⚠	# Never left the machine working unattended.

"Before power up the laser cutter" Checklist

- ❑ **Chiller is ON**
- ❑ **Air Compressor is ON**
- ❑ **The extractor fan is up and running**
- ❑ **Check that the emergency switch is all way up** (Turn the knob in the sense indicated by the arrow to disengage it)

To turn on the laser cutter use the four switches on the right side of the chassis.

How to cut
1. Download your file into the laser cutter;
    a. Use file ->Open/Import to load your file (*best results with dxf file, "R12 line & arcs" version*)
    b. Set power, velocity and function (cutting/engraving) for each layer;
    c. Click the Download button;
2. Place the material on the working plate
3. On the panel hit [Z/U]
4. Select ZAxesMove, use left and right arrow to adjust the bed's height. Set it close to the laser;
5. Select Autofocus (up and down arrows to navigate trough the display, enter to confirm);
6. Press [esc] to go back to the home page.
7. Use the arrows to put the laser in the right place, then hit [origin] to set X&Y axis starting point. The so set origin of the axis will coincide to the software's one (the little red square in the software);
8. Press the [start] button on the panel to begin the cutting.

Mind the air!
Durante il taglio laser l'aria compressa impedisce che i residui si depositino sulla lente, compromettendo le prestazioni della macchina, e favorisce la buona riuscita della lavorazione.
Keep the airflow between 1 and 4 bars.

During cutting keep an eye on the pressure gauge. Use the knob (you have to pull it up to rotate it) to adjust the airflow.

How does the airflow affect the cutting?
Cardboard: Above 2 bars, less precise cut and fire generation risk!
Plexiglass: More air, more opaque
Wood sheet: More air, less burn

How to download your files into the laser cutter

Advices:
- For the best results during import use PLT for your files
- Where in doubt hit [F5] on LaserCut Software to see a movement simulation

If you think something is going wrong don't be afraid to hit the big red emergency stop button.

When the machine restarts after a emergency stop:
Hit enter to resume the current job
Hit cancel to abort the last work.