
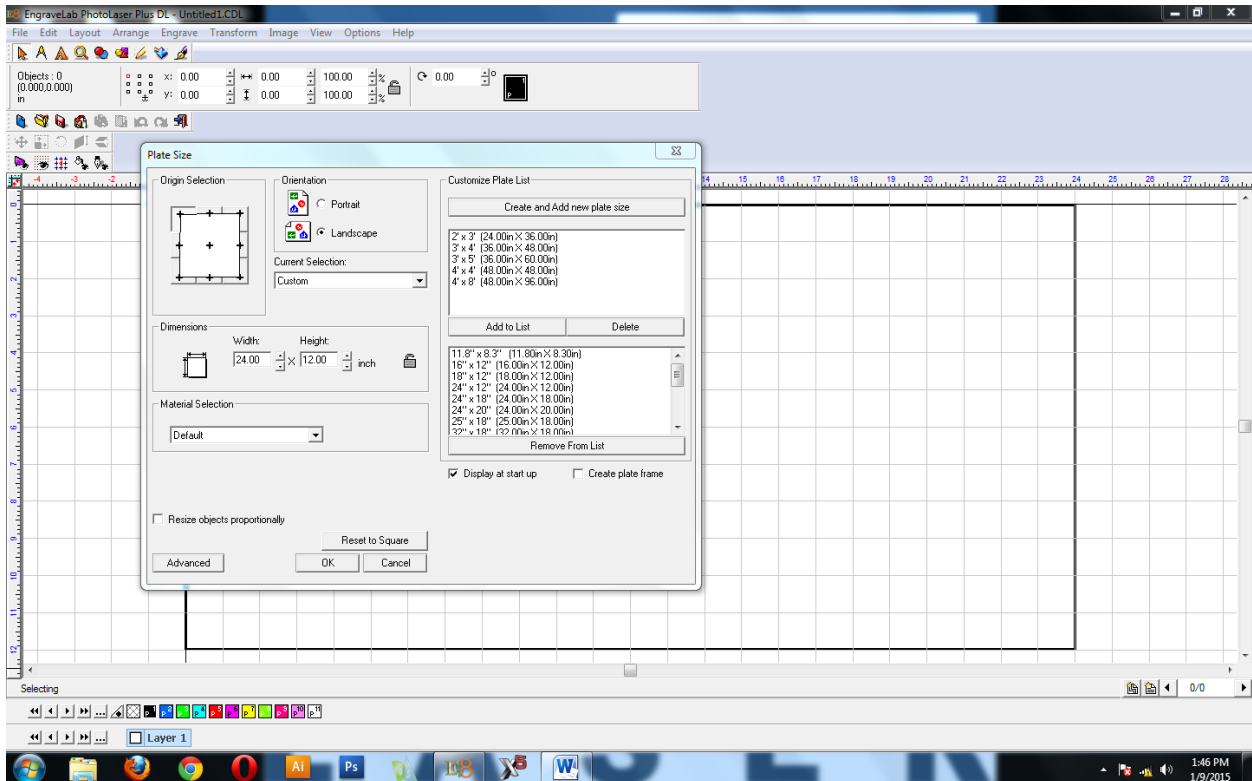


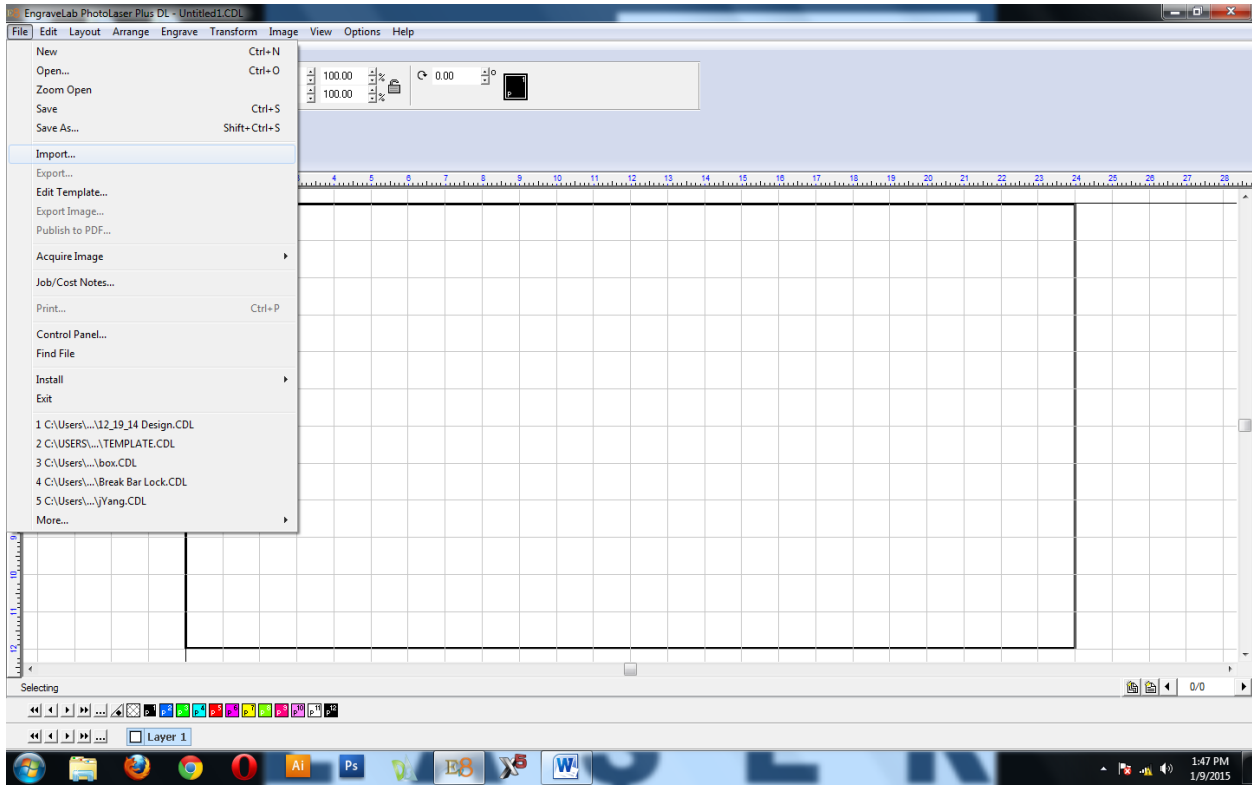
Logon to the computer next to the Epilog Laser, the password is: laser. Choose the  icon on the bottom of the screen.



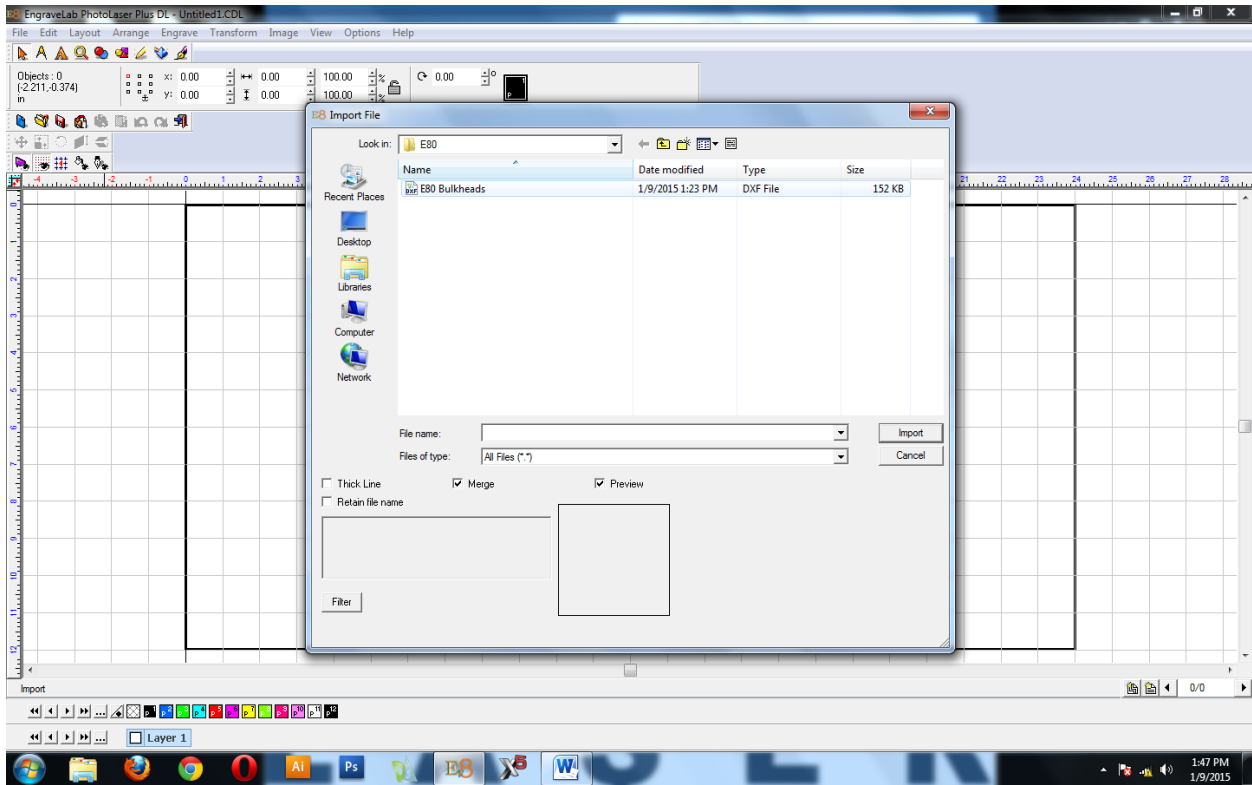
Make sure the upper left corner of “Origin Selection” is selected and verify that the “Width” is 24.00 and the “Height” is 12.00. Click  on:



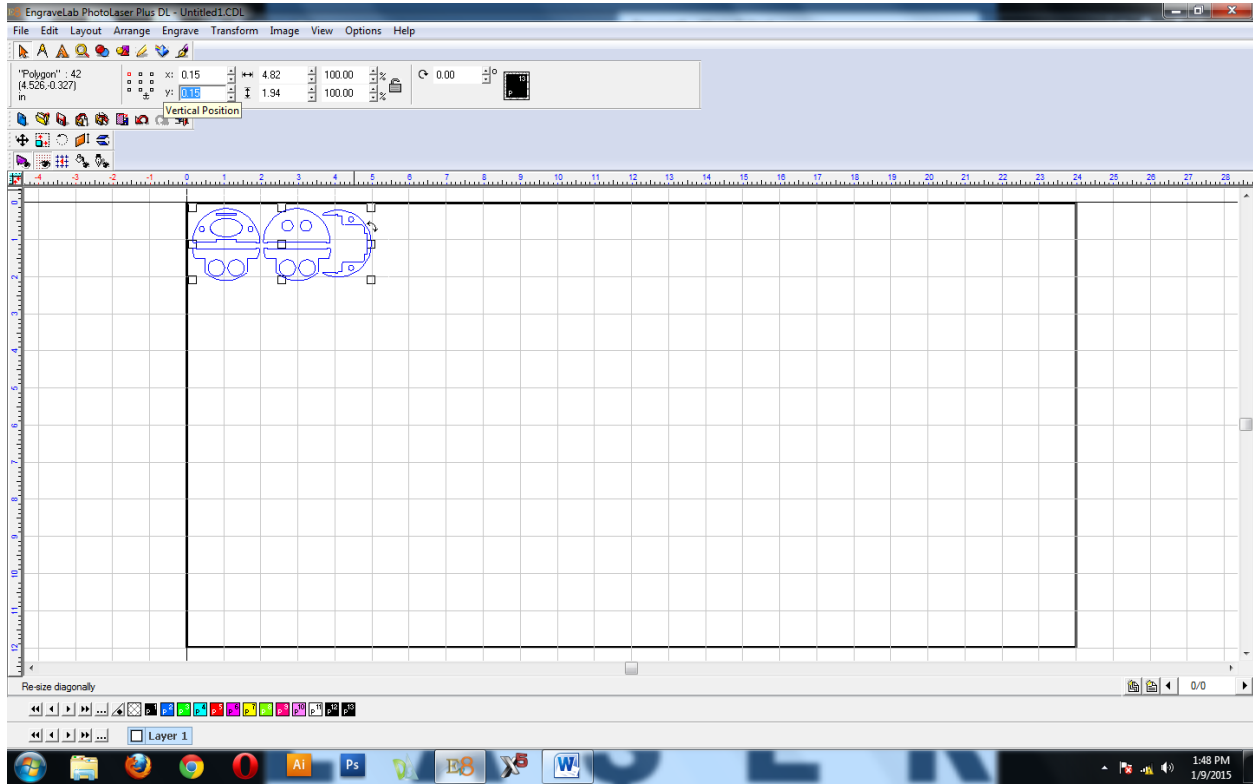
Go to "File" -> "Import".



Select C:\Documents\E80\E80 Bulkheads.dxf.

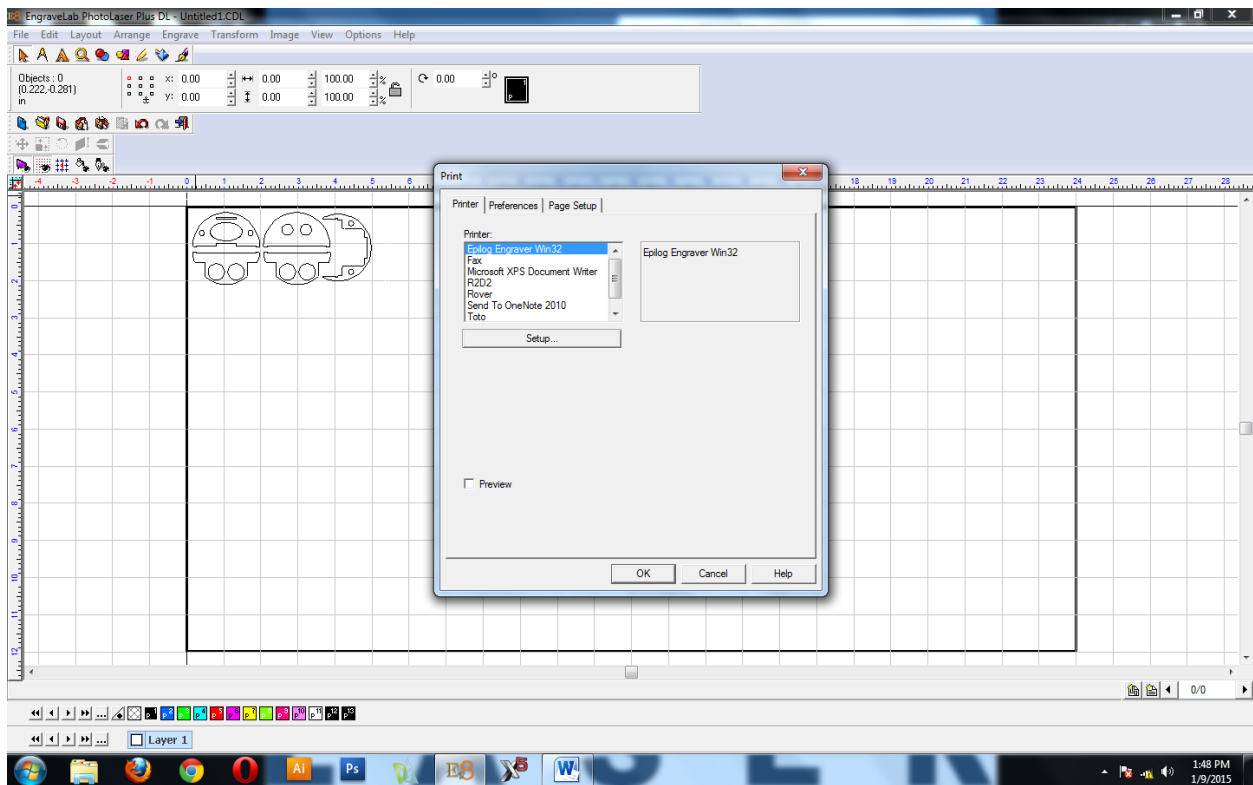


Click on the background then set “X:” and “Y:” to 0.15. You may need to change these values if you are using a previously cut Delrin sheet, just make sure that there is at least 0.15” from any other cuts or edges.

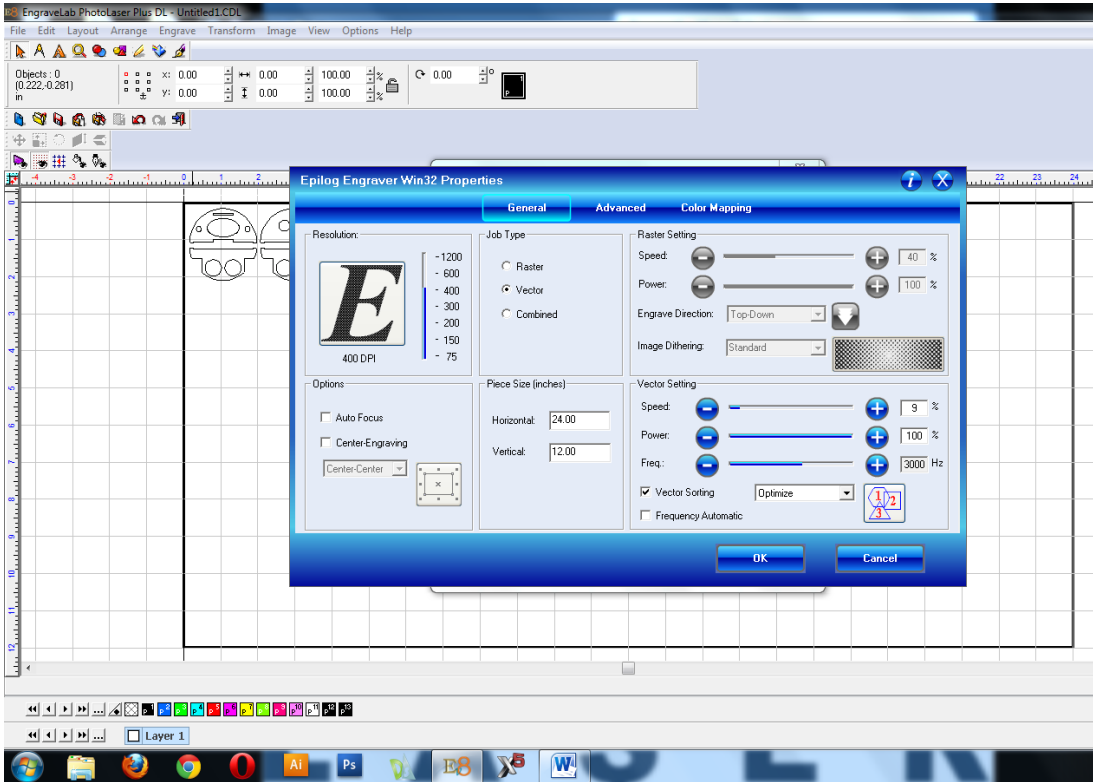


Before proceeding with the software first turn on the filter system with the remote control, turn on the Epilog Laser, then turn on the air supply valve behind the computer, one or two counterclockwise turns will do.

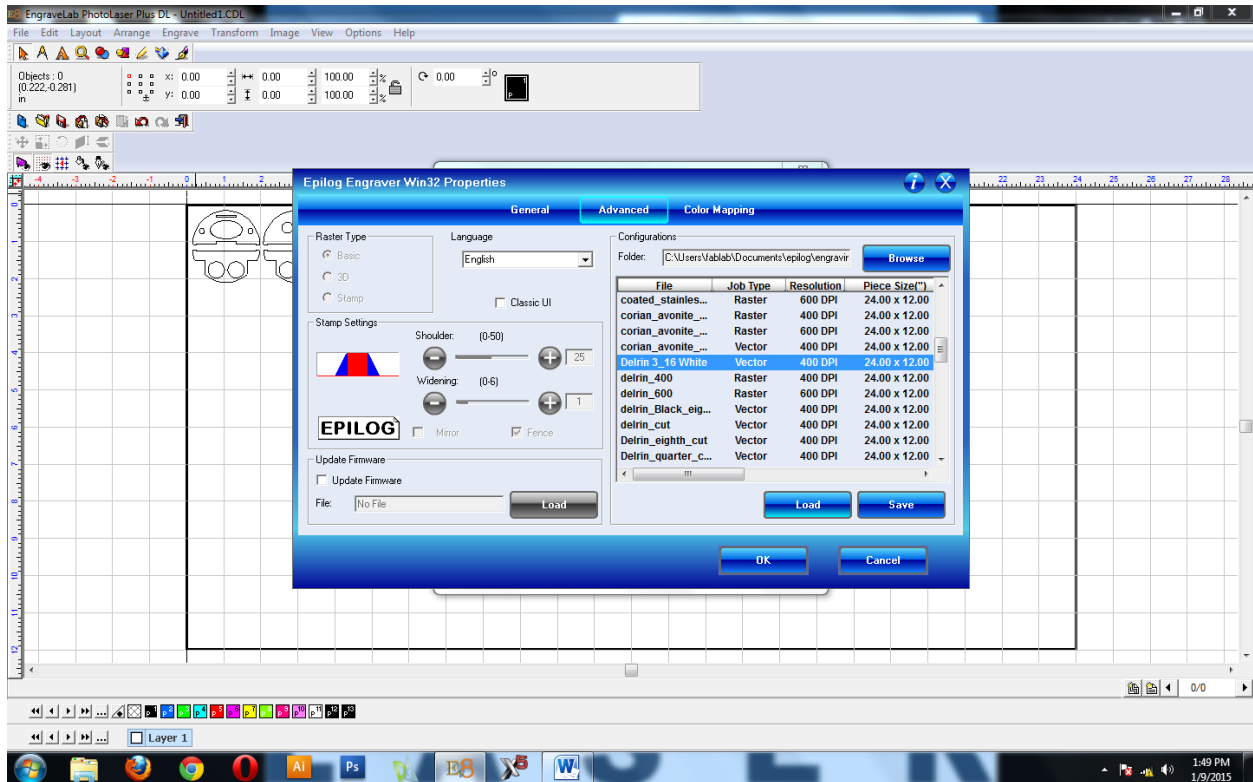
Go to “File” -> “Print” and click  on:



Make sure that “Auto Focus” and “Center-Engraving” are unchecked and that “Horizontal:” is set to: 24.00 and “Vertical:” is set to 12.00.



Select the Advanced tab, then scroll down to: “Delrin\_3\_16 White”, select it and then click OK on:



The laser will need to be warmed up if no one else has used it in the last 30 minutes, to do this simply press the "Go" button on the laser without any material in the machine. Press the "Stop" button after about 10 seconds of run time, the laser will continue to cut until the vector that it is currently cutting is completed. When the machine stops moving, press the "Reset" button.

Load a 3/16" thick piece of Delrin sheet into the laser then press the "Focus" button, place the focusing gauge on the pins of the laser lens assembly as shown below. Raise or lower the table with the arrow up or down buttons until the gauge touches the top surface of the Delrin sheet. When this step is completed, remove the focusing gauge then press the "Reset" button.



Focusing Gauge



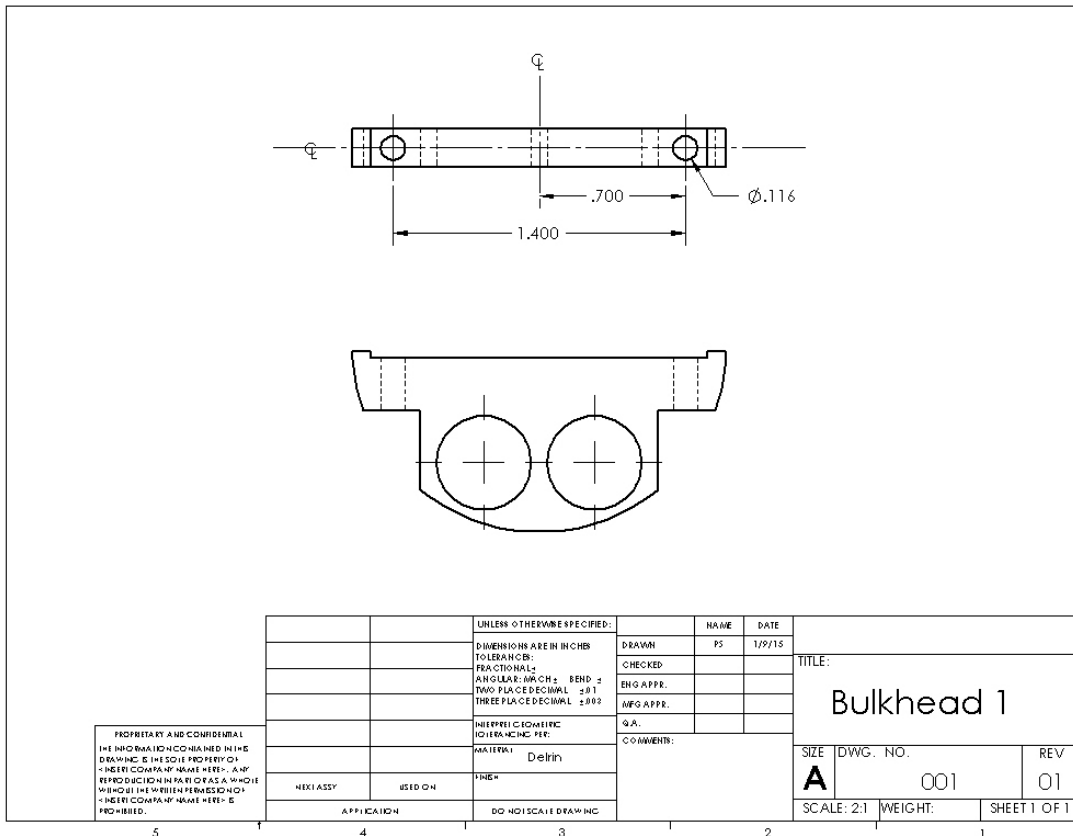
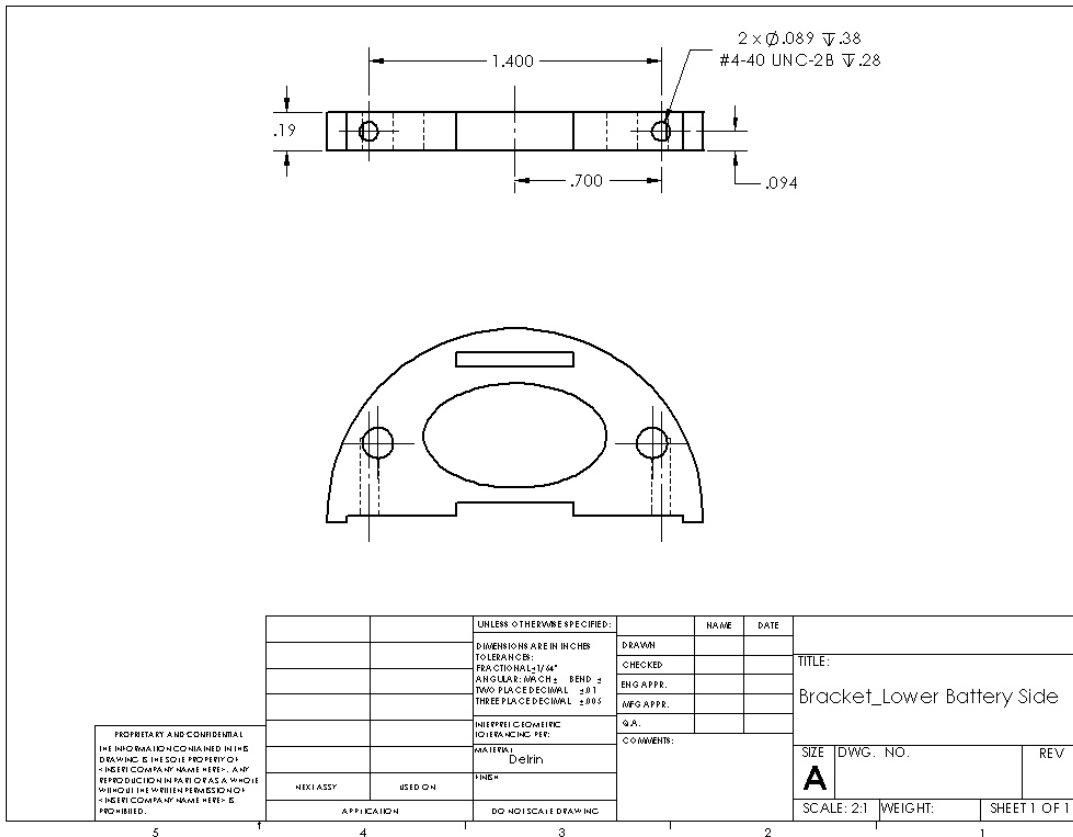
The pins of the laser lens assembly are shown with red circles around them

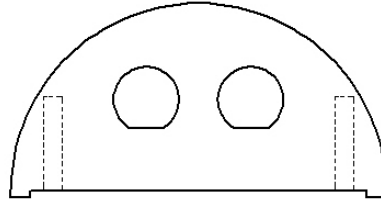
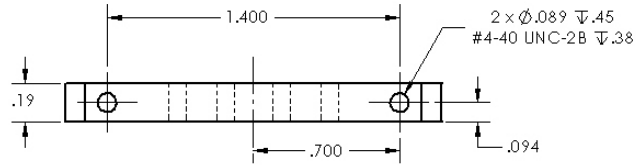


Gauge is in place for focusing

The parts are now ready to be cut, just close the glass lid carefully and press the "Go" button. When you are finished please remove any remaining remnants, close the glass lid, turn off the air supply, turn off the laser, and finally turn off the filter system with the remote control.

The next step is to go to the main students shop then drill & tap the holes as shown in the prints below.





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UNLESS OTHERWISE SPECIFIED:		NAME	DATE
DIMENSIONS ARE IN INCHES		DRAWN	
TOLERANCES:		CHECKED	
FRACTIONAL $\pm .004$		ENG APPR.	
ANGULAR: ARCH: BEND $\pm$		MFG APPR.	
TWO PLACE DECIMAL $\pm .01$		G.A.	
THREE PLACE DECIMAL $\pm .005$		COMMENTS:	
INTERPRETING TOLERANCES PER:			
MATERIAL:			
Delrin			
NEXT ASSY	USED ON		
FINISH			
APPLICATION			
DO NOT SCALE DRAWING			

TITLE:  
 Bracket\_Upper Battery Side

SIZE	DWG. NO.	REV
<b>A</b>		
SCALE: 2:1	WEIGHT:	SHEET 1 OF 1

5

4

3

2

1