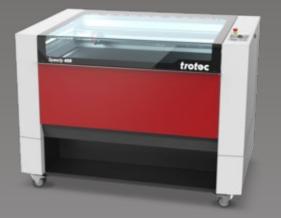
Trotec Speedy 400 Lasercutter



- CO2 Laser
- 100W
- Table Size 1016 x 610 mm
- No external materials allowed

Plywood

3 mm 5 mm

PROJECT HOUSE

MDF

3 mm 5 mm

Acrylic

1 mm 2 mm

- 3 mm
- 5 mm

Machine

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



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.

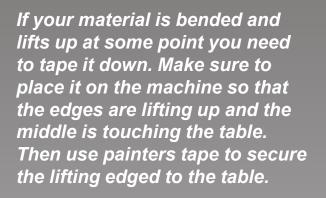
Using the buttons on the right the table can be moved up and down.



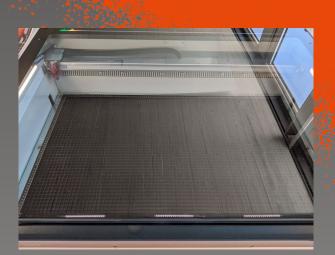


Machine

Move the table upwards to a comfortable position and place your material on the table.



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.

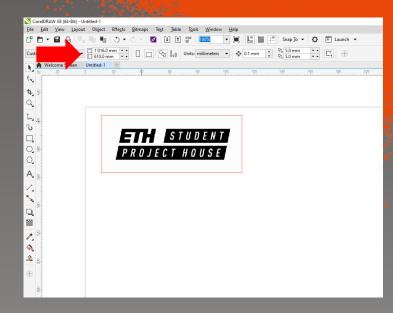




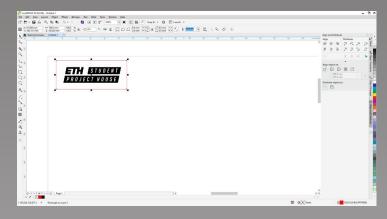




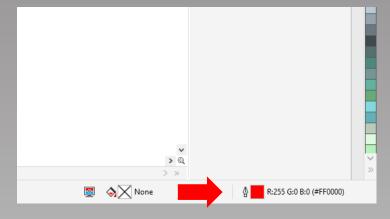
Open CorelDraw and create a new design. Make sure the dimensions are 1016 x 610 mm.



You can import vector files by Drag'n'Drop or create your own in CorelDraw.

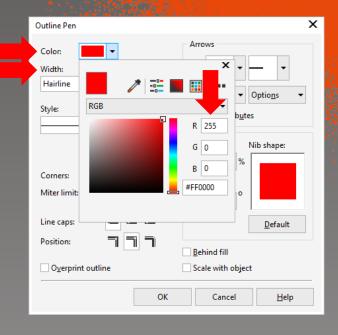


Lines to be cut need to be red hairlines. Double Click in the lower right corner to change the line width and color.



CorelDraw

Make sure that lines that need to be cut are set to a width of "Hairline" and the color is red (exactly R: 255, G: 0, B: 0)



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

Printe	r.	Trotec Engra	ver v11.4.0			▼ Preferences
Page:		Match orien	✓ Use PPD			
Status		Default printe				
Locat	ion:	C:\ProgramD	ata\Trotec	\PrinterDrive	er.Speedy\Trote	
Comr	nent:					Print to file
Print r	ange				Copies	
• Cu	rent do	cument O	Document	s	Number of <u>c</u> opies:	1 🗘
⊖ C <u>u</u>	rrent pa	ge O			696969	
	ges:	1			112233	Collate
				~		
					Print as <u>b</u> itmap:	300 🔅 di
rint sty	In. [CoreIDRAW De	faulte			 Save As
mine seg	ie.	COTEDICANV DE	auns			 Saye As

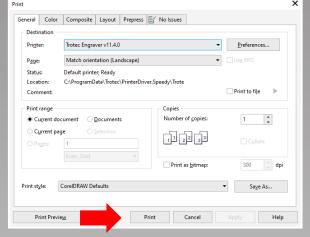
Printer Setup

In the overview that pops up ensure the points listed bellow.

- 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.

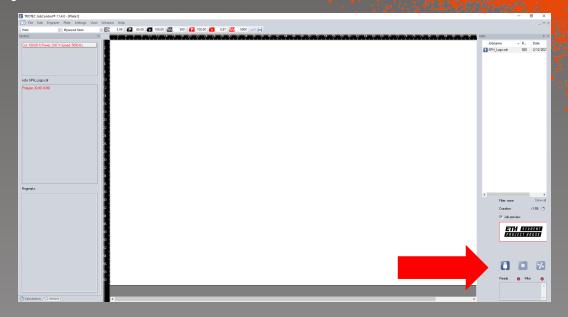
Lastly press the "Print" button to send your file to the cutter software.

General Favorites Print
⊢ *
Size Settings User-defined Size Vidth 1016.00 mm Take from Application Height 610.00 mm Minimize to Jobsize Rotary Attachment Ø mm
Material Settings Holz
Process Options Image: Standard with the second
Invert Shoulder medium Flip vertically Layers ♀ Flip horizontal Z-Adjust/L ♀ ✓ Enhanced Geometries Z-Adjust/L ♀
Process 1, Power



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.



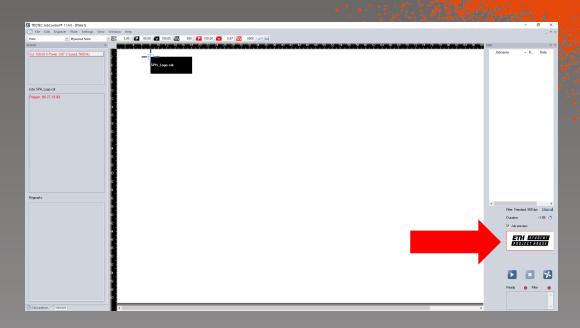
Select your job from the list on the right and drag it onto the virtual machine table left to it. The current laser position is indicated with the small crosshair. You can use it to position your job on the print bed.

TROTEC JobControl # 11.4.0 - [Plate1]		- 0
File Edit Engraver Plate Settings		-
Holz Plywood Smm Vectors	- 😿 5.00 😰 6500 🕶 100.00 🚾 500 😰 100.00 🚾 0.01 🚾 500 🖙 📮 × 2 4 6 8 10 12 14 16 18 20 22 24 26 26 30 32 34 36 38 40 42 44 46 50 52 54 56 58 60 62 64 66 68 70 72 74 76 78 60 62 64 🔥 68 90 5	Jobs
Cut: 100.00 % Power, 0.87 % Speed, 5000 Hz	× 2 4 6 8 0 2 4 6 8 0 2 3 8 0 2 3 8 0 2 3 8 0 0 4 4 6 8 0 2 3 5 5 5 5 5 0 0 0 0 6 6 6 6 0 2 3 8 0 0 0 0 0 0 0 0	Jobname A R., Date
Cut TOLIOUS Power, U.SV % Speed, DOOLH2		SPH_Logo.cdr 500 2/12/
lobs SPH_Logo.cdr		
Polygon, (0.00, 0.00)		
Regnarks		
		٢
		Filter: none Sho
		Duration: <1:55
		🔽 Job preview
		Ready 😑 Filter
Calculation 🖾 Vectors		
STUDENT		
HOUSE		

PROJE

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.



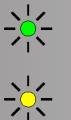
By pressing the small play button on the right, the job will be sent to the machine. The ventilation will turn on automatically and the job will start after 5 seconds.

	ROTEC JobControl @ 11.4.0 - [Plate1]									-	ø
adm × •											
u 10 J 2 2 2 mm J u 10 J 2 2 2 mm J u 10 J											
a norma se s (pen door) he (F) (Lapid argent M2 7:103 argent M2 7:103 argent M2 7:103 b (F) (Lapid argent M2 7:103 b (F) (Lapid b (F)			1 6 8 10 12 14 16	18, 20, 22, 24, 26, 28, 3	0, 2, 34, 35, 38, 40, 42,	44 46 48 50 52 54 5	6 58 60 62 64 68 68 70	72 74 76 78 80 82 84 1	a da Jobs		
etyes (N22.110)	# 100.00 % Power, 0.87 % Speed, 5000 Hz	2 - 4 - 6 -	SPH_Logo.cdr						Jobr	ame A	R Dab
synch. I S S S S S S S S S S S S S	bs SPH_Logo.cdr	10									
Image: State	iygan, (102,7,11,00)	12 16 16 20 22 24 24 26 26 20 24 26 20 27									
	neks	34 - 06 - 43 - 42 - 44 - 46 - 48 -							د	Filter: Standard, 5 Duration: Ø Job preview	00 dpi <u>Sh</u> <1:55
		80 52 54									
											Filter
TUDENT									,		

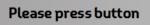
PROJE



Dead Man Switch



All good!





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.





- 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 one minute after the job is done

