

Laser Cutter Large Format Usage Guide

The following instructions are steps for sending jobs to the large format AP Lazer **36 x 48"** laser cutter machine:

Starting Up Machine:

1. Turn on laser laptop
2. Ask staff to turn on AP Lazer (key access not available to students)
3. Turn on air assist (back wall)



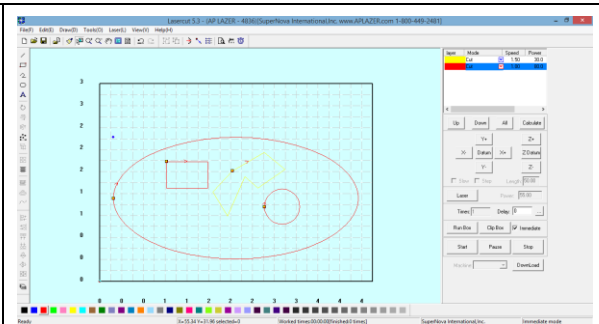
Laser Material Setup:

1. Place material in center of machine
2. Align material to be parallel to laser head



Opening Software:

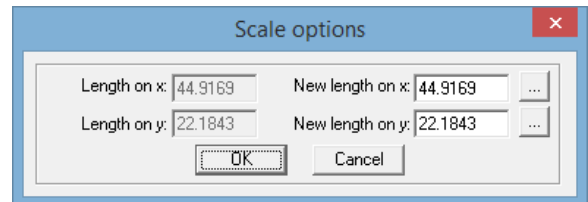
1. Open LaserCut 4836 on laptop desktop
2. File > Import to open your DXF file
File > Open will not work
Large files will crash software



Final File Prep:

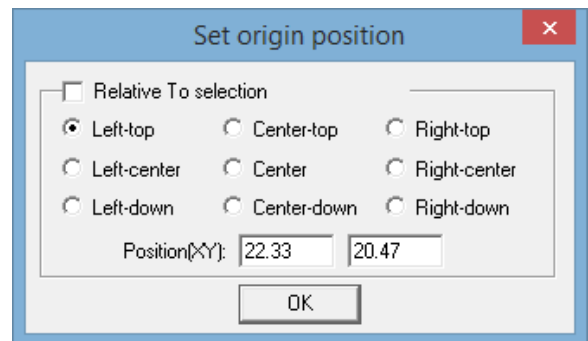
1. Select all lines then select “Edit > Center to table”
2. Keep lines within 1/8” margin of max bed size borders (36 x 48” max)

3. Incorrectly scaled lines can be re-sized with “Draw > Size” according to selection bounding box dimensions



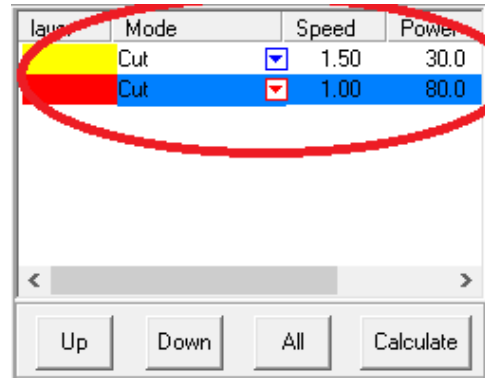
4. Delete outer bounding box and any lines touching or extending past template border
Machine will error-out if lines intersect border

5. Select all lines then select “Laser > Set Origin”
6. Select Left-top
7. Click OK

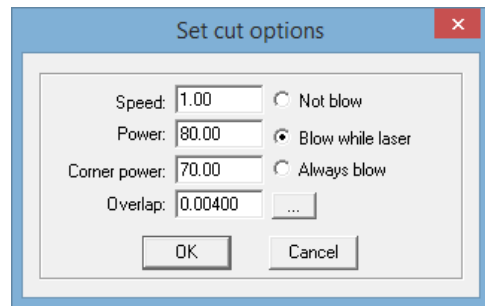


Print Properties Setup:

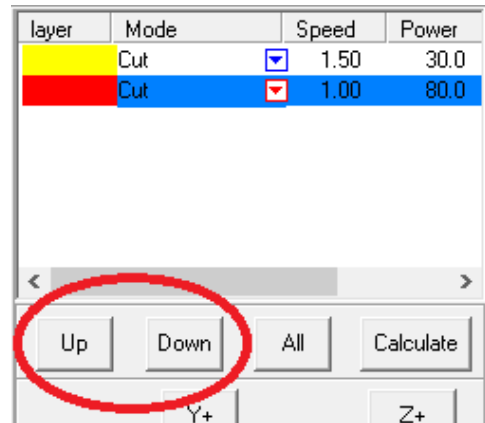
1. All vector lines should be set as "CUT" at right sidebar



2. Change each line color's properties individually by double-clicking the layer's power/speed settings (for cutting-through and scoring)
3. Check "Blow while laser"
4. Leave Overlap at 0.00400
5. Click OK

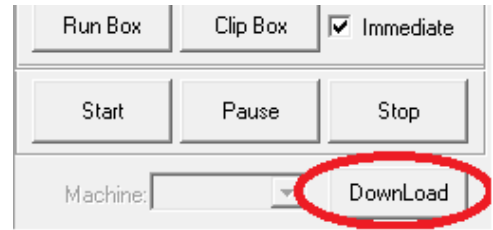


6. Place scoring layers at top by changing layer order using the Up and Down buttons

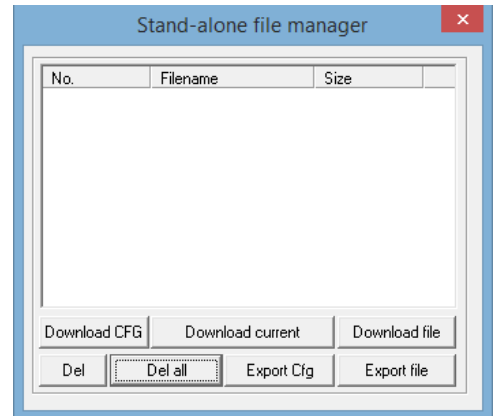


Sending File to Machine and Test:

1. Click Download



2. Click "Delete all"
3. Click "Download CFG"
If you do not hear a beep from the machine, make sure machine lid is fully closed
4. Click "Download current"
5. Wait for job to fully send to machine before proceeding



6. Press "Esc" on console to refresh and re-select menu
7. Press "Test" to trace outer boundaries of laser design
8. If test trace does not fit onto supplied material, relocate material or edit and re-send design



Starting the Sent Job:

1. Press "Esc" on console to refresh and re-select menu
2. Close machine lid firmly
3. Press "Start/Pause" button to begin job
Job will likely move to start at bottom-right of material
4. To pause job, press "Start/Pause" again
5. To end and reset a paused job, press "STOP" button

