

Kern Laser Instructions

- I. Locate laser glasses that are labeled for the Kern Laser
 - o OD 6+ @ 10,600 nm
- II. Load design into Corel Draw. Ensure that layers are in correct order (they will be treated in reverse order) and that you have the correct linewidth (smallest linewidth is cut, all else is engrave). Ensure that it is positioned correctly on canvas.
- III. Change colors of items in Corel Draw to align with vector color options in KCAM 7 if you wish to use different cut settings in one file
 - o KCAM vector colors: Black, Red, Green, Yellow, Blue, Magenta, Cyan, Purple, Orange
- IV. Convert full-color images to greyscale in Corel Draw before exporting to KCAM 7
- V. Export to PDF using red laser button in upper right hand corner
- VI. Open KCAM and load file.
- VII. Click SETUP to set speed, power, and laser frequency in VECTOR COLORS. Check all colors necessary for the design.
- VIII. Click IMAGE SETTINGS to set LASER POWER FOR BLACK and LASER POWER FOR WHITE corresponding to engraving settings for different materials. Set ENGRAVING SPEED -> INCHES PER SECOND
- IX. Turn switch to ON. Press START for laser system and vacuum blower (Chiller will automatically turn on)
- X. Turn both blowers ON (press right arrow once)
- XI. PUT ON LASER GLASSES
- XII. Connect jumper cables in 5-second delay. All lights will be green except laser enable and DSP enable (laser enable turns green during process)
- XIII. Ensure all holes are covered in stock material without blocking cut area

- XIV. Click CUT button to load Cut and Engrave Menu.
- XV. Click AIR ON/OFF to check air comes out of laser nozzle
- XVI. Check process you are doing (cut, engrave, cut/engrave)
- XVII. Press CONTINUE to start cutting file. Laser will move to position
- XVIII. Press ENTER or click CONTINUE to start process. Monitor and click stop/emergency stop if necessary.
 - o NOTE: the laser cuts continuous lines. It will only punch through the material once.
- XIX. Turn laser OFF by cycling laser key. Turn both blowers OFF. STOP laser system and STOP vacuum blower. Turn switch OFF.