

01 - Lightburn Job Setup

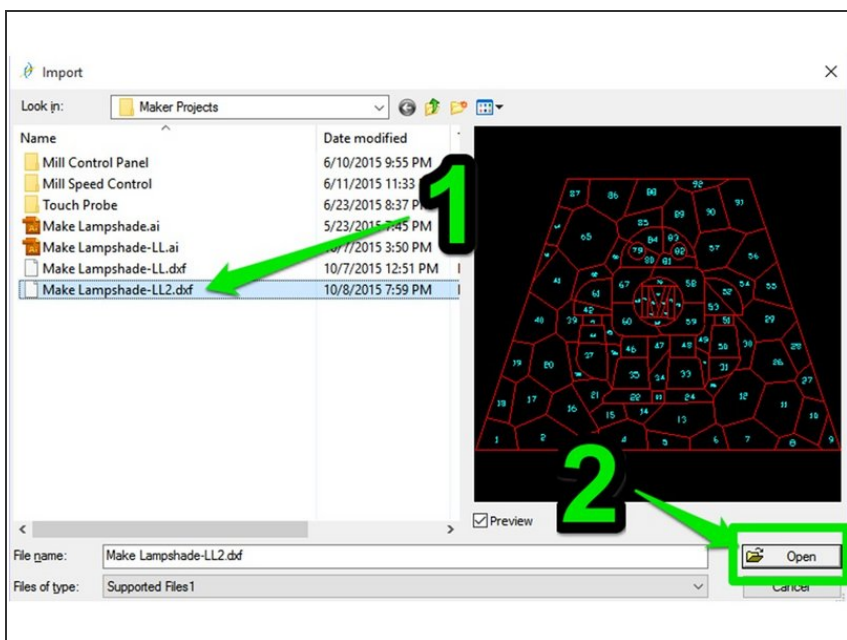


Step 1 — Open RDWorks



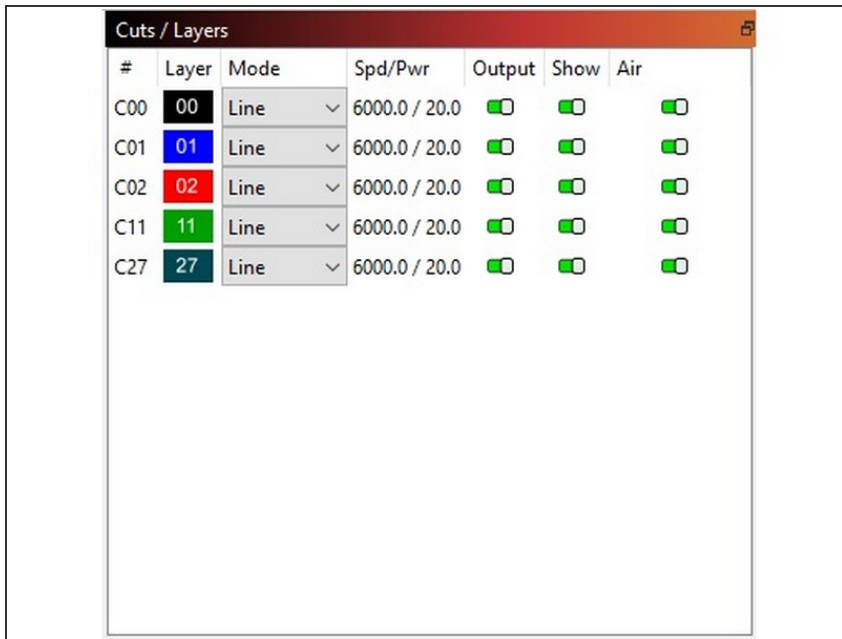
- Double click the RDworks Icon on the desktop to start RDWorks

Step 2 — Import your artwork



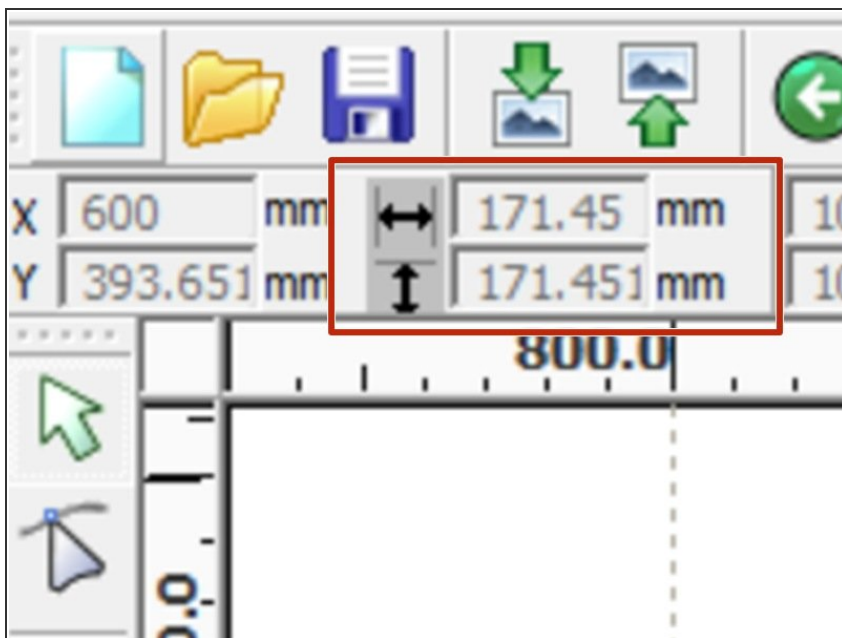
- Click File -> Import on the menu bar
- Select your file and click "open"
- The laser cutter can import dxf and ai files most easily for vector formats. Additional formats are supported for image engraving.

Step 3 — Check Layer Import



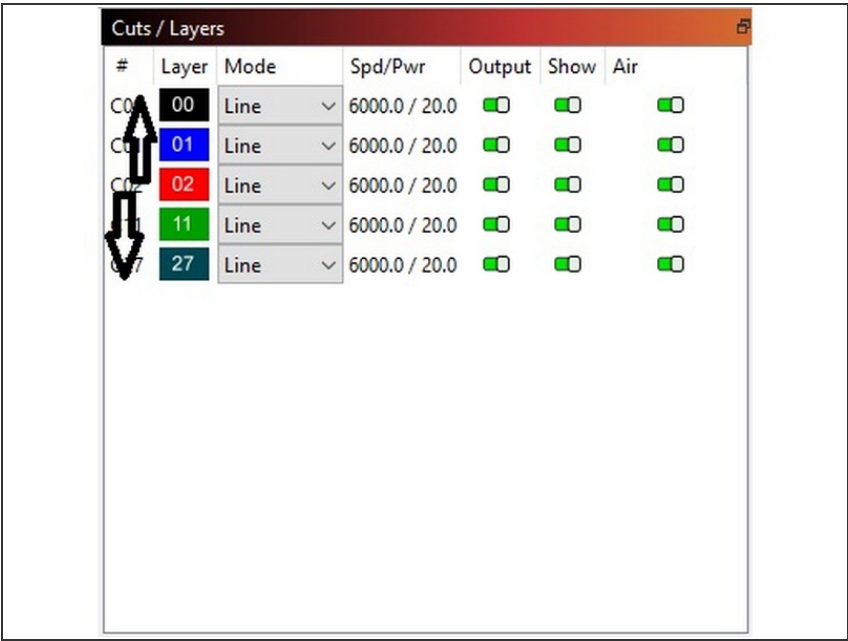
- Layers or colors will be separated depending on the file type you are importing. (Refer to documentation for specific programs for details).
- Check the "Cuts / Layers" in the top-right of Lightburn to see that your layers imported correctly.
- Click the "Window" at the top, and make sure Cuts / Layers are selected if you do not see it.

Step 4 — Check the Dimensions of Your Import



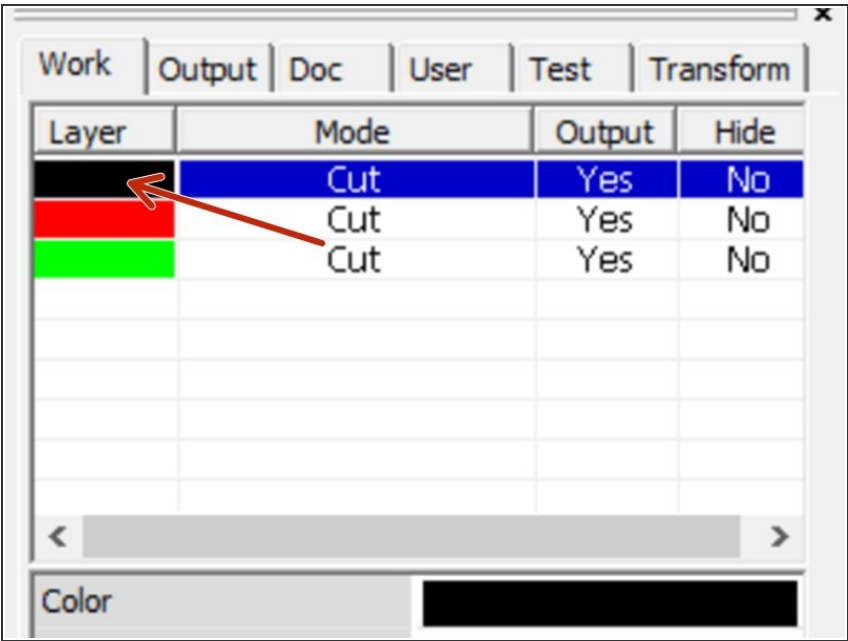
- Press Ctrl-A to select all objects.
- Check that the dimensions displayed in the top-left of Lightburn are correct for your desired output size. Adjust as needed. If you can't see, make sure in full screen.
- ① DXF files can be imported with the wrong units. Checking the overall job dimensions helps prevent surprises.

Step 5 — Check Layer Order



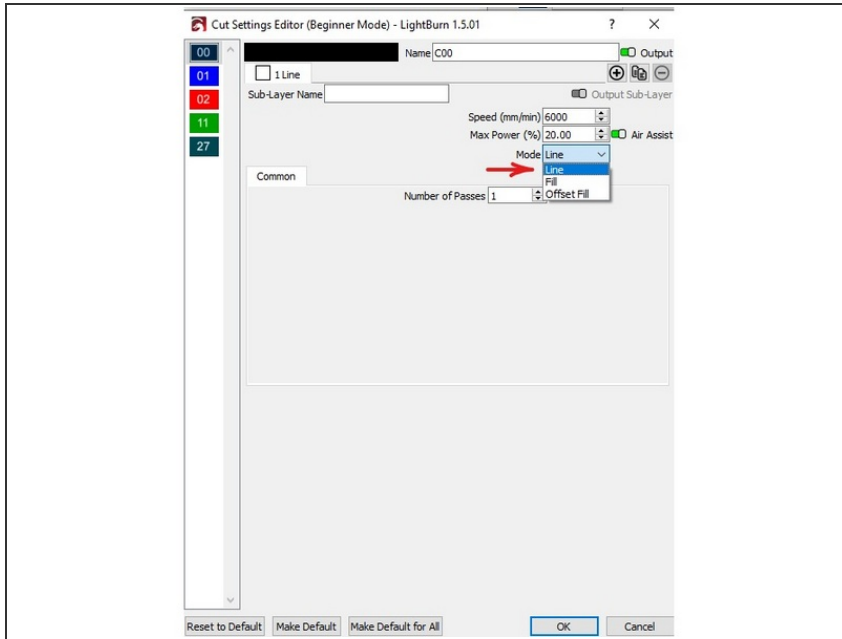
- i* If your job has multiple “layers”, the layers will be cut in the order they are displayed in the work panel.
- Reorder layers by dragging and dropping them into the correct order.
- i* Key Point: It probably makes sense to set engrave layers before cut layers as the focus or position can change once the job is free from the surrounding material.

Step 6 — Change Layer Settings



- Double click a layer to open the settings dialog.

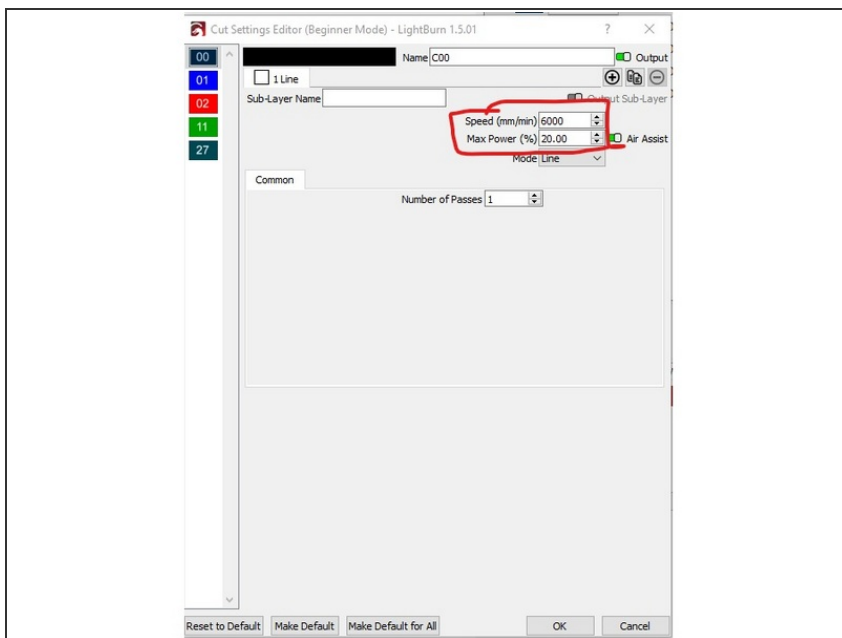
Step 7 — Layer Settings: Processing Mode



● Processing Mode

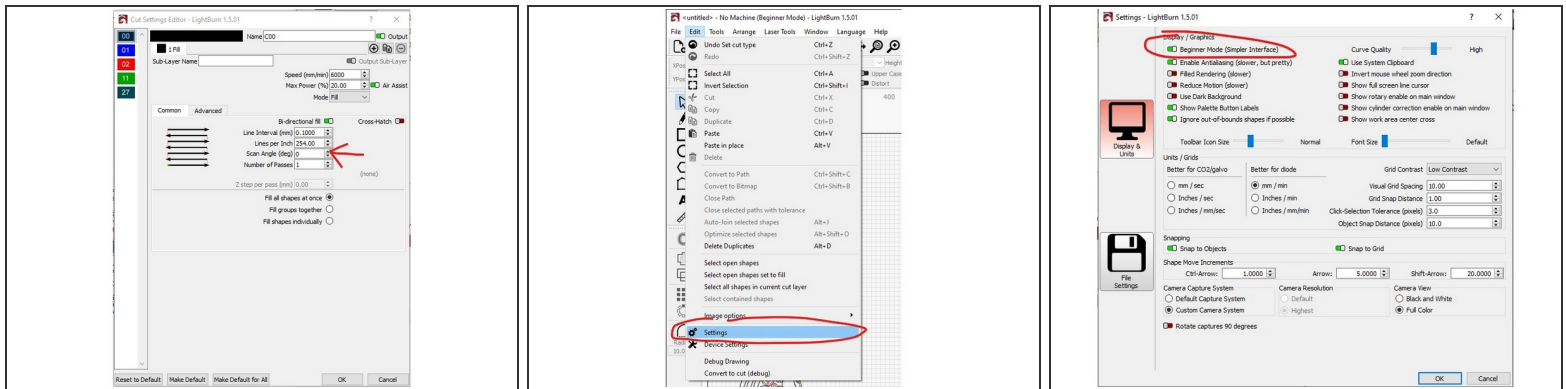
- **Line:** The laser cutter will **follow** your vectors.
- **Scan:** The laser cutter will "Fill" across your atwork, turning the laser on and off depending on if your shape it closed or not.
- **Output:** Controls whether the layer will be output to the machine.
 - ❗ Even if "output" is "off" the layer will still be used when calculating the origin point. This is useful for reburning only portions of your design.

Step 8 — Layer Settings: Common Settings



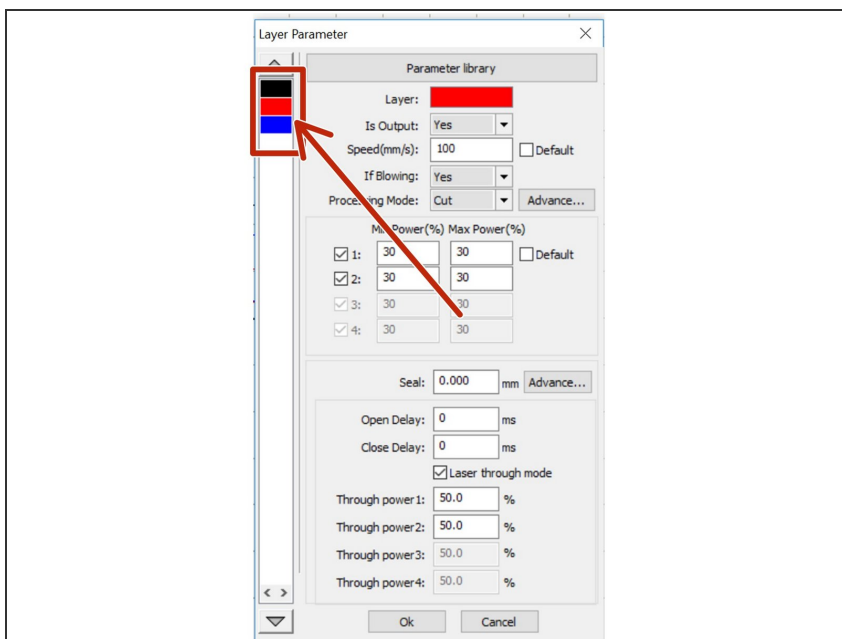
- **Speed:** Sets the speed the laser will use when running the layer.
 - For a deeper engraving, decrease the speed.
 - For a lighter engraving, increase the speed.
- **Power:** The power the laser cutter will use to drive the tube.
 - ❗ Max value: 50% (the laser will clip beyond this number)
 - For a lighter engraving, decrease the power.
 - For a deeper engraving, increase the power.

Step 9 — Layer Settings: Scan Specific Settings



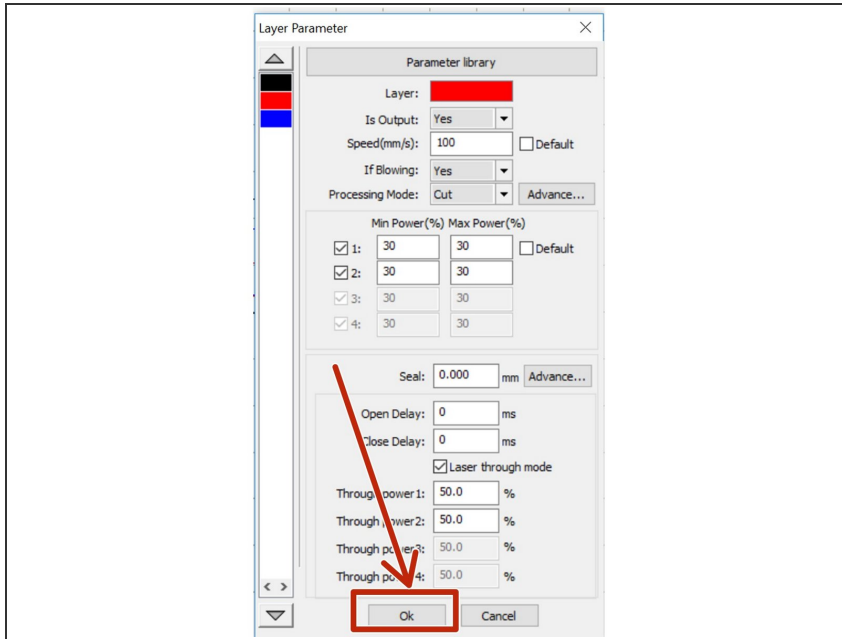
- In order to gain access to the Fill settings, at the top select "Edit", then "Settings". Then disable "Beginner mode".
- **Scan Mode:** Controls the direction of the scan operation. CHANGEME
- **Xswing:** Scan horizontally, burning in both directions. CHANGEME
- **YSwing:** Scan vertically, burning in both directions. CHANGEME
- **X-unilateralism:** Scan horizontally, only burning in one direction (slower) CHANGEME
- **Y-unilateralism:** Scan vertically, only burning in one direction (slower) CHANGEME
- **Interval:** The amount the laser cutter will "step" between each scan line. 0.1mm is a good starting number.

Step 10 — Layer Settings: Switching Layers



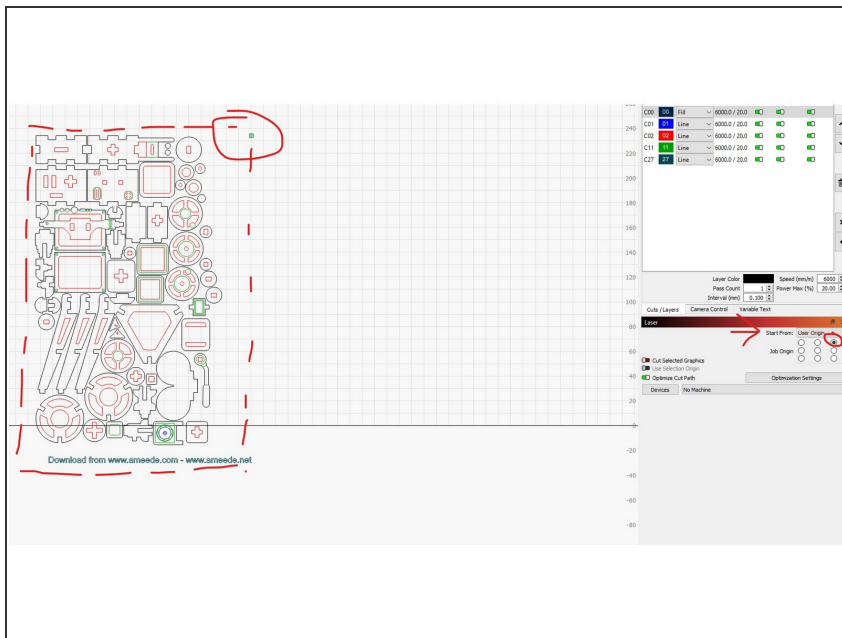
- To jump between layers, you can click the layer swatches on the left hand side of the layer properties dialog.

Step 11 — Layer Settings: Save Settings



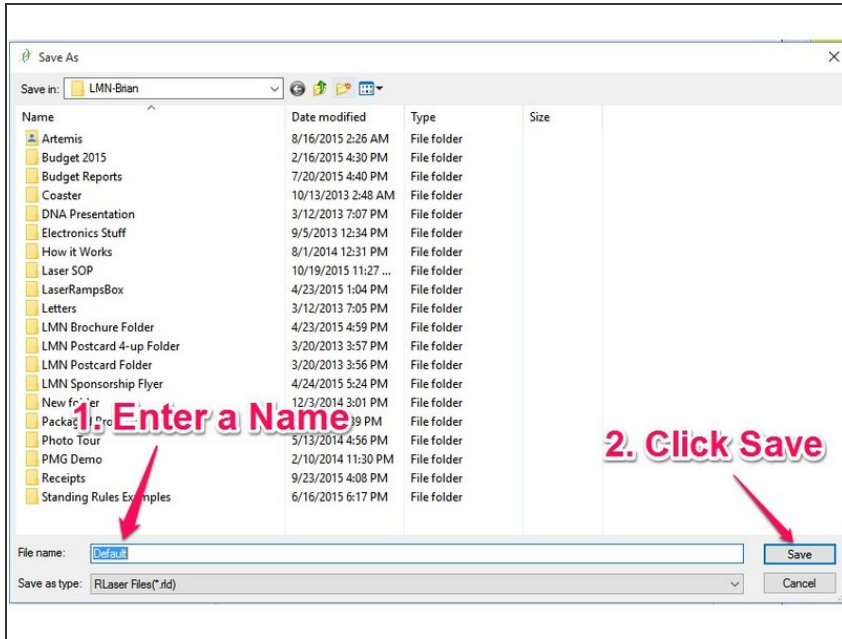
- Click "OK" to save your layer settings.

Step 12 — Set Origin Position



- The origin determines how the laser cutter will reference your design to the actual material.
- You can choose from 9 positions. When setting up the machine, you will align this position on your artwork to the correct location on your material.
- Choose: *Start From: User Origin* from the "Laser" bar to access the dropdown
- Click "Close" to save your settings.

Step 13 — Save your RLD file (optional)



- Saving your RLD file saves all of your layer settings and job setup. You can also skip this step and go directly to running your job.
- Select *File* -> *Save*
- Enter a Filename
- Click "Save"
- ⓘ Please avoid leaving files saved on the desktop. Create a folder in "Documents" if you need to save something.
- ⚠ Files saved on the laser cutter computer may be deleted at any time, **without warning**. Please take responsibility for your own files and backups!

You've successfully completed your job setup. You're now ready to proceed to [laser cutter startup!](#)