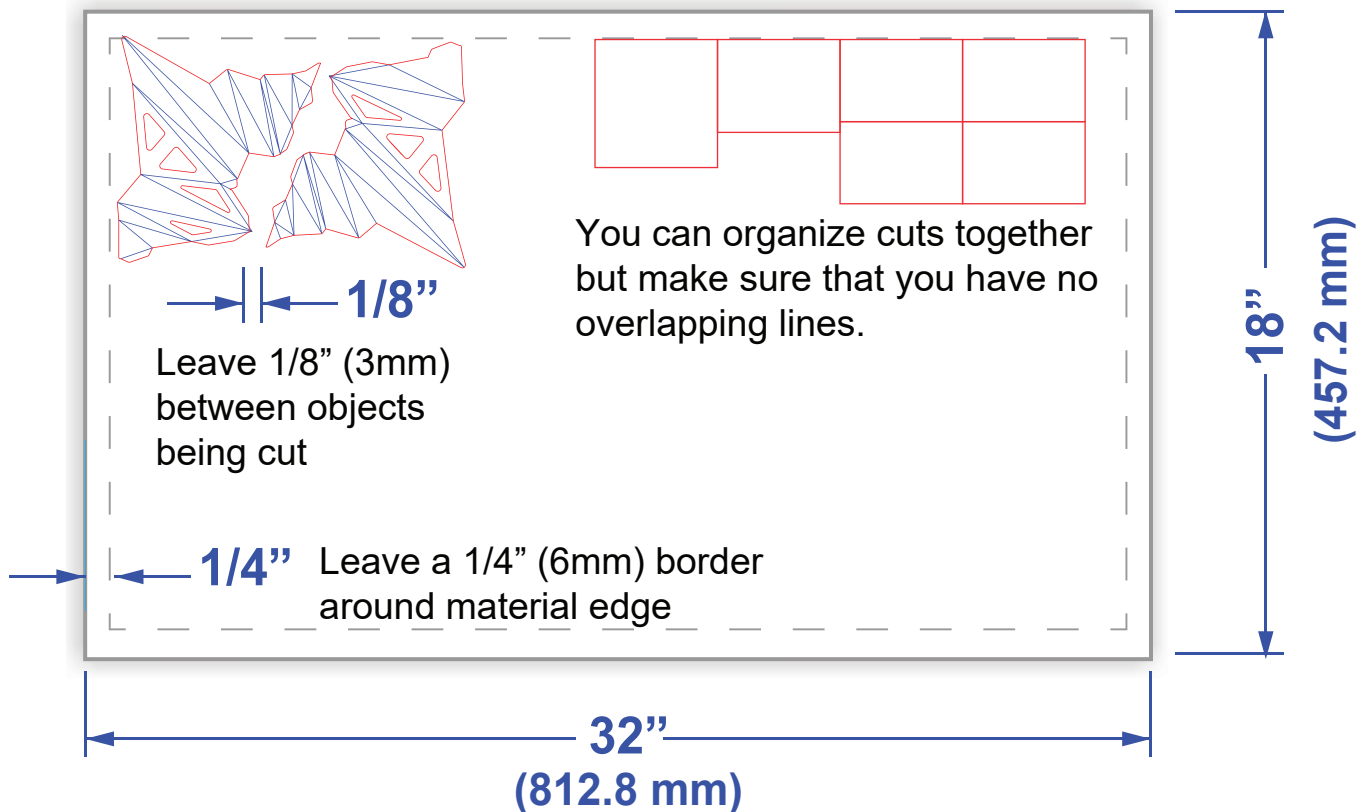


## General Setup in Rhino:

### On your computer:

- Setup your document to the proper size of the laser beds 18" x 32" (457mm x 812mm)
- Know the size you need your material cut down to before you come in.
- Use the proper colors (defaults in Rhino) and line weights (0.001 in.):  
Cut- Red (255,0,0)                      Etch 1- Blue (0,0,255)                      Etch 2- Cyan (0,255,255)  
Raster- Black (0,0,0)
- For all files leave a 1/4" (6mm) border around the edge of your material. This is to ensure accuracy even if your material is not square, or the machine is slightly off.
- Layout your materials smartly. Nest your geometry to save space, but leave at least 1/8" (3mm) space between your pieces.
- Overlapping lines are a fire hazard. Use the "Overkill" command in AutoCAD and the "SelDup" + "Delete" commands in Rhino to get rid of overlapping lines.
- Joined lines save time. Lots of exploded lines can cause the laser cutter to jump across the bed adding significant travel time. Please join your lines.
- Avoid hatching in your files. Preset hatching patterns, especially concrete, has a lot of small unnecessary geometry. This adds a considerable amount of time to your file.
- Avoid downloaded CAD blocks of furniture, fixtures and trees. These are usually extremely messy files with explodes linework that won't join. Your file will run more quickly with simple shapes you create.



## Material Tips:

- Acrylic melts as it burns, so long thin strips of acrylic will warp up and distort. If you need these in your model please purchase acrylic dowels/rods.
- Your material should be completely flat. Any bowing in your material will change the focus on the laser and it will cut wider in those areas. If you have significant warping in your material it won't cut all the way through and could result in a fire.
- You can laser cut dowels up to 1/4" thick. It works better if several are taped together like they are a single sheet. Have a cut line 1/4" in from the border to start to ensure lengths are accurate.
- Reflective surfaces are not laser cuttable, but there are some exceptions to this rule.
  - Mirrored acrylic and foil papers can be cut with the reflective side facing down. You'll need to mirror your geometry before cutting.
  - Metal and glass may be etched if coated with a laser marking spray

## Materials List:

Maximum allowable material thickness is 0.25" or approx. 6mm

Allowable Materials	Prohibited Materials
Acrylic/Plexi	PVC/ABS
Wood <0.25"	Polycarbonate/Styrene
Plywood*	Foam/Foamboard
Matboard	Metal
Chipboard	Glass/Mirror
Various Papers	Reflective Surfaces
Corrugated Cardboard**	Stone
Cotton Fabric/Felt	MDF

\*Please ensure that your plywood is of higher quality/grade and is intended for laser cutting

\*\*Cardboard must be sitting flat, any bow on cardboard is a fire risk. We suggest using the Zünd

**Do not have overlapping lines**

We will not cut any plastic other than Plexi or Acrylic.

If your material is not labeled: We have the right to refuse to cut it.

If you do not see a material on this list or are unsure about a material - Please ask.

**Machines shut down 15mins before closing for cleaning**

**Please plan ahead**