

# **Laser Carving and Cutting Software (Multi-doc Version)**

# **Instruction For Operation**

In case that the actual operation mode and functional setting, etc. don't conform to the instruction due to the software upgrading, the software shall prevail.

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# Chapter I General

## 1.1 Introduction on Laser Carving and Cutting System

The laser carving and cutting system realizes the effective control to the laser numerically-controlled machine tool through computer and complete the machining according to users' different requirements. The system is composed of control main board, control panel and supporting software. The instruction introduces how to use the software to complete the laser machining task.

## 1.2 Support Plug-in

Drawing Software		Operation System			
Software Name	Version	WinXP	Win7(32)	Win7(64)	Win8(64)
<b>CorelDraw</b>	12	√	√	√	?
	X4	√	√	√	?
	X5	√	√	√	?
	X6	√	√	√	√
	X7	√	√	√	√
<b>AutoCad</b>	2004	√	√	√	?
	2010	√	√	√	?
	2012	X	√	√	?
	2013	X	√	√	√
	2014	X	√	√	√
	2015	X	√	√	√
<b>Adobe Illustrator</b>	CS5	√	√	√	√
	CS6	√	√	√	√
	CC 2014	X	√	√	√

Note: "√" indicates support, "X" indicates nonsupport and "?" indicates no test.

## 1.3 Format of Support File

- (1) Vector Format: dxf, ai, plt, dst and dsb, etc.
- (2) Bitmap Format: bmp, jpg, gif, png and mng, etc.
- (3) Project File: pwj

## 1.4 Operating System Environment Requirements

- (1) Operating system of WindowsXP or above.
- (2) Above CPU586; PIII or above is recommended.
- (3) The internal memory of over 1G is recommended.

## Chapter II Installation of Software

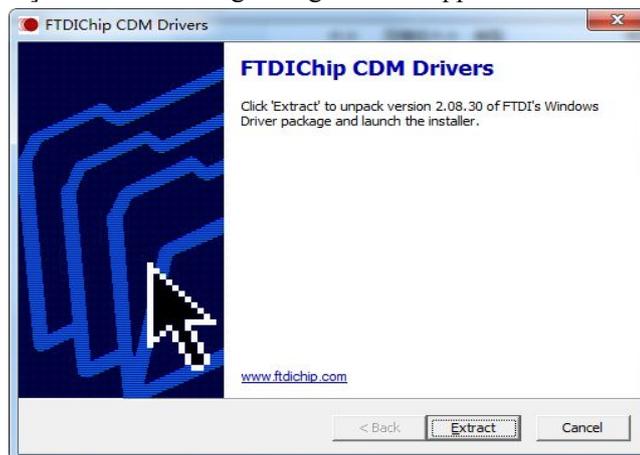
### 2.1 Install Drive

It shall be specially noticed that the drive program must be installed for the first installation. Otherwise, the machine can't be connected to!

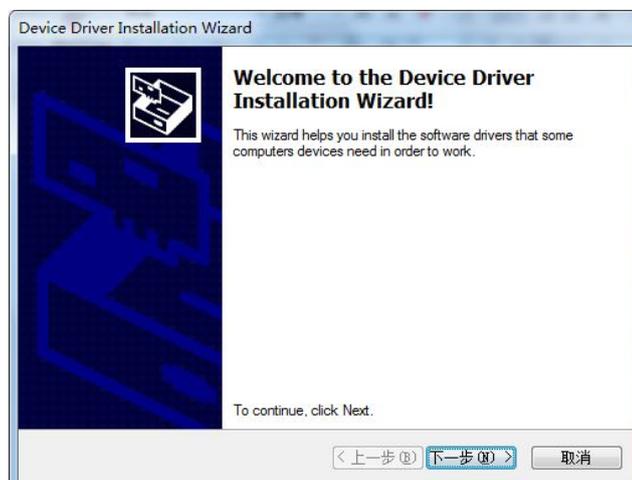
- (1) Double-click the setup.exe under the installation directory, and the following dialog box will appear:



- (2) Click [Install the drive] and the following dialog box will appear:



- (3) Click [Extract] and the following dialog will appear:



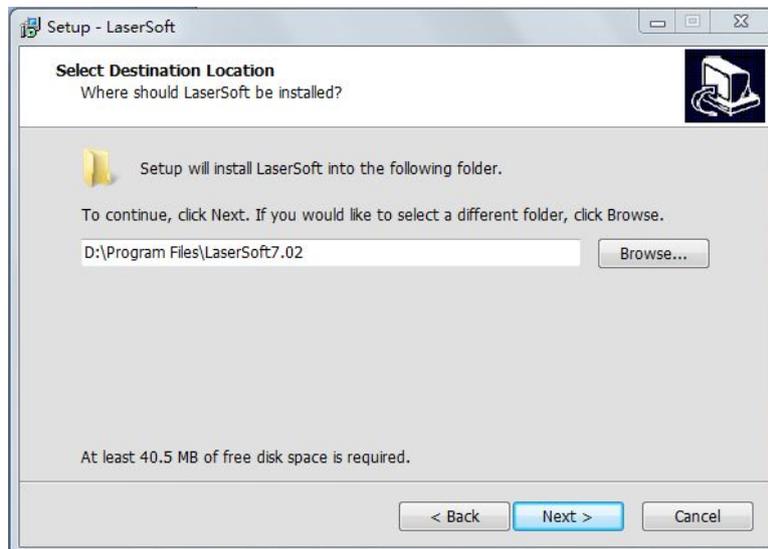
- (4) Click [Next Step] and the following dialog box will appear:



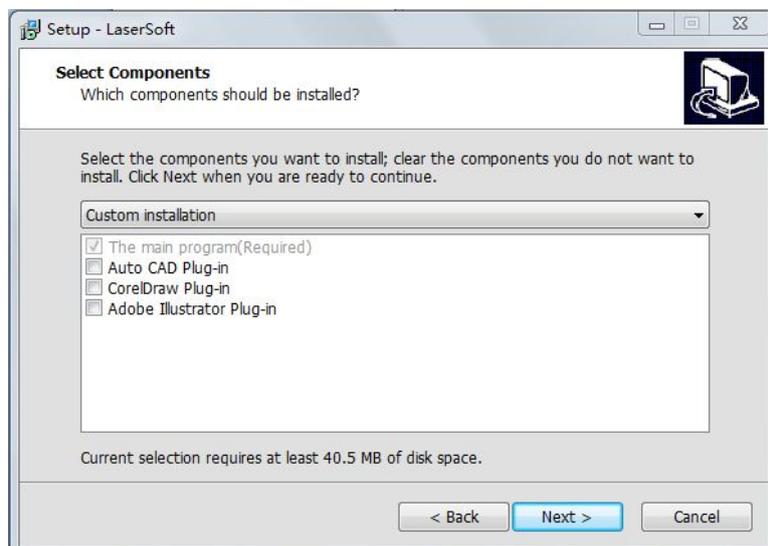
(5) Click [Completed].

## 2.2 Installing Software

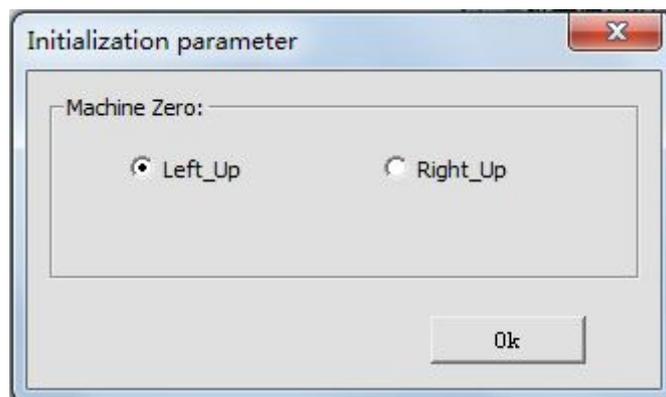
(1) Click [Install Software] and the following dialog box will appear:



(2) Click [Next >] after selecting the installation path, and the following dialog box will appear:



- (3) Click [Next >] after selecting the plug-in to be installed, and the following dialog box will appear. Select the position of original point of machine and click [OK] to enter the dialog box of software initialization. Select the position of original point of machine and click [OK].

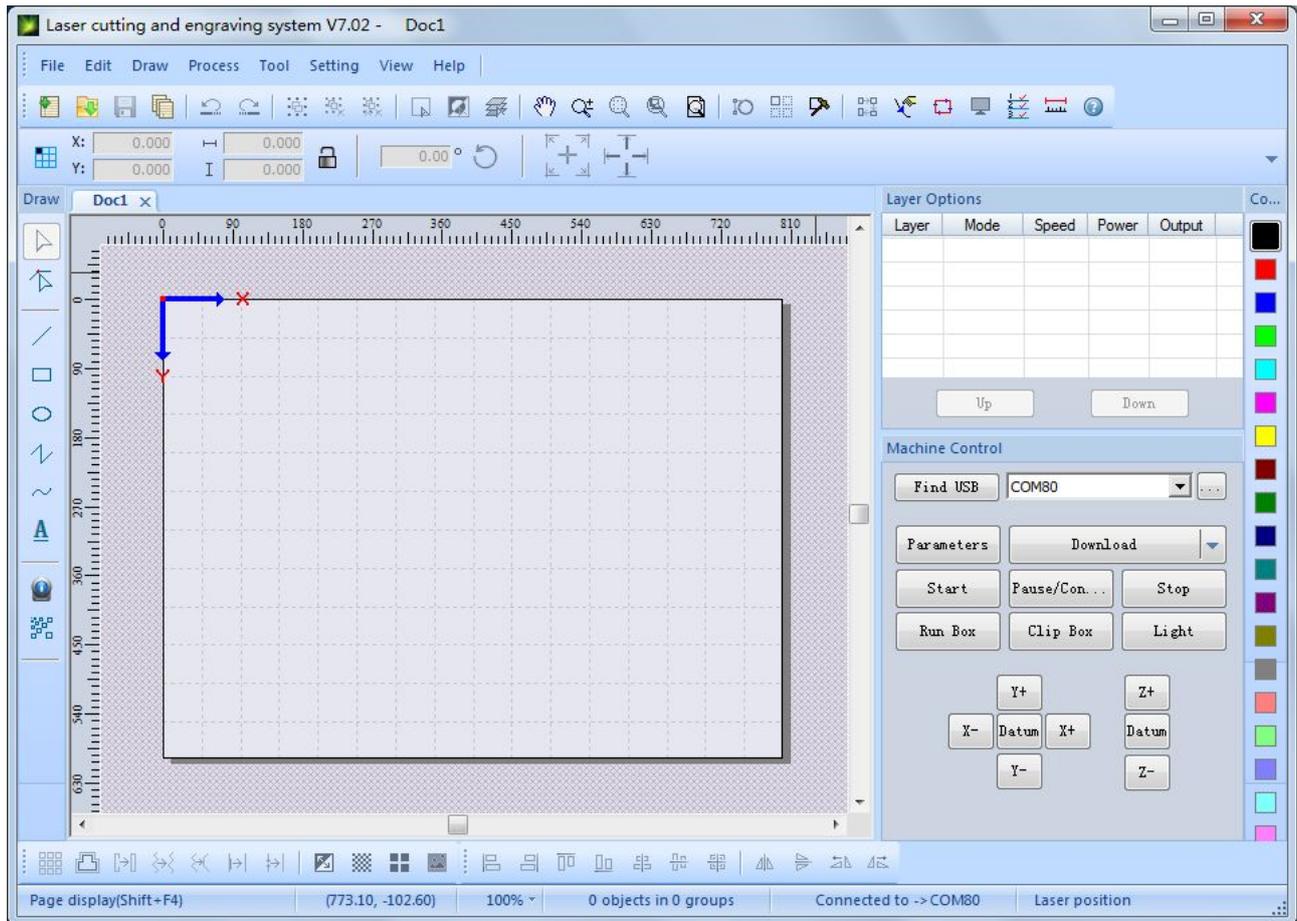


## Chapter III Basic Operation of Software

### 3.1 Main Interface of Operation

After starting the software, you will see the operation page shown below. The familiarity on such operation page

will be the base for laser machining by use of such software.



**System Menu Column:** Main functions of such software all can be completed through implementing the order option in the menu column. Implementation of menu order is the most basic operating mode; the menu column includes 8 functions: file, edit, drawing, operation, tool, setting, view and help.

**System Tool Column:** The corresponding shortcuts of common functions include new file, open/lead-in of file, file save, display/conceal of latest files, cancel, rework, group, ungroup, all groups cancel, all selection, reverse selection, select as per layer, moving tool, zooming tool, zooming of selected objects, zooming of all graphs, display as per the page, set lead line, virtual array, system setting, path optimization, manual sorting, show path, analog simulation, graph check, distance measurement and help.

**Object Attribute Column:** The position and size of selected objects and shortcut of moving function, including rotate, move to upper left, move to the uppermost, move to the upper right, move to the right-most, move to the lower right, move to the lowest, move to left lower, move to the left-most, move to the center, fine adjustment up/down/left/right and zoom.

**Drawing Tool Column:** The corresponding shortcuts of common functions in [Drawing] menu include selection, node edit, straight line, rectangle, oval, clearing, curve, text, camera and light guide plate.

**Operating Tool Column:** The corresponding shortcuts of common functions in [Operating] menu include array copy, draw-in and external expansion, closed figure, curve smoothing, node optimization, delete overlap line, combine joined line, image inverse, image hanging net, set up image block, set up image contour, left alignment, right alignment, upper alignment, lower alignment, horizontal center, vertical center, center alignment, horizontal flip, vertical overturn, turning left at 90 degrees and turning right at 90 degrees.

**Layer Tool Column:** Modifying the color of object to be selected; a color is a layer.

**Layer Attribute Column:** Displaying and setting the machining.

**Equipment Control Column:** Using the control panel to complete several tasks of laser machining, including the setting of communication mode, graph loading and operation to machine, etc.

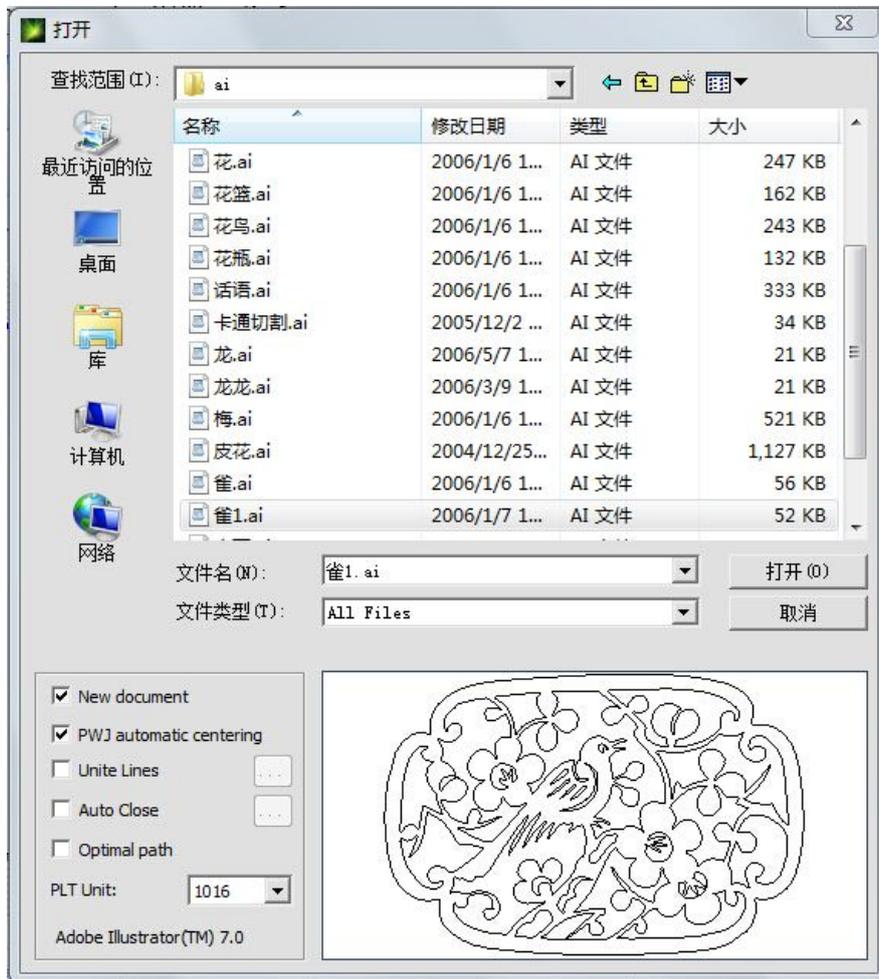
## 3.2 File Menu

### 3.2.1 New

Click the [File]/[New] in the menu column, or click the new icon  on system tool column, or press Ctrl+N to create new machining file.

### 3.2.2 Open/Import

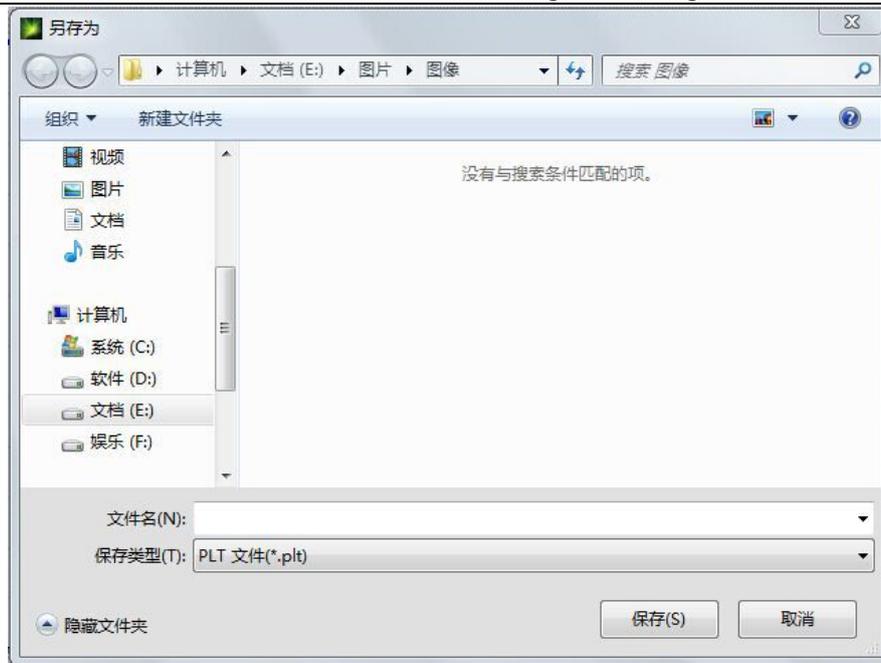
(1) Click [File]/[Open] in the menu column, or click  on system tool column, or press Ctrl+O, and the following dialog box will appear:



(2) Select the file to be opened and then click [Open].

### 3.2.3 Export

Click [File]/[Export] in the menu column or press Ctrl+E, and then the dialog box of lead-out will appear. Input the file name, and then click the button [Save] to lead out the graph in the software into the file in the format of PLT.

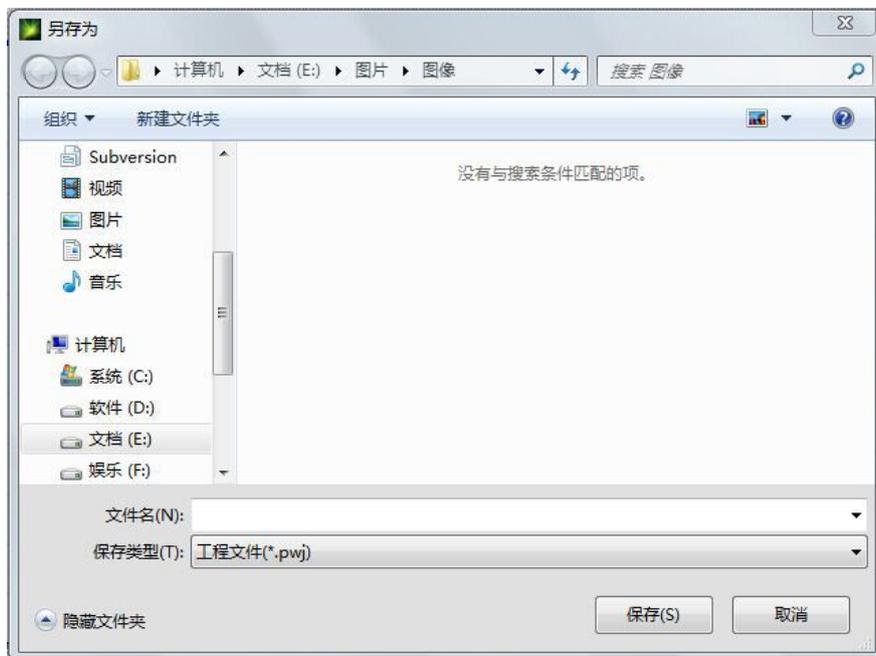


### 3.2.4 Save

Click [File]/[Save] in the menu, or click  in the system tool column to open the icon, or press Ctrl+S, fill in the save name, select the save controls, and click save to save the file in the format of PWJ. If the file opened currently is not in the format of PWJ, the function “Save As” will be auto-called.

### 3.2.5 Save As

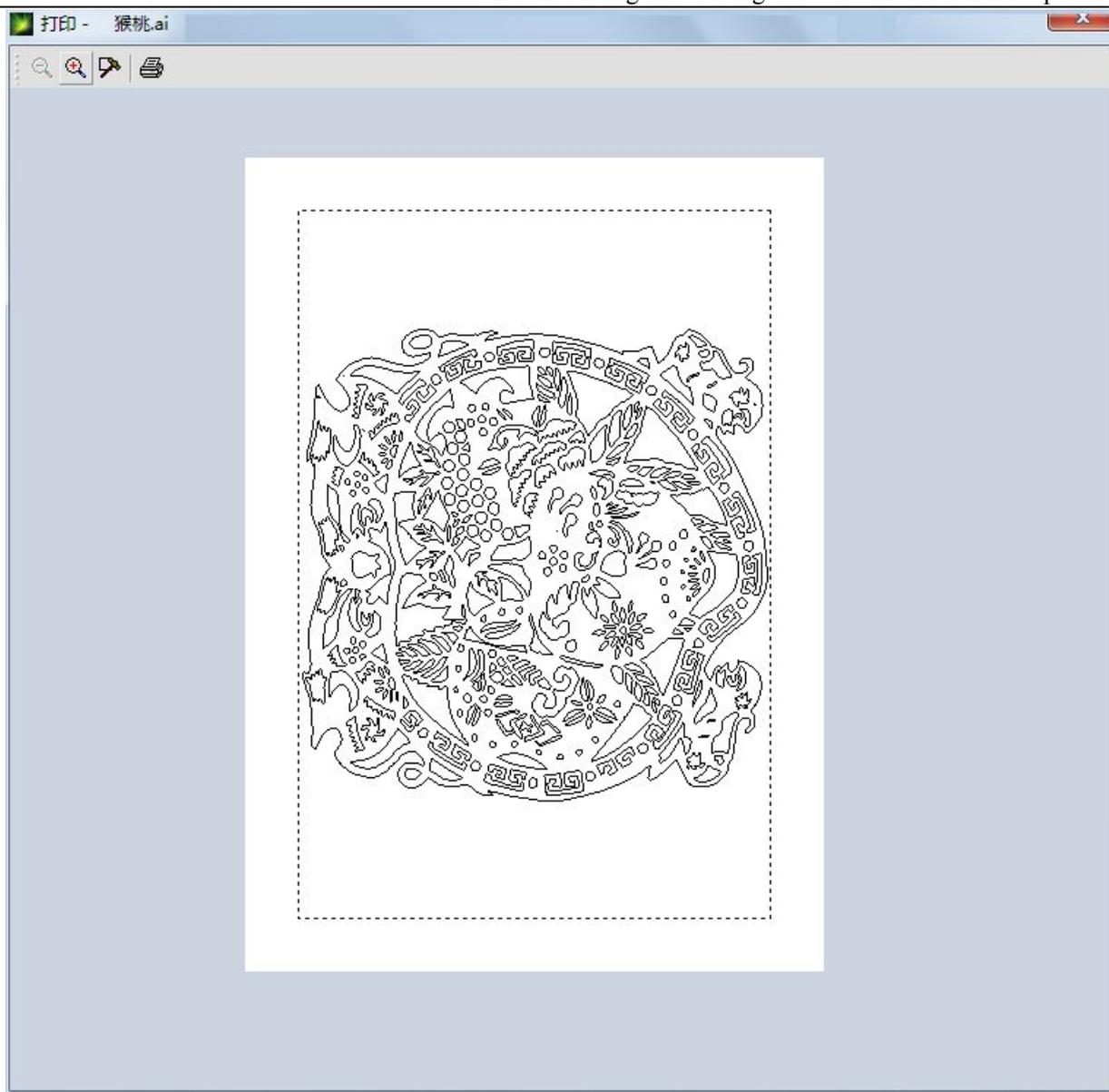
(1) Click [File]/[Save As] in the menu column, or press Ctrl+Shift+S, and the following dialog box will appear:



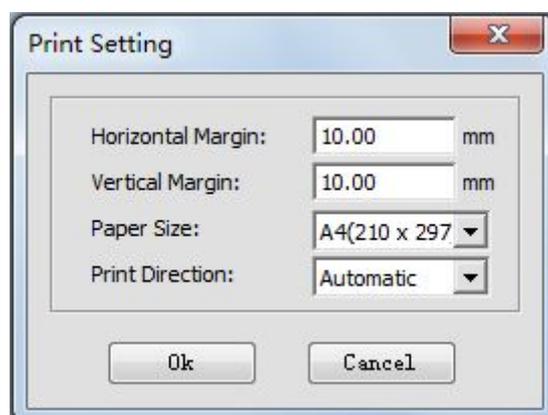
(2) Input the file name in the file name editing box, and then click [Save].

### 3.2.6 Print

(1) Click [File]/[Print] in the menu column, or press Ctrl+P, and the following dialog box will appear:



(2) Click the button  and the print setting window will pop up. See the figure below:



(3) Click the button  for printing

### 3.3 Edit Menu

#### 3.3.1 Undo

Click [Edit]/[Undo], or click the icon  in the system tool column, or press Ctrl+Z to return to the state of previous edit.

#### 3.3.2 Redo

Click [Edit] / [Redo], or click the icon  in the system tool column, or press Ctrl+Y to recover to the state at previous step.

#### 3.3.3 Cut

Select the graph to be cut and click [Edit]/[Cut] or press Ctrl+X.

#### 3.3.4 Copy

Select the graph to be copied and click [Edit]/[Copy] or press Ctrl+C.

#### 3.3.5 Paste

Select the graph copied/cut and click [Edit]/[Paste] or press Ctrl+V.

#### 3.3.6 Delete

Select the graph to be deleted and click [Edit]/[Delete] or press the key Delete.

#### 3.3.7 Select

Click the [Drawing]/[Select] in the menu column, or click  on the edit tool column to shift to the state of “select”. At this state, you may select the object. The following is five methods to select objects.

◆ Click [Edit]/[Select All] in the menu, or click  in the edit tool column, or press Ctrl+A to select all objects.

◆ Click to select single object by mouse, and other objects are in non-selected state.

◆ Box the objects (internal selection/cross selection)

Internal selection: Press the mouse and drag it, and the object in the box completely will be selected.

Cross selection: Press the mouse and drag it, select the box in the box completely and all objects in contact with it will be selected.

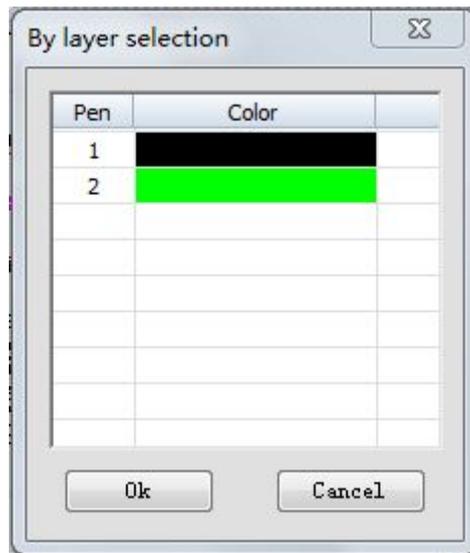
◆ Add selected object/ subtract selected object

Add: Press Ctrl/Shift and click the unselected object, and such object becomes selected state and other objects in selected state are still in selected state.

Subtract: Press Ctrl/Shift and click the selected object, and such object becomes unselected state.

◆ Select object as per layer color

Click  in the system operation column, and the following dialog box will appear:



Select the color of object to be selected, and then click [OK] and all objects in such color layer will be selected.

### 3.3.8 Reverse Selection

Click [Edit]/[Reverse Selection] in the menu column, or click the icon  in the system tool column, or press Ctrl+Shift+I, and the selected object becomes unselected state and unselected objects become the selected state.

### 3.3.9 Group

Click [Edit]/[Group] in the menu column, or click the icon  on the system tool column, or press Ctrl+G to group several selected graphs.

### 3.3.10 Ungroup

Click [Edit]/[Ungroup] in the menu column, or click column  in the system tool column, or press Ctrl+U to ungroup the selected several grouped graphs currently.

### 3.3.11 All Groups Cancel

Click [Edit]/[Cancel All Groups] in the menu column, or click the icon  in the system tool column, or press Ctrl+Shift+U to ungroup all selected grouped graphs.

### 3.3.12 Rotate

The shortcut button is as shown in the figure: 

- (1) Rotate left at 90 degrees Select the graph to be rotated and click [Edit]/[Rotate]/[Rotate Left at 90 °]
- (2) Rotate right at 90 degrees Select the graph to be rotated and click [Edit]/[Rotate]/[Rotate Right at 90 °]
- (3) Rotate vertically Select the graph to be rotated and click [Edit]/[Rotate]/[Rotate Vertically].
- (4) Rotate Horizontally Select the graph to be rotated and click [Edit]/[Rotate]/[Rotate Horizontally].

### 3.3.13 Alignment

The shortcut button is as shown in the figure:

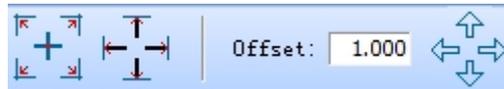


- (1) Left alignment Select the graph to be aligned, and click [Edit]/[Align]/[Left Alignment].
- (2) Right alignment Select the graph to be aligned, and click [Edit]/[Align]/[Right Alignment].
- (3) Top alignment Select the graph to be aligned, and click [Edit]/[Align]/[Top Alignment].
- (4) Bottom alignment Select the graph to be aligned, and click [Edit]/[Align]/[Bottom Alignment].
- (5) Central alignment Select the graph to be aligned, and click [Edit]/[Align]/[Central Alignment].
- (6) Horizontal center Select the graph to be aligned, and click [Edit]/[Align]/[Horizontal Center].
- (7) Vertical center Select the graph to be aligned, and click [Edit]/[Align]/[Vertical Center].

### 3.3.14 Move

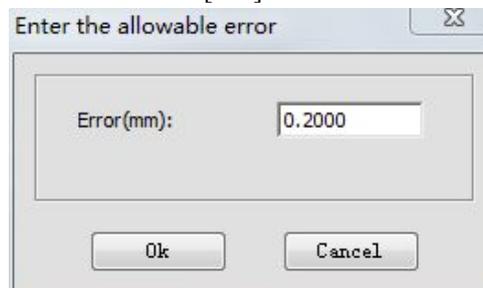
(1) Move shall be with reference to the breadth rectangle, to top left corner, top right corner, lower right corner, lower left corner, central point, left, upside, right and lower side. The shortcut button is located in the object attribute column as shown in the figure below.

(2) Fine adjusting Move tiny distance up and down or left and right. The shortcut button is located in the object attribute column as shown in the figure below.



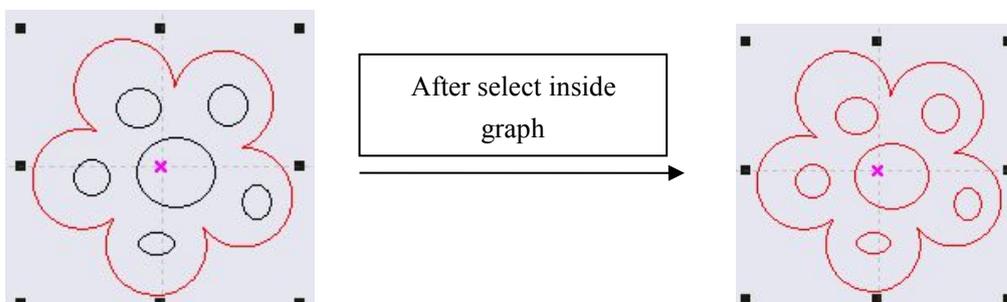
### 3.3.15 Select the same graph

Click the [Edit]/ [Select style] /[Select the same graph] in the menu column, and the following dialog box will appear. Input the parameter and click the button [OK].



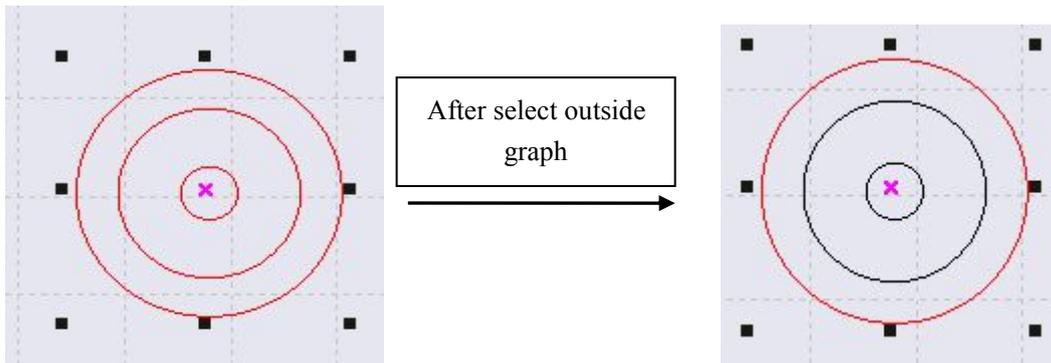
### 3.3.16 Select inside graph

Select the periphery of graph and click [Edit]/ [Select style] /[Select inside graph], And all internal graphs will be boxed as shown in the figure below:



### 3.3.17 Select outside graph

Select several graphs, and click [Edit]/ [Select style] /[Select outside graph] in the menu column, and the last graph will be selected.



### 3.3.18 Select unclosed graph

Select several graphs and click the [Edit]/ [Select style] / [Select unclosed graph], And the non-closed graph will be selected.

## 3.4 Draw Menu

### 3.4.1 Select

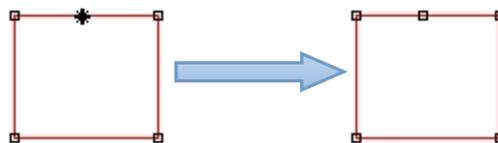
Click [Draw]/[Select] in the menu column or click  in the drawing tool column to select the graph or part of the graph to move, delete or change layer, etc. of the selected part.

### 3.4.2 Node Edit

Click [Draw]/[Node Edit], or click  in the edit tool column to enter the node edit mode.

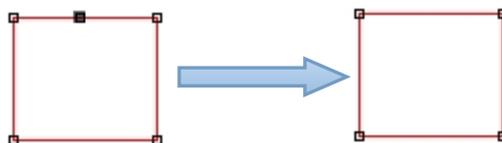
#### ◆ Add Node

Select a point on the selected object and then click  in the object tool column to add such selected point as the object node.



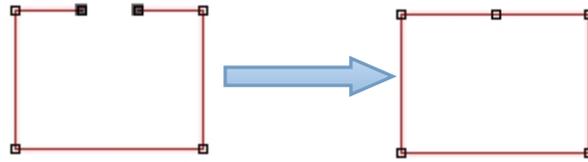
#### ◆ Delete Node

Select a node on the selected object and then click  in the object tool column to delete such node.



#### ◆ Connect Node

Use the mouse to select two nodes, and then click  in the object operation column to connect such two nodes.



#### ◆ Disconnect Node

Use the mouse to select a node, and then click  in the object operation column to disconnect such node.

#### ◆ Disconnect all nodes

Use the mouse to select two nodes, and then click  in the object operation column to disconnect all nodes.

### 3.4.3 Line

Click [Draw]/[Line] in the menu, or click  in the edit tool column. Drag the mouse on the screen to draw any straight line. Press “Ctrl” and drag the mouse at the same time to draw the horizontal line.

### 3.4.4 Polyline

Click [Draw]/[Polyline] In the menu column, or click the edit tool column . Drag the mouse on the screen and click the mouse to draw any line.

### 3.4.5 Rectangle

Click [Draw]/[Rectangle] In the menu column, or click  in the edit tool column. Drag the mouse on the screen to draw a rectangle of any size. Press “Ctrl” and drag the mouse at the same time to draw a square.

### 3.4.6 Ellipse

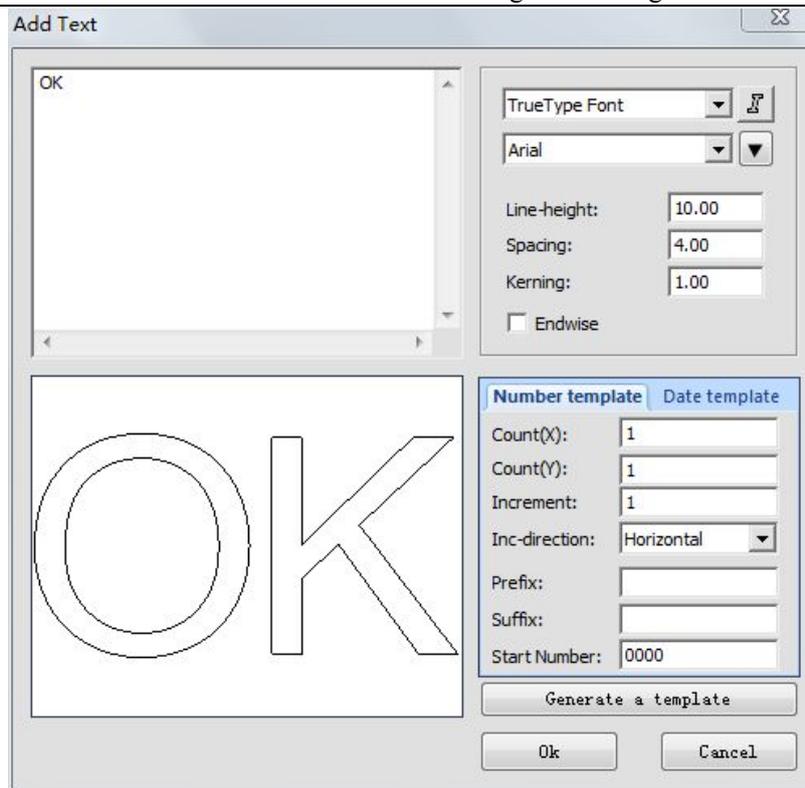
Click [Draw]/[Ellipse] In the menu column, or click  in the edit tool column. Drag the mouse on the screen to draw an oval of any size. Press “Ctrl” and drag the mouse at the same time to draw a perfect circle

### 3.4.7 Bezier Curve

Click [Draw]/[Bezier Curve] in the menu column, or click  in the edit tool column. Drag the mouse on the screen and click the mouse to draw the Bezier curve.

### 3.4.8 Text

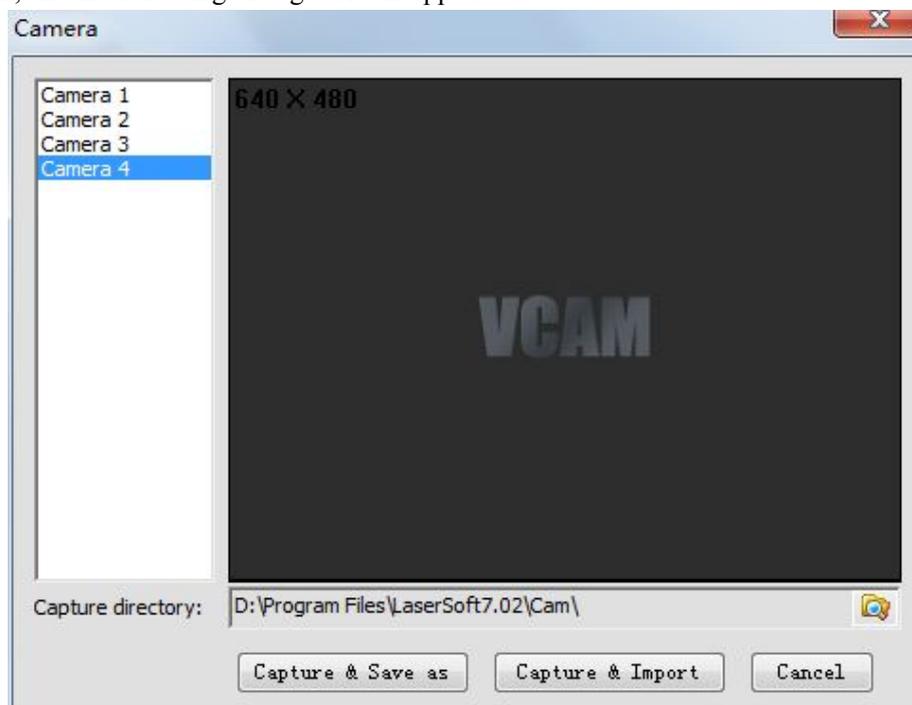
Click [Draw]/[Text] in the menu column, or click  in the edit tool column. Double click the mouse left on the screen, and the following dialog box will appear:



Select the Font, input or select the font size, and then input the text. Then, click [OK].

### 3.4.9 Camera

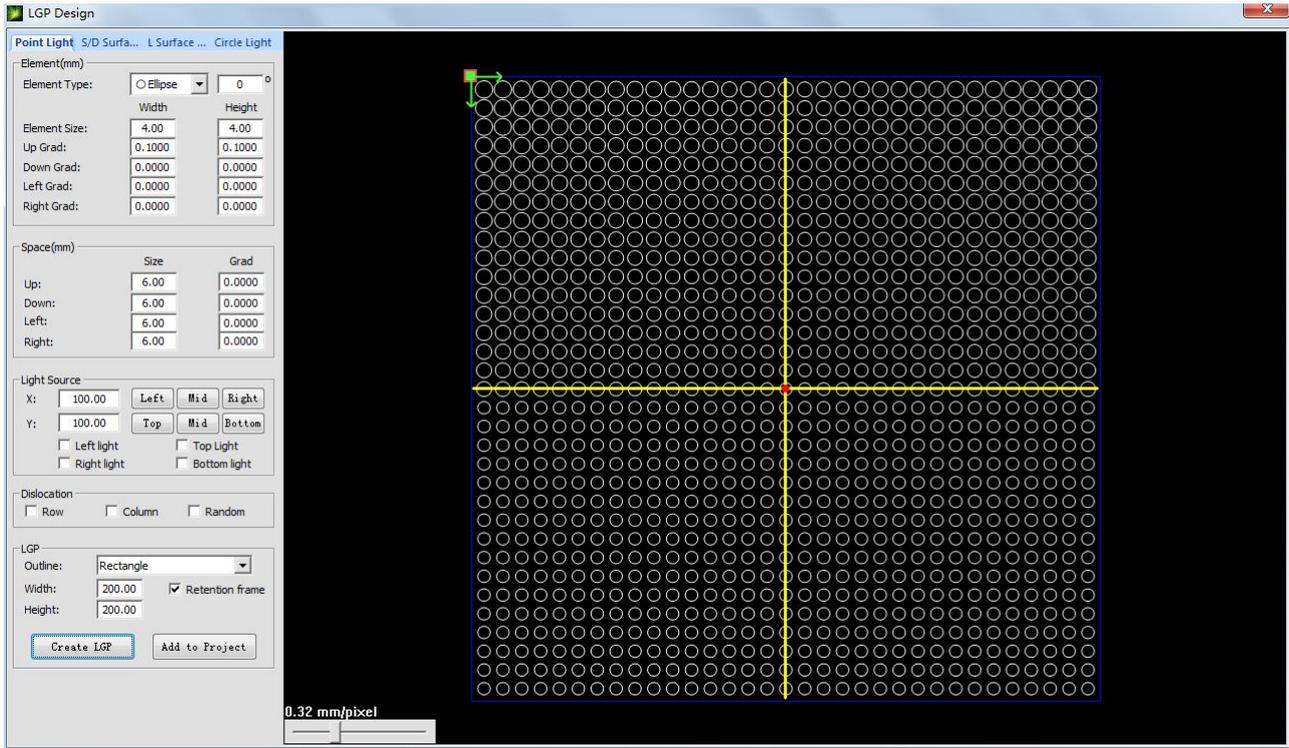
Click [Draw]/[Camera] in the menu column, or click  in the edit tool column. Double click the mouse left on the screen, and the following dialog box will appear:



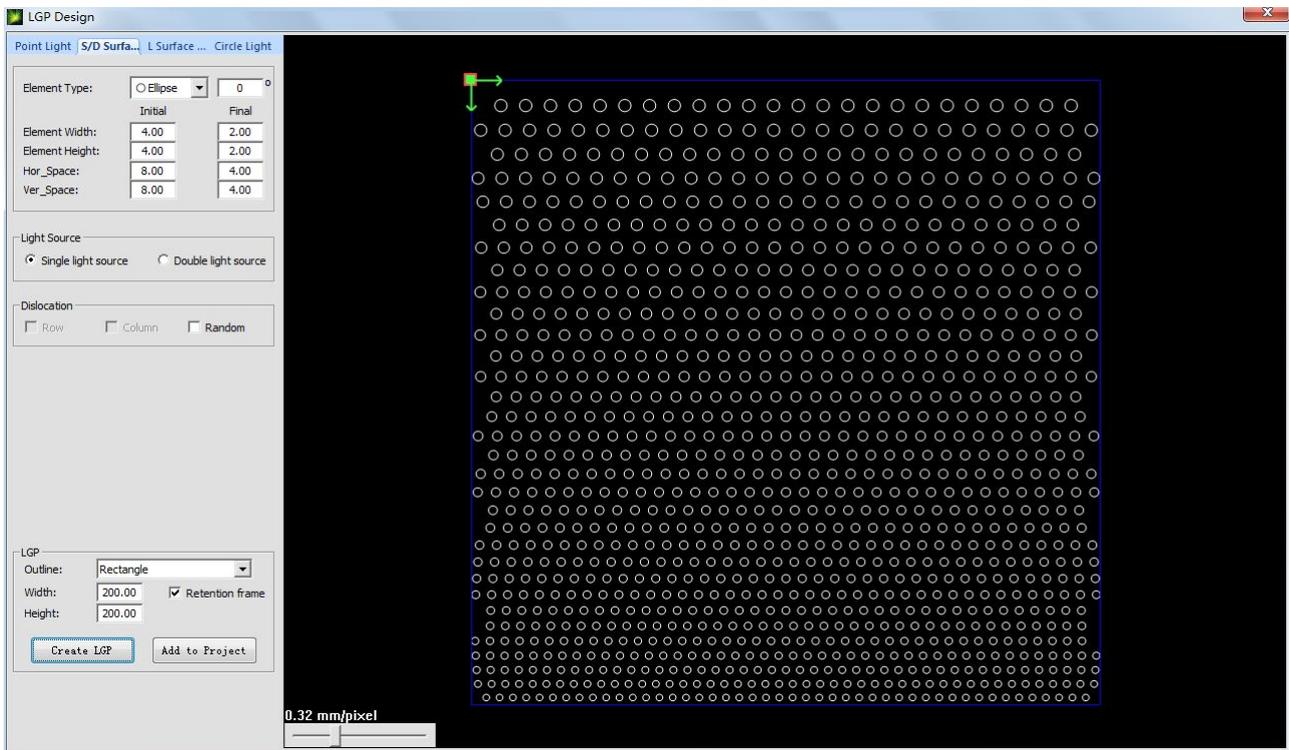
### 3.4.10 LGP Design

Click [Draw]/[LGP Design] in the menu column, or click  in the edit tool column, and the light guide plate design window will pop up.

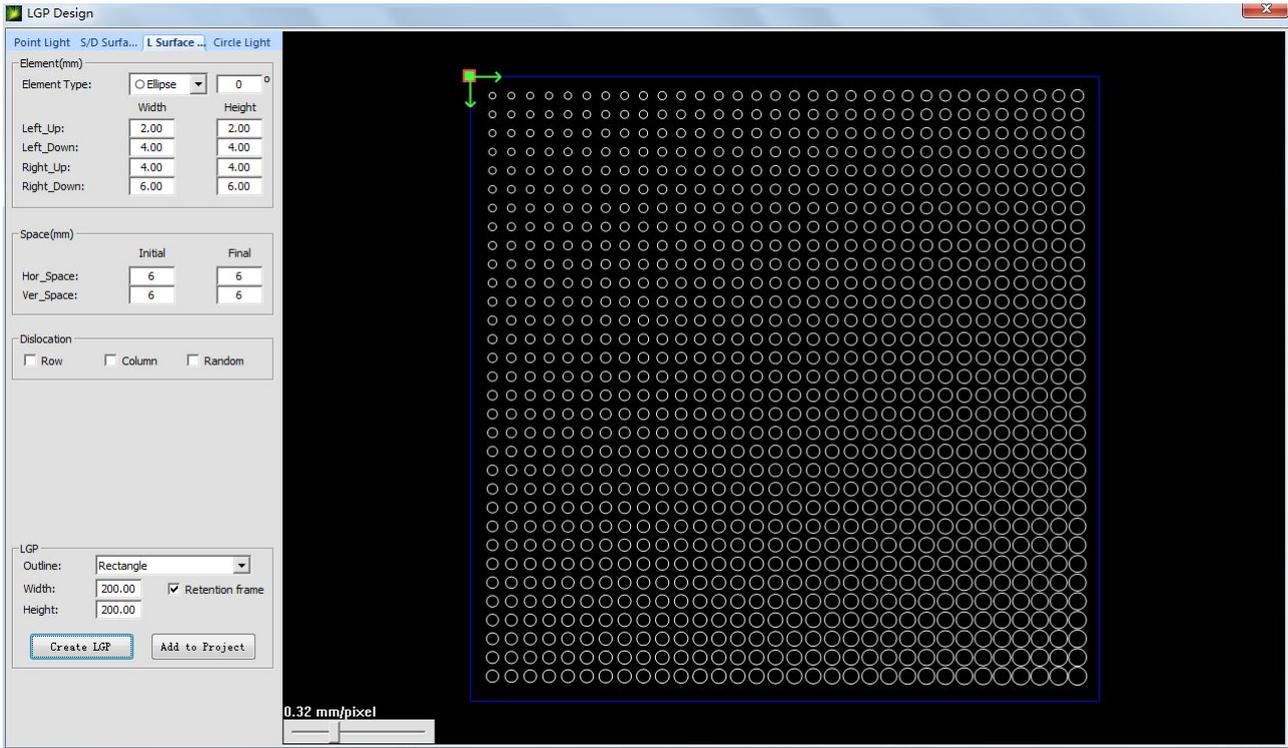
◆ Point Light Source



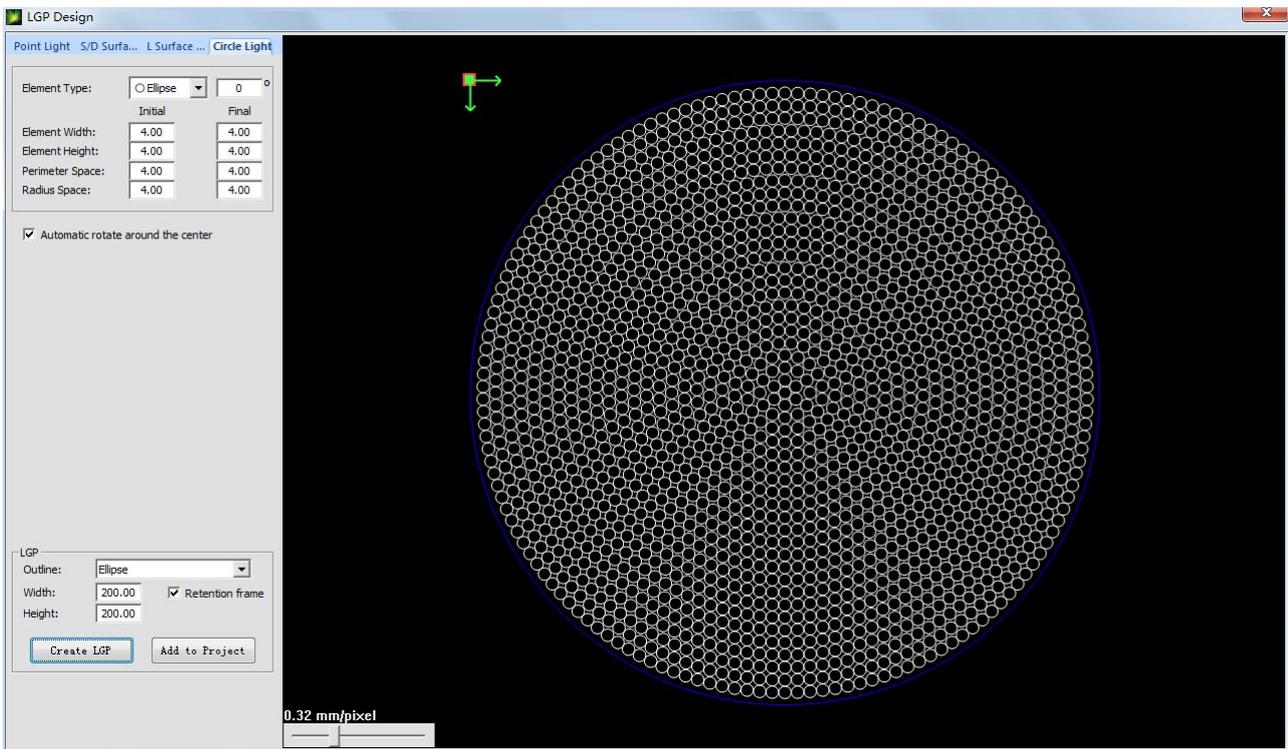
◆ Single/Double-Faced Light Source



◆ L Area Light Source



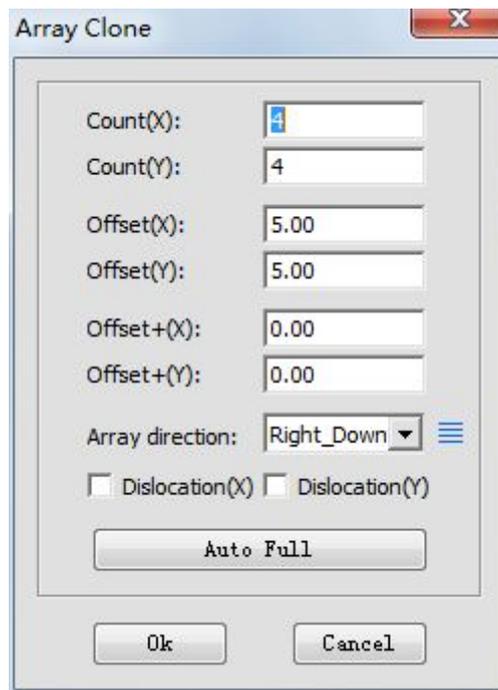
◆ Center Light Source



3.5 Operation Menu

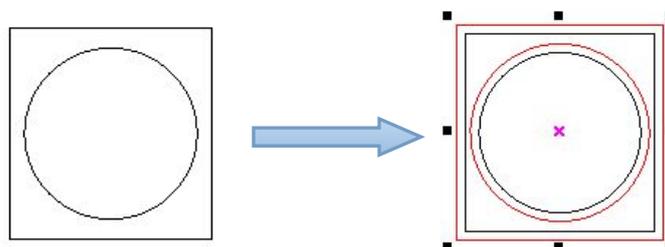
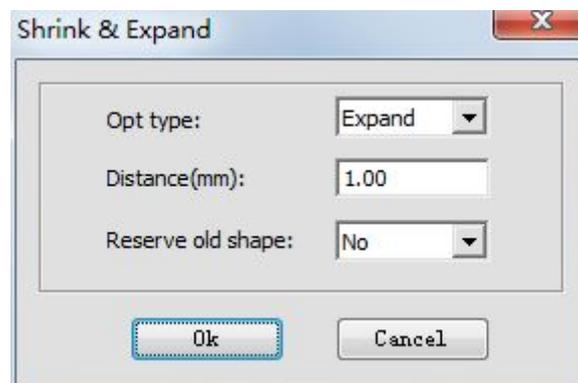
3.5.1 Array Copy

Select the object to be treated, and then click [Operation]/[Array Copy] in the menu column, or click  in the operation tool column, and the array copy window will pop up. Click “OK” after inputting the parameters



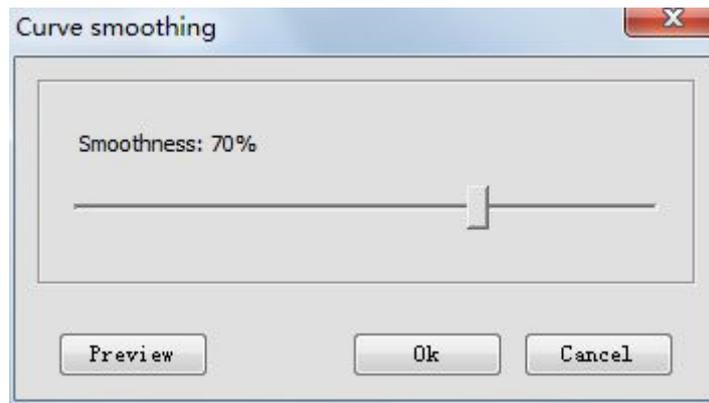
### 3.5.2 Shrink & Expand

Select the object to be treated, and then click [Operation]/[Shrink & Expand] in the menu order, or click  in the operation tool column, and the following dialog box will appear. Input the parameter and click [OK].



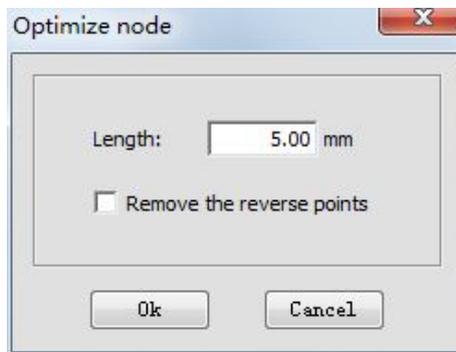
### 3.5.3 Curve Smoothing

Click [Operation]/[Curve Smoothing] in the menu column or click the icon  in the operation tool column, and the adjusting window of curve smoothing will appear. The larger the smoothing degree is, the graph is smoother and the corresponding graph is more distorted.



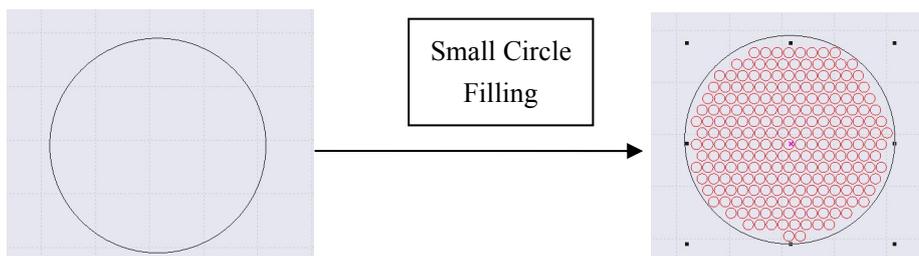
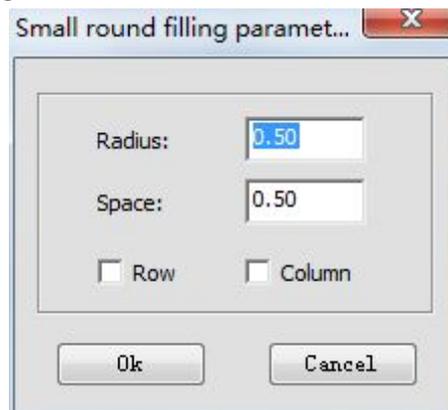
### 3.5.4 Node Optimization

Click [Operation]/[Node Optimization] in the menu column or click the icon  in the operation tool column, and the node optimization window will pop up. Input the parameter and click [OK]. The larger the optimization degree is, the graph is smoother and the corresponding graph is more distorted.



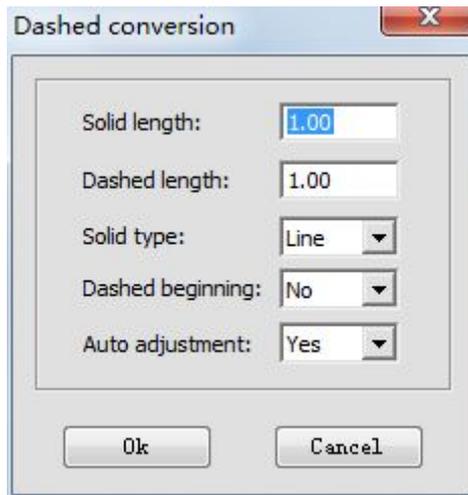
### 3.5.5 Small Circle Filling

Select the graph to be filled (it must be closed graph), click [Operation]/[Advance]/[Small Circle Filling], fill in the parameter of small circle filling and click “OK”.

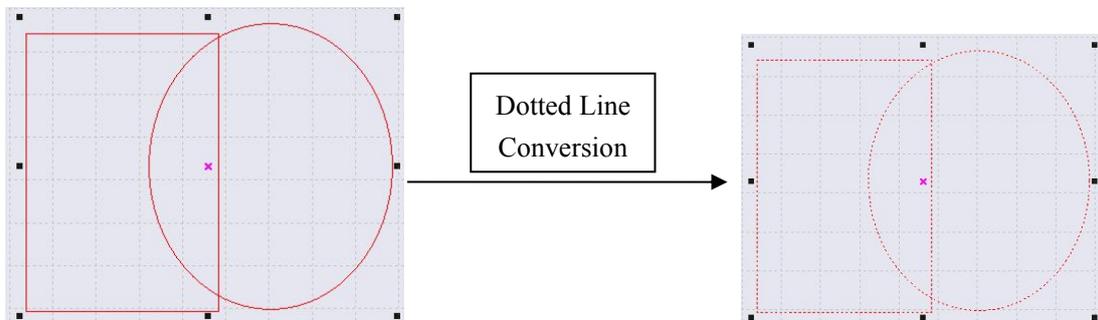


### 3.5.6 Dashed Conversion

Select the graph and click [Operation] / [Advance] / [ Dased Conversion], as shown in the figure below:



As shown in the figure below, fill in the data as per your own need:

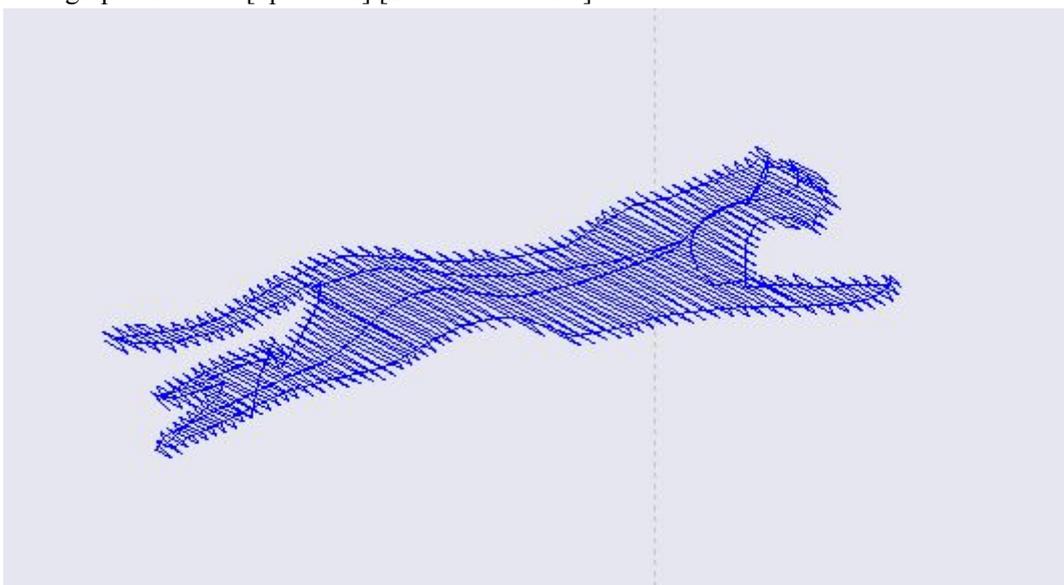


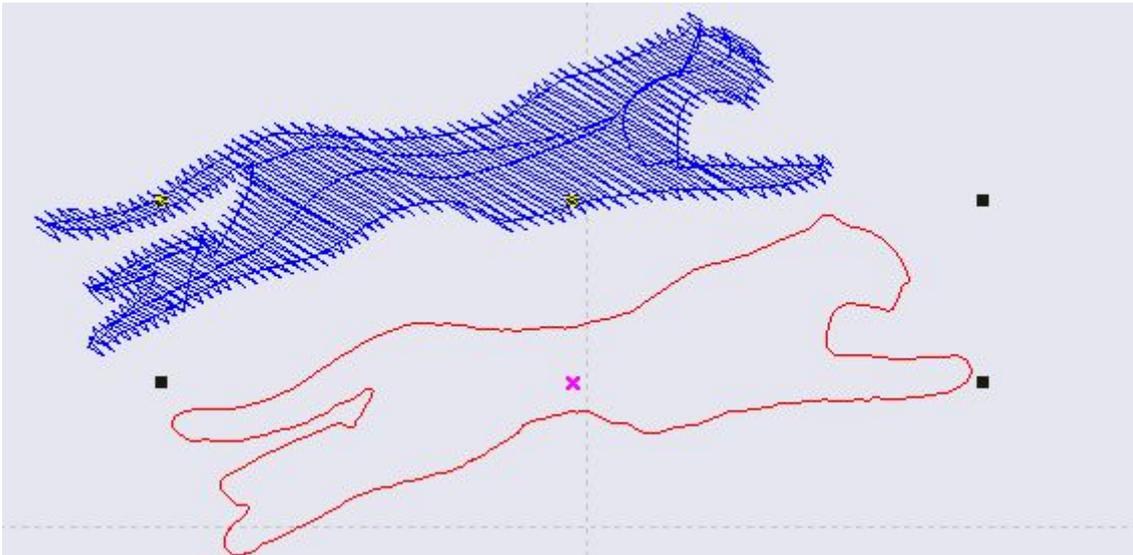
### 3.5.7 Approximate Circle Conversion

Composite the graph of approximate circle into circle to make the cutting smoother. Select the graph, and click [Operation] / [Advance] / [Approximate Circle Conversion].

### 3.5.8 DST Contour Line

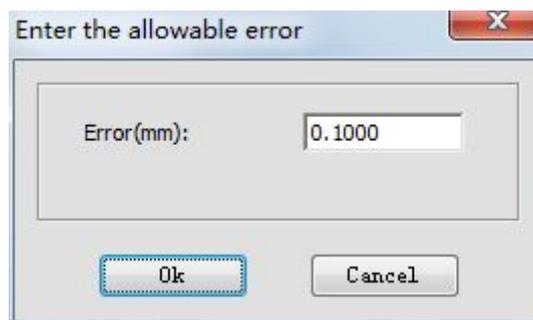
Select the graph and click [operation] / [DST contour line]





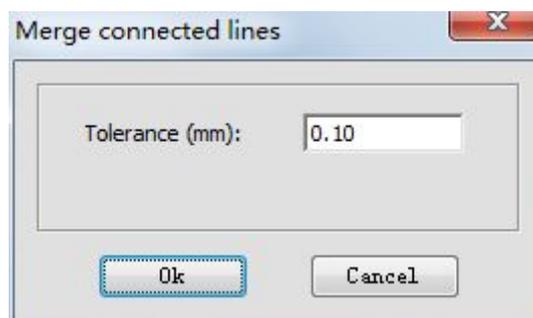
### 3.5.9 Delete Overlap Line

When the overlap ratio of two straight lines is good, the overlap line can be deleted and the overlapping deviation shall not be set too large generally, for fear that delete by mistake is caused. Click the [Operation]/[Delete Overlap Line] in the menu column, the following dialog box will appear. Input the allowed deviation and click [OK].



### 3.5.10 Combine Joined Lines

Combine multiple line segments joined into a line segment. Click [Operation]/[Combine Joined Lines] in the menu column, and the following dialog box will appear. Input the allowed error and click [OK].



### 3.5.11 Set Lead Line

The lead line function refers to leading out of the open knife and close knife in cutting some articles with high accuracy. Click [Operation]/[Set Lead Line] in the menu column, the following window will appear at the left/right side of main window. Input the corresponding parameter, and click [Apply into Selected Graph] or [Apply into All Graphs].

**Lead line setting**

Cut-in     Cut-out

Lead-in Line

Type:     Line     Arc

Len Length:    2.00    mm

Line Angle:    0.00    °

Arc Radius:    5.00    mm

Arc Angle:    60.00    °

Lead-out Line

Type:     Line     Arc

Len Length:    2.00    mm

Line Angle:    0.00    °

Arc Radius:    5.00    mm

Arc Angle:    60.00    °

Applied to the selected

Apply to all

[Lead-in line]: Lead in a line segment/arc from the cutting start point.

[Lead-out line]: Lead out a line segment/arc from the cutting end point.

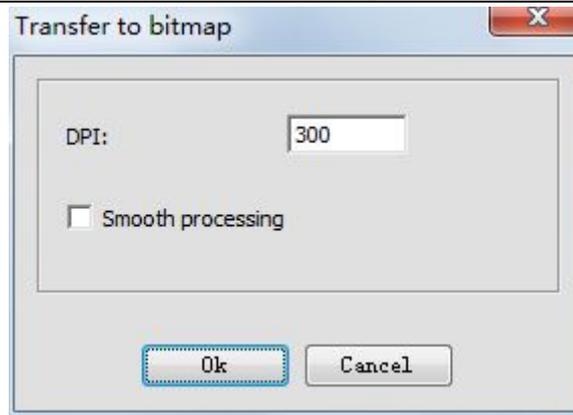
[Concave cut]: When the lead line is in the graph and multi-layer is connected, the concave and convex will be shifted automatically with the outermost layer as the benchmark.

[Convex cut]: When the lead line is outside the graph and multi-layer is connected, the concave and convex will be shifted automatically with the outermost layer as the benchmark.

After the lead line is generated, you may use the mouse to edit in the main window.

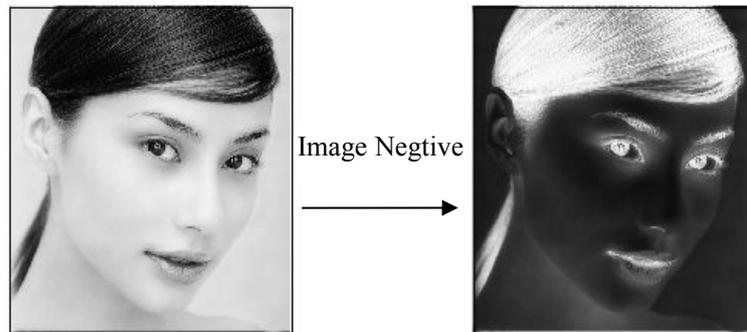
### 3.5.12 Covert Graph into Image

Select the graph to be converted, click [Operation]/[ Covert Graph into Image] and the following window will pop up. Input the parameters and click [OK].



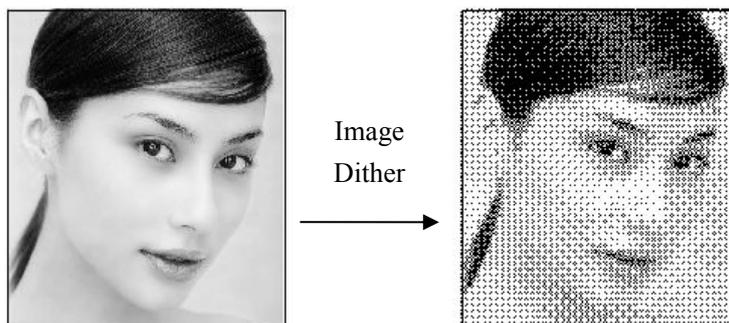
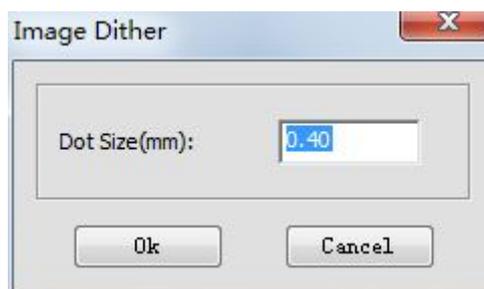
### 3.5.13 Image Negative

Select the bitmap object to be treated with inverse and click [Operation]/[Image Negative] in the menu or click  in the operation tool column.



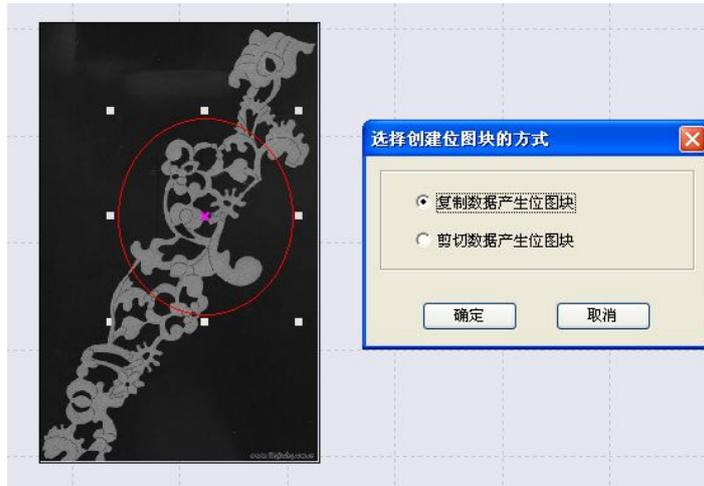
### 3.5.14 Image Dither

Select the bitmap object to be treated with hanging net, click the [Operation]/[Image Dither] in the menu column or click  in the operation tool column, and the following dialog box will appear. Input [Dot Size] and click [OK].

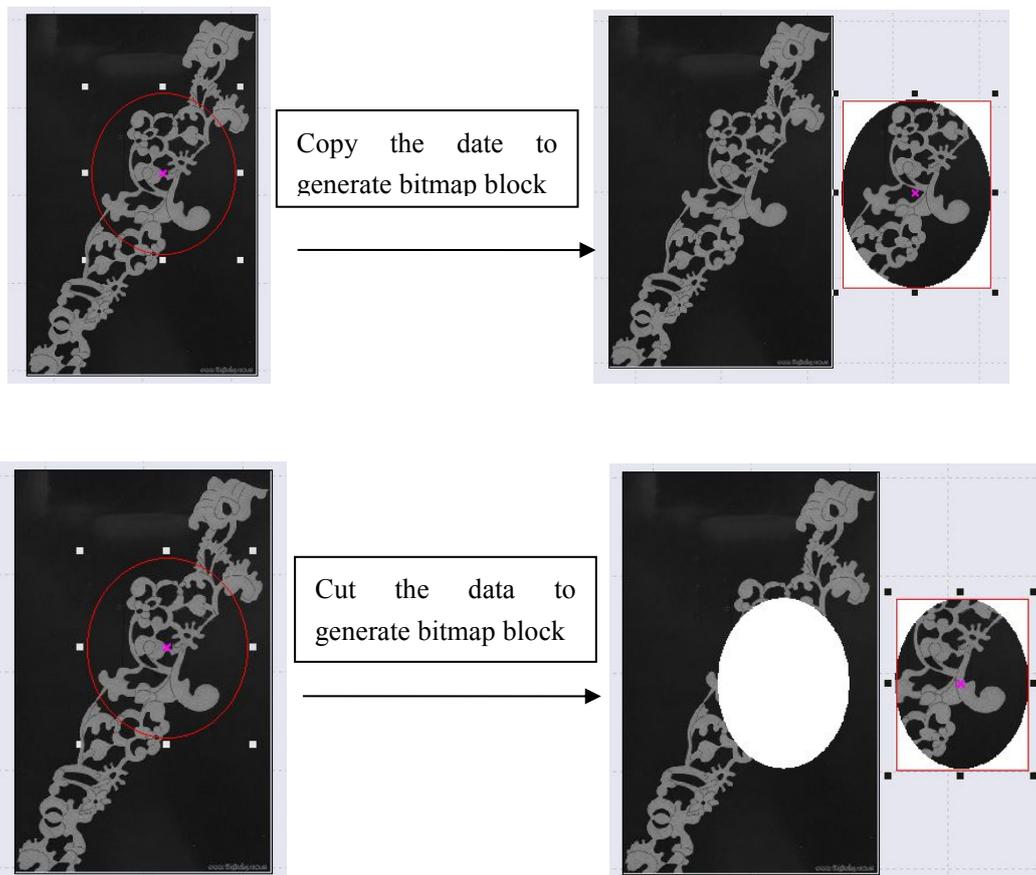


### 3.5.15 Create Image Block

Select a closed graph object (on image) and click [Operation]/[Create Image Block] in the menu column or click  in operation tool column, as shown in the figure below:

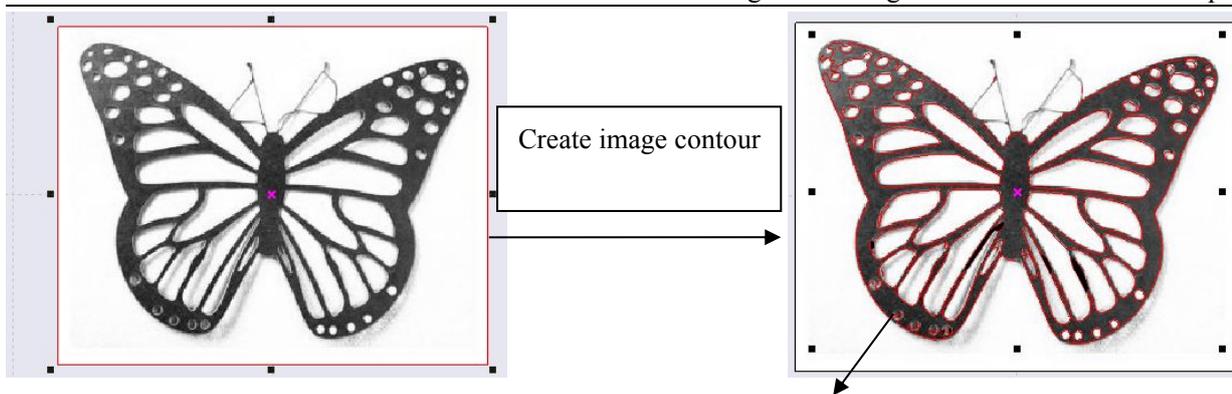


Select copy or cut as per your own need and click the button “OK”, as shown in the figure below:



### 3.5.16 Create Image Contour

Select the carving image, and click [Operation]/[Create Image Contour] in the menu column or click the icon  in the operation tool column, as shown in the figure below:

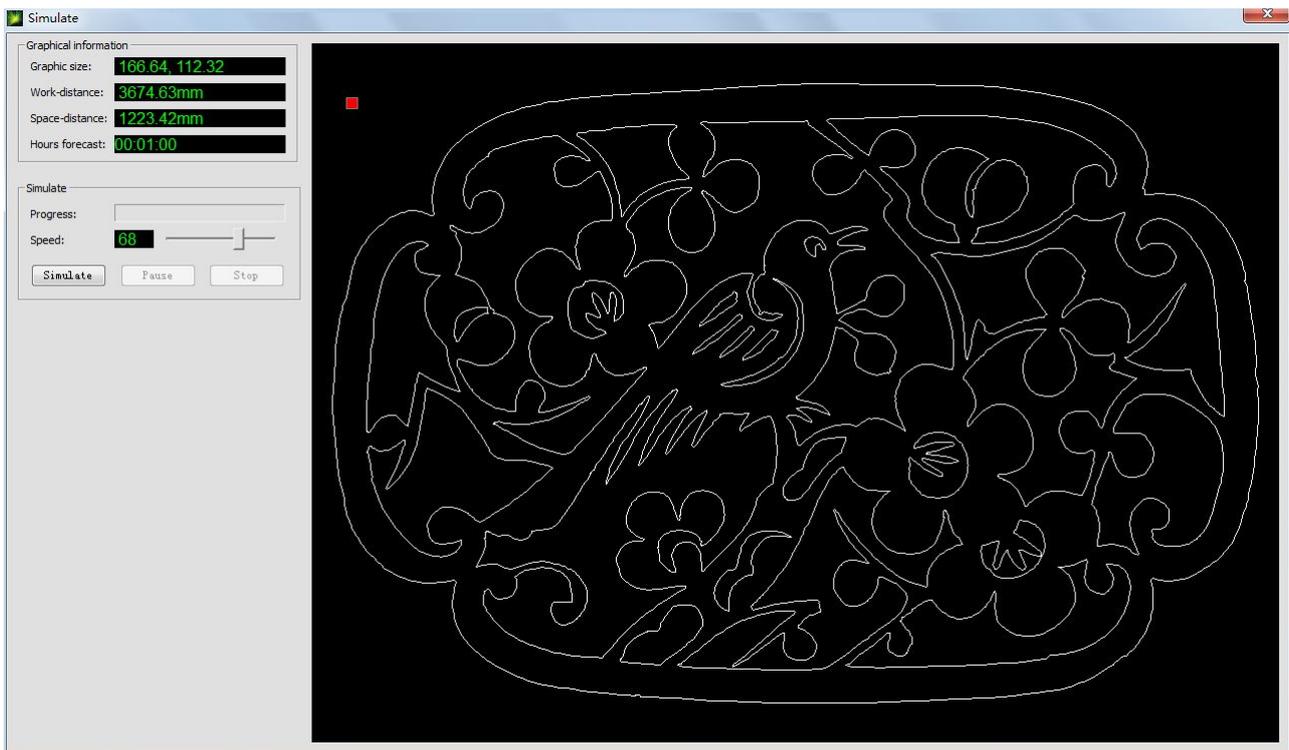


### 3.6 Tool menu

#### 3.6.1 Simulate

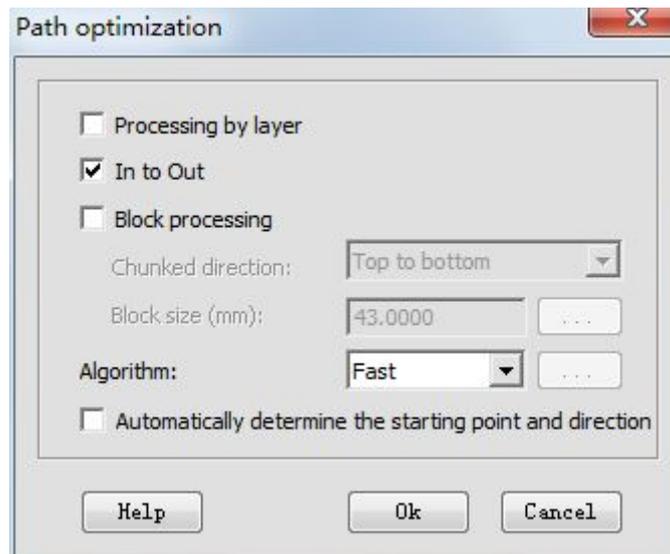
Simulation is to simulate the graphics processing operation. By simulation loading, simulation data like in actual processing can be obtained, such as processing time, processing path and distance.

Click on menu bar [Tool] / [Simulate] or click on system toolbar icon  or press F5, popup simulation window appears.



#### 3.6.2 Automatic sorting

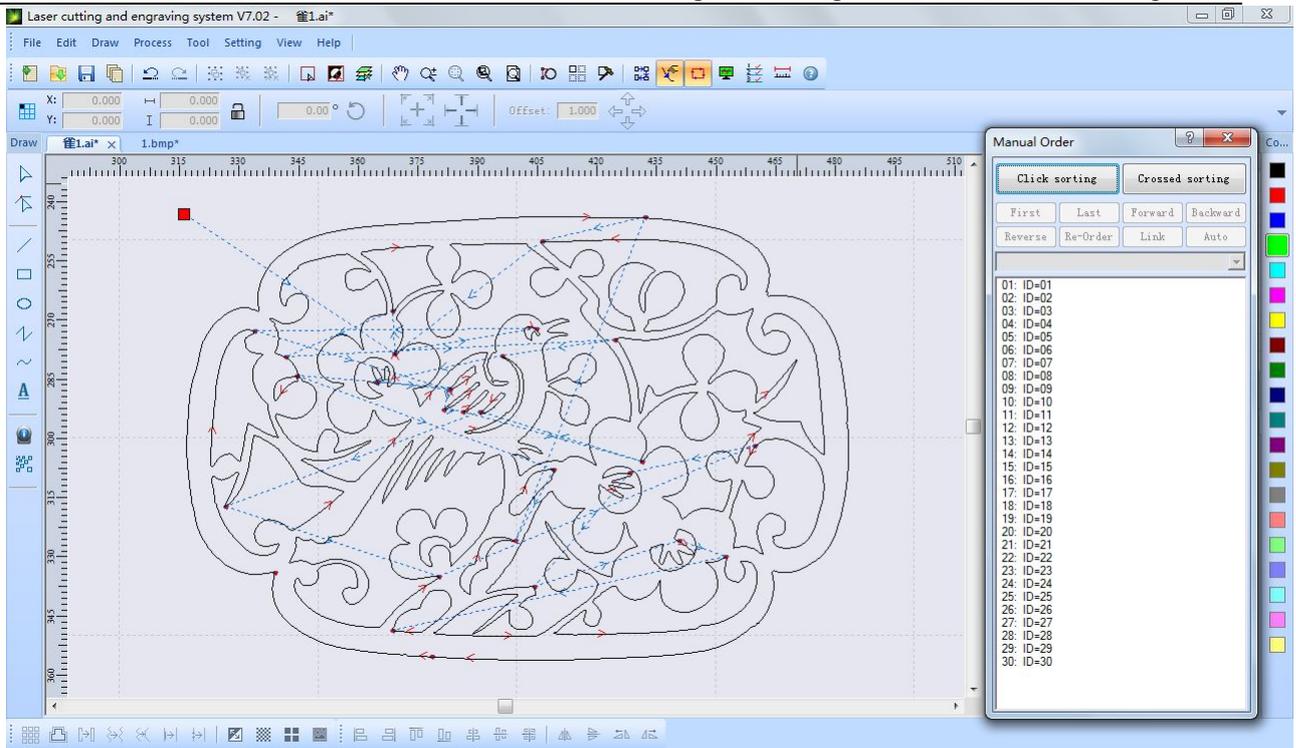
It is used to automatically arrange the processing sequence of all objects in current document. Click on menu bar [Tool] / [Automatic sorting] or click on system toolbar . As shown in the figure below:



- Select [**Processing by layer**]; when laser cutting, process the graphics of some color first, then process the graphics of other color.
- Select [**In to out**]; When laser cutting, process the graphics inside first, then process the graphics outside.
- Select [**Automatically Determine the starting Point and direction**]; When arrange the graphics, automatically determine the starting point and direction of graphics cutting.
- Select [**Block processing**], the graphics will be arranged in given [split field direction] according to [Size of Block], respectively including from top to bottom, from bottom to top, from left to right, from right to left. [Process in Blocks] is commonly used to arrange regular array of graphics, several options at this time [Size of Block] is set as the height of single graphics in array; [Block processing] can also be used to arrange the graphics with a large amount of data.

### 3.6.3 Manual sorting

Users can use [Manual sorting] to artificially set the cutting serial number of each object in graphics, starting point and cutting direction. Click on menu command [Tool]/ [Manual sorting] or click on system toolbar . As shown in the figure below:



◆ Change cutting serial number of object

(1)Single graphics operation                      Select one graphics, then this graphics can be moved to the [First], [Forward], [Back], [Last].

(2) Multiple graphics operation                  Select multiple graphics, then these graphics can be [Connected], [Inverted], [Automatic] sequenced.

(3)List graphics operation                      Select one graphics in the list and drag to another row, then its processing sequence will be changed.

(4)Sequencing by click                          Click on [Sequencing by Click], then click the graphics in view area according to the processing sequence; first click, first process. It is easy to operate.

(5)Sequencing by row                          Click on [Sequencing by Row], then click the mouse and row in the view area. The graphics first rowed will be processed first. During operation, the mouse can be released. Press again to continue, also the selected graphics can be canceled by the right mouse button.

◆ Cutting starting point

The cutting starting point of object is shown as “■”. Click on the object path can change change the cutting starting point of the object.

◆ Cutting direction

The cutting direction of object is shown as “↖”. The direction of the arrow indicates the cutting direction. Click on [Inverted] can make the cutting direction contrary to the original.

**3.6.4 Adjust the direction of starting point (idle line minimum)**

Without changing the processing order of the graphics, taking the idle line between two graphics minimum as the principle, automatically change the starting point and direction of each graphics.

**3.6.5 Adjust the direction of starting point (gap compensation)**

Without changing the processing order of the graphics, taking the idle line between two graphics with a close to 45 degree angle to the horizontal line as the principle, automatically change the starting point and direction of each graphics.

### 3.6.6 Move

Click on menu bar [Tool] / [Move] or click icon  on system toolbar, or press the right mouse button, move and display current view.

### 3.6.7 Zoom

Click on menu bar [Tool] / [Zoom] or click icon  on system toolbar, then click on the graphics by the left mouse button, it will be zoomed in; while click on the graphics by the right mouse button, it will be zoomed out.

### 3.6.8 Zoom the selected graphics

Click on menu bar [Tool] / [Zoom the Selected Graphics] or click icon  on system toolbar, the selected graphics will be zoomed in.

### 3.6.9 Zoom all graphics

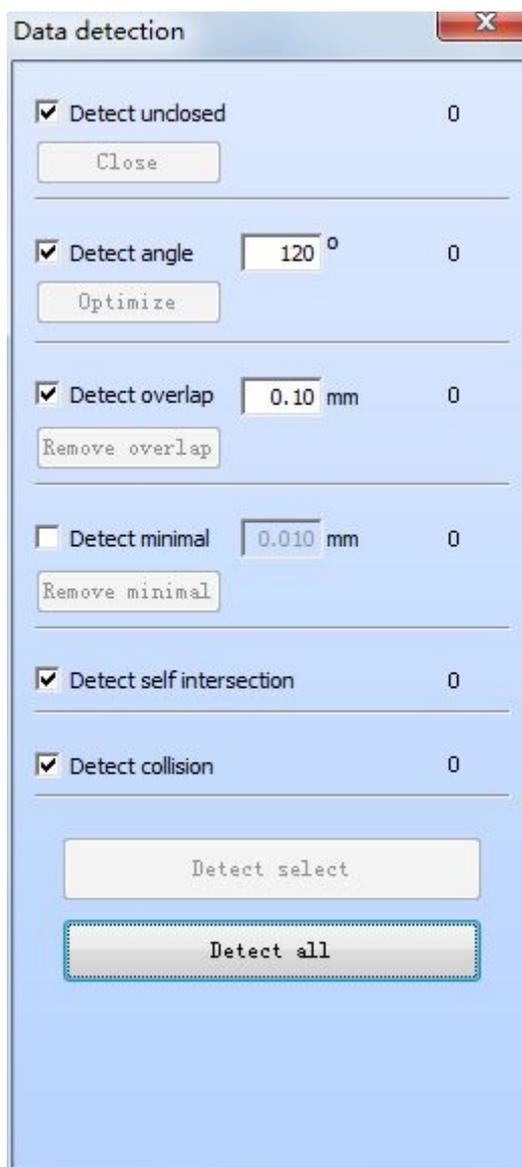
Click on menu bar [Tool] / [Zoom all Graphics] or click icon  on system toolbar, all objects can be fully displayed.

### 3.6.10 Page Display

Click on menu bar [Tool] / [Page Display] or click icon  on system toolbar, page in the graphics can be fully displayed.

### 3.6.11 Data detection

Data detection can detect the graphics overlapping, intersection, self-intersection, sharp corener and minimal graphics. Click on menu bar [Tool] / [Data Detection], or click icon  on system toolbar, popup data detection window(as the picture below),tick the object to be detected, click on [Detect the Selected Graphics] or [Detect all Graphics] , the detected graphics will be selected, and in the following picture the number of detected graphics will be displayed.



### 3.6.12 Measure

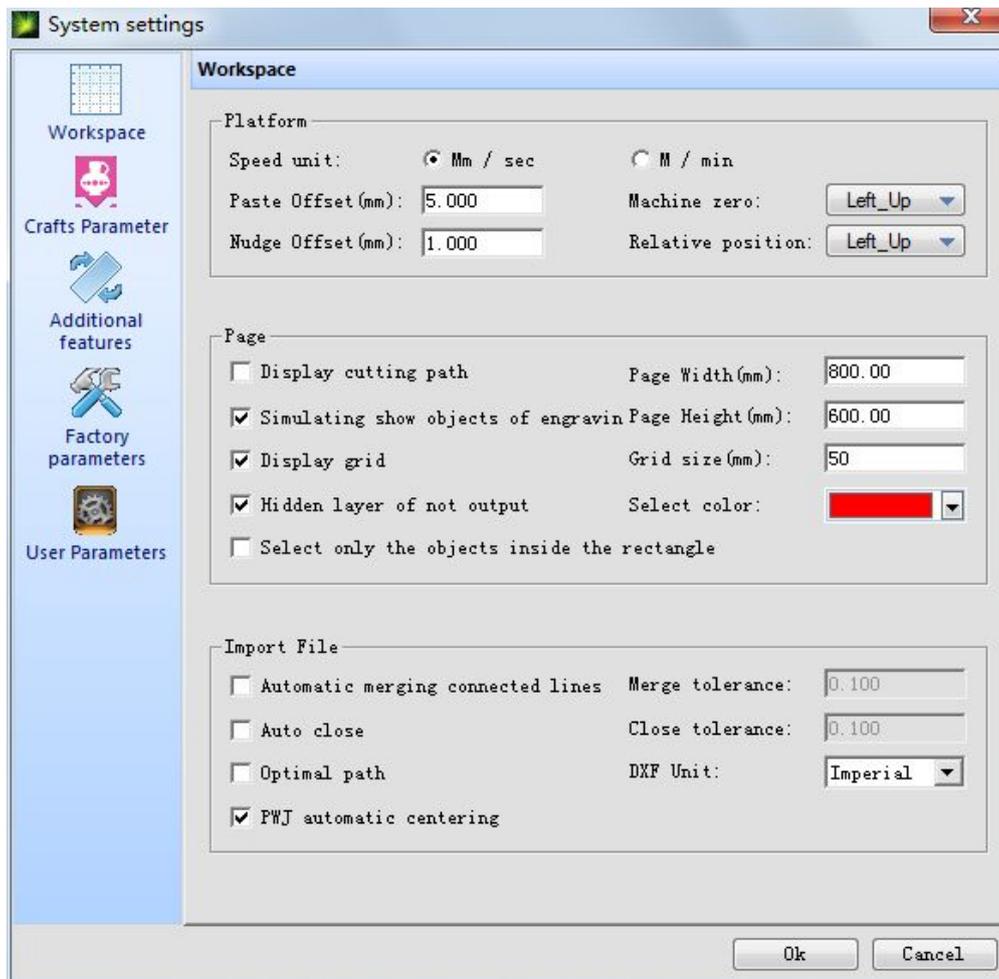
Distance measurement can measure the distance between any two points. Click on menu bar [Tool] / [Measure] or click icon  on system toolbar, enter into distance measurement mode.

## 3.7 Setting menu

### 3.7.1 System setting

Click on menu bar [Setting] / [System setting] or click icon  on system toolbar, popup system setting window.

#### ◆Workspace



### (1) Platform parameters

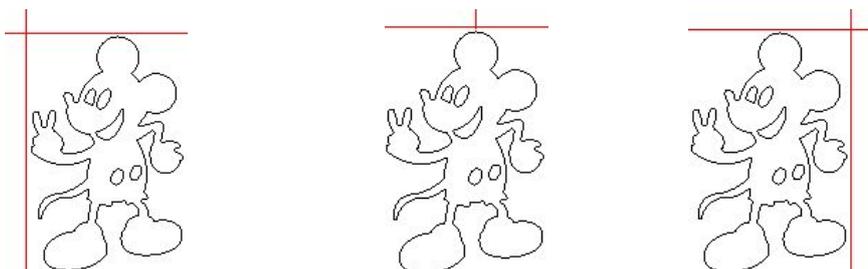
**[Speed Units]:** All speeds involved in the software, unit types used in the software.

**[Nudge Offset]:** Fill in the size according to the requirements.

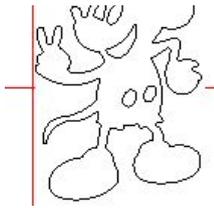
**[Paste Offset]:** Fill in the size according to the requirements.

**[Machine Zero]:** The zero position of current machine, make sure that it is consistent with the actual machine zero point. Otherwise the graphics processed may be right and left reversed or up and down reversed (pay special attention to this).

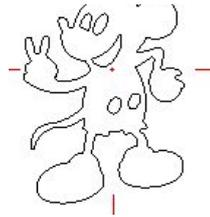
**[Relative Position]:** The position of laser head relative to the processing graphics; suggest this parameter consistent with the machine zero point. Following is the effect picture of the laser head position relative to graphics at different setting values (the crosspoint of two red lines is the laser head):



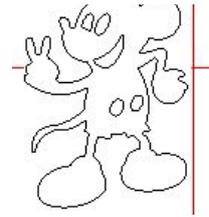
Laser head is at  
"upper left"



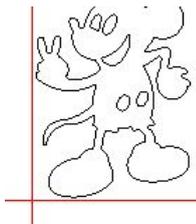
Laser head is at  
"middle up"



Laser head is at  
"upper right"



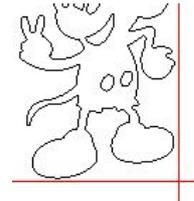
Laser head is at  
"left middle"



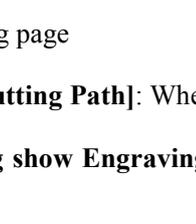
Laser head is at  
"middle"



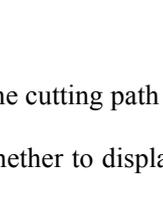
Laser head is at  
"right middle"



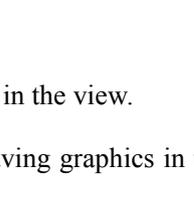
Laser head is at  
"lower left"



Laser head is at  
"lower middle"



Laser head is at  
"lower right"



## (2) Working page

**[Display Cutting Path]:** Whether to display the cutting path of graphics in the view.

**[Simulating show Engraving Graphics]:** Whether to display the engraving graphics in the way of filling in the view.

**[Display Grid]:** Whether to display the grid in the view.

**[Grid Size]:** The distance between the grid lines.

**[Hide Layers of Not Output]:** Whether to hide the layers not output.

**[Select only objects inside the rectangle]:** Whether to only select graphics inside the frame when frame selection.

**[Page Width]:** The width of working page.

**[Page Height]:** The height of working page.

**[Select Color ]:** Select the display color of the object.

## (3) Import file

**[Auto Merge connected Lines]:** When import the graphics file, whether to merge link lines.

**[Merge Tolerance]:** Only when distance between link lines smaller than this value, they can be merged.

**[Auto Close]:** When import the graphics file, whether to merge the unclosed graphics.

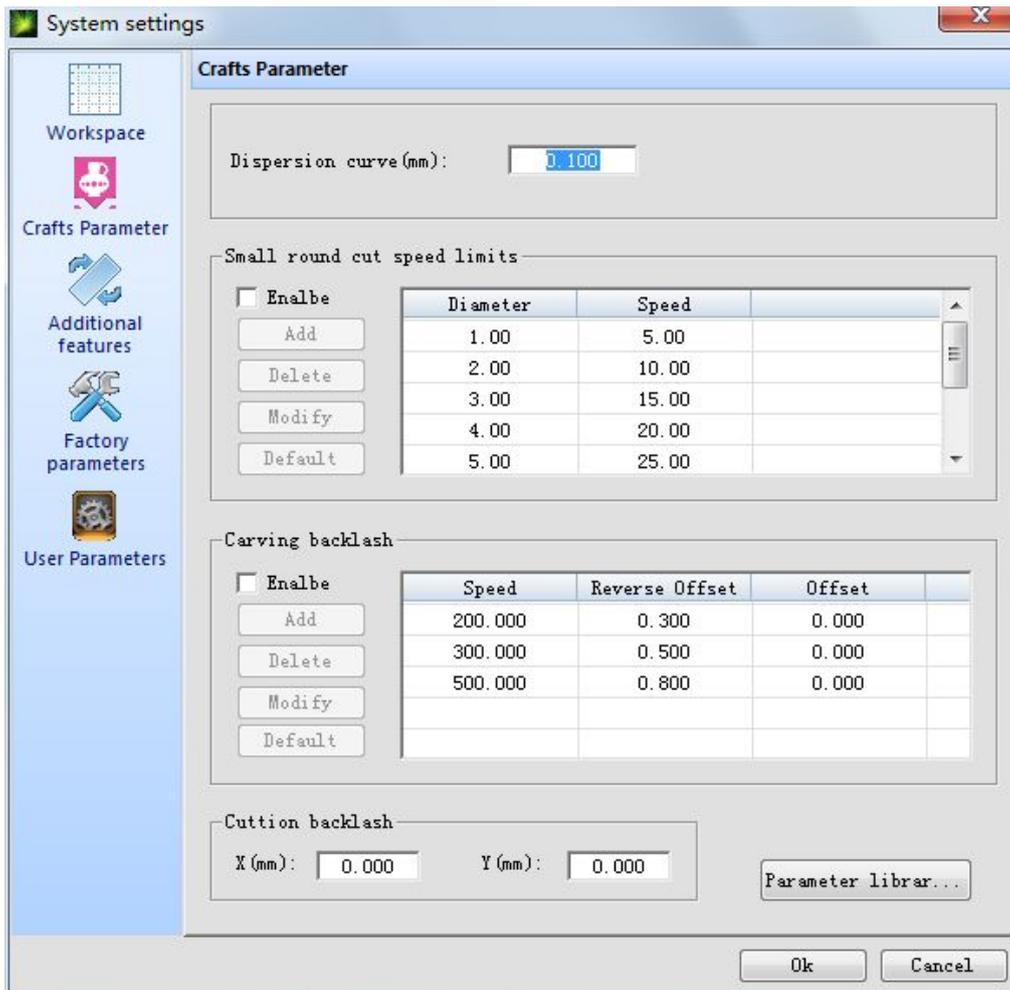
**[Close Tolerance]:** Only when the distance between starting point and ending point of the unclosed graphics smaller than this value, it will be closed.

**[Optimal path]:** When import the graphics file, whether to optimize the graphics.

**[DXF Unit]:** If DXF file without specified unit, set the unit here.

**[PWJ Automatically Centering]:** When open PWJ file, whether to make it centered.

◆ Technological parameter



(1) Curve discrete length

The smaller this value, the higher the accuracy of graphics, but computation speed is more slow, and it may affect the processing speed. Generally to cut organic glass, choose smaller values; for other kind of cutting, please use the default value of 0.1.

(2) Small circle cutting speed limit

During processing, the system will automatically identify whether the processing object is small circle with speed limit. Then according to the diameter of the circle, use the set limit speed to process the circle. If the parameter configuration is appropriate, it will greatly improve the cutting quality of small circle. You can click [Add], [Delete], [Modify] to set this parameter.

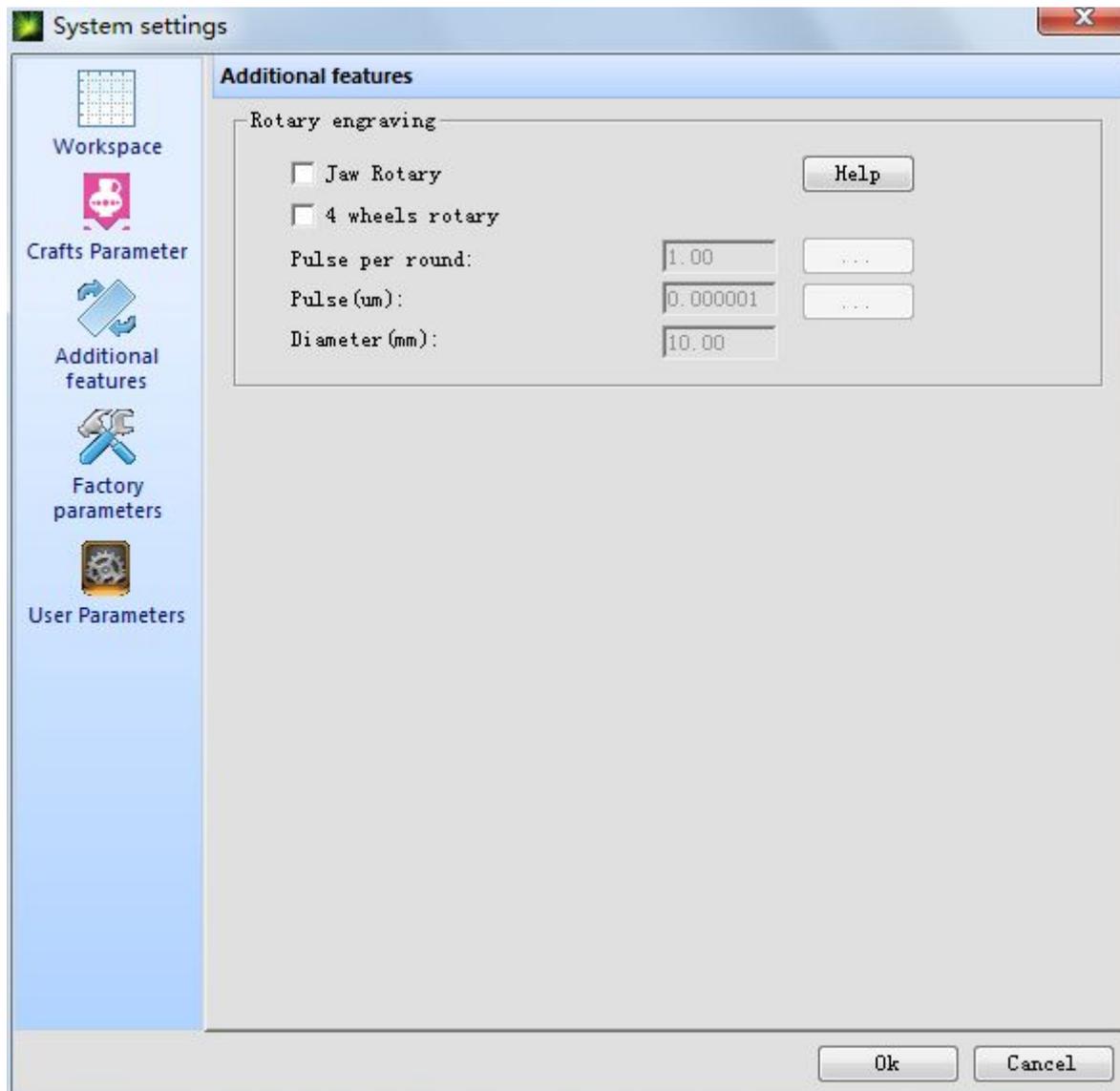
(3) Carving reverse gap

When laser curve graphics two-ways, due to mechanical return gap, it may cause uneven edge of graphics after scanning. So the reverse gap is added to modify. There is pecific reverse clearance under specific speed. Generally, the greater the speed, the bigger the reverse clearance is. Reverse gap value can be positive or negative.

(4) Cutting reverse gap

Adjust the overall location offset of the cutting graphics.

## ◆ Additional function



**[Jaw Rotary]:** After select fixture rotation carve, Y axis is the axis for rotation; parameters can be adjusted according to "rotating pulse equivalent", "pulse count of a circle", "current diameter" .

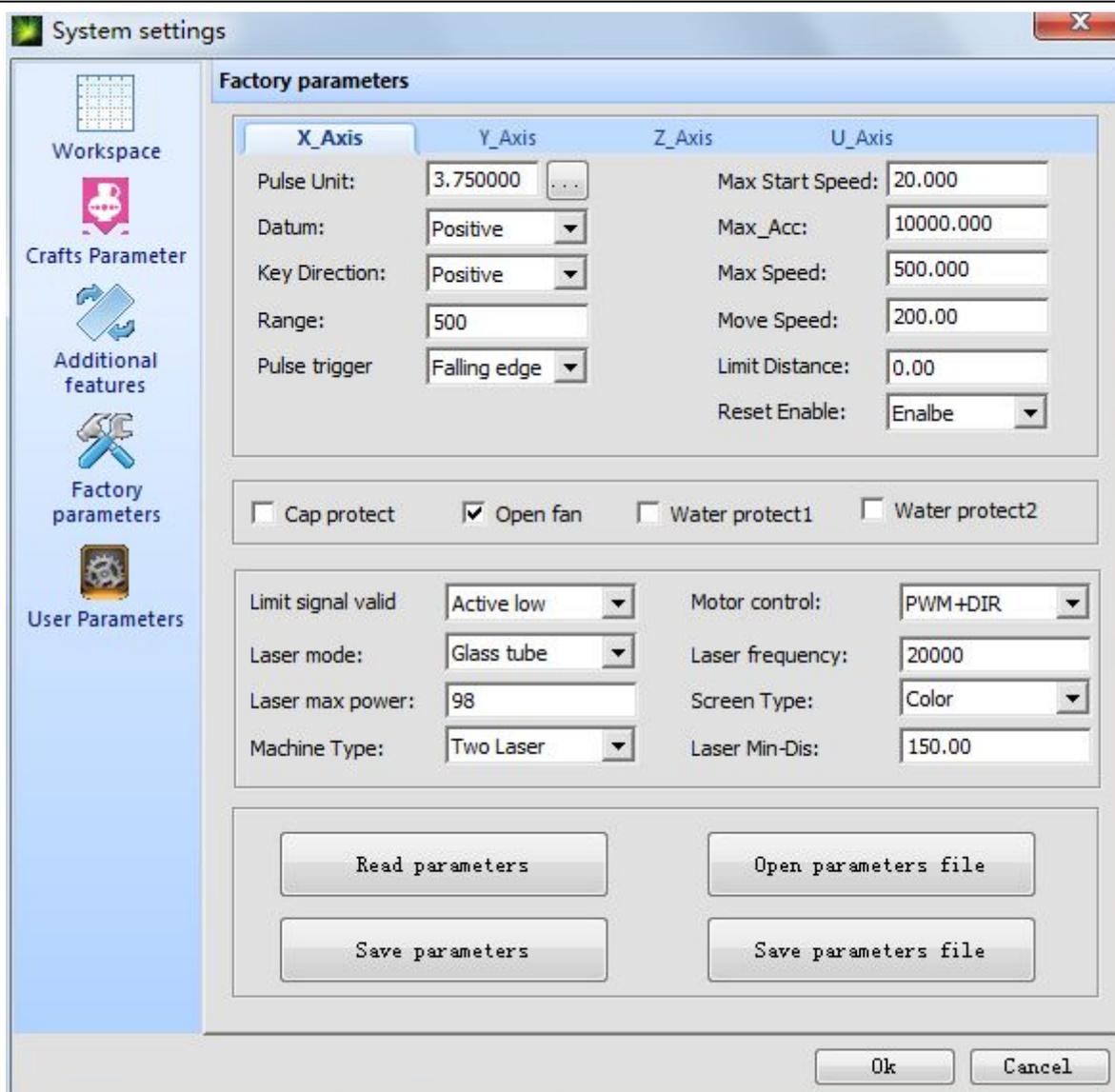
**[Four-Wheel Rotary]:** "rotating pulse equivalent" and "pulse count of a circle" are effective.

**[Pulse (Um)]:** When send a pulse to the motor, the absolute traveling distance of corresponding rotating axis (unit: um).

**[Pulse per round]:** The number of pulses required for one revolution of the workpiece.pulse count of a circle= fine fraction of motor driver\*drive ratio

**[Diameter (mm)]:** Measure the diameter of the workpiece.

## ◆ Manufacturer parameters



Manufacturer parameters include the parameters of machine properties, about the safety performance and machine configuration. They are set up by the manufacturer before they leave the factory, users without permission to modify these parameters. Manufacturer parameters are saved in mainboard. When reinstall, the software parameters will not be lost.

Under this parameter page, two methods can modify parameters:

- ◆ Click on [Read Parameters], then manually modify the parameters. And then click on [Save parameters].
- ◆ Click on [Open Parameter File], then click [Save Parameters File]. This method will set all parameters at one time. You can click on [Save Parameter File] to save the manufacturer parameters on current mainboard to parameter file.

Introduction of main parameters:

**[Pulse Unit]:** When send a pulse to the motor, the absolute traveling distance of corresponding motion axis (unit: mm). If the pulse equivalent set is not correct, size of the processed graphics will be different from the actual size.

**[Datum]:** It indicates the moving direction of motion axis. X limit on the left, direction of X original point is positive; X limit on the right, direction of X original point is negative. Y limit on the up (inside), direction of Y original point is negative; Y limit on the below (outside), direction of Y original point is positive.

**[Key Direction]:** It indicates the moving direction of pannel keypad or software keypad which controls the motion. When the direction of X keypay is positive, the keypad direction is consistent with actual direction; When the direction of X keypay is negative, the keypad direction is opposite with actual direction; other axis is similar.

**[Range]:** Actual workbench breadth of the machine.

**[Max Start Speed]:** Namely the takeoff speed of the motor, generally set between 5~20.

**[Max\_Acc]:** The maximum acceleration that the motor and machine can withstand. At working, the motor will will at less than or equal to the maximum acceleration speed.

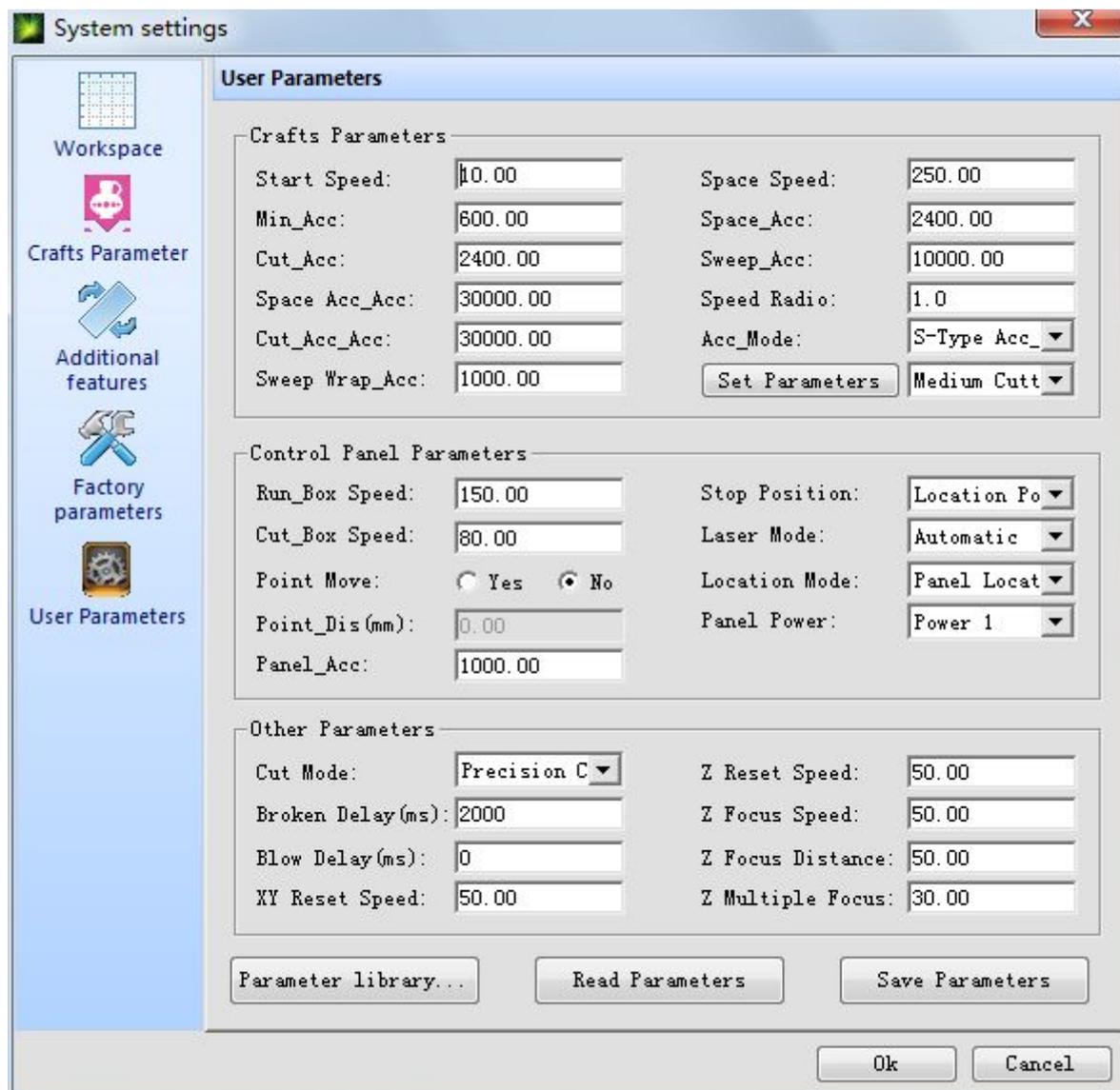
**[Max\_Speed]:** The maximum speed that the motor and machine can withstand. At working, the motor will will at less than or equal to the maximum speed.

**[Laser Mode]:** Including three modes, such as glass tube 、 radio-frequency tube CO<sub>2</sub> (withour precombustion), radio-frequency tube CO<sub>2</sub> (with precombustion)

**[Laser Frequency]:** Generally set the laser frequency of glass tube between 10000 ~ 20000.

**[Laser Max Power]:** Generally set as 98.

◆ User parameters



(1) Crafts parameters

**[Space Speed]**: During processing, it is the fast running speed of laser head when no laser sending out.

**[Space\_Acc]**: During processing, it is the maximum running acceleration of laser head when no laser sending out.

**[Space\_Acc\_Acc]**: It is the change frequency of idel acceleration. The greater this parameter is, the faster the idle acceleration and the greater the corresponding viberation is. Generally the value is between 10000~60000.

**[Start Speed]**: Initial speed of axis motion.

**[Min\_Acc]**: The minimum acceleration of axis motion during process.

**[Cut\_Acc]**: Maximum acceleration of laser head motion when laser sending out during processing.

**[Cut\_Acc\_Acc]**: It is the change frequency of cutting acceleration. The greater this parameter is, the faster the idle acceleration, and the greater the corresponding viberation is. Generally the value is between 5000~50000.

**[Sweep\_Acc]**: When laser engraving, the maximum acceleration of laser head motion, generally greater than 8000.

## (2) Control panel parameters

**[Run\_box Speed]**: When no laser sending out, the moving speed along the frame of the processing graphics, it is mainly used to locate.

**[Cut\_box Speed]**: When laser sending out, the moving speed along the frame of the processing graphics, it is mainly used to locate.

**[Location Mode]**: The location mode includes software location and keypad location.

**[Stop Position]**: It is divided into machine original point and location point.

**[Laser Mode]**: Includes manual and automatic.(manual refers to run according to the power and speed set on the panel,automatic refers to run according to the power and speed set in the software).

**[Point Move]**: The system default is no, and it can be changed according to the requirement.

**[Panel Power]**: Select corresponding output power according to personal requirement. This system includes: Power and Power 2.

## (3) Other parameters

**[Cutting Mode]**: Includes “precision cutting” and “fast cutting”. For higher quality of cutting, select “precision cutting”; for lower quality of cutting, select “fast cutting”. “Faster cutting” is more efficient than “precision cutting”.

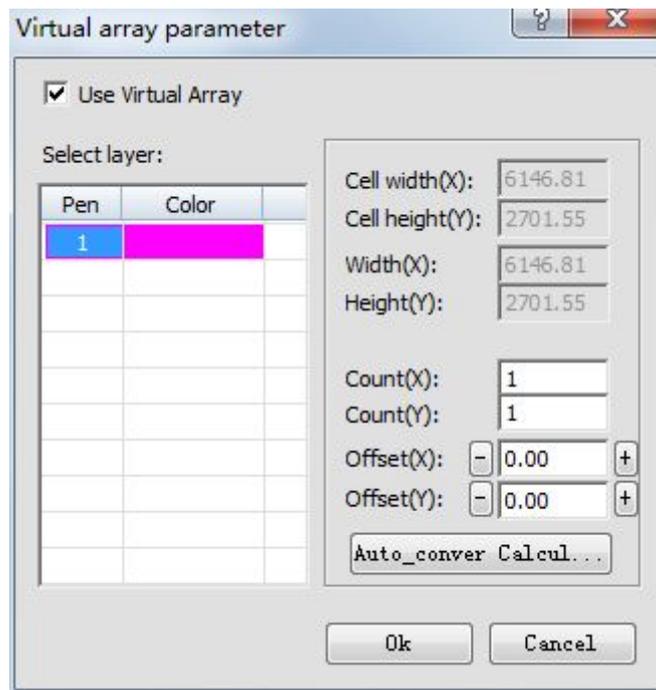
**[Power-off Delay]**: When the machine is stoped unexpectedly (such as the power cut off), the graphics be continued after restart. Set [power-off delay] can make the outage connected, generally set about 1000ms.

**[Reset Speed]**: The speed of machine back to the origin point. For larger breadth, this parameter can be appropriately increased.

**[Blowing Delay]**: When use blowing function, delay some time after cutting and then close the blowing function

### 3.7.2 Virtual display (double head intermotion)

Click menu command [Set] / [Virtual Array], or click system toolbar , following dialogue box appears:



**[Cell width (X)]**: Original size of processing data.

**[Cell height (Y)]**: Original size of processing data.

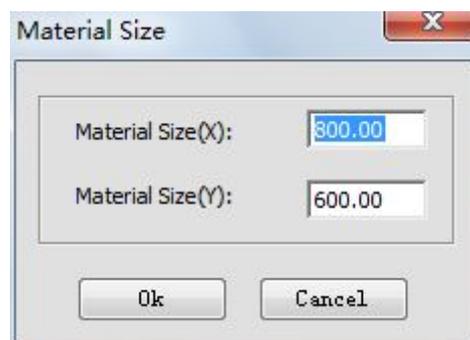
**[Count]**: Row number or column number of data to be output.

**[Offset]**: Distance between each row or each column.

**[Width]**: Width of all data after array.

**[Height]**: Height of all data after array.

Automatical full calculation: according to the set interval, automatically calculate the row number and column number needed to cover all the work breadth. Click [Automatical Full Calculation] button, following dialogue box appears:

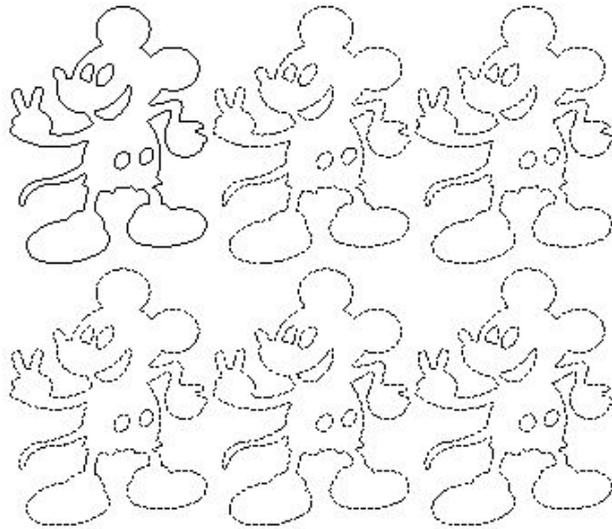


**[Material size (X)]**: The length of the material to be processed (default value is the length of the workbench).

**[Material size (Y)]**: The width of the material to be processed (default value is the width of the workbench).

The system will automatically calculate the numbers needed to cover the processing material according to the set material size.

Array parameter setup example is illustrated below:



### 3.7.3 Import parameters

Click on menu bar [Set] / [Import Parameters], select to import the graphics parameters which already saved in the computer.

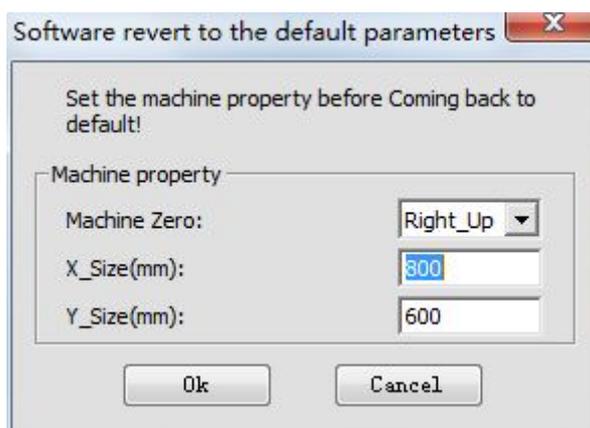
### 3.7.4 Export parameters

Click on menu bar [Set] / [Export Parameters], export the graphics parameters and save on corresponding location in the computer.

### 3.7.5 Restore default parameters

When the user set many parameters of the software as inappropriate values, software operation and laser output may occur to some abnormal situation. Restore the software parameters to default values, then all parameters of the software can be restored to default appropriate values (may be not the ideal values).

Specific operation to restore software parameters to default values: click on menus command [Set] / [Restore Default Parameters], following dialogue box appears:



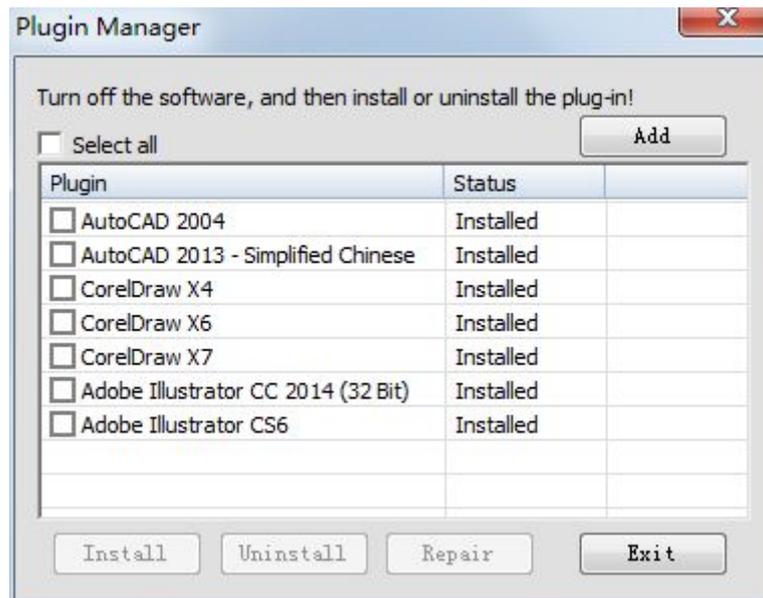
Correctly select [Machine Zero], set [X\_Size] and [Y\_Size], then click on [Ok] .

Note: Make sure to correctly set [Machine Zero], [X\_Size] and [Y\_Size], otherwise the processed graphics may be inconsistent with the actual (inconsistent in size, graphics image).

### 3.7.6 Plugin manager

Detect whether the local installation drawing software (AutoCAD、CorelDraw、Adobe Illustrator) with

plugins installed. To install/uninstall plugins, click on menu bar [Set] / [Plugin Manager], popup following window appears.



Check the plugin to be installed, click [Install] / [Uninstal] to install/uninstall the corresponding plugin.

### 3.8 Layer parameters

Layer Options				
Layer	Mode	Speed	Power	Output
	Cut	150.00	25.00	✓
	Cut	200.00	55.00	✓

Up      Down

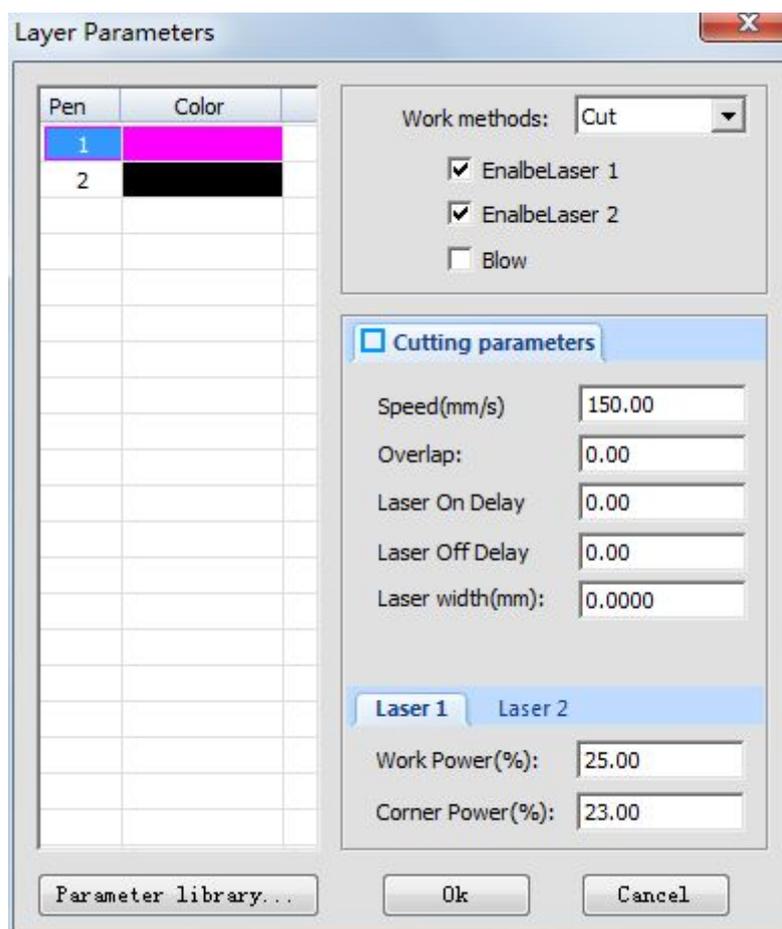
Layer parameters display the processing related parameters, whether to output, the layer order.

◆ Click the last column [Output] of each layer, to determine whether output the layer. Layer not outputted, will not be processed.

◆ Select layer, click [Up] / [Down], the layer order can be adjusted.

◆ Double click the layer, pop-up processing parameter setting window.

(1) Laser cutting



Select “Cut” in [Work Methods], display cutting parameters, as the figure above.

**[Speed]:** The maximum speed of laser head when cutting.

**[Overlap]:** Because of mechanical error, the closed graphics may not be cut down. This parameter will help to solve this problem. But this parameter should not be too large, it is recommended that the adjustment of mechanical assembly precision to solve the problem.

**[Laser On Delay]:** laser outputting time before cutting.

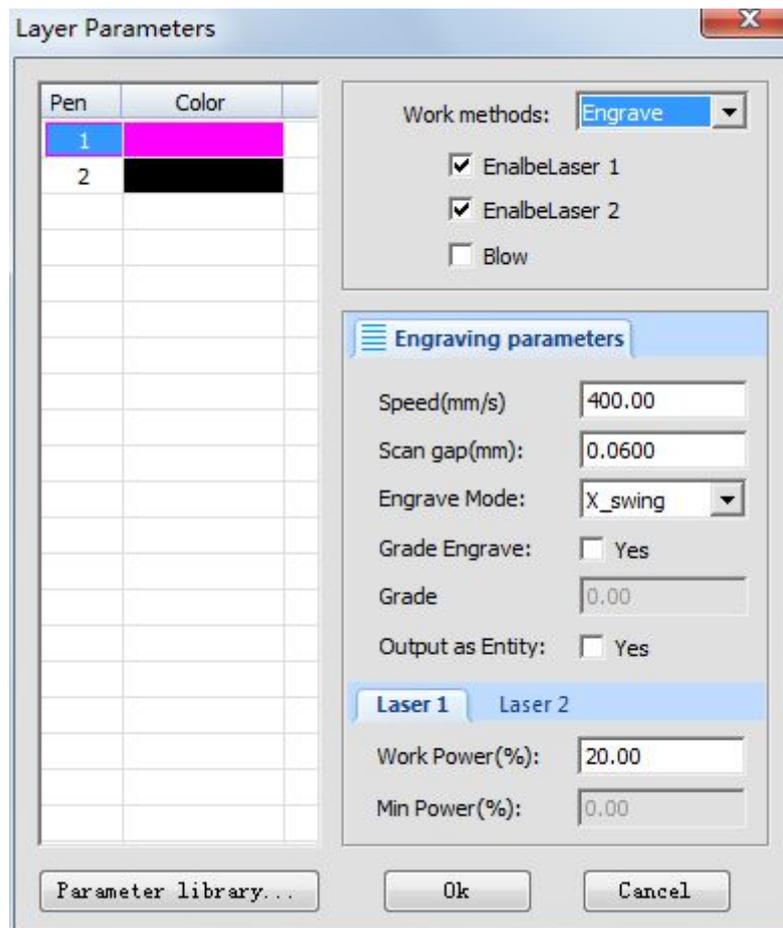
**[Laser Off Delay]:** laser outputting time after cutting.

**[Laser Width]:** according to this value, graphics automatically shrink inward or outward expand.

**[Work Power]:** adjust the maximum of laser power when processing this layer (in percentage).

**[Corner Power]:** when variable motion, the power value at the lowest speed. (By adjusting the above two parameters, ensure that the turn during processing with same effect as straight cutting).

(2) Laser engraving



Select “Engrave” in [Work Methods], display engraving parameters, as the figure above.

**[Speed]:** The scanning speed when engraving.

**[Scan gap]:** Gap between scanning line.

**[Engrave Mode]:** Including "horizontal two-way", "horizontal one-way" and "vertical two-way", "vertical one-way".

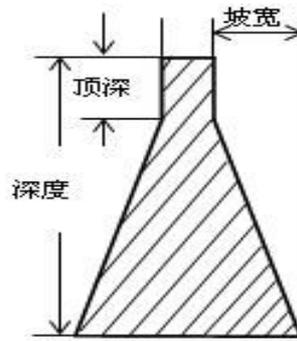
**Horizontal two-way:** Laser outputs the laser scanning graphics in a horizontal direction back and forth.

**Horizontal one-way:** Laser outputs the laser scanning graphics in a horizontal direction back and forth, but only when it scans to one direction, the laser output. such as: when the laser head scans from right to left, the laser output, but no laser when scan from left to right.

**Vertical two-way:** Laser outputs the laser scanning graphics in a vertical direction back and forth.

**Vertical one-way:** Laser outputs the laser scanning graphics in a vertical direction back and forth, but only when it scans to one direction, the laser output., such as: when the laser head scans from up to down, the laser output, but no laser when scan from down to up.

**[Grade Engrave]:** Select “yes”, [Slope Length] and [Minimum Power] effective.slope engraving schematic figure:



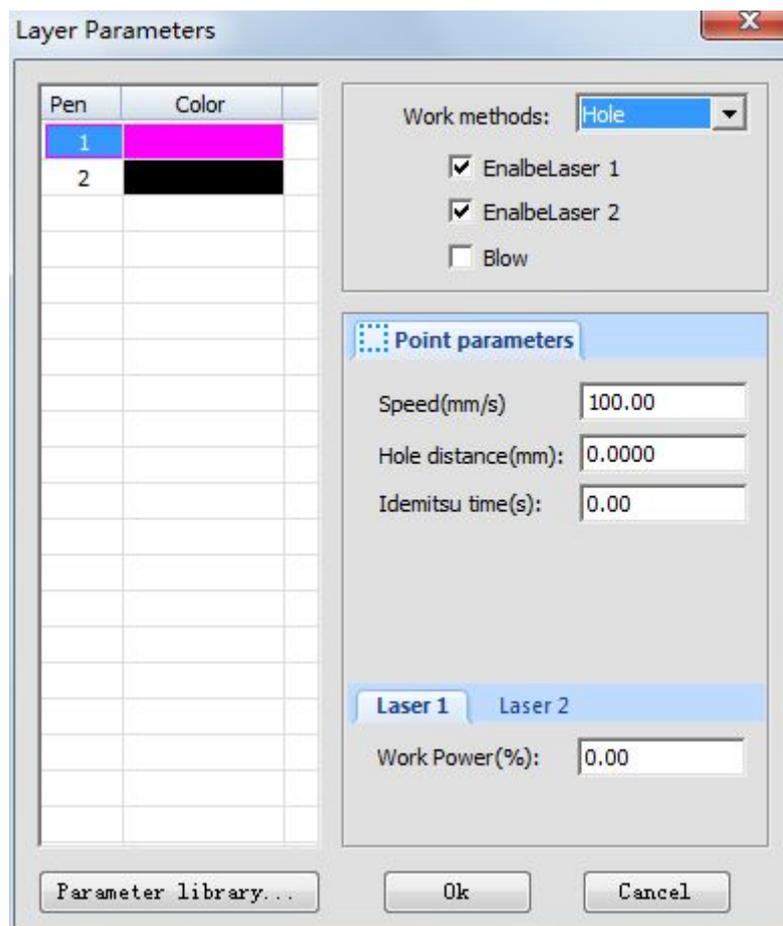
**[Grade Length]** “Slope degree” in the schematic figure.

**[Output as Entity]:** During engraving scanning, whether take the edge of graphics as the starting and ending points, otherwise take the frame of graphics as the starting and ending points.

**[Work Power]:** The laser power when adjust and process this layer (in percentage).

**[Min Power]:** The minimum value of laser power when adjust slope engraving. This value determines the top depth of the slope.

### (3) Laser hole



Select “Hole” in [Work Methods], display drilling parameters, as the figure above.

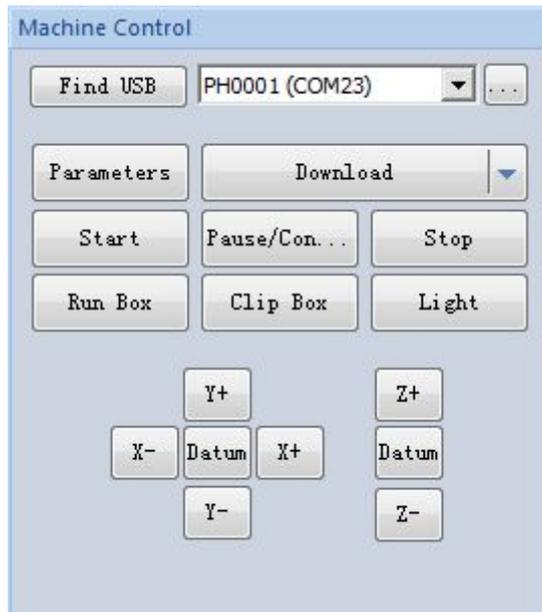
**[Speed]:** Moving speed of laser head.

**[Hole Distance]:** Gap between holes.

**[Idemitsu time]:** When drilling, the stay time of laser head.

**[Work Power]:** The laser power when processing this layer (in percentage).

### 3.9 Machine control



**[Start]:** Start the processing of current file which matched with “control panel” (refer to: operation manual of “control panel” matching with the system.(load a file to mainboard, “control panel”will automatically select this file.)

**[Pause/Continue]:** If machine in working situation, click on [Pause/Continue],work will pause ; if machine in working situation,click on [ pause/continue] ,work will continue.

**[Stop]** : Machine stop current work.

**[Run Box]:** The laser head will form a rectangle according to the size of processing data, mainly used to determine the position for processing workpiece.

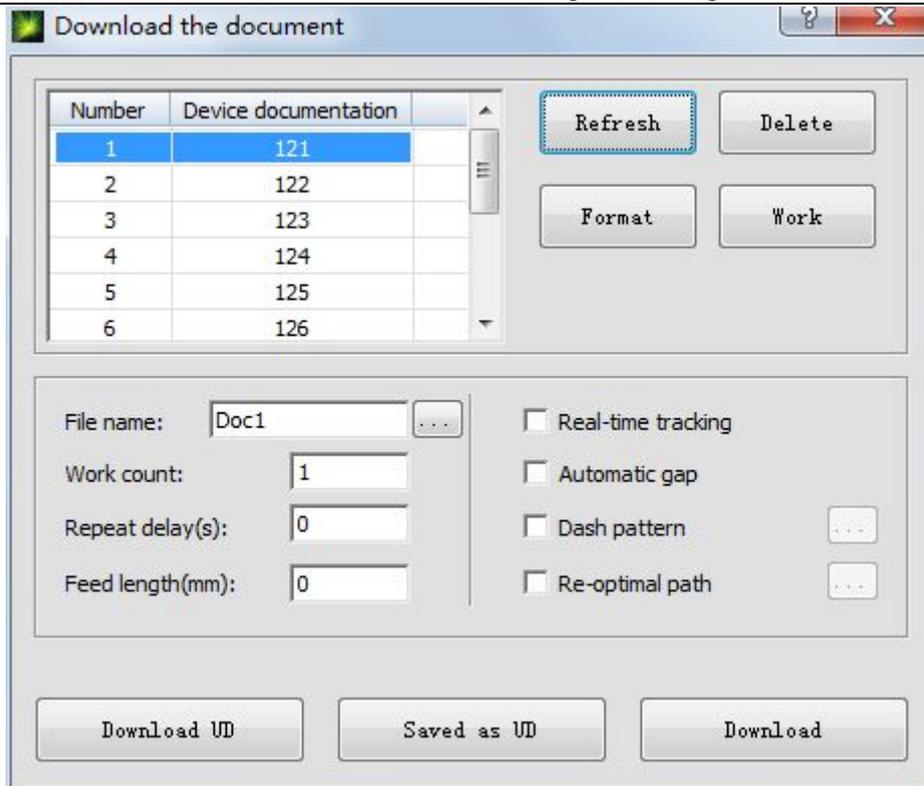
**[Clip Box]:** Cut the processed workpiece from material.

**[Light]:** Press [laser output] button, laser sent out; release laser output] button, laser shut down.

**[Datum]:** “original point”is“reset”. Click this button, laser head (or axis Z) will slowly move the machine original point.when touching the machine limit, fast move to positioning location.This function can eliminate the accumulated error, generally must be conducted before processing.

**[X-] [X+] [Y-] [Y+] [Z-] [Z+]:** Move laser head (or axis Z). When it is “jog“, click once, the laser head moves once. The moving distance is the set “jog distance”; when it is not “jog”, press the button, laser head (or axis Z) begin to move; release the button, laser head (or axis Z) stop to move.

**[Download]:**Click on [Download] button, following dialogue box appears:



**[File name]:** The name of the file load to mainboard.

**[Work count]:** The processing timers of loaded file. When start processing, the system can automatically repeat the processing of this file data.

**[Repeat delay]:** Processing for many times, delay time after each processing.

**[Feed length]:** the distance of feeding axis (Z axis) after each processing.

**[Download]:** Through USB line/internet cable, load the document in current software to mainboard; mainboard use the file name of set document property, to save the graphics data to file system of mainboard. After load, press the “file” button on “control panel” which match with the system, then you may find that the last file in file system is the file just loaded (refer to: operation manual of “control panel” matching with the system).

**[Save as UD]:** Offline file (extension name of ud/uo) saved to computer, and then copies to U disk. It can be loaded to mainboard through U disk interface.

**[Download UD]:** Load the offline file stored (ud file) to mainboard.

**[Refresh]:** namely query all files stored in the mainboard. Click [Refresh], file list of equipment document will show all filenames of all files stored in the mainboard, and [Work], [Delete], as the figure below:

**[Work]:** Select a file in the file list, click on [Work] button, can start the processing of this file.

**[Delete]:** Select a file in the file list, click on [Delete] button, can delete this file from mainboard.

**[Format]:** Formatting motherboard memory. All files stored in mainboard will be lost.

# Chapter 4 CorelDraw Plugin

## 4.1 CorelDraw edition support

CorelDraw12、CorelDraw13、CorelDrawX4、CorelDrawX5、CorelDrawX6、CorelDrawX7

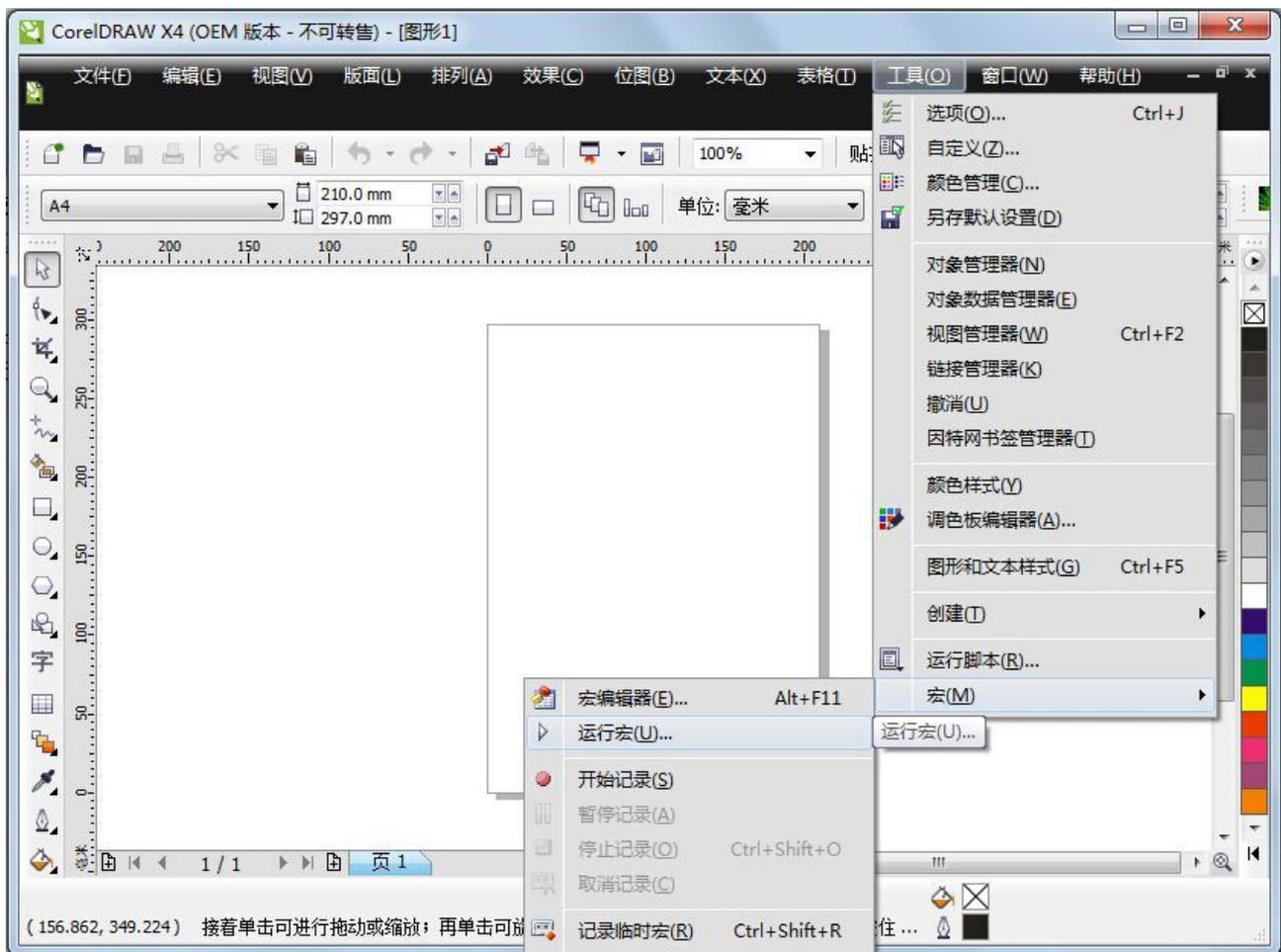
## 4.2 Operating system support

WindowsXP, Windows7 (32/64), Windows8 (32/64)

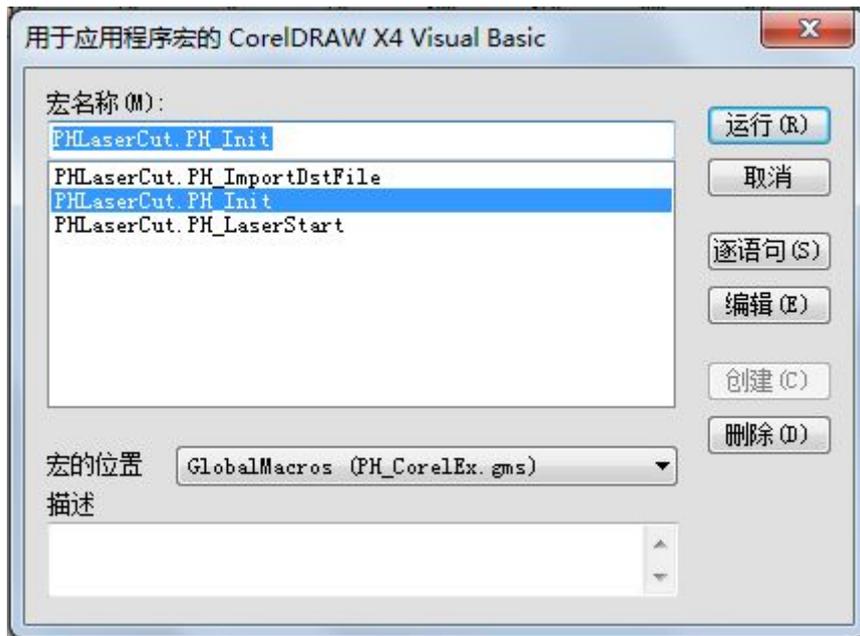
## 4.3 Manually load“PH\_LaserCut”toolbar

After install CorelDraw plugin, start CorelDraw, CorelDrawX4 as an example.

(1) Click on [Tools] / [Macro] / [Run Macro], shown as the figure below:

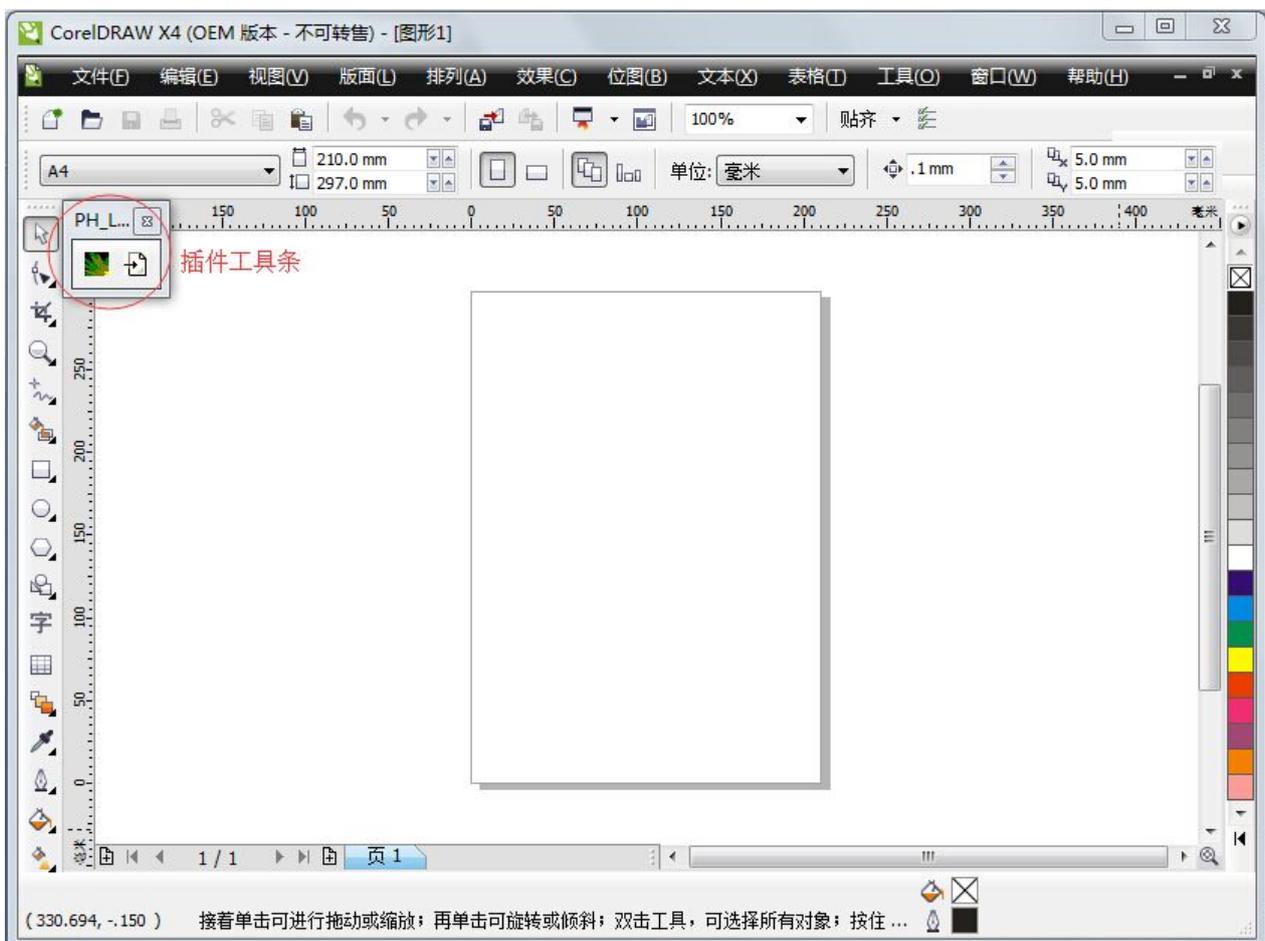


(2) Following dialogue box appear:



(3) In [Macro Position] select “GlobelMacros (PH\_CoreEx.gms)”, than in [Macro Name] select “PHLaserCut.PH\_Init”.

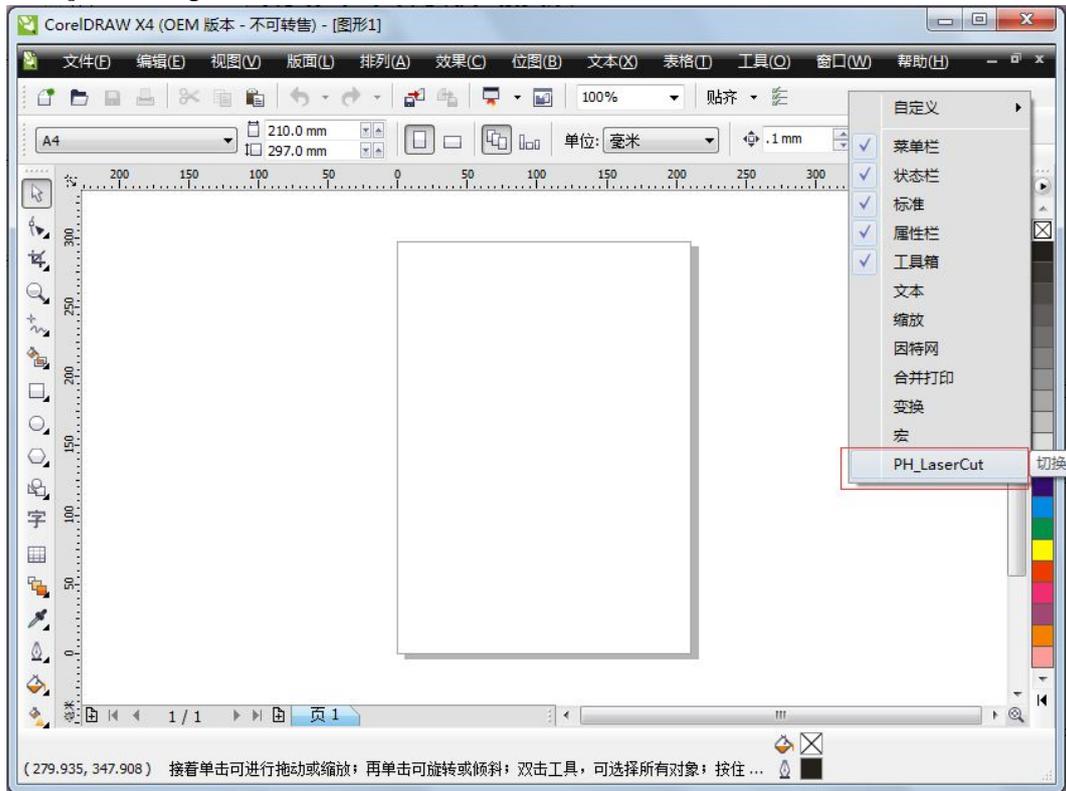
(4) Click on [Run] button, CorelDraw main interface will add“PH\_LaserCut”toolbar, as the figure below:



(5) In CorelDraw, already manually load “PH\_LaserCut” toolbar, later restart CorelDraw , “PH\_LaserCut”, toolbar will appear.

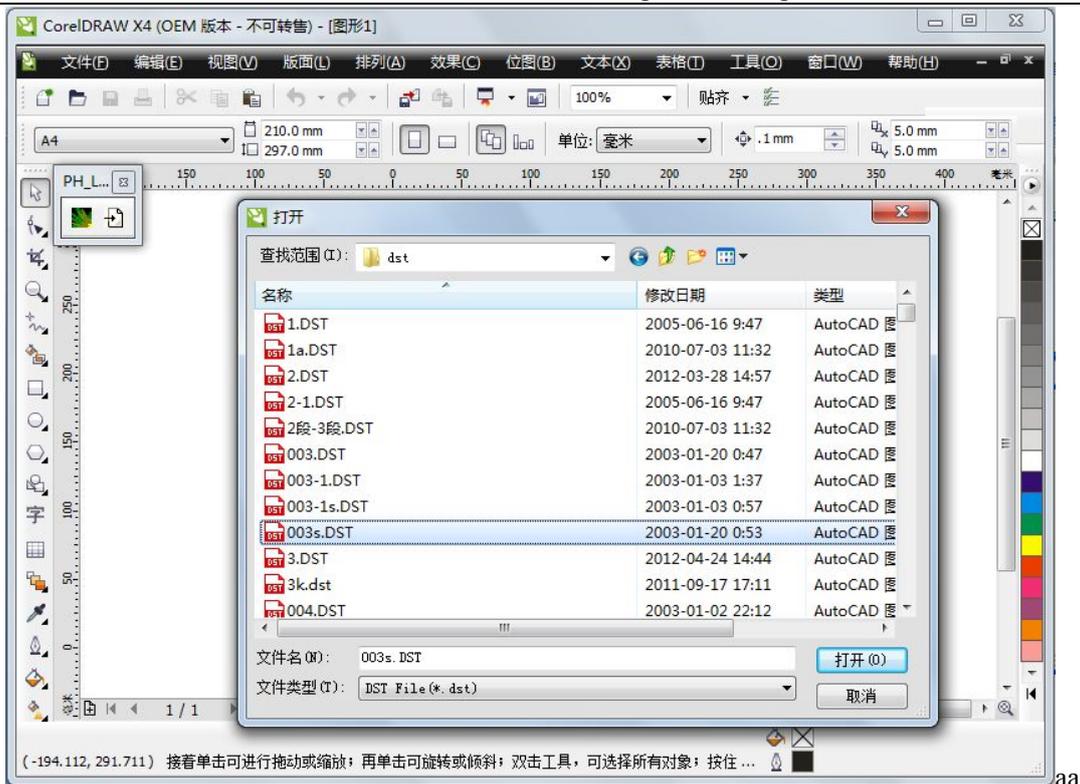
#### 4.5 Display the hidden “PH\_LaserCut”toolbar

During use of CorelDraw, user may close “PH\_LaserCut”toolbar, so need to display the hidden toolbar. Click on toolbar by right mouse button, following menu appear, then click on [PH\_LaserCut]. As the figure below:



#### 4.6 Import DST/DSB file

Click on import button  on “PH\_LaserCut”toolbar, following dialogue box appear:



Select the DST/DSB file to loaded, then click on [Open] button.

#### 4.7 Transfer from CorelDraw to Lasersoft

Compile the graphics in CorelDraw, click on  button on the “PH\_LaserCut”toolbar, directly transfer to universal version, and the graphics compiled in CorelDraw will also shown in view of universal version.

## Chapter 5 AutoCAD Plugin

### 5.1 CorelDraw version supports

AutoCAD2004, AutoCAD2008, AutoCAD2010, AutoCAD2012, AutoCAD2013, AutoCAD2014, AutoCAD2015

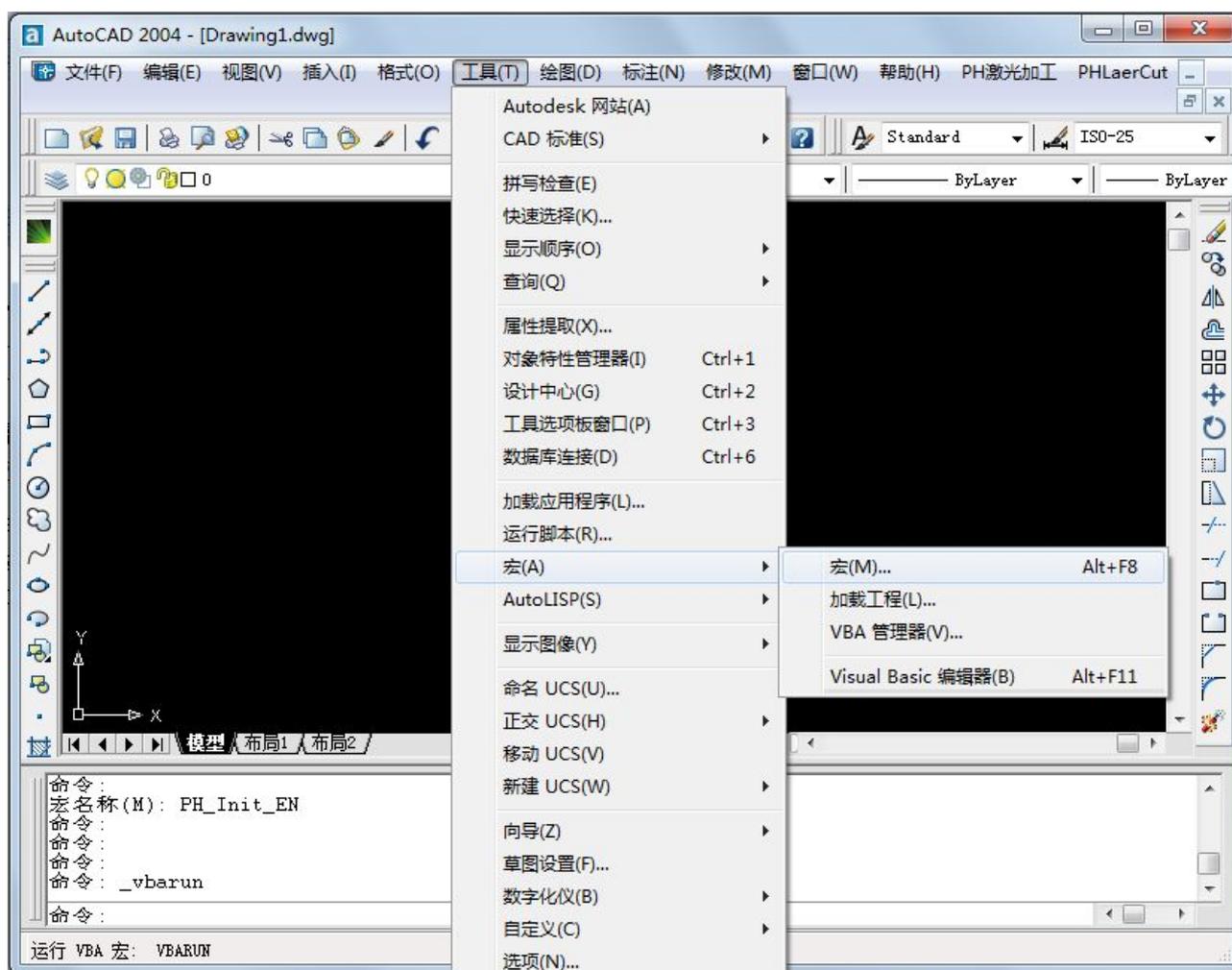
### 5.2 Operating system support

WindowsXP, Windows7 (32/64), Windows8 (32/64)

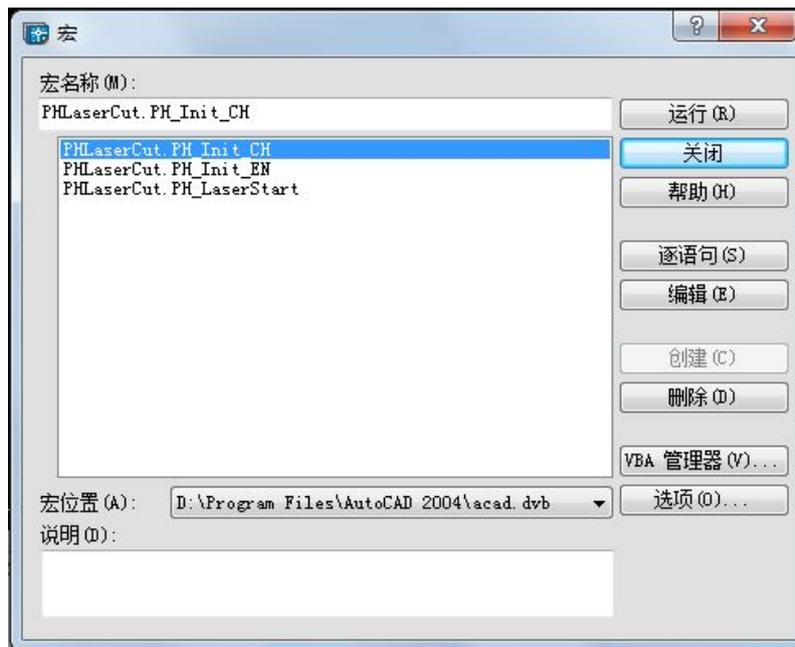
### 5.3 Manual load “PH Laser Processing” menu and “PH Laser Processing” toolbar

Install AutoCAD plugin and start AutoCAD, hereafter taking AutoCAD2004 as an example.

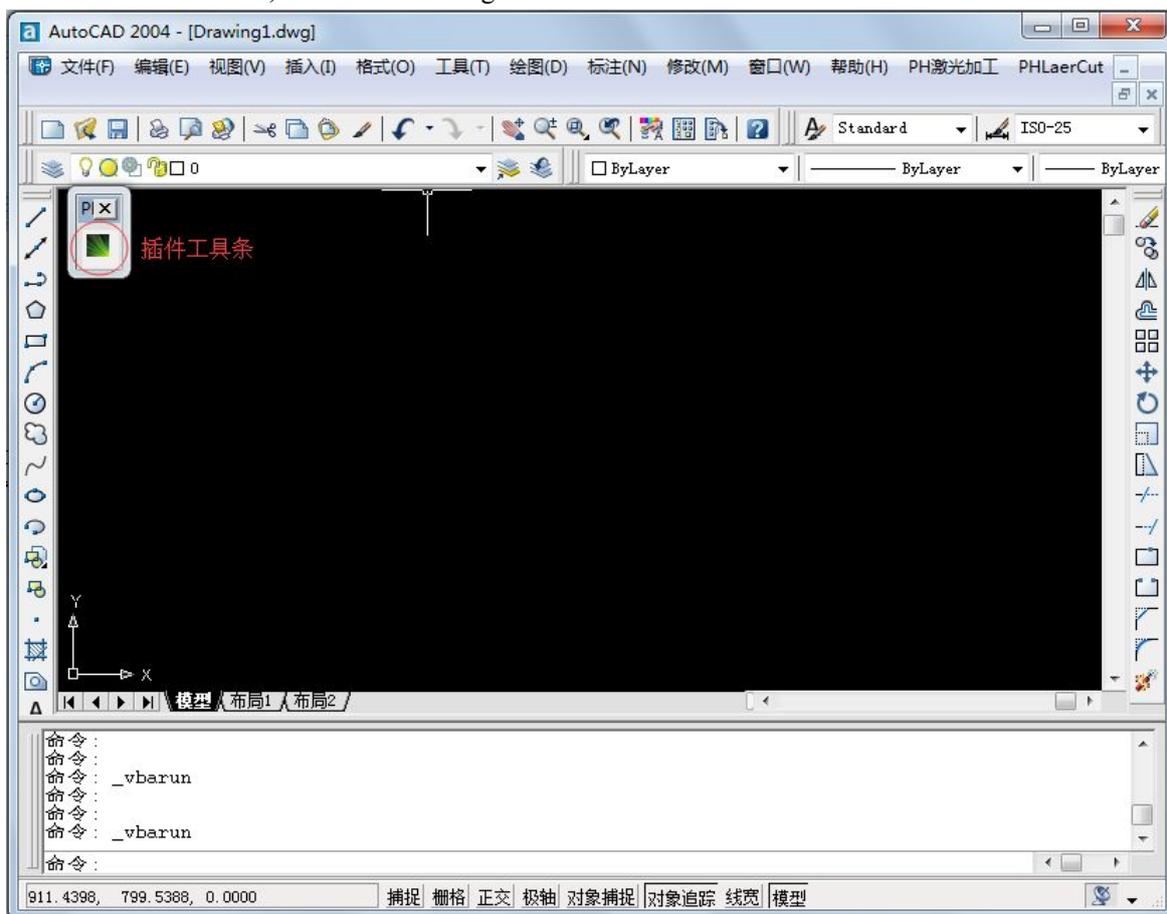
(1) Click menu [Tools]/[Macro]/[Macro], as shown in the following figure:



(2) The dialog box appears as follows:



(3) Select “PHLaserCut.PH\_Init\_CH” in [Macro Name] and click [Run] button. Then the laser plugin toolbar is added in AutoCAD, as shown in the figure below:



#### 5.4 Transfer from AutoCAD to LaserSoft

Upon the completion of graph editing in AutoCAD, click menu [PH Laser Processing]/ [Laser Process], or click the  button in “PH Laser Processing” toolbar, where it directly switches to universal version software, and the AutoCAD-edited graph is displayed in the view of universal version.

## Chapter 6 Adobe Illustrator Plugin

### 6.1 Adobe Illustrator version support

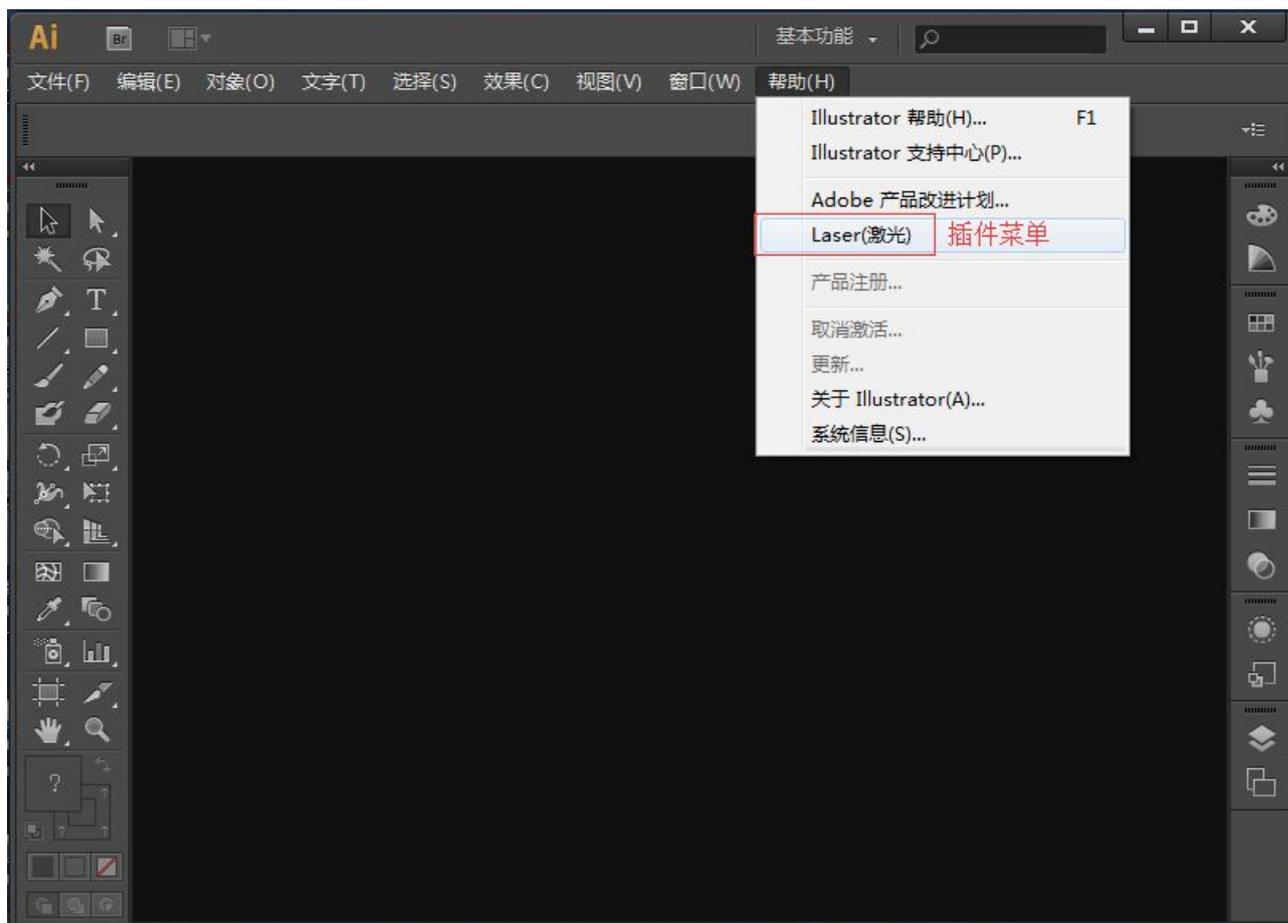
Adobe Illustrator CS5, Adobe Illustrator CS6, Adobe Illustrator CC2014

### 6.2 Operating system support

WindowsXP, Windows7 (32/64), Windows8(32/64)

### 6.3 Transfer from Adobe Illustrator to LaserSoft

Edit a graph in Adobe Illustrator, click menu [Help]/ [Laser], and directly switch to universal version where the Adobe Illustrator-edited graph is displayed in its view.



## Chapter 7 FAQ Answering

### 7.1 USB is unable to connect

USB serial port connection failure has five common scenarios:

1. No reaction is experienced by computer to USB plug-in and pull-out, and its reason may lies in:
  - (1). Machine is off, and starting the same will do;
  - (2). Computer USB interface failure, and exchange USB interface or find another computer;
  - (3). USB line is broken, and exchange the line will do.
2. After USB plugin, the forward solution right of computer desktop notes “unknown device”, which may result from:
  - (1). USB plugs in the wrong interface of mainboard (there are two USB interface on mainboard, one for USB flash disk and one for USB line), so plug in the other USB interface;
  - (2). Use invalid USB patch cord, which is a normal scenario, so get rid of or exchange the USB patch cord.
3. Corresponding serial port shows "?/!" in the computer device manager after USB plugin, which is due to incorrect driver installation, and reinstallation of driver will do.
4. It notes “serial port is occupied!” and the possible reasons may be:
  - (1). Operating system is occupying this port, so re-plug in USB;
  - (2). Mainboard serial port module or USB interface fault, which requires manufacturer overhaul;
5. Other faults, and it shall be delivered to the manufacturer for overhaul.

#### Special Instruction:

USB serial communication is suitable for short distance communication, and the USB connection line is better not to be so long, say 10m as longest.

### 7.2 When start processing, machine is immovable or moves in a mess way or part of the graphs is under no processing

- ◆ Check the graphic data, and those exceeding the breadth shall not be incised.
- ◆ Check the setting of “relative graph location”.

### 7.3 The faceplate gives a prompt of [buffer distance insufficiency]

- ◆ Check the setting of engraving accelerated speed which is normally set at 8,000 or more.
- ◆ Keep the graph outline border away from machine breadth boundary.

### 7.4 When loading documents, it gives a prompt of [The current document data is empty]

- ◆ Check the graving output graph for sealing.
- ◆ Check all layers for output choice of “NO”.

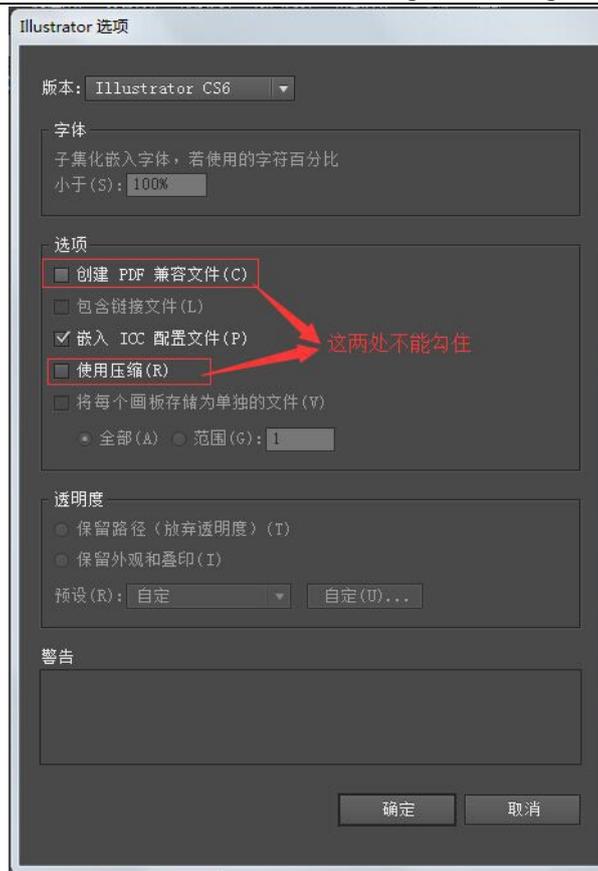
### 7.5 The processed graph is the mirror image of actual graph

Check the setting of “machine dead center position”.

### 7.6 Unreadable AI documents

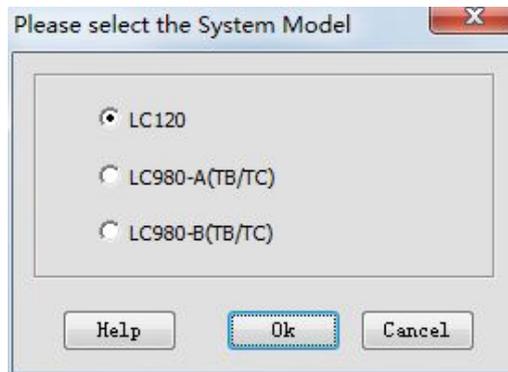
AI documents are normally generated by CorelDraw or Adobe Illustrator, and when save AI using adobe Illustrator:

1. Do not use compressed format or PDF format.
2. As for text, first create a profile of test (if it is a plug-in call, it needs no processing, and the plugin will automatically processing)



### 7.7 How to choose mainboard type when saving off-line file

It needs to choose system type when saving off-line files, as shown below, and wrong choice may lead to nonfunctional machine or disordered incision.



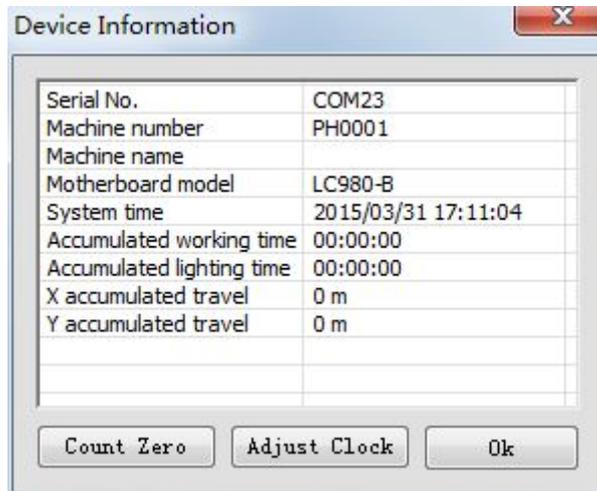
In normal condition, the mainboard type can be judged by faceplate.

Mainboard	Faceplate	Description
LC120	Black-and-white screen	15 buttons on faceplate (no number key), no touch-control
LC980-A	Large colorized screen	33 buttons on faceplate (with number keys), touch-control
LC980-B	Small colorized screen	15 buttons on faceplate (no number key), touch-control

If not know the machine type clearly, check it according to the following steps:

Step 1: open the software on the computer to be connected and properly connect the machine;

Step 2: click **Connected to -> PH0001 (COM23)** in status bar, and prompt machine info windows as shown below, where the machine type is described in the red box position.



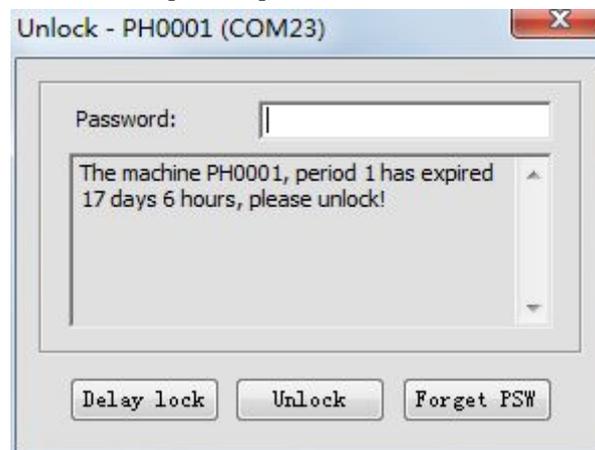
### 7.8 Machine is locked (only apply to the encrypted machine)

(1) Advance hint for due date

For encrypted machine, it shall popup the hint upon software started three days prior to the due date.

(2) Unlock

If it is about to reach or reaches the date due, click [Help]/ [Unlock] menu, input unlock password in the popup window shown below, and click [Unlock] button.



(3) Forget password

If machine supplier forgot password, click [Forget password] button, input file name in the popup window, save LPW file and send it to the supplier. Machine supplier shall parse the above-sent file and give back the password, re-input the password and click [Unlock] button.

## Chapter 8 Shortcuts

Shortcut Key	Function Description
F1	Display help file
F2	Enter zoom display mode
F3	Enter translation display mode
F4	Enter zoom-all-image display mode
F5	Enter simulation window
F7	Enter manual sorting mode
F8	Display/hide recent files
F9	Enter system setting window
Shift+F2	Enter zoom-selected-image display mode
Shift+F4	Display as per page size
Alt+S	Enter selection mode
Alt+N	Enter node edit mode
Alt+L	Enter draw-line mode
Alt+P	Enter draw-polyline mode
Alt+R	Enter draw-rectangle mode
Alt+E	Enter draw-ellipse mode
Alt+B	Enter draw-Bezier-curve mode
Alt+T	Enter draw-text mode
Alt+C	Open camera
Alt+Q	Enter LGP design window
Alt+G	Enter mesh generation window
Shift+A	Array copy
Shift+C	Closed figure
Shift+D	Delete overlapping line
Shift+L	Generate lead line
Shift+I	Image counter-color
Shift+N	Image network
Ctrl+C	Copy
Ctrl+V	Paste
Ctrl+X	Cut
Ctrl+Y	Redo
Ctrl+Z	Restore
Ctrl+U	Ungroup
Ctrl+G	Group
Ctrl+Shift+U	Ungroup all
Ctrl+N	New document

Laser Carving and Cutting Software-Instruction for Operation

Ctrl+O(I)	Open project file, lay in graphic file
Ctrl+E	Export Plt file
Ctrl+S	Save
Ctrl+Shift+S	Save-as
Ctrl+1	Shift to bottom left corner of page
Ctrl+3	Shift to bottom right corner of page
Ctrl+5	Shift to page corner
Ctrl+7	Shift to bottom left corner of page
Ctrl+9	Shift to upper-right corner of page
Ctrl+→	Right justify
Ctrl+←	Left justify
Ctrl+↑	Up justify
Ctrl+↓	Down justify
→	Right shift
←	Left shift
↑	Up shift
↓	Down shift
Delete	Delete