

# TROTEC LASER CUTTER

**CO2 Laser**

**100W**

**Table size: 1016 x 610 mm**

**No external materials allowed**



# MATERIALS

PLYWOOD	MDF	ACRYLIC
3 mm	3 mm	1 mm
5 mm	5 mm	2 mm
		3 mm
		5 mm

# MACHINE

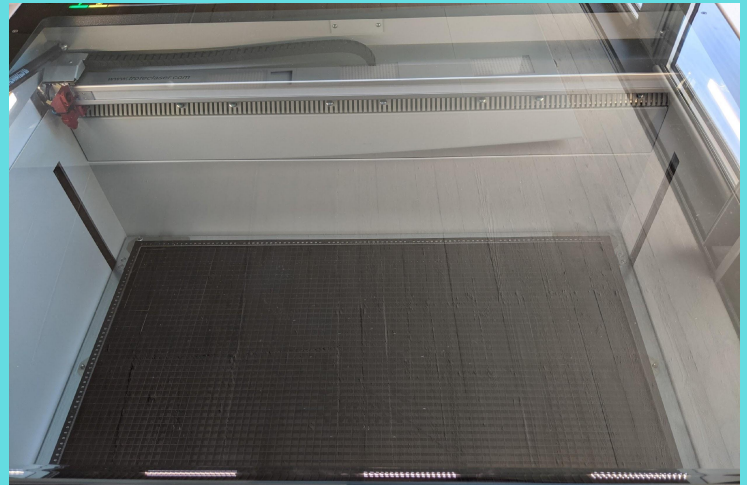
## Turning on

After logging into the machine you will need to start it up. To do so turn the key all the way to the right.



## Self checks

The machine will run several self checks and calibrate the axis. This process will take a few seconds and will cause the table to move all the way down.



## Moving the table

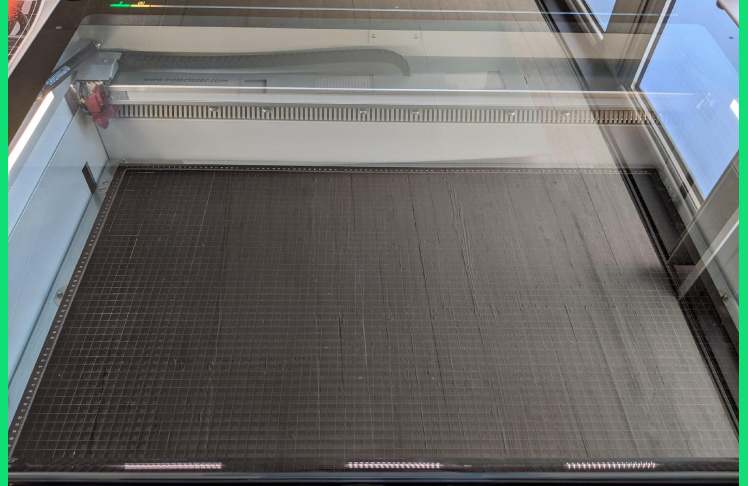
Using the buttons on the right the table can be moved up and down.



# MACHINE

## Insert material

- Move the table upwards to a comfortable position and place your material on the table.
- If your material is bended and lifts up at some points you need to tape it down. Make sure to place the material so that the edges are bending up when securing the material, this will guarantee the material will lay flat.



## Auto focus

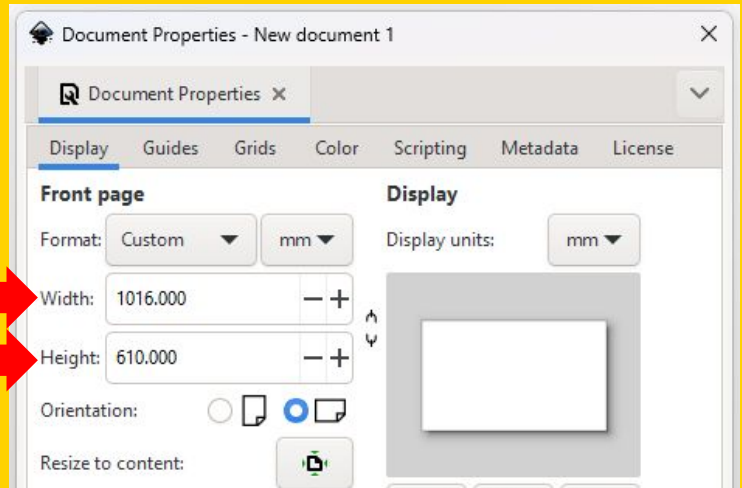
Now move the laser to a location above the material using the X & Y Arrows and then run the auto focus routine by pressing the Z up and down buttons at the same time.



# INKSCAPE

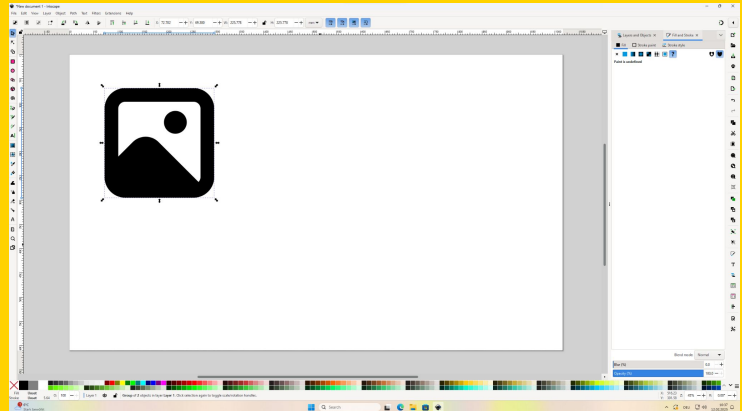
## Set the file

Open a new file in Inkscape and make sure that the file size is 1016 x 610 mm. You can set or check it in the “Document Properties...” in the “File” menu.



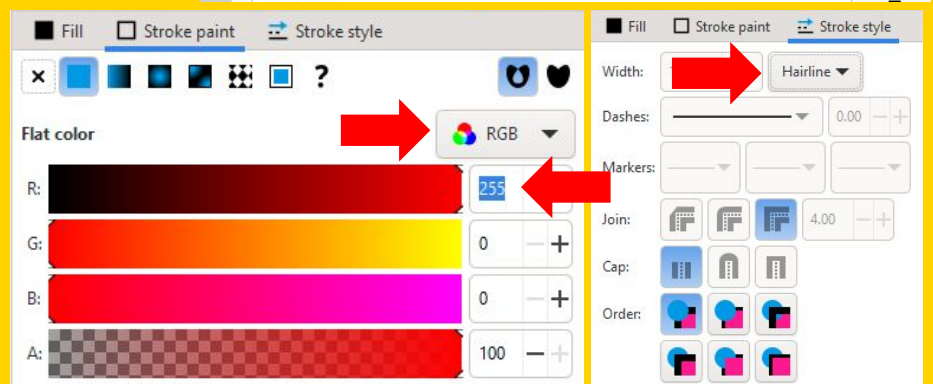
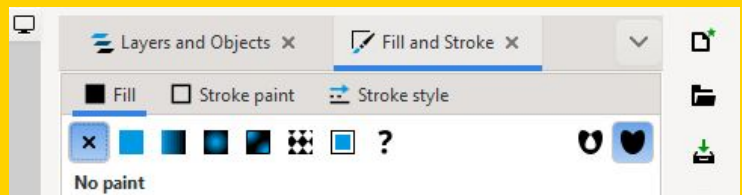
## Importing files

You can import vector files by dragging them onto the page or create your own file with Inkscape tools.



## Line setting

The lines that need to be cut have to be RGB RED (255,0,0) with a stroke width of Hairline. Fill is none (“x”).



# or COREL DRAW

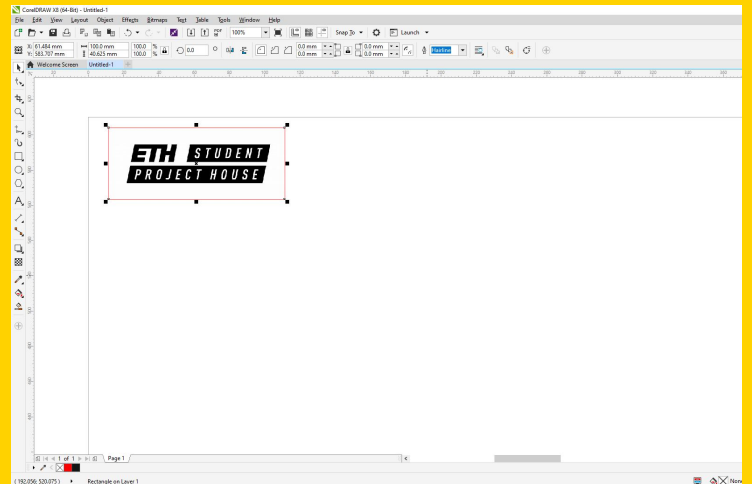
## Set the file

Open a new file in Corel Draw and make sure that the file size is 1016 x 610 mm.



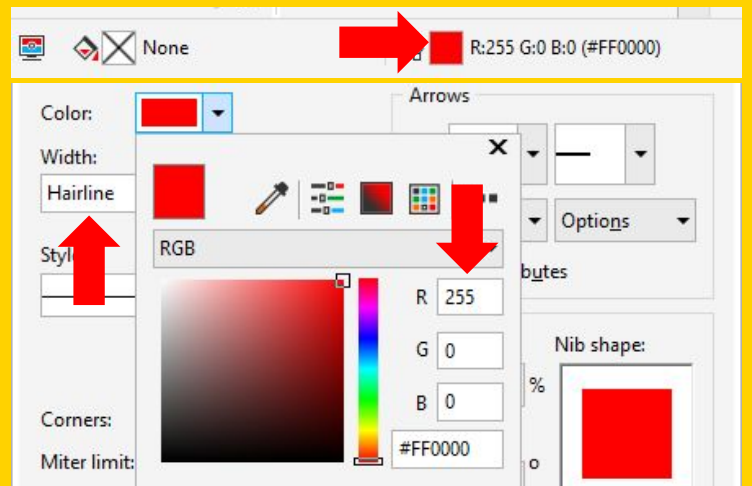
## Importing files

You can import vector files by dragging them on the Corel Draw page or create your own file with Corel Draws tools.



## Line setting

The lines that need to be cut have to be RGB RED (255,0,0) with a thickness of Hairline.



# PREPARE FILE FOR CUTTING

## Engraver Settings

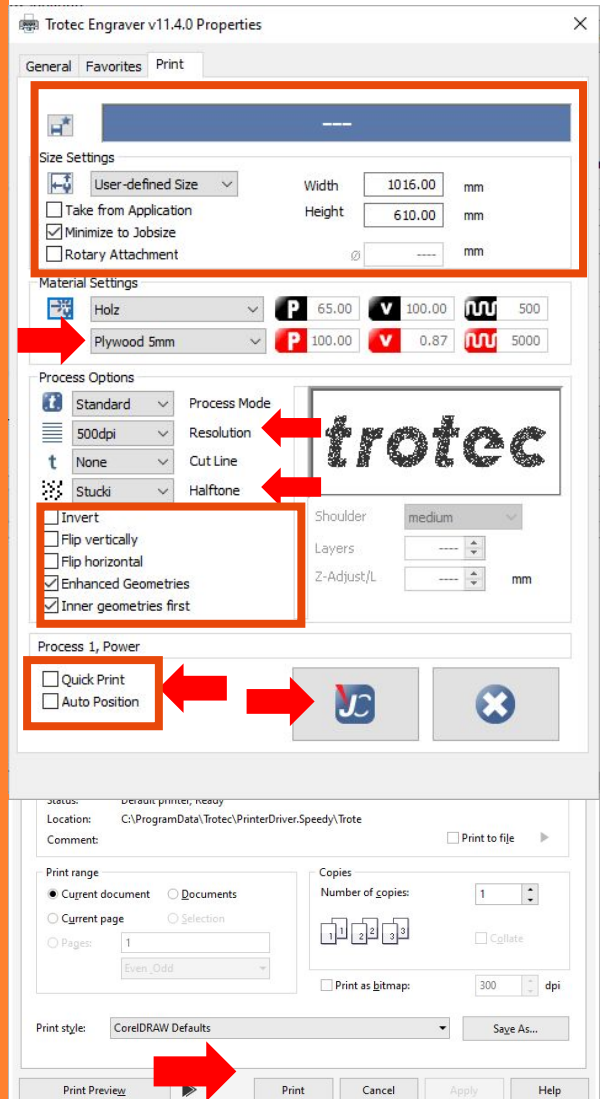
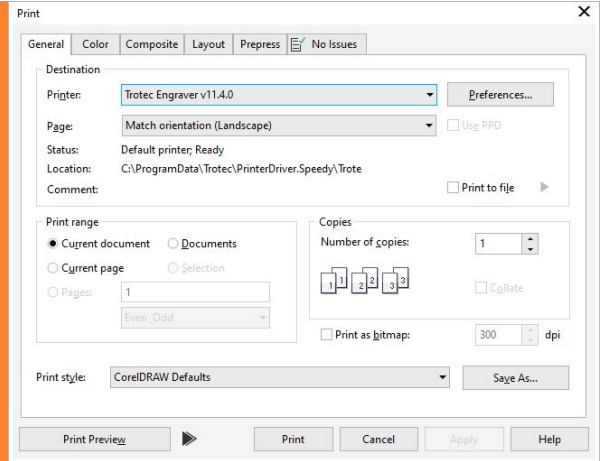
Once you are done either press Ctrl + P or click on print under the file tab. Then select the [Trotec Engraver] and click [Preferences] or [More settings].

## Preferences

- Ensure the settings are the same as shown in the 3 red boxes on the right.
- Select the material you want to use.
- The following 2 settings may be adjusted. The engraving Resolution and the engraving pattern (Halftone).
- Once you are done press the big “JC” button.

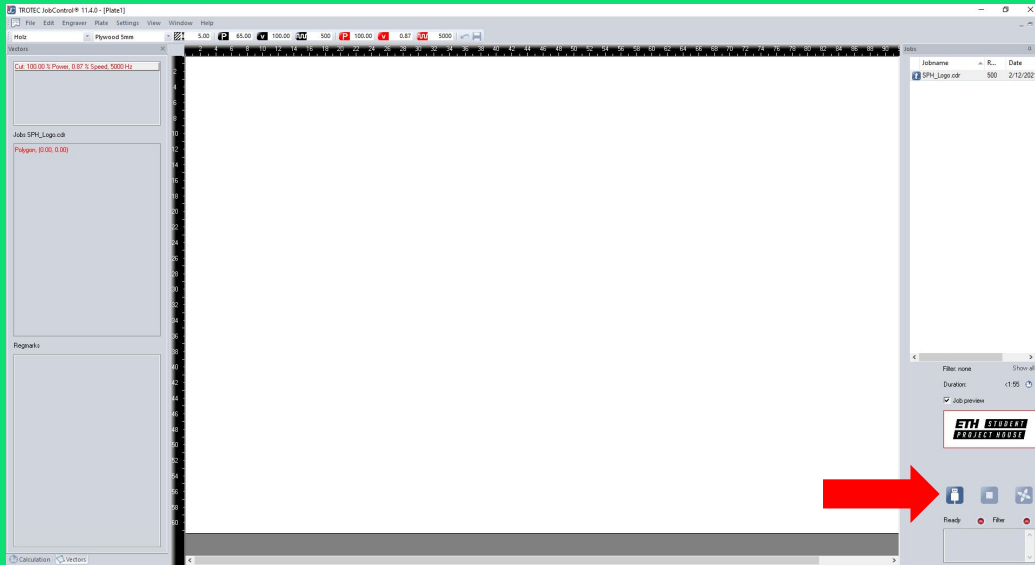
## Print

When everything is set up press the [Print] button to send your file to the cutter software.

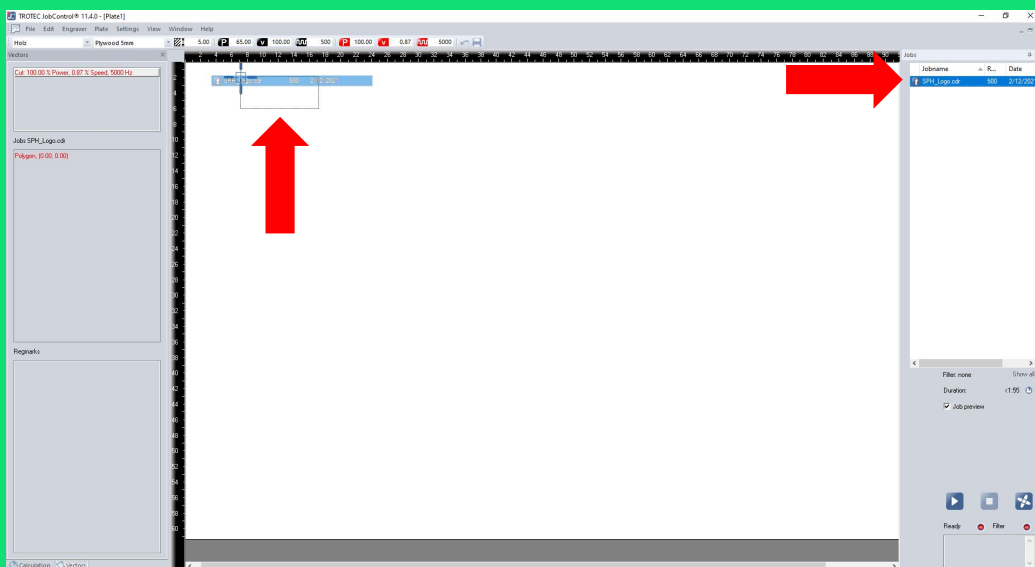


# JOB CONTROL

A new software named “Job Control” opens. The first step is to connect the software to the machine by pressing the small USB plug on the right side. The machine will take a second to synchronize.



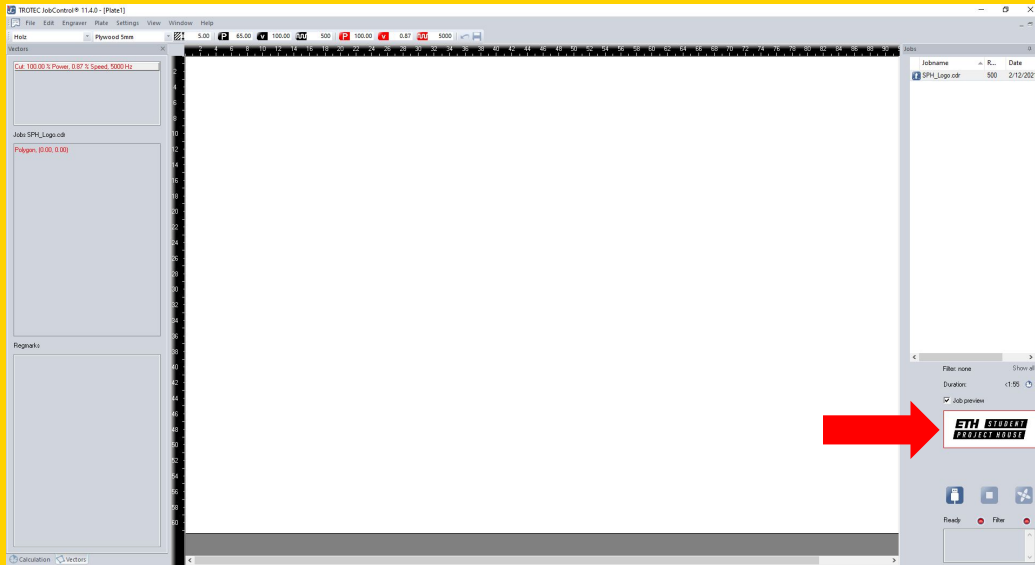
Select your job from the list on the right and drag it onto the virtual machine table left to it. The current laser position is indicated with the small crosshair. You can use it to position your job on the print bed.



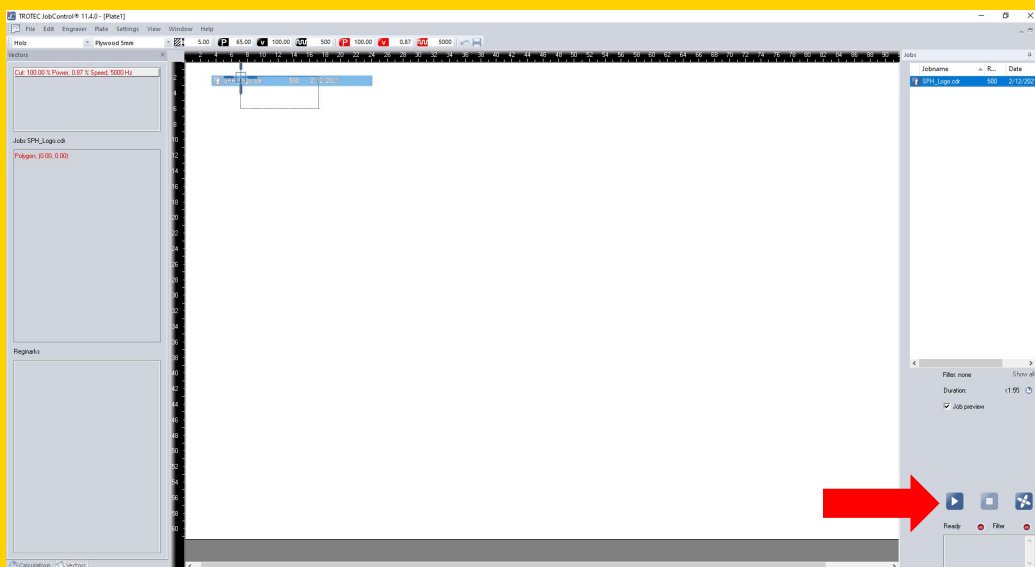


# JOB CONTROL

When clicking on your job on the table you can see a small preview on the right to verify you selected the correct job.



By pressing the small play button on the right, the job will be sent to the machine. The ventilation will turn on automatically and the job will start after 5 seconds.



# VENTILATION

The ventilation should turn on automatically, if the ventilation is not on contact a manager to fix it.

**When your cutting/engraving job is done you will have to wait until the ventilation turns off to open the lid.**

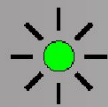
This procedure will make sure that all gasses will be removed and the place does not smell.



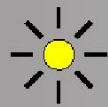
Ventilation

# SAFETY

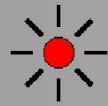
## Dead Man Switch



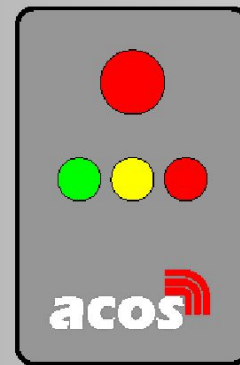
All good!



Please press button



Press button or machine will auto turn off



A job can be stopped using the stop button on the control panel. In case of emergency press the safety off on top of the control panel.



# SAFETY RULES

- **NEVER** leave the cutter unattended
- **ALWAYS** use our presets
- **NEVER** change the presets
- **NEVER** use unknown materials
- **ALWAYS** ask when in doubt
- **Keep the door closed for until ventilation turns off after the job is done**