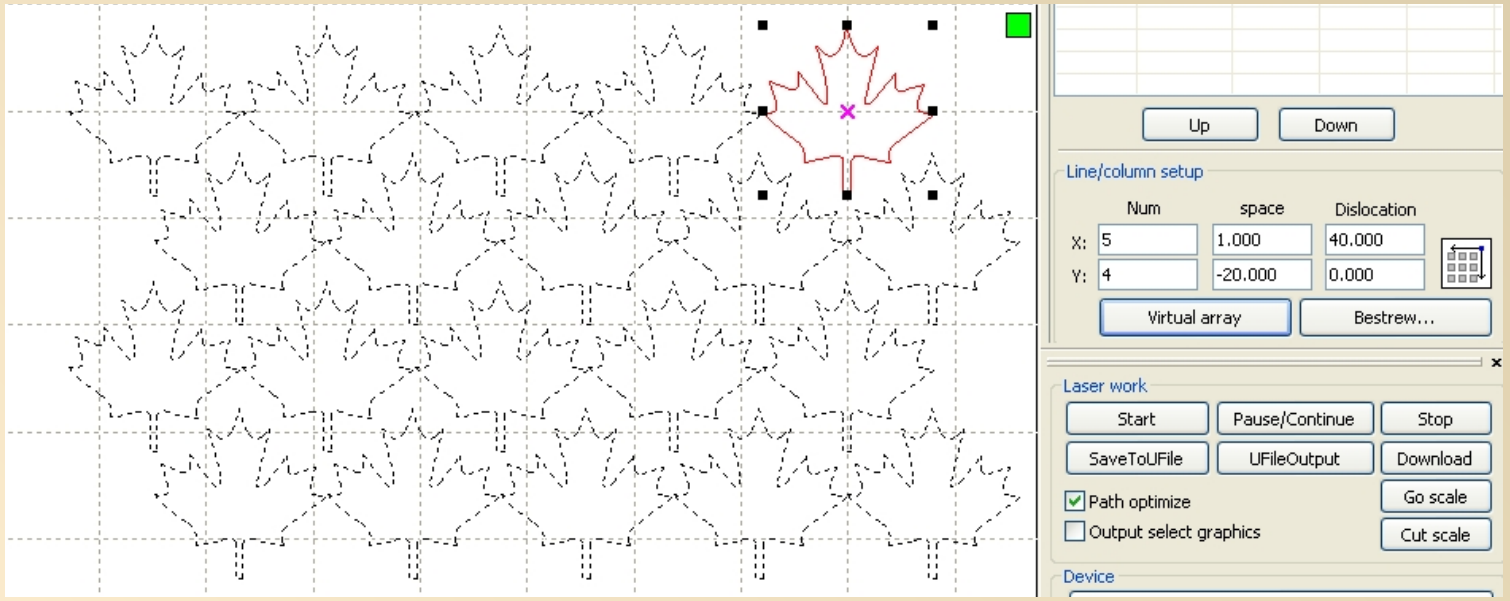
Gap : 1mm Length : 0mm



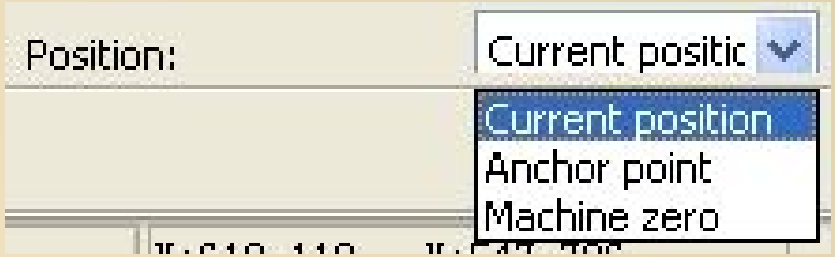
Gap : 1mm Length : 2mm

Line/column Setup





Position



Obviously, this function is used to set up starting point for laser head. It has 3 choices: present, previous, machinery

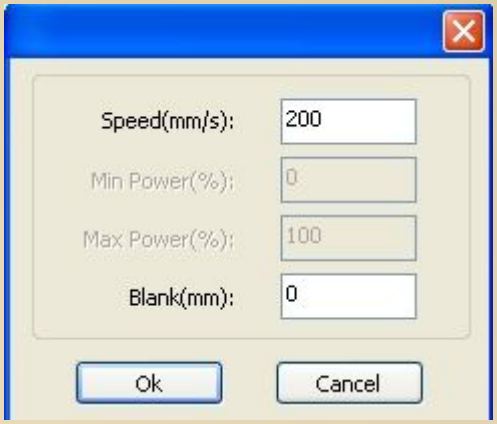
1.Present: Laser Head stats to move from the present location.

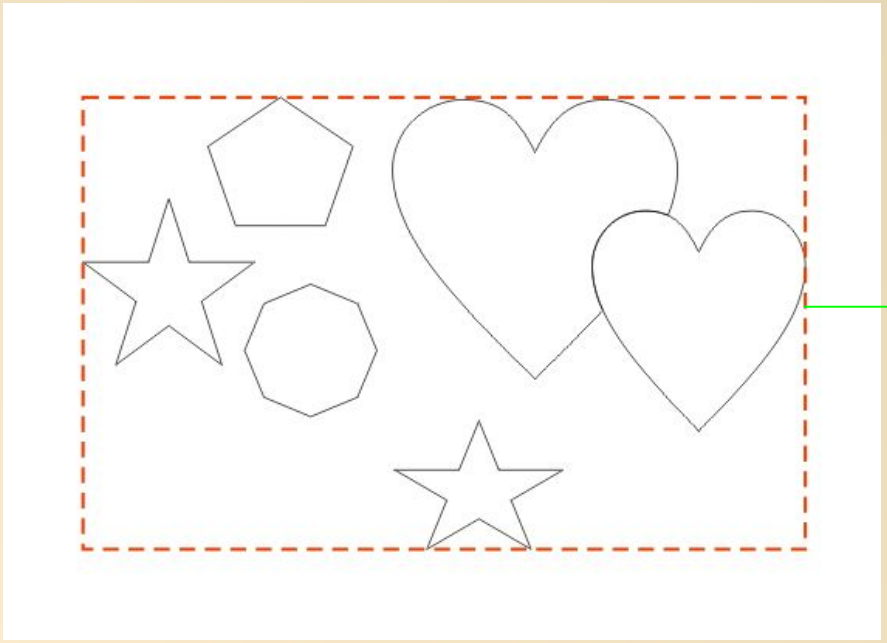
2.Previous: Choose this one, laser head moves from the previous setting point. And it can be changed by "Origin" on panel.

3. Machinery: Laser Heads moves back to Zero Point, that is the right side at the top of platform.

Go scale

Single click Go scale





Frame

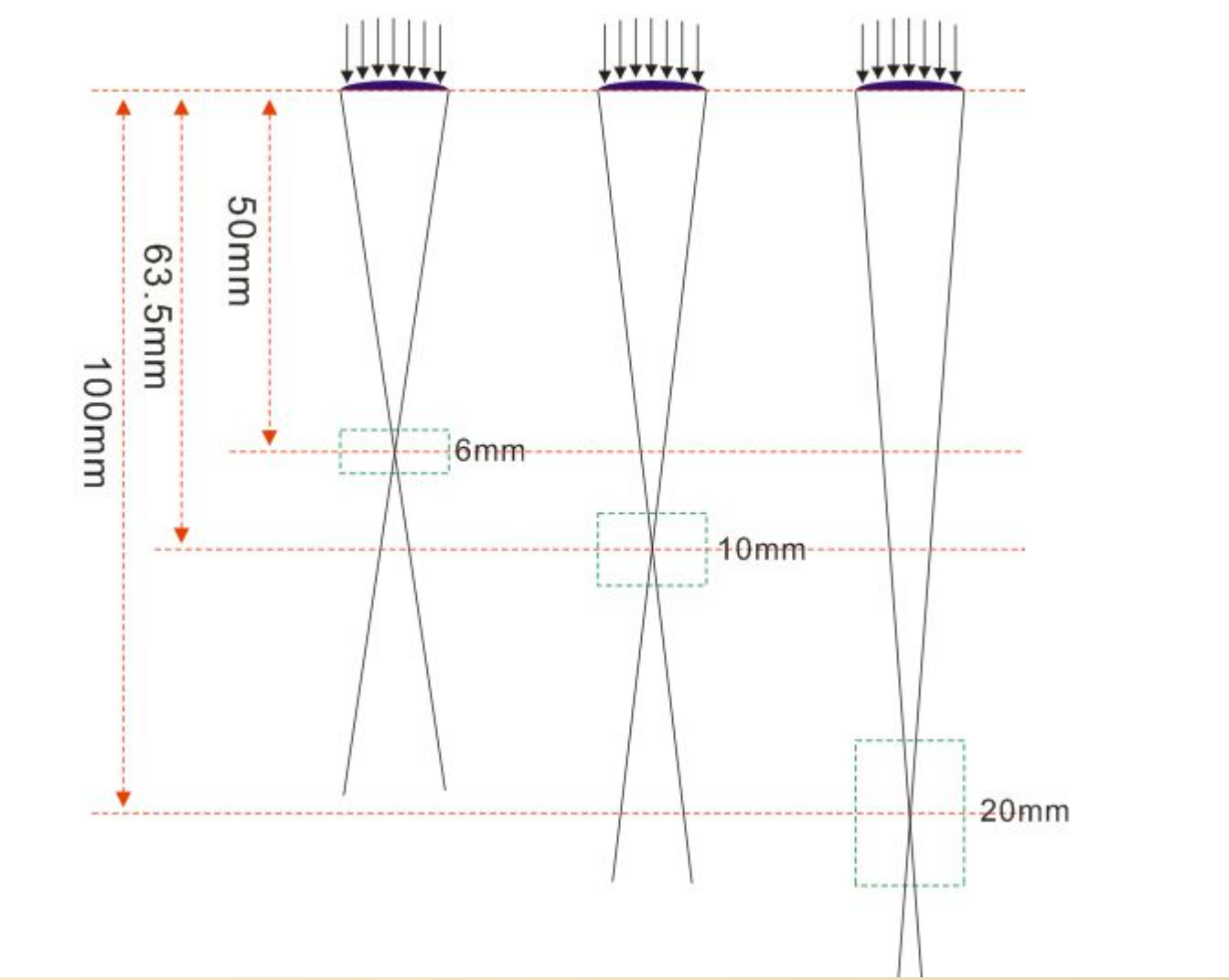
Start Pause/Continue Stop

1. Start: Press this button so as to give order to machine to start to work.

2.Pause/Continue: Single click for pause, and double click to continue.

3. Stop: Machine stops working if we press this button.

How to choose different size focus lens



Air Pressure

Fabric Cutting: Adjust accordingly if there is no deformation for fabric sheet. The larger the pressure is, the better the cutting result will be.

Fabric Engraving ： Not too large not too small.

Acrylic Cutting: Increase pressure a little for those under 2mm.

Decrease it if acrylic is beyond 2mm to prevent possible error.

Acrylic Engraving: Small pressure is ok to get transparent result.

Double Color Board Cutting: Large pressure is necessary to prevent from black edge.

Double Color Board Engraving ： Never use large pressure.

Wood Cutting: Must use large air pressure.

Wood Engraving: Not too large not too small.

80W Laser Tube Cutting Parameter (Reference Photo No.4)

Lens f63.5 / Thickness	Speed (mm/s)		Power (%)		Remarks
	Best Speed	Applicable Speed	Min. Power	Max. Power	
1mm	60	35-100	75	80	Reference Photo No. 1
2mm	50	30-80	75	80	Reference Photo No. 1
3mm	20	10-30	75	80	Reference Photo No. **2**
5mm	8	6-17	75	80	Reference Photo No. **2**
8mm	4	3-6	75	80	Reference Photo No. **3**
10mm	4	2-5	75	80	Reference Photo No. **3**
Lens f100 / Thickness	Speed (mm/s)		Power (%)		Remarks
	Best Speed	Applicable Speed	Min. Power	Max. Power	
1mm	55	20-90	75	80	Reference Photo No. **1**
2mm	45	15-70	75	80	Reference Photo No. **1**
3mm	15	8-28	75	80	Reference Photo No. **2**
5mm	7	5-15	75	80	Reference Photo No. **2**
8mm	4	2-6	75	80	Reference Photo No. **3**
10mm	3	2-5	75	80	Reference Photo No. **3**
12mm	2	1-5	75	80	Reference Photo No. **3**

100W Laser Tube Cutting Parameter (Reference Photo No.4)

Lens f63.5 / Thickness	Speed (mm/s)		Power (%)		Remarks
	Best Speed	Applicable Speed	Min. Power	Max. Power	
1mm	100	40-130	75	80	Reference Photo No. **1**
2mm	60	30-90	75	80	Reference Photo No. **1**
3mm	25	10-40	75	80	Reference Photo No. **2**
5mm	12	8-20	75	80	Reference Photo No. **2**
8mm	5	2-7	75	80	Reference Photo No. **3**
10mm	4	2-6	75	80	Reference Photo No. **3**
Lens f100 / Thickness	**Speed (mm/s)**		**Power (%)**		**Remarks**
	Best Speed	Applicable Speed	Min. Power	Max. Power	
1mm	60	30-100	75	80	Reference Photo No. **1**
2mm	30	20-50	75	80	Reference Photo No. **1**
3mm	15	10-30	75	80	Reference Photo No. **2**
5mm	10	7-15	75	80	Reference Photo No. **2**
8mm	5	2-9	75	80	Reference Photo No. **3**
10mm	4	2-6	75	80	Reference Photo No. **3**
12mm	3	2-5	75	80	Reference Photo No. **3**
15mm	1.5	1-3	75	80	Reference Photo No. **3**

135W Laser Tube Cutting Parameter (Reference Photo No.4)

Lens f63.5 / Thickness	Speed (mm/s)		Power (%)		Remarks
	Best Speed	Applicable Speed	Min. Power	Max. Power	
1mm	100	40~150	75	80	Reference Photo No. 1
2mm	60	30~90	75	80	Reference Photo No. 1
3mm	25	10~35	75	80	Reference Photo No. 2
5mm	12	8~18	75	80	Reference Photo No. 2
8mm	6	3~9	75	80	Reference Photo No. 3
10mm	5	3~7	75	80	Reference Photo No. 3

Lens f100 / Thickness	Speed (mm/s)		Power (%)		Remarks
	Best Speed	Applicable Speed	Min. Power	Max. Power	
1mm	60	40~120	75	80	Reference Photo No. 1
2mm	50	30~75	75	80	Reference Photo No. 1
3mm	20	10~30	75	80	Reference Photo No. 2
5mm	10	8~15	75	80	Reference Photo No. 2
8mm	6	3~10	75	80	Reference Photo No. 3
10mm	5	3~7	75	80	Reference Photo No. 3
12mm	4	2~6	75	80	Reference Photo No. 3
15mm	2.5	1~4	75	80	Reference Photo No. 3
20mm	1	1~2	75	80	Reference Photo No. 3

300W Laser Tube Cutting Parameter (Reference Photo No.4)

Lens f63.5 / Thickness	Speed (mm/s)		Power (%)		Remarks
	Best Speed	Applicable Speed	Min. Power	Max. Power	
1.9mm with paper	80	30-120	80	85	Reference Photo No. 1
3.4mm with paper	40	10-70	80	85	Reference Photo No. 2
4.7mm with paper	20	8-30	80	85	Reference Photo No. 2
8mm with paper	10	3-15	80	85	Reference Photo No. 3
9.7mm without paper	7	3-10	80	85	Reference Photo No. 3
Lens f100 / Thickness	**Speed (mm/s)**		**Power (%)**		**Remarks**
	Best Speed	Applicable Speed	Min. Power	Max. Power	
1.9mm with paper	70	30-110	80	85	Reference Photo No. 1
3.4mm with paper	40	10-62	80	85	Reference Photo No. 2
4.7mm with paper	18	8-28	80	85	Reference Photo No. 2
8mm with paper	10	3-15	80	85	Reference Photo No. 3
9.7mm without paper	7	3-10	80	85	Reference Photo No. 3
14.6mm without paper	3	1-6	80	85	Reference Photo No. 3
20mm without paper	2	1-3.5	80	85	Reference Photo No. 3
25mm without paper	1	0.8-2	80	85	Reference Photo No. 3

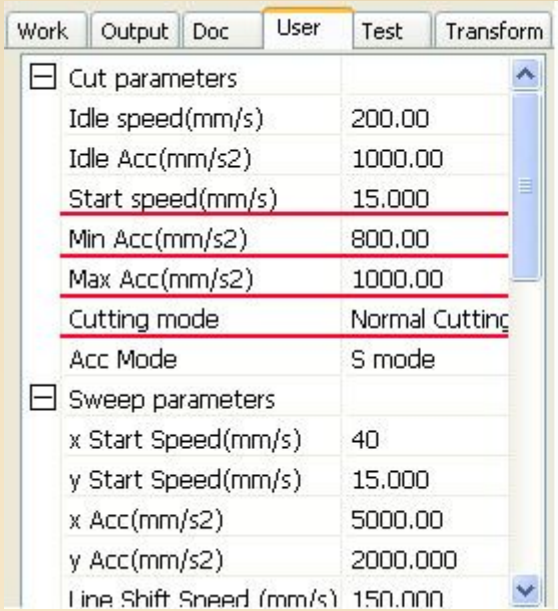


Photo 1

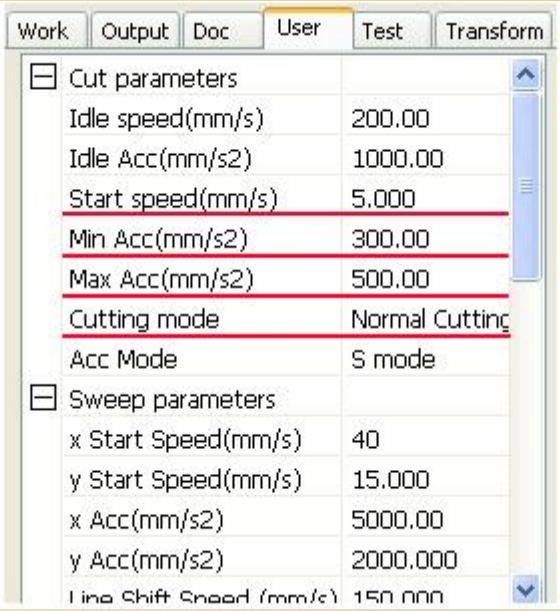


Photo 2

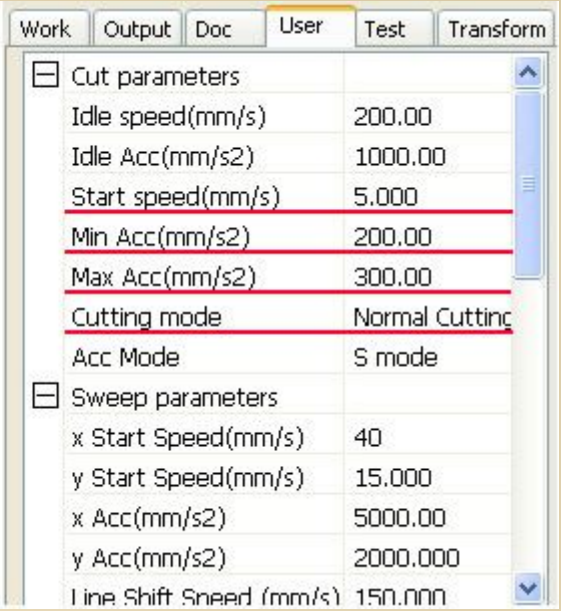


Photo 3

1mm
Max. applicable speed cutting result

1mm
Best Speed Cutting Result

2mm
Max. applicable speed cutting result

2mm
Best Speed Cutting Result

3mm
Max. applicable speed cutting result

3mm
Best Speed Cutting Result

5mm
Max. applicable speed cutting result

5mm
Best Speed Cutting Result

8mm
Max. applicable speed cutting result

8mm
Best Speed Cutting Result

10mm
Max. applicable speed cutting result

10mm
Best Speed Cutting Result

12mm
Max. applicable speed cutting result

12mm
Best Speed Cutting Result

15mm
Max. applicable speed cutting result

15mm
Best Speed Cutting Result

Photo 4

135W Glass Tube Plywood Cutting Parameter				
Lens **f63.5** / **Thickness**	Speed (mm/s)		Power (%)	
	Best Speed	Applicable Speed	Min. Power	Max. Power
1mm	80	30-120	75	80
3mm	40	10-70	75	80
5mm	20	8-30	75	80
8mm	10	3-15	75	80
Lens **f100** / **Thickness**	Speed (mm/s)		Power (%)	
	Best Speed	Applicable Speed	Min. Power	Max. Power
1mm	70	30-100	75	80
3mm	30	10-50	75	80
5mm	15	8-25	75	80
8mm	12	5-15	75	80
12mm	4	1-6	75	80

60W Laser Tube Engraving Parameter (Reference Photo No. 6)

Lens f50 / Material	Speed (mm/s)		Power (%)		Scanning Gap (mm)	Remarks
	Best Speed	Applicable Speed	Min. Power	Max. Power		
Acrylic	200	10-400	18	18	0.08 (0.05 以上)	Reference Photo No. 5
Double Color Board	200	10-400	18	18	0.08 (0.05 以上)	Reference Photo No. 5
Wood	200	10-400	18	18	0.08 (0.05 以上)	Reference Photo No. 5
Denim	200	10-400	18	18	0.25 (0.05 以上)	Reference Photo No. 5

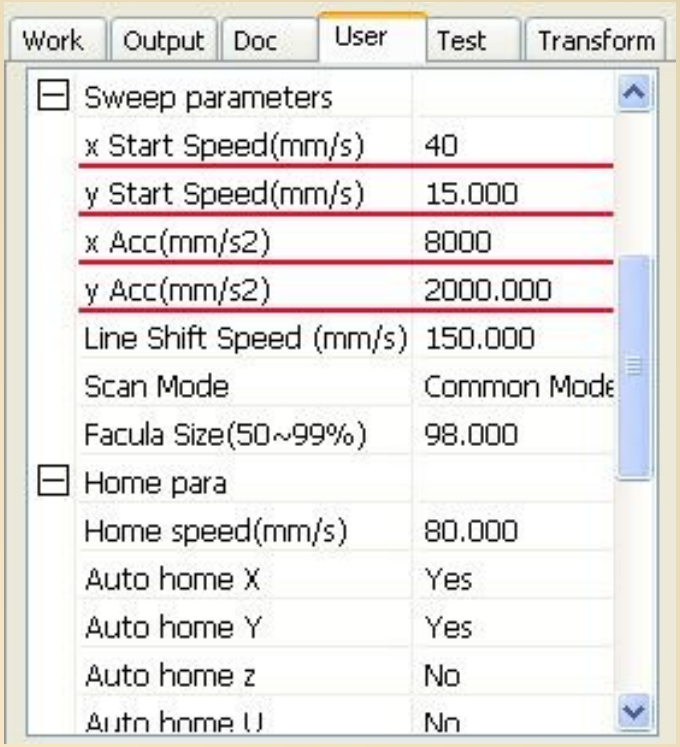


Photo 5

Acrylic Engraving Result

Double Color Board Engraving Result

Wood Engraving Result

Denim Engraving Result

Photo 6

60W Laser Tube Half-cutting Parameter

Lens f50 / Material	Speed (mm/s)		Power (%)		Remarks
	Best Speed	Applicable Speed	Min. Power	Max. Power	Min. Power is to control corner laser force while max. power take control of laser force for straight line. With improper min. power, the result won't be good, neither there is no light nor black edge.
Wood	20	1~200	8.8	9	
Double Color Board	20	1~200	8.8	9	Better not using large power laser tube
Acrylic	20	1~200	8.8	9	40w glass laser tube or RF metal laser tube will be a good option
Reflective Materials	20	1~200	8.5	8.5	HS 60W laser tube is so good as SP 60W for min. power

Thanks for your patient browsing.