

Rotate Marking Instructions

- Text rotate marking
- 1. Create a new text, click the "fl" icon on the right, enter the text, modify the text size, and the application will take effect (set the text according to the marking requirements)



2. Adjust the text direction as required, place the text in the center of the processing area, and fill in the text.



Cloudray Laser





3. Menu bar—laser—Rotate Text Mark—Set parameters



| | • | Rotate Avis | |
|--------------------|----------------|---------------|-------------|
| ✓ Enable | □ Invert A | | |
| ID Y 👻 | | Gear Ratio | |
| | 12000 | Part Diameter | 10 mm |
| Step per rotation | 12800 B | J | |
| Dist per rotation | 5 mm | I Zero | |
| Min Coor. | -1000 mm | Zero Speed | 100 pulse/s |
| Max Coor. | 1000 mm | Zero Offset | 0 mm |
| Min Speed | 100 pulse/s | Zero time out | 10 5 |
| Max Speed | 5000 pulse/s | | |
| Acc. time | 100 ms | | |
| ✓ Finish goto star | t postion | Seels Come | 1.000 |
| , | 1 5000 | scale comp. | |
| Speed | d jouu pulse/s | Space Comp. | 0 mm |
| | | Shear Comp. | 0.000 mm |

CLOUDRAY

A: Enable extended axis, reverse mode, enable Y axis (enable X or Y axis according to the direction in which the rotation axis is placed).

B: The value of the number of pulses per revolution is the subdivision value on the drive, and the number of pulses usually used is 12800 or 25600.

C: Enable the function of the rotary, the gear ratio value is determined according to the reduction ratio of the rotating axis, the workpiece diameter is the actual diameter of the workpiece to be processed.

4. Enter the diameter of the workpiece to mark





• Vector file rotate marking:



1. Import vector files, modify text size and parameters, and fill files



2. Menu bar—Laser—Split Mark2—Set Parameters

| Laser Help AngleRotate AngleRotate2 MultiFileMark PowerRuler RingTextMark RotaryMark RotateTextMark SplitMark2 ProjectMark Configuration Parameters marke | MarkDemo version Part Time 0.00 Total num Continuous W Mark Selected V Force split V Force all split Vart Diamete 50.000 Enable cross split 0.100 Light (F1) Mark (F2) Enable Art (F2) | part 00 Total 00 Coto special position when finish Axis step 5.00 ▼ ← → x 5 Param(F3) Quit(F5) X |
|---|--|---|
| ID X ▼ Step per rotation 126 | nvert A 300 B | ate Axis C atio 1 ameter 50 mm |
| Dist per rotation 5 Min Coor. -10 Max Coor. 100 Min Speed 100 Max Speed 500 Acc. time 100 | mm Zero S 00 mm Zero S 00 mm Zero O 0 pulse/s Zero tin 0 pulse/s □ Acc | ro peed 100 pulse/s ffset 0 mm me out 10 s surate Zero |
| I Finish goto start posti Speed 500 | on Scale C D pulse/s Space Shear C | comp. 1.000 Comp. 0 mm Comp. 0.000 mm |

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C: Enable the function of the rotary, the gear ratio value is determined according to the reduction ratio of the rotating axis, the workpiece diameter is the actual diameter of the workpiece to be processed.

D: The smaller the split size, the better the engraving effect. Usually the split size is 1~5mm.



3. Enter the diameter of the workpiece to mark

| MarkDemo version Part Time part 0 R 00:00:00 00:00:00 Total num Time Total 00:00:00 00:00:00 | X 0.000 Special pos 0.000 | | |
|---|--|------------------|----------------------|
| Mark Selected | E foto special position when finish | Part Diameter | × |
| ✓ Force split ✓ Force all split [*]art Diamete[†] 50.000 nm ✓ Enable cross split | Axis step $\overline{5.00}$ \checkmark Split Size χ $\overline{5}$ \rightarrow | <u>[50. 000]</u> | mm <u>C</u> ancel |
| 0.100 Light(F1) Mark(F2) | Param(F3) Quit(F5) | | |