MARCH 1, 2023



EPILOG FUSION EDGE - 50 WATT - 24 IN. BY 24 IN.



OPERATING EPILOG LASER STEP BY STEP: HOW TO ENGRAVE AND VECTOR CUT

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PROCESS OVERVIEW

1	2	3	4	5	6	7	8
Open Artwork in Inkscape.	Print from Inkscape to Epilog Dashboard application on the computer.	Place material in laser cutter and focus laser.	Align artwork to material in Epilog Dashboard application on the computer	Select settings for vector cutting and engraving in Epilog Job Manager on the computer	Print from Epilog Job Manager application on the computer to laser cutter memory.	From touch screen control panel on laser cutter initiate engrave/vector cut.	Clean up.
*							

Using These Instructions

Read one step entirely once before following the instructions to get a clear idea of the goal and process for that step. Then re-read and follow the instructions. If you have a question about a step, the answer is probably in the details column.

Date: 12/15/2022

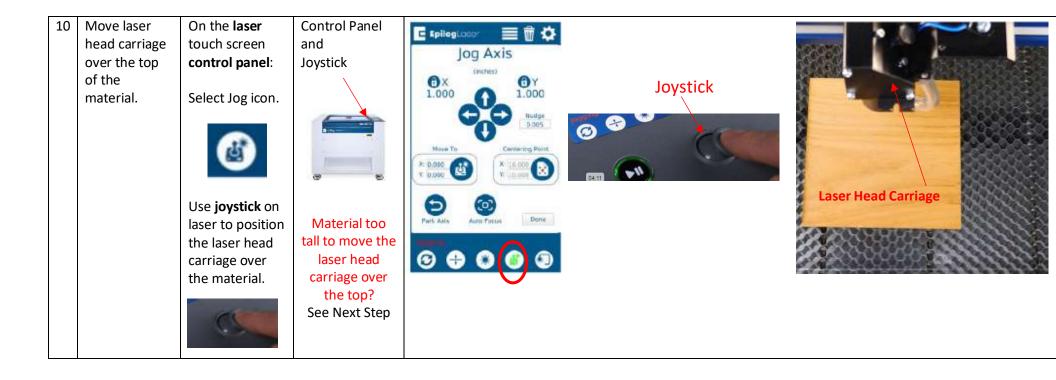
#	Step	Key Points	Details	Picture
1	Turn Laser Cutter on	 There are two keys needed: Main Power Tool Box Once the key is turned, you will see the equipment start to power on. 	The key will allow power to all the equipment. The laser will take a minute or two to boot up. The touch screen control panel on top of the laser will light up and begin to home the laser.	FusionEdge E tellegi.core com
2	Turn on Air Filtration system	Power button is red when the system is off. Touch button to turn on. Power button should turn green and you will hear fan power up.	If all lights are green, skip to step 4. If the arrow lights are red, go to step 3.	ECCEA THE WORLD LEADER IN FUME EXTRACTION TECHNOLOGY

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3		This step is only	Red lights on	
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		to step 4.	See staff for	
		to step 4.	assistance.	
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			fan speed.	FUME EXTRACTION TECHNOLOGY
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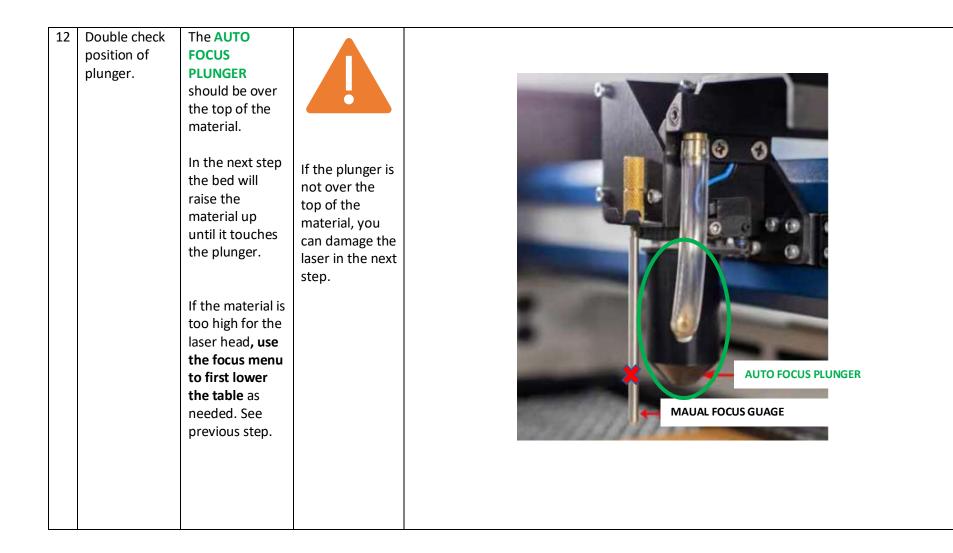
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		will see the vector and	the material.	Code 0 1/2 3/4 1/2
		engrave process.	Lines that are .003 inches wide or thinner	
		Some designs will come across with only a vector or an	are assumed to be vector cut lines.	
		engrave. You can always change the process to be the one you want later.	Engrave: This process applies the artwork to the surface of the material.	Time 0/00.252 Charted (0/22/2019 10/02 kml) Printed 16/22/2019 10/02 kml) Printed 16/22
9	Place Material into Laser	For best results. place under one of the overhead cameras.	Cameras are mounted in the center on the underside of the hood door.	
		Close the lid of the laser.	Closing the lid is required for the cameras to see the material.	



11	Material Too	If the material is	When you are	
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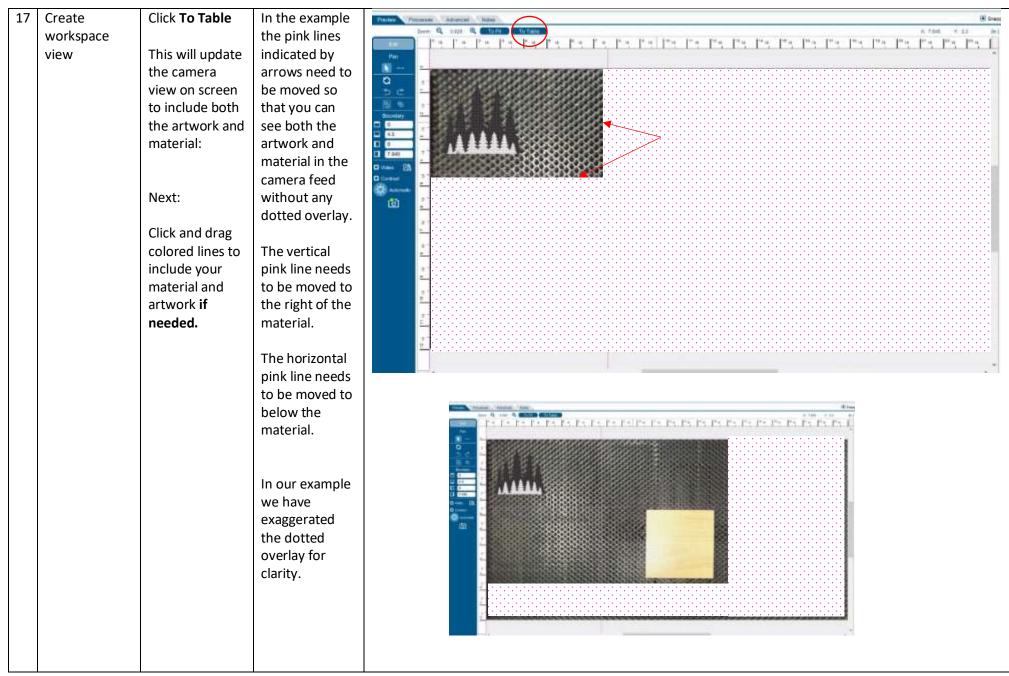


13 Focus Laser (auto focus) While in Jog menu on the laser: Select the focus icon and use the screen controls to move the table so the top of the material touches the plunger will touch the top of the material. Image: Control the table. 7 Focus Laser (manual focus) Select the focus touches the plunger will touch the top of the material. Image: Control the table. Image: Control the table. 8 Select the focus isor working, if the auto focus gauge. The joystick will also control the table. This step is needed only if the auto focus isor working, if the auto focus gauge. The joystick will also control the table. This step is needed only if the auto focus isor working, if the auto focus gauge. The joystick will also control the table.				1	
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14	Park the laser head carriage.	On the laser touch screen tap:	This will park the laser head carriage in the upper left corner of the table. You will need it out of the way to align your artwork to the material.	
15	Design View in the Epilog Dashboard	Sometimes you need to adjust the zoom to see both your material and artwork . Click To Table button for quick adjust. Or use the zoom controls to the left of the To Fit button.	Adjust the view on the computer screen to allow you to see both the design and the material. If you are not seeing a live view, check the video box to turn on the camera. Your artwork or material may be difficult to see with the dotted overlay and may not appear exactly as shown in our example image.	<complex-block></complex-block>

Page **11** of **29**

1. On the computer select PAN.to see in the camera view.2. UNCHECK the video box.Switching to the Pan mode and turning off the camera will allow you to see if your artwork is there and the location of the artwork.Image: Computer select image: Computer sel	 tprogramming zerost
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Page **13** of **29**

18	Align artwork with material	Click and drag your design graphic over the material. See the tip in step 16 about how to find your artwork if it is hard to see.	You will want to align the graphic with the material so that it appears where you want it applied to the material.	
19	Zoom in to check alignment. OPTIONAL	Click the button: To Fit This will zoom the camera in to focus in on the artwork and material. You may need to physically straighten your material by hand in the laser to improve the alignment.	Zooming in after your initial alignment allows you to fine tune the placement. TIP: Placing material in the upper left against the guide rulers can help ensure getting material square.	Edit Epilog Dashboard 2.1.5 Machine: Fusion Pro 48 3.4 Name: WOOD-name-badge.cdr Preview Processes Advanced Notes Zoom: Q 0.112 Q To Fit To Table Edit 0 2 4 6 8 10 12 14 16 18 20 22 24 26 28

20	Select Process: Click on process image to select.	Select process: • Engrave • Vector You may only have one option that appears. You can change the process to be either Engrave or Vector later. EPS 21 TO 34: Gu	Engrave applies the artwork lines and shading to the surface of the material. Vector cuts through the material along the lines.	Clicking the image will expand the process. Click the image in the expanded view will collapse the process.
21	Adjust Settings: Split By OPTIONAL No selection required.	Color: moves every color in the graphic to a separate process. Hairlines: move .003 inch (.077mm) wide lines to a separate process Color & Hairlines: sends each color and hairline to a separate process so you can select the settings for each type of line.	If you have color coded your artwork so that you can apply different power and speed setting to different lines (cut some line, engrave some lightly, engrave some deeply, etc.) you may want to try using the Split By Color setting.	<complex-block> Image: Contract of the contra</complex-block>

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22	Settings:	Merge the	If the laser has	Engraving Process Vector Process
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23	Cotting	You can change	Off laser will	
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			material along	
			the lines.	

24	Resolution	Use the slider to	DPI: dots per	Engraving Process	
	Setting REQUIRED Engraving Only	 select engraving resolution DPI value. 300 DPI: glass, marble, acrylic 400 DPI: default 600 DPI: artwork with fine detail 1200 DPI: very small fonts 	inch (sometimes known as PPI). See the Suggested Material Settings document to help select a DPI value.	Engrave CO2 / Figsze CO2 / Figsze Soft Ey: Soft Ey: Color O Haisines Mirgs with: O Process Type Engrave Process Type Engrave Process Type Engrave Sold % Sold % So	A COLORED COLO
25	Settings: Speed Power REQUIRED See the Suggested Material Settings document to help select values.	Speed: controls how fast the laser moves over the material. Power: controls the intensity of heat applied by the laser. UNSURE? Test using a scrap of the same material. Start with a low power and a high speed. Adjust until you achieve the desired results.	Slower speeds and/or higher power result in deeper engravings or vector cuttings. Slowing the laser speed has the same impact as increasing the power.	Process type Engrave Resolution Resolution Speed Power Solution Speed	Vector Image: Crop Vector String S

26	Settings: Frequency Vector Only	Frequency is only active on vector cutting processes. Frequency controls the number of laser pulses the laser fires per inch of travel. See the Suggested Material Settings document to help select values.	Lower frequencies are good for materials such as wood that shows charring on the edges when cut. Higher frequencies are good for materials such as acrylic.	Engraving Process Evgram Evgram System System Evgram Evgram System Sys	
27	Settings: Dithering OPTIONAL No selection required. Engraving Only	Dithering: Grayscale Photo: Stucki or Jarvis Text and ClipArt: Standard Line Art : Bayer	Dithering is only for engraving process and is used to enhance outcome of grayscale photos.	Engraving Process Sport Spo	

8 Settings: Unidirectional OPTIONAL No selection required. Engraving Only	Recommended Setting: OFF	Turning this on sets the engraving process to run left to right only. This requires more sweeps of the laser and results in a longer process.	Usidentional Off Cost
9 Settings:	Recommended	Enhances	
Precision Sync	Setting: OFF	engraving quality but increases the total run time.	Engraving Process
No selection required. Engraving Only		This setting is only available for engraving processes.	Process Type Engrave V Resolution Store Speed Store Power Store Different Bancard V Undefine Sync Off Con Presstor Sync Off Con Different Office Different Office

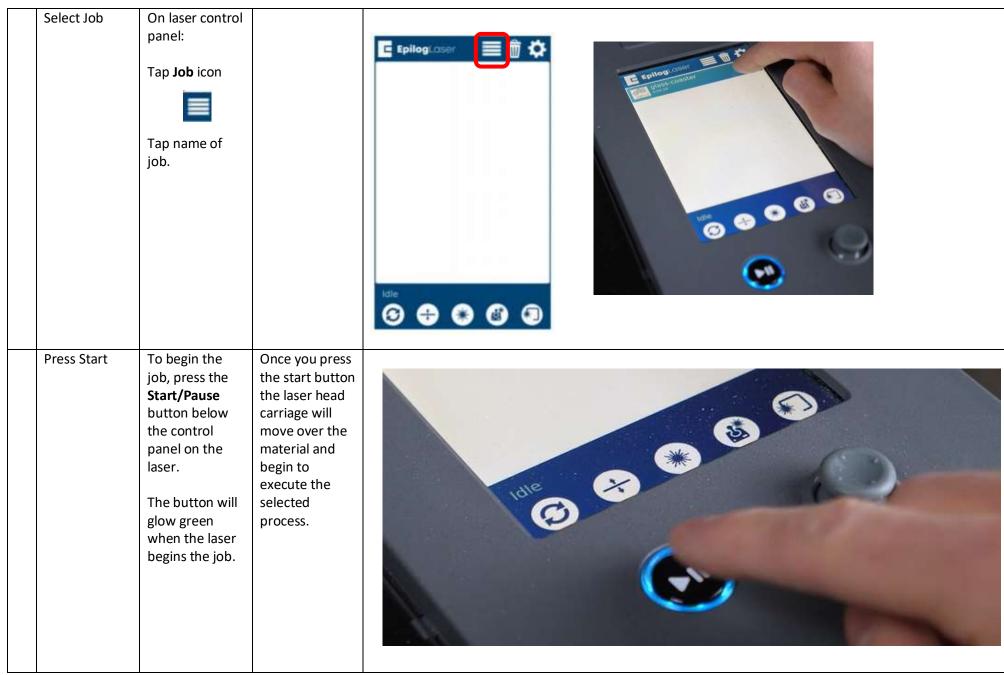
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30	Settings:	Enter the	Sometimes	
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	<mark>OPTIONAL</mark>	same material.	second or third	Recolution 500 Spood 50.0 % Process Type Vector V
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31	Settings:	Recommended	Allows you to	
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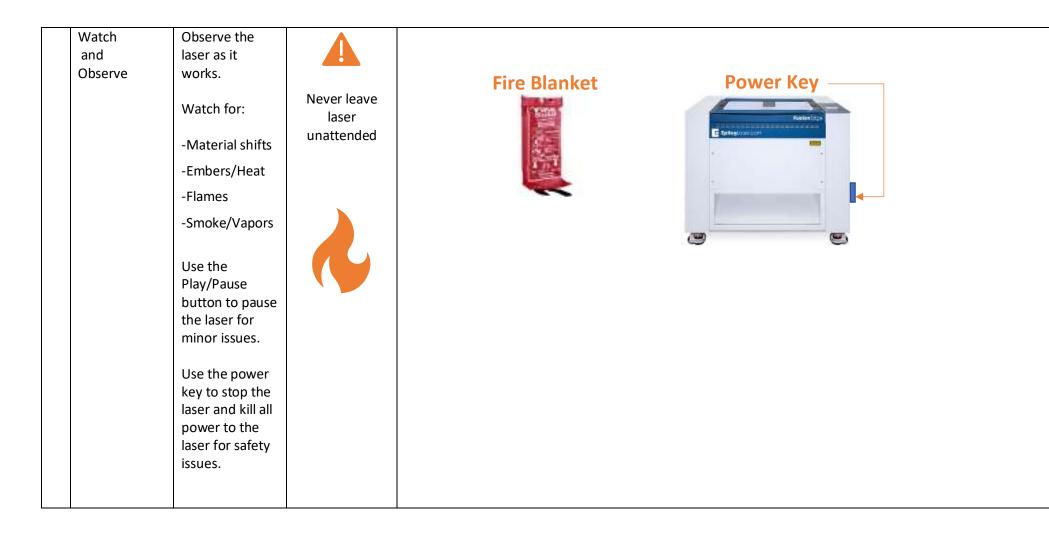
32	Settings:	Recommended	Only for Vector	
52	Jettings.	Setting: ON	Cutting process.	
	Beziers	Setting. UN	Cutting process.	Vector Process
	Deziers			Vector En C02 / Vector En S906 / S006 / S096 En Run Time: 0:00:08 En
	VECTOR ONLY	This setting fine-tunes how the path of the laser follows each point in a curve when vector cutting.		Split by: Color ● Hairlines Merge with: ● Process Type Vector Speed ● Øwer ● <
33	Settings:	Select:	Only for Vector	
	Vector Sorting	None: Lines cut in order the lines were created.	Cutting Process Recommended Setting:	Vector Process
	VECTOR ONLY	Inside/Out: Internal lines will be cut before the external lines. Optimize: Process in order of next closest node to reduce run time.	Inside/Out	Merge with: •••• Process Type Vector Speed •••• Vector Sorting Optimize Thickness •••• Offset •••• Speed •••• Speed •••• Speed •••• Speed •••• Sp

34	Check Run	The total time	Give yourself an	
	Time	to complete the	additional 15	Vector Process
		job is displayed	minutes after	Vector Process Engine (b)
		for all the	your job	
		process you	completes to	Run Time: 0:00:08 Split by: O Calor O Hairlines
	REQUIRED	plan on running.	clean up and	Split by: O Color O Hairlines Process Type (Engrave
			checkout.	Marge with: Resolution
		Be sure to get a		Process Type Vector V Speed 50.0 %
		total time for all	Need more	Power (50.0 %)
		your engrave	time? You will	Prequency Sol.0 % Bedens Off Off Off Off Off Precision Sync Off
		and vector	need to stop	Vector Sorting Optimize Victes
		processes.	now and make	Uydes L
			a new	Offset. 0 in.) Ciraction
		<mark>Do you have</mark>	reservation.	
		<mark>enough time</mark>		
		<mark>before the end</mark>	You will not be	
		<mark>of your</mark>	able to start a	
		reservation?	process and	
			then resume it	
			at a later date.	
	Repeat for	Repeat setting	If your artwork	
	each process.	selections for	has both vector	
		each engrave	cutting lines	
		and vector	and engraving	
		process in your	lines, you will	
	Steps 20 to 34	project.	want to select	
			the settings for	
		You will select	all your	In the next step, you print the artwork to the laser. This will
		all your settings	engraving	send the instructions to execute the engrave processes first
		and send all the	processes and	and then automatically execute the vector processes.
		processes to the	vector process	
		laser to	first.	
		execute.		

Print to Laser	Click Print	This will send the job and settings selected from the computer to the laser. This will load the job in the laser memory, but the job will not run.	
Confirm air assist compressor is running.	Be sure air assist compressor is running and air is coming through the nose cone of the laser head carriage. When you place your hand or a slip of paper under the nose cone you should feel air coming out or see the paper being blown downwards.	The air assist is essential for preventing fires. The air assist clears the soot and fine particles that are the first to catch fire.	NOSE CONE

Confirm Ventilation is Running	Make sure the BOFA ventilation is on and running. The green light on the power button should be glowing green. Red lights on the arrow keys indicates a problem.	This system will filter the air from the inside the laser. It is UNSAFE to run the laser without the ventilation system on.	ECCEA
Confirm all doors and panels are closed.	Close the hood of the laser.	It is UNSAFE to run laser with any doors or panels open.	





Park laser	After the job		EpilogLaser 📃 🏛 🌣
head carriage.	completes:		
	Press the reset icon: If the laser head carriage will return to upper left of the laser bed area.	Before removing the material, it is important to park the laser head carriage out of the way to give you room to easily remove your material from the laser.	
Remove Material	Open the hood/lid door of the laser. Remove your material.	Once the laser head carriage is parked and out of the way, you can then remove your project from the laser. Take care not to bump laser head carriage, mirrors, or cameras.	

Clean Up	Vacuum up soot and debris from laser bed. Wipe down interior of laser with a barely damp rag as needed. Wipe down table and work surfaces as needed. Return tools to toolbox.	Soot and debris in the laser are fire hazards.	Vorktable has tabletop outlets.
Check Out	See staff. Return access keys.	Staff will verify the area is clean and check all tools are present and in correct location in toolbox.	
Post Processing	Use a damp towel to wipe off any soot or debris.	At home you can do a final clean-up of your project.	

TOOL INVENTORY

Drawer 1 – 3 items



Drawer 2 – 2 items

Drawer 3 – 2 items



- Instructions
- Suggested Settings Sheet

Measuring tape

Calipers

Scissors

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Drawer 4 – 2 items



Drawer 5 – 3 items (STAFF ONLY)



• Cleaning solution

BOFA manual

Epilog manual

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- Cleaning Instructions
- Allen Wrench



- Focus Gauge (bag)
- Rotary Rim Part



• Rotary Tool