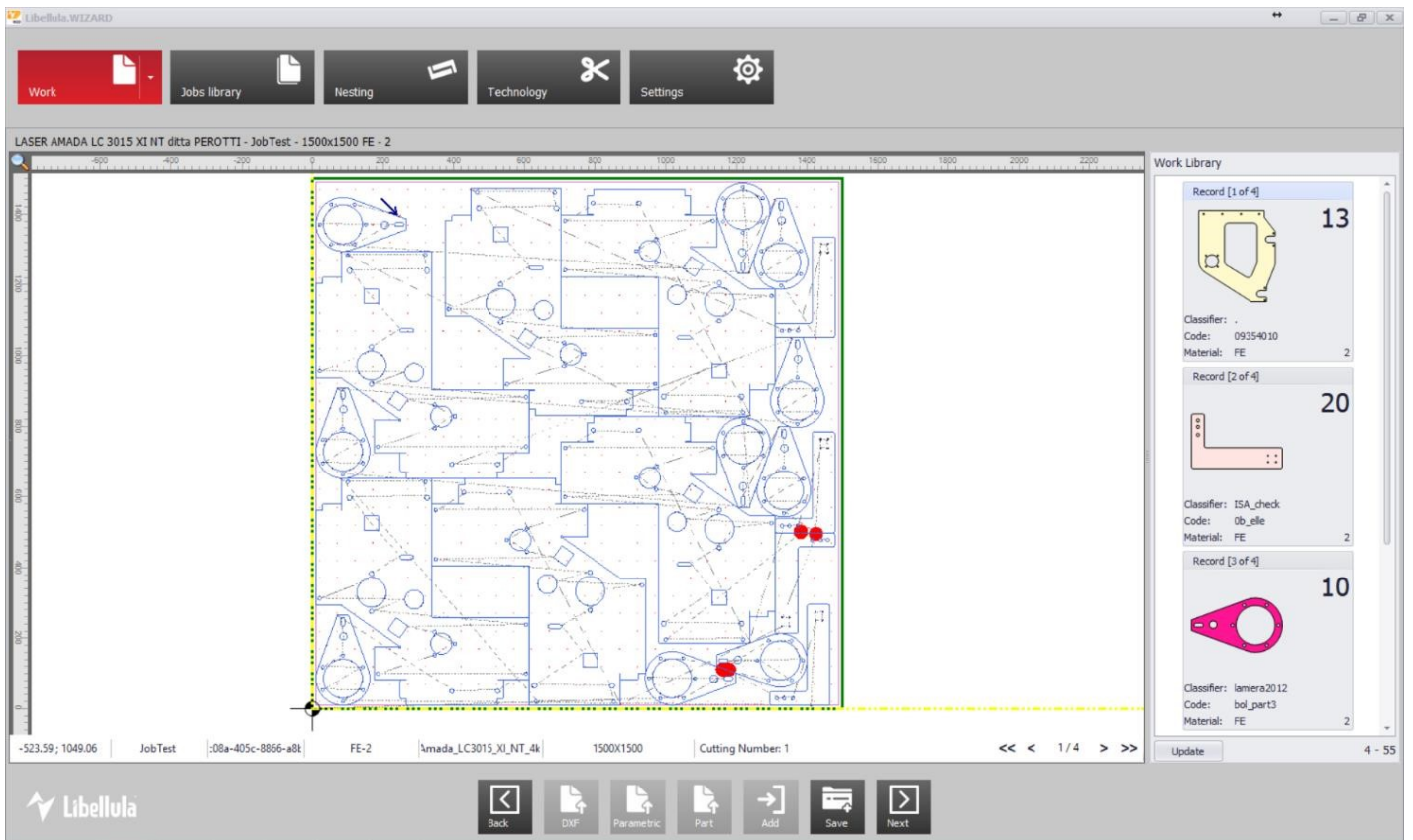


## Libellula.Wizard

Software solutions for programming laser, plasma, oxyfuel and water jet cutting machines



Industrial manufacturing control  
Synergy driver for the enterprise  
Optimization of business performance

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## I. Presentation



### **Libellula Wizard**

Libellula.WIZARD is a CAD/CAM application dedicated to the programming of any type of sheet metal cutting machines. The software is available in three versions, depending on the machine configuration, and has been developed for touch screen and multi-touch terminals. It allows to directly import DXF/DWG and offers a wide library of parametric patterns to rapidly draw parts for production.

The guided procedure ensures a fast preparation of the machine, without learning efforts. The production cycle can be displayed before machine start by means of a realistic 3D simulation, in order to verify its compliance with the real cutting process.

#### **1. Touch screen**

Libellula.WIZARD has a very modern user interface ready to be used on touch and multi-touch screens.

#### **2. User friendly**

Libellula.WIZARD is an extremely easy-to-learn product and has been developed by our Engineers according to a Zero Training concept

#### **3. One click**

Libellula.WIZARD guides the user to production through a simple path and minimizing the time dedicated to program preparation. By passing to next page, the user gets to machine programming.

#### **4. Realistic simulation**

In the complete version, Libellula.WIZARD allows to verify the recently created production cycle in a realistic environment to test its functionality.

## 5. Parametric shapes

A wide number of parametric shapes commonly used in the sheet metal production is made available in parametric mode in order to speed up drawing for the parts to be manufactured.

### Configurations

Libellula.Wizard has three versions:

	Libellula.Wizard 1	Libellula.Wizard 2	Libellula.Wizard 3
DXF/DWG Import	yes	yes	yes
2D icon parametric library	yes	yes	yes
Sheet properties description	yes	yes	yes
Icon handling	single	multiple	multiple
Nesting type	matrix	automatic	automatic
Cutting technology calculation	manual	manual	manual/automatic
Technological tables	-	-	yes
Cutting path visualization	yes	yes	yes
Cutting path check	-	-	yes
Path error correction	manual	manual	automatic
Post-Processor	yes	yes	yes
2D cycle simulator	yes	yes	-
Realistic 3D cycle simulator	-	-	yes
Cutting time calculation	-	-	yes
Interface customization	yes	yes	yes
Mod.HVAC optional module	-	yes	yes
Mod.BEVEL optional module	-	-	yes
Mod.STORAGE optional module	-	yes	yes
Mod.VISIO optional module	-	yes	yes

### 1. Libellula.Wizard 1

This is the entry-level configuration of Libellula.WIZARD.

This environment allows importing DXF/DWG files, to place them one by one on a single plate and to duplicate them according to a matrix pattern, in order to reduce scrap.

As far as the cutting path is concerned, the type and application of lead-in shall be defined on each single part. All identical parts will be automatically handled accordingly.

Before creating the post-processor, the user shall input the FEED parameters or any other instructions to be applied during cutting.

### 2. Libellula.Wizard 2

This version includes all functions described for version 1, but additionally it allows creating a list of parts to be cut, matched with respective quantities.

An automatic nesting will position the parts on a plate of the selected format in order to reduce scrap.

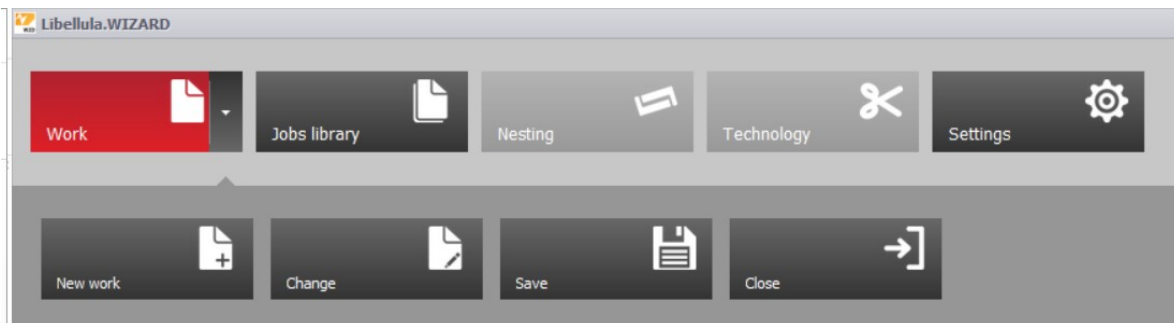
For any single different part, the user shall indicate the position of the lead-in.

### 3. Libellula.Wizard 3

This is the complete configuration of Libellula.WIZARD, offering automatic nesting and automatic calculation of the cutting path. The system automatically select and applies the best type and position of lead-ins for any of the parts available on the plate.

Furthermore, all optimal parameters to handle the cutting technology will be automatically compiled thanks to specific parameters tables. This configuration allows any operator to get to a correct programming of the machines in your workshops without any investment efforts that might be required to learn a new system.

## II. Work



### New Work

#### 1. Creating a new work

Machine	SwiftCut1250 PowerMax65	
Classification		
Job Name	TestJob	
Available	999	
Dimension x	1250 mm	Dimension y 2500 mm
Material	MS	Thickness 1
Trim x -	10 mm	Trim y - 10 mm
Trim x +	10 mm	Trim y + 10 mm
Distance	6 mm	Cut diameter 1.4 mm
<input type="button" value="OK"/> <input type="button" value="Cancel"/>		

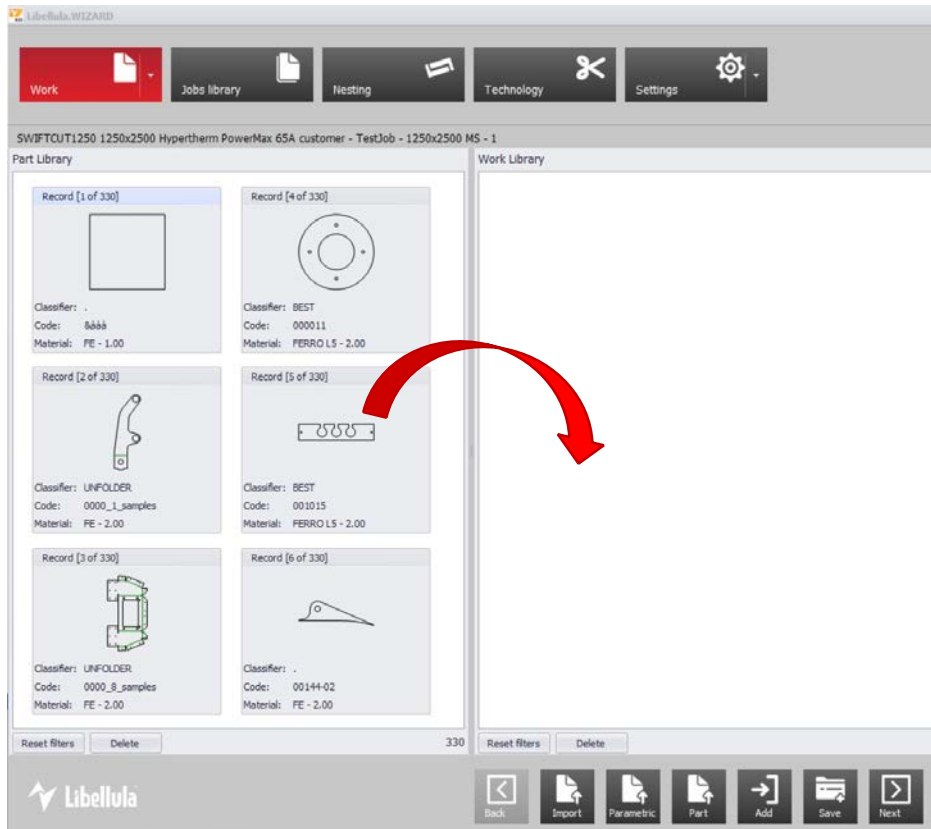
When creating a new work you will have to set the different parameters:

- Chose the machine in the given list
- Set, if needed a classification
- Set a Job name
- Set the X and Y dimensions
- Set the Trims : trims are the distance not cut from each side of the sheet
- Set the Distance

- Set the Cut Diameter Then Click on OK.

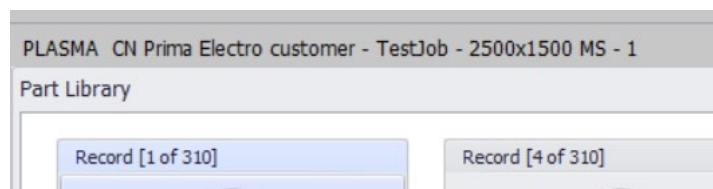
## 2. Part Library and Work Library

The second step of creating a work is the part and work Library.

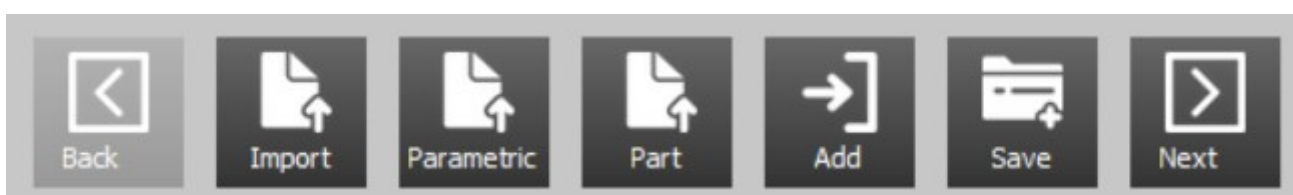


This screen is represented in three different parts:

- On the bottom the Work Menu
- The work Library on the right
- The part library (or Parametric Library) on the left with above the name of the machine, the name of the job, the dimensions of the job and the material and thickness.



At the bottom of the screen you can find the menu buttons :



The "Back" button is not used on this screen cause it is the first one.

The "Import" allows you to import DXF, DWG and Libellula Icon parts

The "Parametric" and "Part" buttons are used to set the Parametric or Part library on the left.

The "Add" button, is to add a selected Part or parametric in the work

The "Save" button is to save the work

The "Next" button will only do the automatic nesting if there is something in the work.

Info: Parametrics are standard Parts for which you can personalize some of the dimensions.

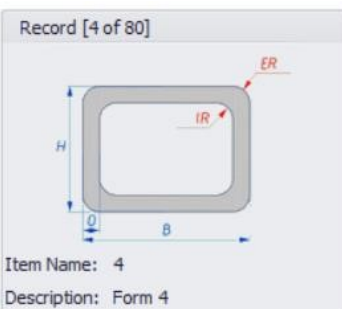
### Descriptions:



This is a part in the Part Library

It is composed by five parts:

- Record number
- Image
- Classifier
- Code
- Material



This is a part in the Parametric Library It

is composed by four parts:

- Record number
- Image
- Item Name

Description This is a part in the Work Library It is composed by seven parts:

- Record number
- Image
- parts (top right) (here 2)
- parts nested (middle right) (here 0)
- a parametric it will set the name of the job)

- Number of
- Number of
- Classifier (for
- Code
- Material
- Thickness



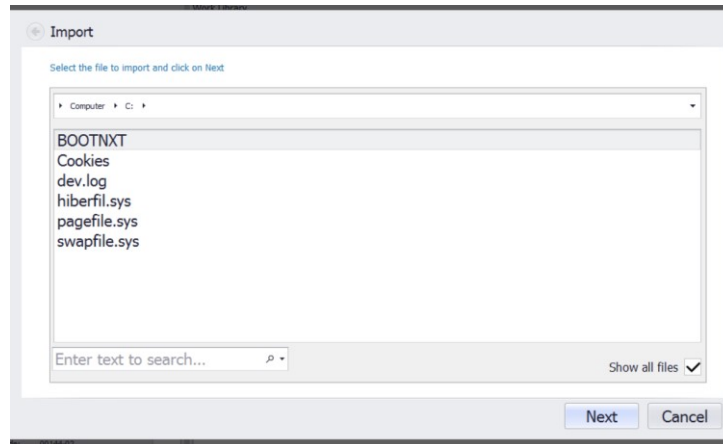
2  
0

(bottom right)

### Import a Part

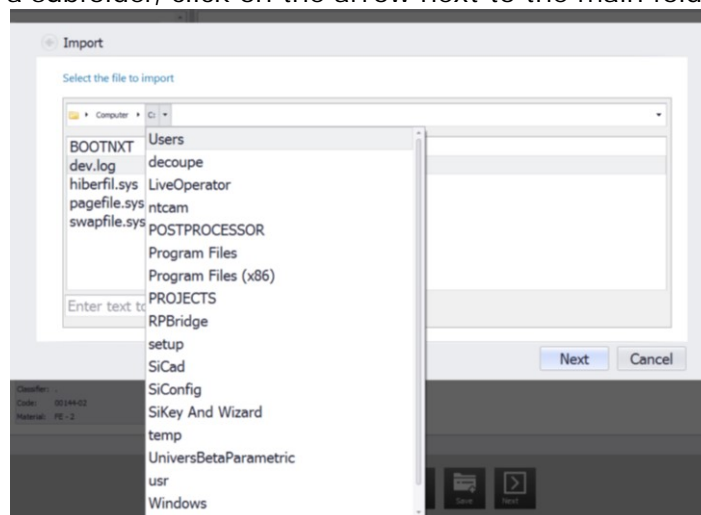


After clicking on the button, you will have to find your DXF, DWG or Libellula Icon with this window:

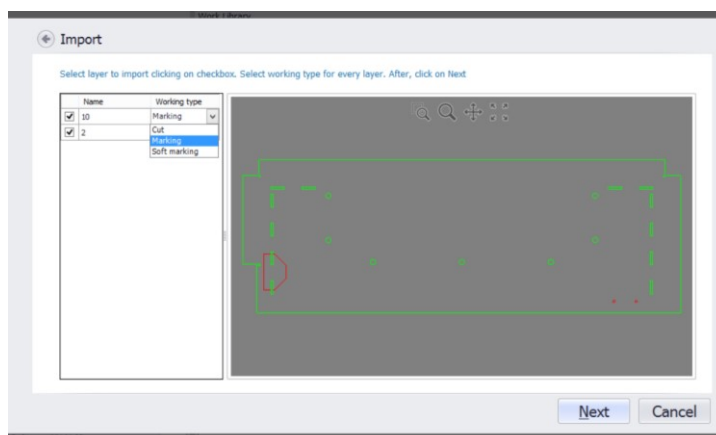


Only the DXF, DWG and Libellula Icon are shown, to see all the files click on the show all files in the right bottom.

To find a file in a subfolder, click on the arrow next to the main folder.




Then choose your icon and click on the "Next" Button. The next window will appear.



If your part has several layers, you can choose to select or unselect them and although set their working type: Cutting, marking or soft marking.

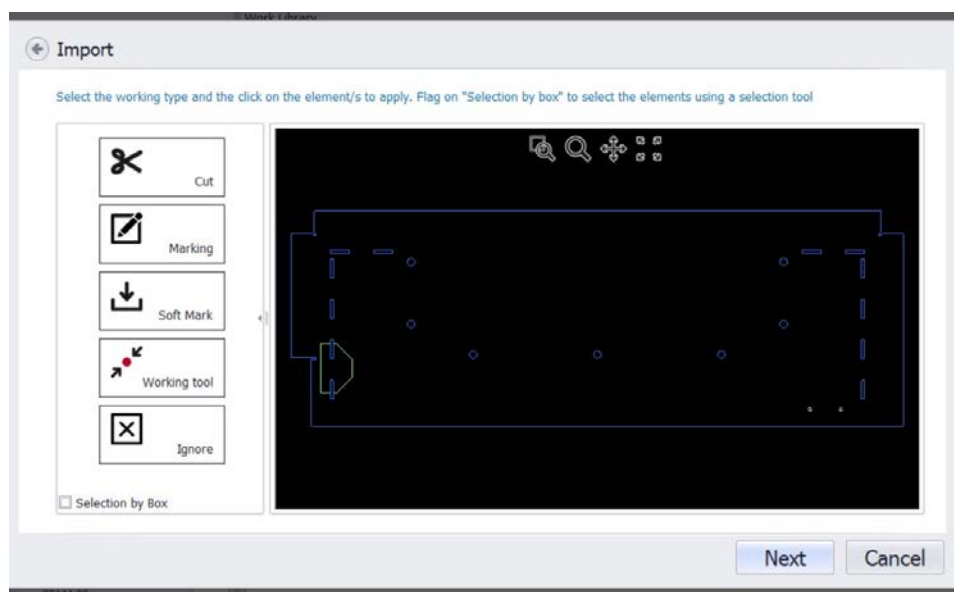




You can change the visualization with the button in the top  : Zoom window (select the part on which you want to zoom by drawing a rectangle around it), Zoom, Pan (move) and Zoom Fit (zoom on the part)

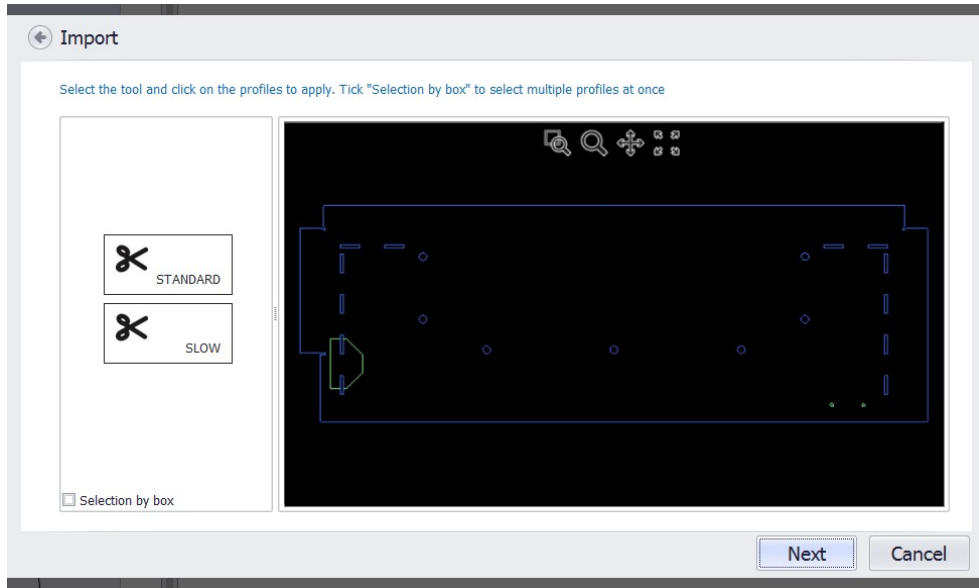
Then click Next.

You will then be able to change the technology type of some parts of your Part: Select the technology type and then the lines you want to change: Cut, marking, chiseling, or working tool (choose then Drilling Flaring or Tapping) or Ignore to Ignore some parts. To select the part click on it or use the selection by box (in the bottom left) and draw a box around the elements you need to change.



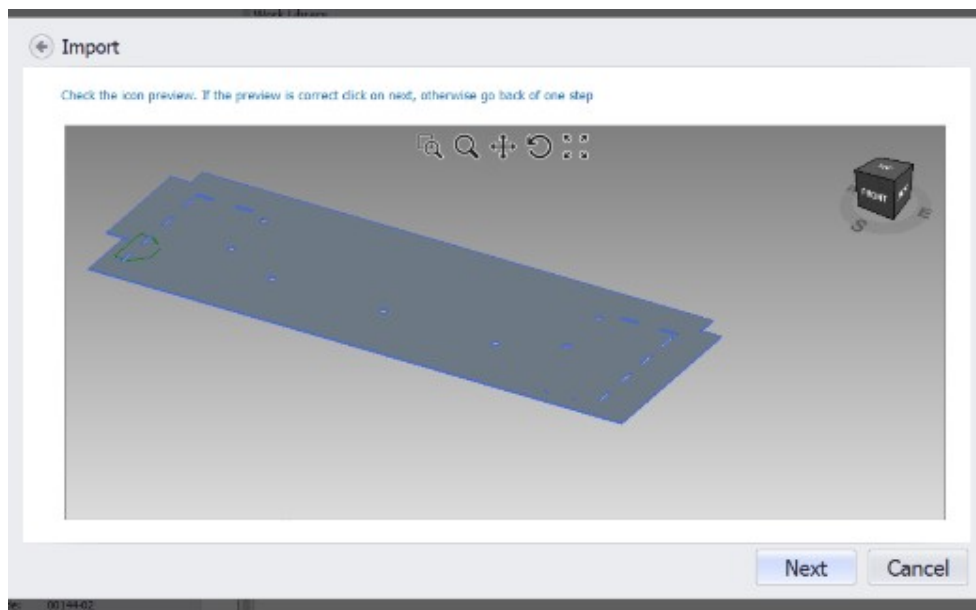
Then click Next.

You will then be able to change the tool for some elements of your Part: select the tool and then the element you want to change. You will be able to choose between all the tools configured for the machine of the current job. To select the element click on it or use the selection by box (in the bottom left) and draw a box around the elements you need to change.



Then Click Next.

You will then see the preview of your Part



: Zoom window (select the part on which you want to zoom by drawing a rectangle around it), Zoom, Pan (move), Rotate and Zoom Fit (zoom on the part)

With this cube, you can follow



the orientation of your part.



Import

Fill icon data

	Bystronic_Bystar8025_4k4
Code	13038-SBM-01201
Classification	2014-11-work_TMF13038
Description	Article 13038-SBM-01201
Material	INOX316
Thickness	1.5

Finish Cancel

At last, fill in the information's of the Part (Machine, code, classification, description, material, thickness), click on finish and set the quantity desired. Your part is then directly put in the work library but is although in the Part Library, so you won't need to import the same again.

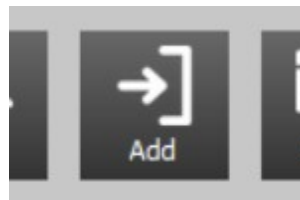
## Add a Part (part or parametric)



Open the part or parametric library on the left with these buttons.

You can set a part in your work, after selecting him, by three different ways:

- drag and drop the part into it
- double click the part
- use the Add Button on the bottom of the screen

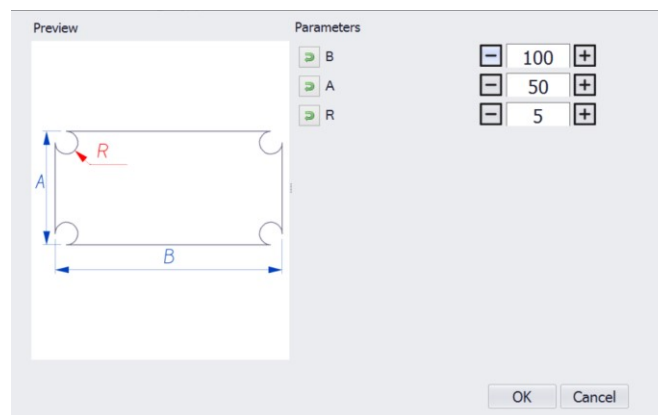


### Special case for a parametric:

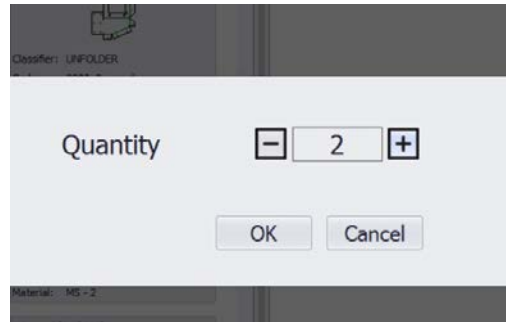
Only for a parametric, you will have the chance to choose the values of the parameters (or you can leave the standard).

After validating, you will not be able to change them again. However, you can delete the nondesired parametric from the work and add a new one and set the chosen values.

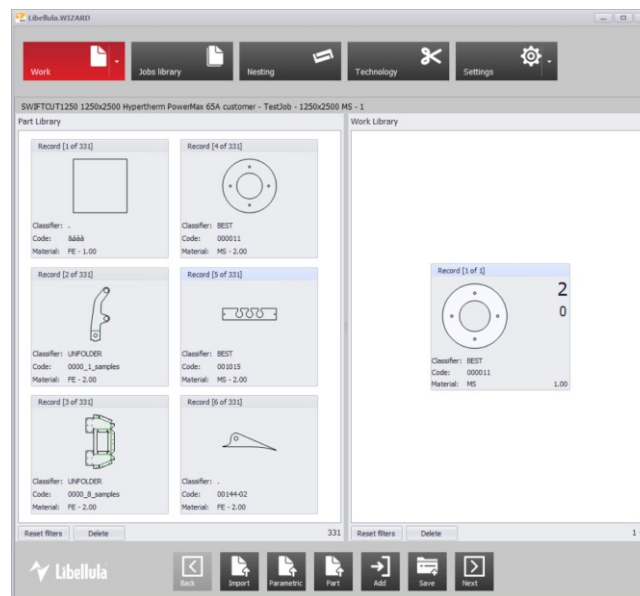
You can although set several times the same parametric with different values.



After adding (or validating values for a parametric), it will ask you the quantity of parts you want in your work.



After that, your part is in the work with the quantity marked in the right top of it.




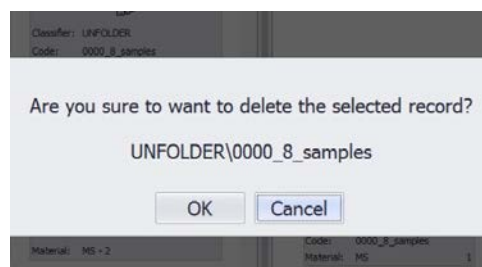
To change the number of parts after adding them into the Work Library, just click under the number and change it.

Special case for a parametric:

After adding a parametric in the work, it will take as classifier, the name of the job, as code "parametric\_" with an increasing number and as material and thickness the ones selected for the Work.

To delete a part from the work or the Library, select it (by clicking on the top where it is written "Record..."), and then push the Del button on your keyboard or click on the Delete Button in the

bottom . It will ask you to validate your choice.



If you delete a part from the part Library, it will be definitely delete.

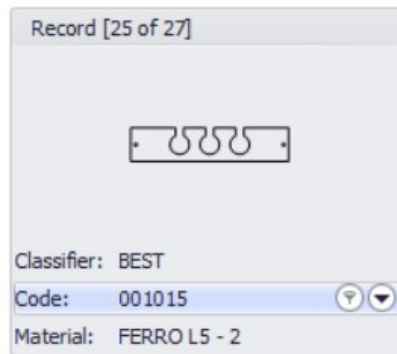
For each library, you can define an order or a filter for the display.


On each part, you can find the two buttons  that will appear when passing the mouse on different parts of it:

- the picture
- the classifier (for parts, or parametric in the work library)
- the code (for parts, or parametric in the work library)
- the material - thickness (for parts, or parametric in the work library)
- the item name (for parametric in the parametric library)
- the description (for parametric in the parametric library)
- the number of parts (only in work library)
- the thickness (only in work library)

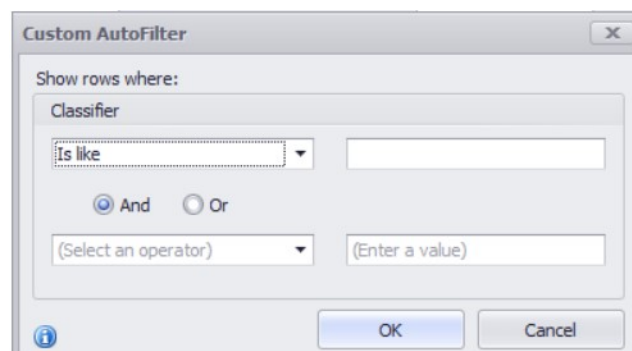
The button with the arrows  is to sort the Library in ascending or descending depending on the part you chose.

For example: you click on the arrows of the code 2 times so the arrow is like on the picture: the parts will be ordered by code descending.



The other button  is the filter button. When clicking on it, all the different name of the part you clicked (in our first case the classifier part) will appear. When you chose one of them, only the part with that name will be in the list.

You can although chose to make a (Custom) filter, it is the first option in the list.

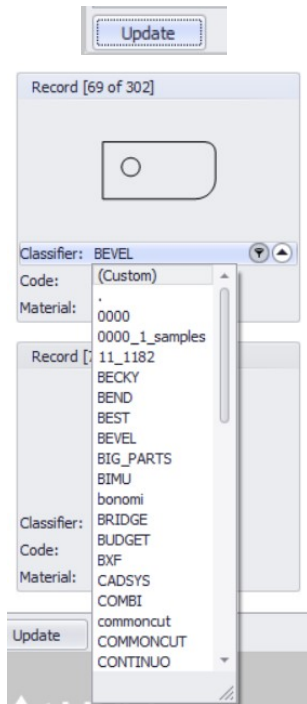


You can filter in many ways: if the part you choose, is equal, different, null, not null, greater, less... than a value you can put and / or something else. You have many different choices to make a filter.

Tip: in the cases: "Is Like" and "Is not Like" you can use "\_" to represent any single character or "%" to represent any series of characters.

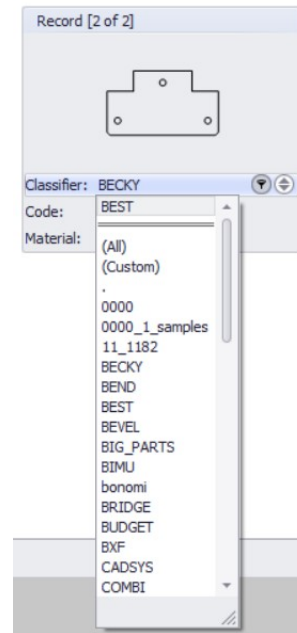
In our second case, a filter has already been activated before, and another is active: the first in the list is the filter you already used, and an extra option (All) appear, so you can erase the filter you have set only on this part.

So for example if you set a filter on the classifier and on the code, to erase them both two options:  
 Update or go on each filter button and click on (All) or click on the button in the left bottom corner:

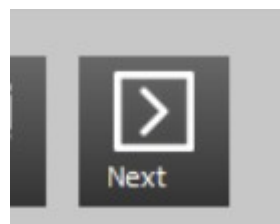


1rst

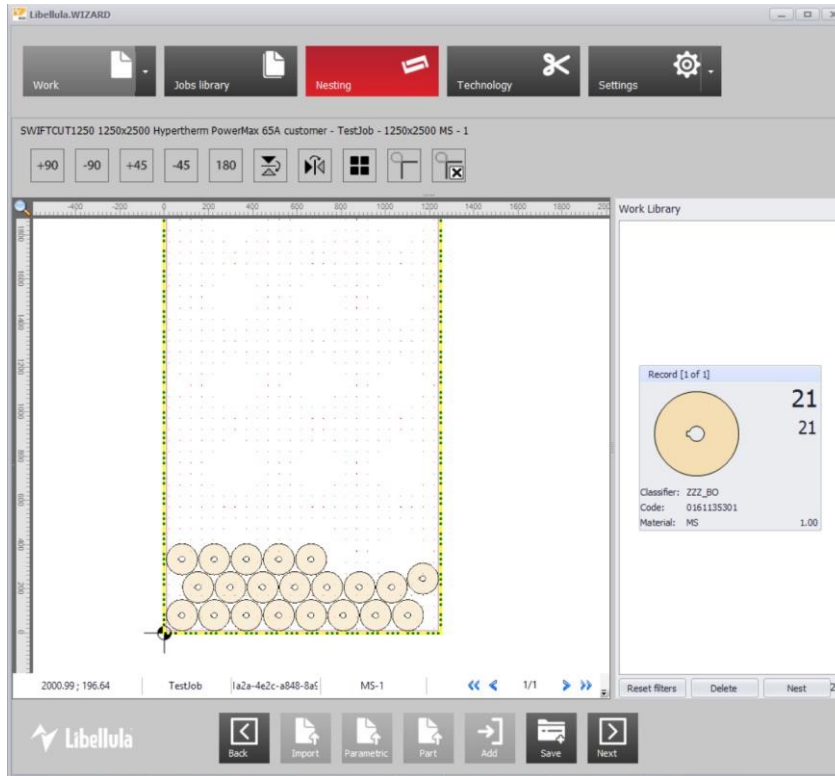
case: 2nd case:



After having all the parts you need in the Work library you can click on next.



### 3. Nesting screen



After clicking on next in the work screen, you will come on the nesting screen. Here you will see an automatic nesting made with the parts you choose.

In the middle, the nesting with under it all the information:

- Position of the mouse
- Name of the job
- The third number is only used for internal use, not for the users.
- Material and thickness
- Machine
- Dimensions of the plate
- Cutting number: this number is used when there are several exact same plates. (In the under example there are in total 3 plates, 2 of the current plate and 1 from the second



- Number of plates : you can click on it to see the next, previous, first or last plates

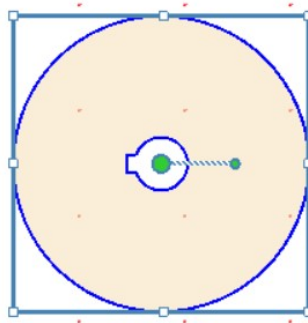
On the left, your work library.

On the bottom, you will find the same buttons as before

- Back: you go back on the previous screen to add parts in your nesting, be careful your work done will be lost.
- Save
- Next : to make the post processor - The other buttons are not used here.

In the nesting, you can move every part manually.  
When clicking on it, it will be selected with a blue contour.





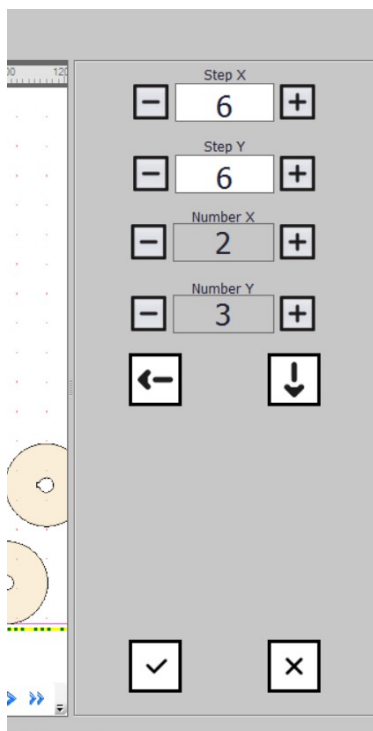
In the middle, you will see two green circles.

- The big one in the middle is to move the part (hold the click and move, works although on other point of the part)
- The little one on the right is to turn the part (hold the click and move to turn) Around the part, eight points.
- The four in the corners are used to duplicate the part in four different directions. Pass the mouse on them to see which direction it is and click. (bottoms for left and right and tops for top and bottom)
- The four in the middle of the sides are to move the part to the closes side. Top, bottom left or right

You can although use the buttons on the top to move the parts:



- Rotation: +90°, -90°, +45°, -45° and 180°
- Mirroring right or bottom
- Matrix
- Add loop and remove loop



When clicking on the Matrix button, some settings will appear on the right in place of the part list.

Set the x and y step, the number of parts and the directions. In the bottom, two buttons:



: Validate



: Undo

To add a loop click on the insert point or click on OK to add all

Loop type  
  Circular

Radius

Apply angle

Collision check  
  On

Profile type  
  Vertex

When clicking on the loop button, some settings will appear on the right in place of the part list.

Set the loop type Circular or linear.

Then the Radius (or length) and the apply angle.

Set the collision check on or off and the profile type: Vertex or Profile.

Then click on the loops will  
To remove last button



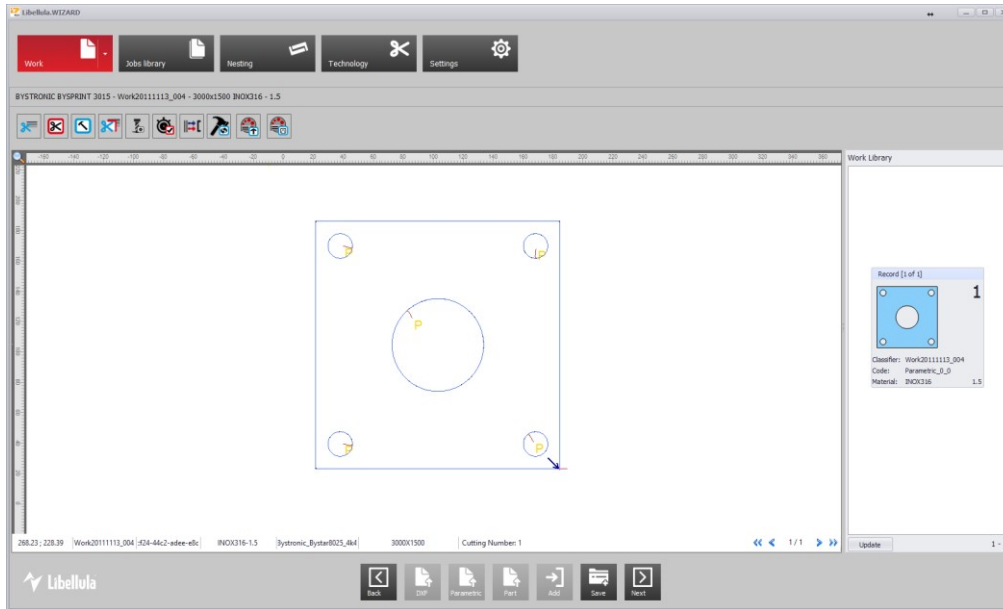
validate and all be set.  
loops use the

Click on single loop to remove it, or click on OK to remove all

## 4. Technology

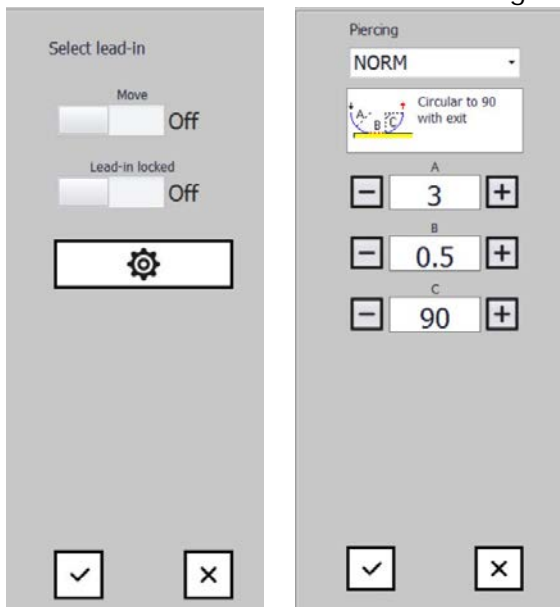
### Set up of working rules

This form will appear every time the part has no working rules saved.



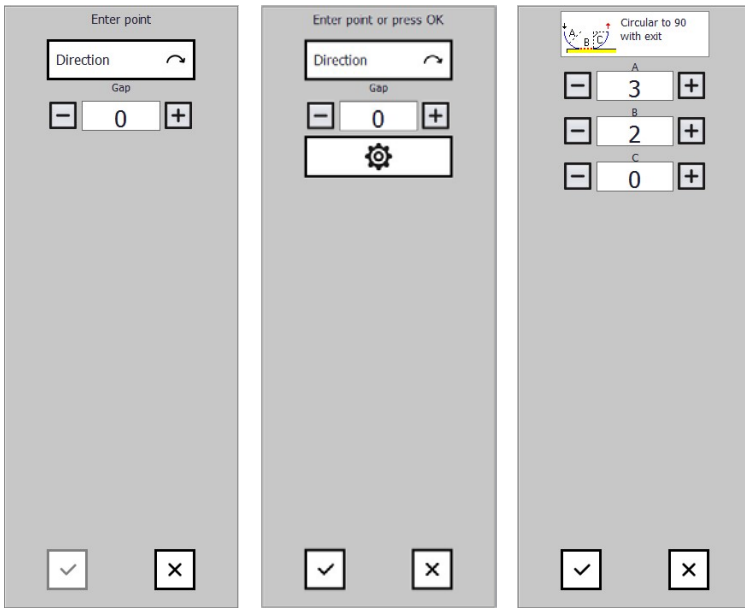
You can set the working rules with the menu on the top: Manual cut, free cut on sheet, cut all no bevel elements, Bevel cut, Bevel cut elements, working time, lead in sequence (and lead in modify), Tool table, Load turret, and save turret.

Click on "next" and the working rules will be saved and the form switch on the next part.

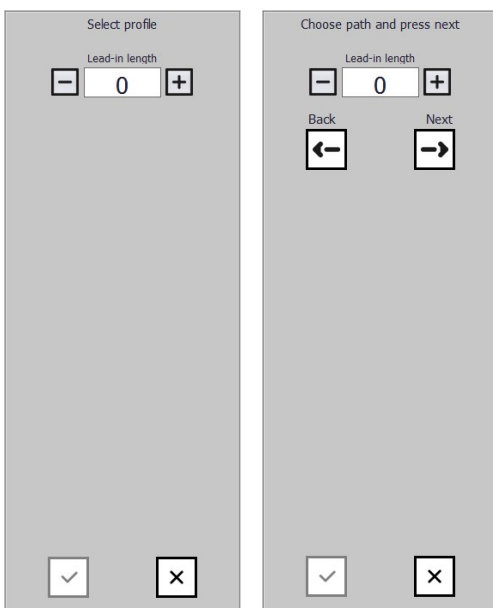


When clicking on the lead in button, some settings will appear on the right, in place of the part list.

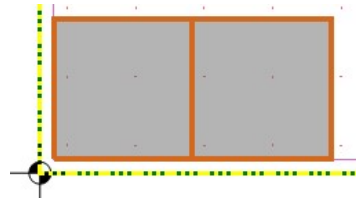
Select your lead in and the options and a configuration button will appear



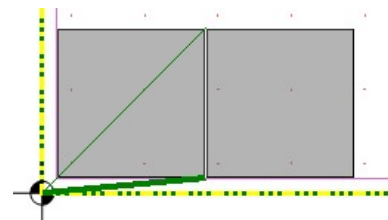
When clicking on the bridges button some settings will be shown on the right, in place of the part list. In particular can be changed the parameters about cut direction and gap length. Select the cut points and a configuration button will appear. By clicking on it the lead in and piercing parameters can be set. At the end click on the confirmation button and the bridges will be applied on the profiles.



When clicking on the common cut button some settings will be shown on the right, in place of the part list. In particular can be changed the lead in length parameter. Select the profile to cut and the part will be highlighted with a border:

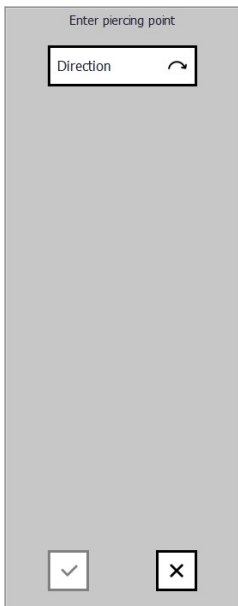


By pressing on the confirmation button the possible cut options will appear:

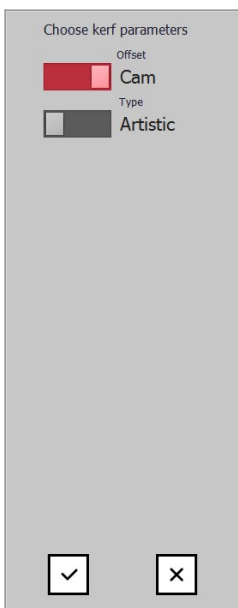


Choose the desired path and press next.

At the end click on confirmation button and the common cut will be applied on the profiles.



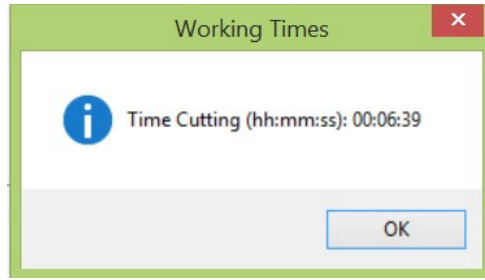
When clicking on the common piercing button some settings will be shown on the right, in place of the part list. In particular can be changed the cut direction parameter. Select first the piercing point and then the cut points. At the end click on the confirmation button and the common piercing will be applied.



When clicking on the modify kerf button some settings will be shown on the right, in place of the part list. In particular can be changed the offset and the kerf type parameters. Choose the desired settings and click on the confirmation button to delete all the workings and apply again the working rules, a warning message will be shown.



The cutting time button indicates the cutting time for the whole job.



This button opens the general report of the nesting in a pdf file.

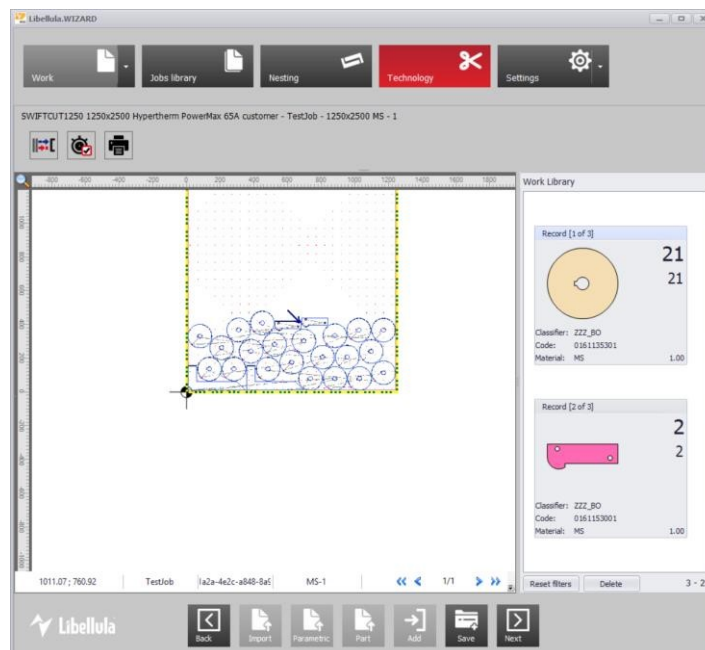
General Work Informations		Machine	
Work TestJob		SwiftCut1250_PowerMax65	
30/12/2014 10:26:07		Page: 1 / 2 Rev: 3.1.0	

Data sheet Plate					
Sheets n°	1	Work File name	TestJob		
Sheet code		Description			
Material	MS	Sheet (Kg)	24.531	Common cutting time	00:00:00
Thickness (mm)	1	Icons weight (Kg)	2.563	Qty Icon	25
Dim XY (mm x mm)	1250 x 2500	Scrap (Kg)	21.070	Cutting Number	1
Dim Trm (mm)	1229.6 x 488.88	Scrap %	87.962	Time Cutting (hh:mm:ss)	00:06:39
Notes			Dim Ref.	RX=10 RX:10 RY=10 RY:10	

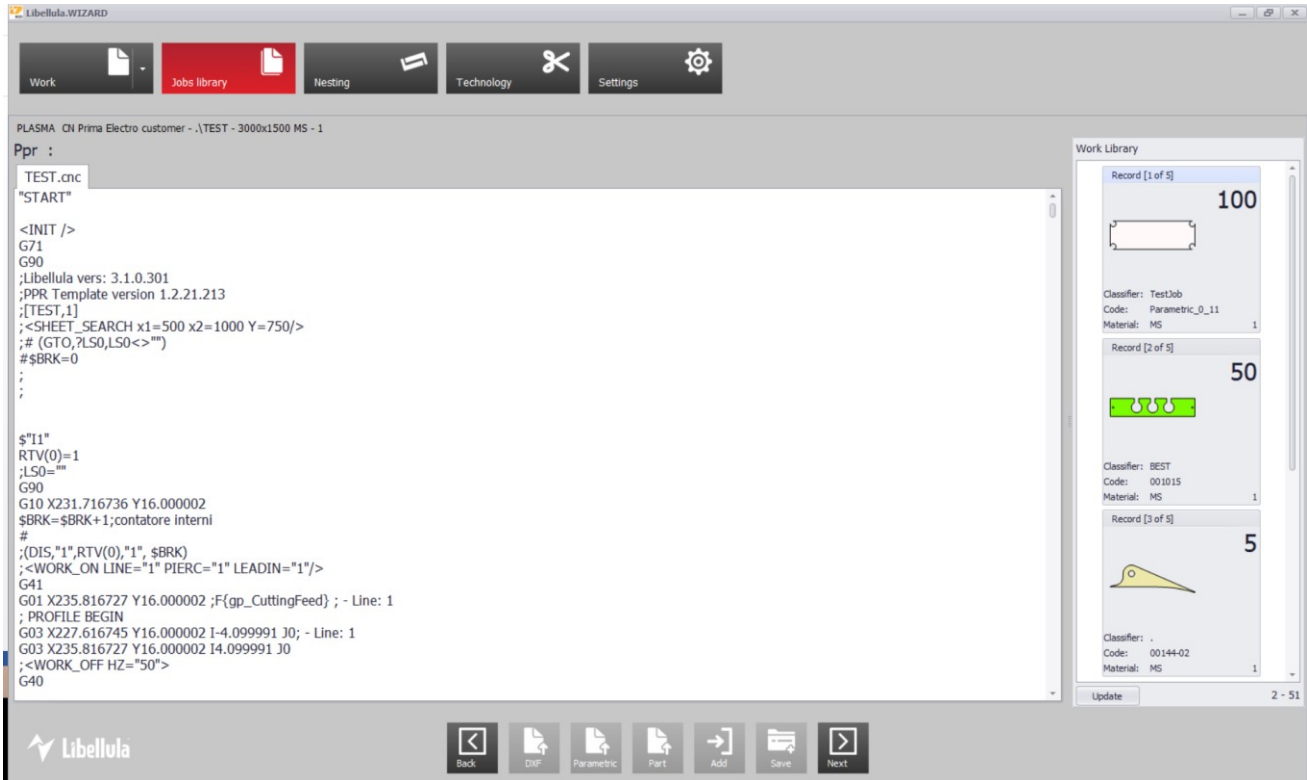
  

ID	Icon code	Description	Size (mm x mm)	Perimeter (mm)	Icons weight (Kg)	Qty Icon	Time Cutting (hh:mm:ss)
1	143256-08A-1022		342 x 142	840.74	-	2	00:00:33 (00:00:45)
2	ZZZ_BO2-01130301		140 x 140	827.87	0.7	21	00:04:30 (00:05:18)
3	ZZZ_BO2-010150801		150.5 x 14	481.9	0.543	2	00:00:30 (00:00:45)



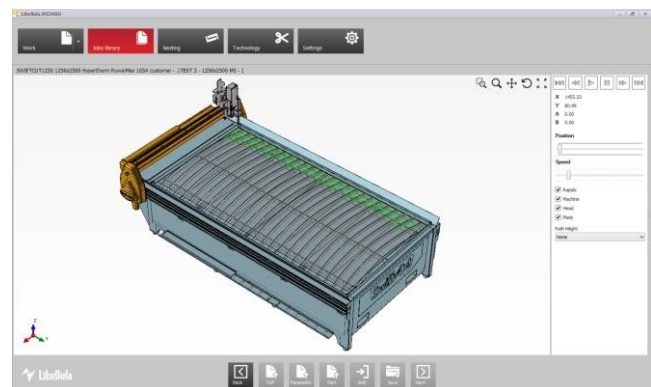
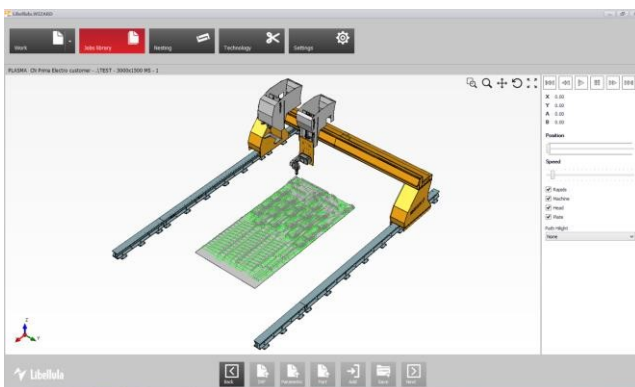
The working rules are loaded for every part and the rapid movement are added automatically.

## 5. PPR

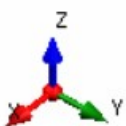


After creating your nesting, you will have the possibility to check your PPR and then come back or go on next. It will first open a nesting report. Then click again to go on the machine view.

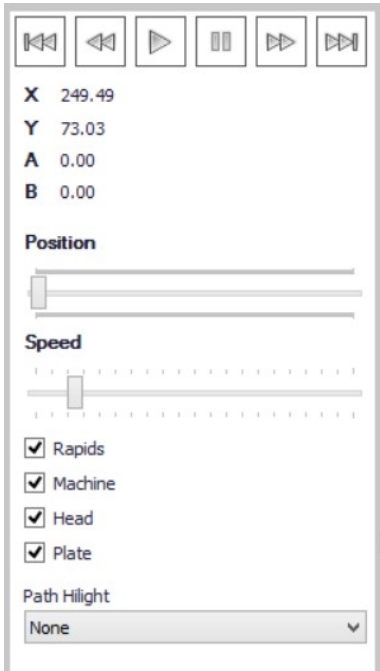
## 6. Machine view



: Zoom window, Zoom, Pan, Rotate and Zoom Fit



Follow the display of the plate and machine

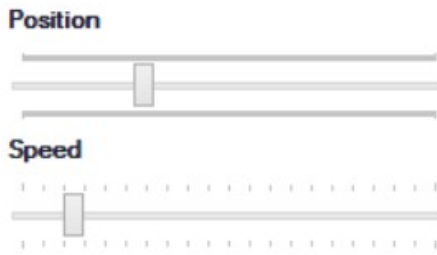


Here you can check the different options to show.



X 1455.22 : Position of the laser  
 Y 80.99  
 A 0.00  
 B 0.00

: begin,  
 backward,  
 play,  
 pause,  
 forward,  
 end.



: Position  
 in time of  
 the laser

and speed of the display of the  
 cutting

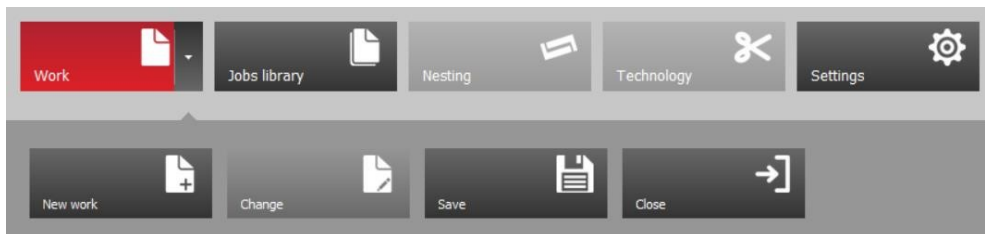
- Rapids
- Machine
- Head
- Plate

Display of the Rapids, the machine, the head of the machine and the plate.

Path Highlight  
 None

Then you can choose the highlighted path:  
 None, Rapids Only, Cutting/Tracing/Welding Only or Both.

## Change



The change button is only to change the parameters of the job you are working on. You can change all the information. Then click on OK.

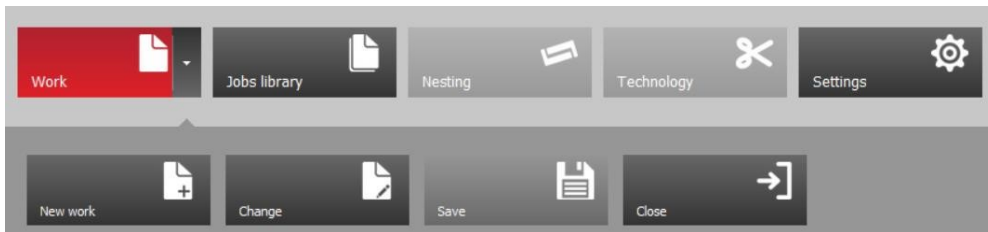




Machine	SwiftCut1250_PowerMax105	
Classification		
Job Name	TEST 2	
Available	999	
Dimension x	1250 mm	Dimension y 2500 mm
Material	MS	Thickness 1
Trim x -	10 mm	Trim y - 10 mm
Trim x +	10 mm	Trim y + 10 mm
Distance	4 mm	Cut diameter 1.4 mm

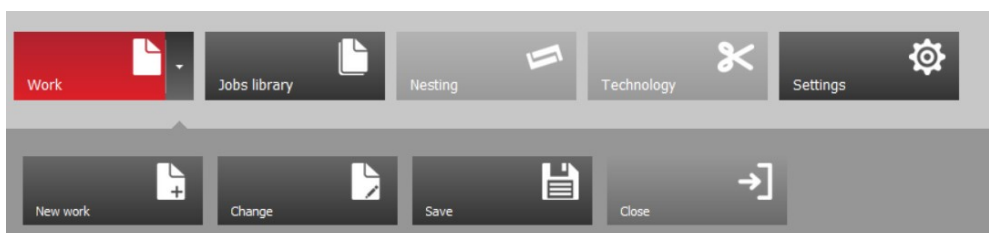
OK Cancel

## Save



The save button in the menu allows you to save the job you are working on. You can although use the button on the bottom of the work

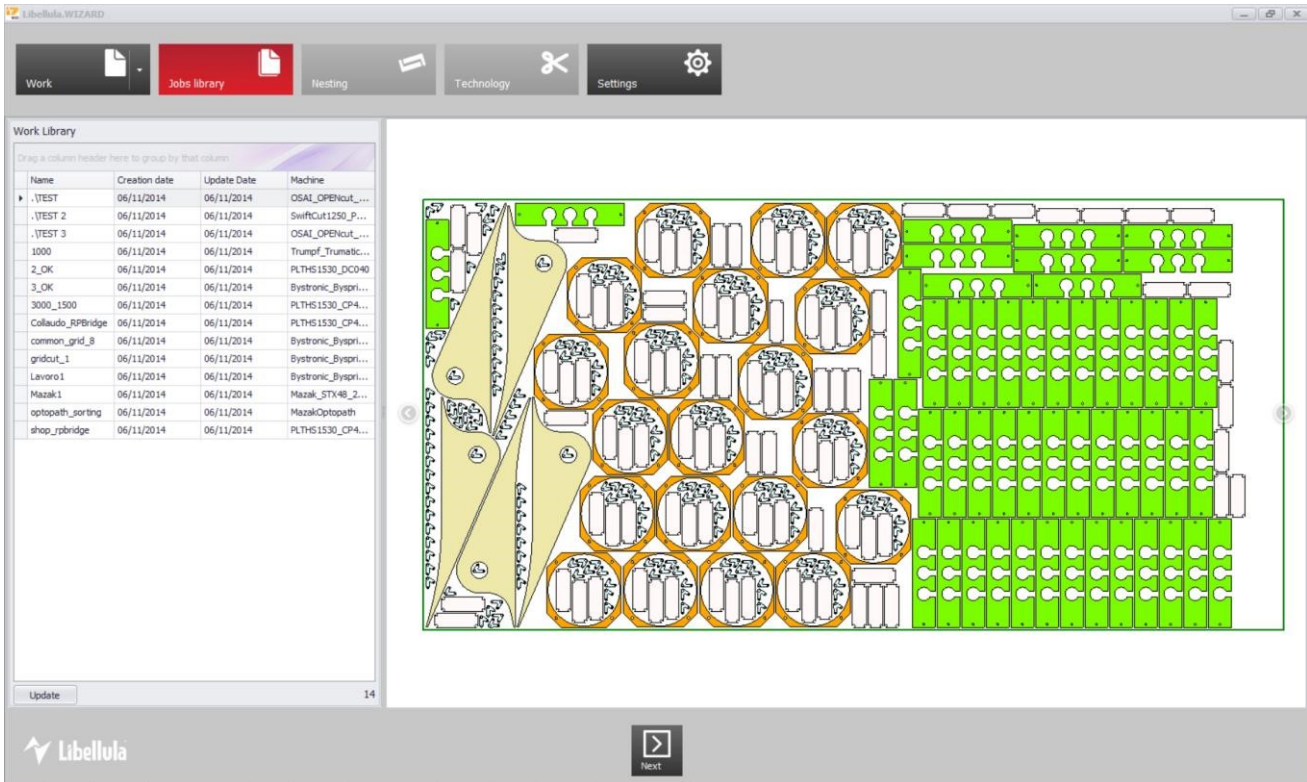
## Close




Before closing a job, you will be asked to save the job if it is not already done.



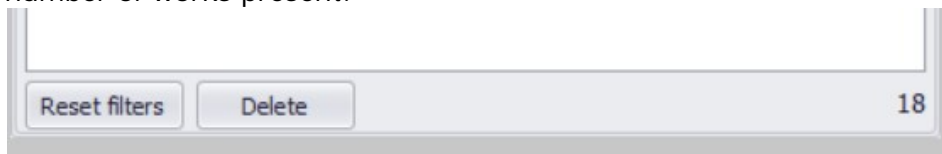
### III. Jobs Library




In this screen, you will see the entire different saved job. On the right the preview of the selected job.

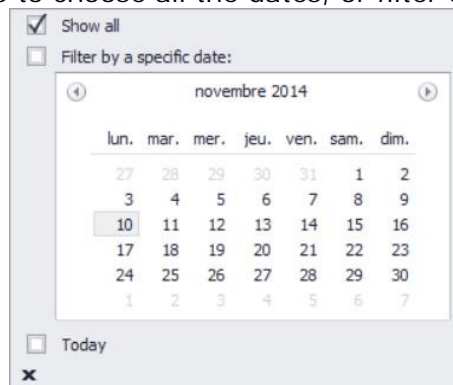
With the two arrows,  it is possible to view the different plates on a same work.

On the left, the list of the jobs with the name, the creation date, the updated date and the machine. In the bottom of it, a reset filters to actualize the list and undo the filter, the delete button and the number of works present:

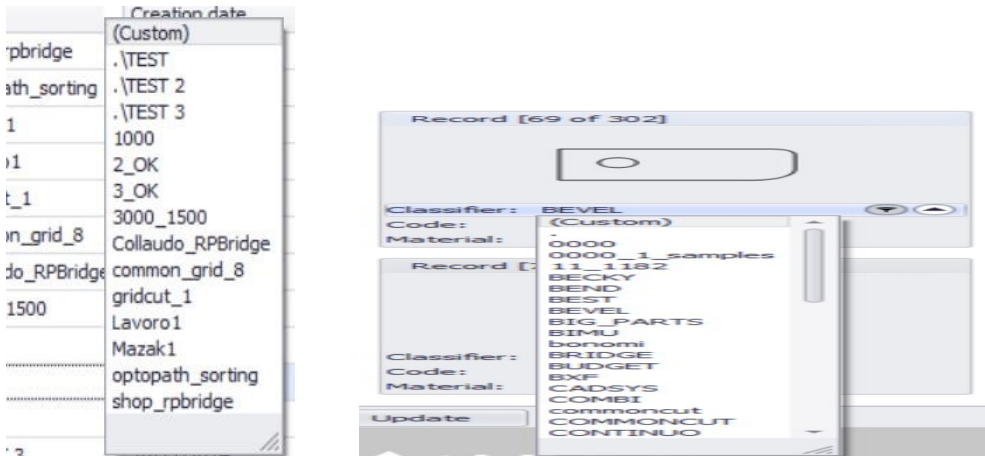


You can order each column by clicking on it or set a filter with the filter button in the top right of each column. 

For the dates, you will be able to choose all the dates, or filter on a specific date.



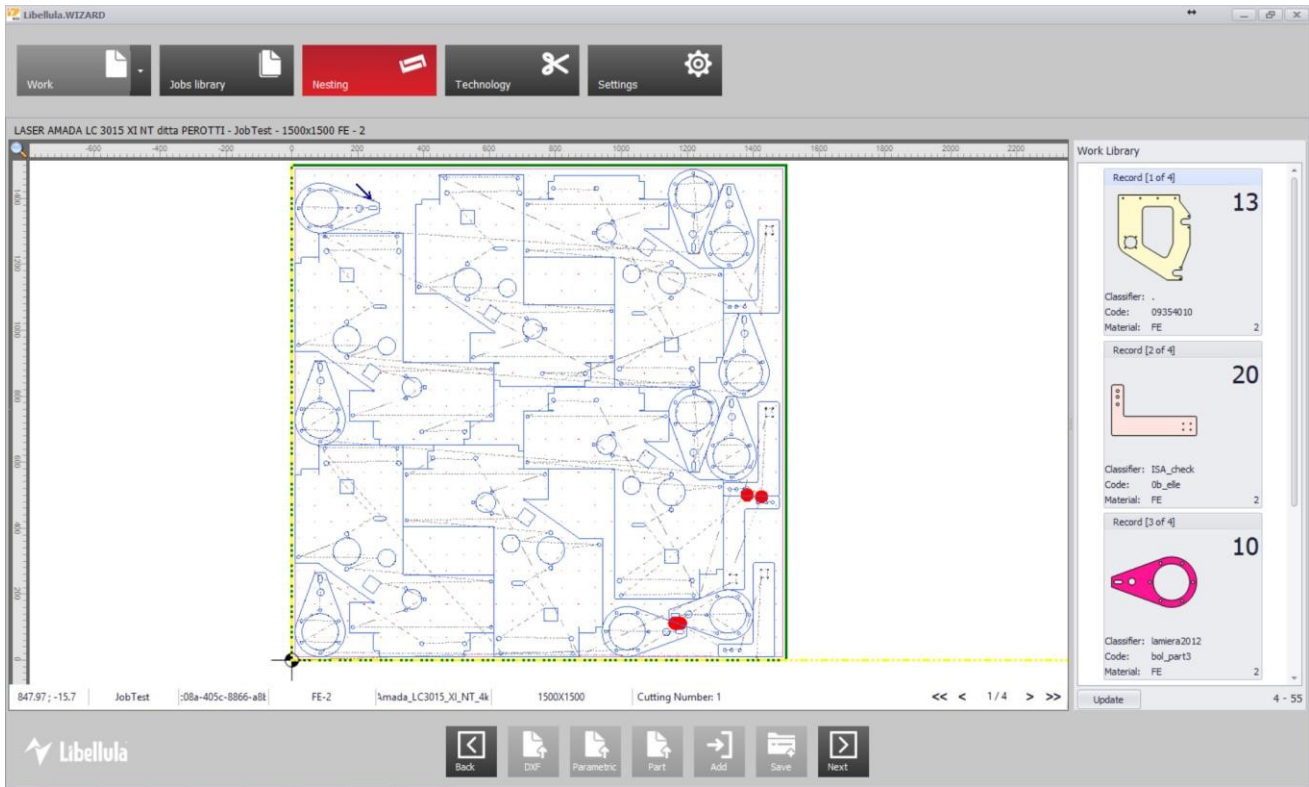
For the other columns, you will be able to filter by name or custom.



You can filter in many ways: if the part you choose, is equal, different, null, not null, greater, less... than a value you can put and / or something else. You have many different choices to make a filter.

Tip: in the cases: "Is Like" and "Is not Like" you can use "\_" to represent any single character or "%" to represent any series of characters.

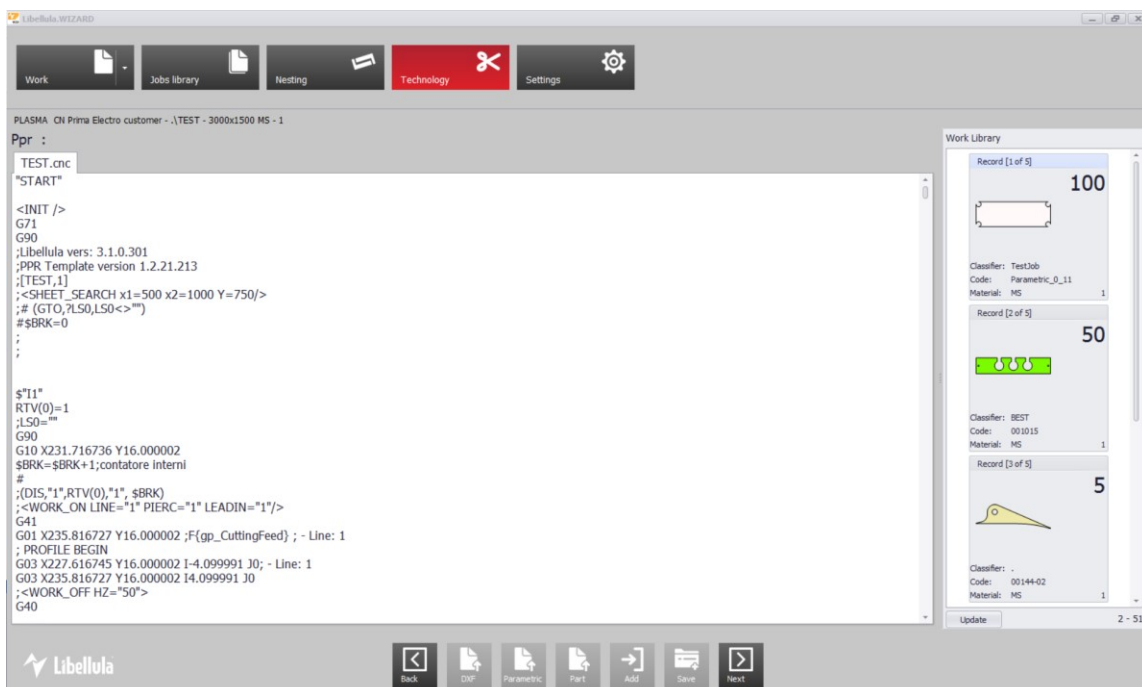
## IV. Nesting Button



You can use the nesting button only when you are on a work and have already created the nesting.

For all the details look in the previous descriptions: [II - Work -> New work -> Nesting Screen](#)

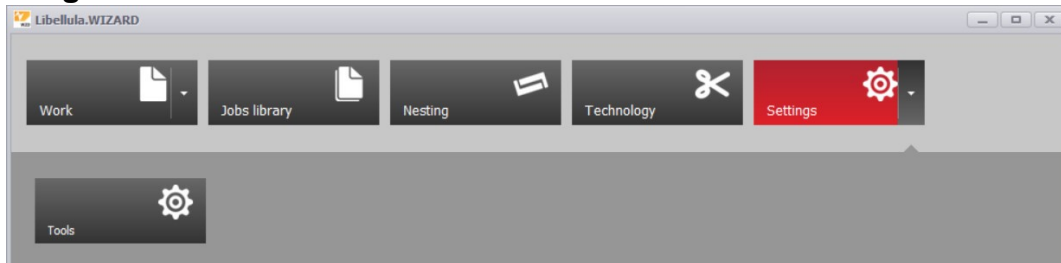
## V. Technology Button



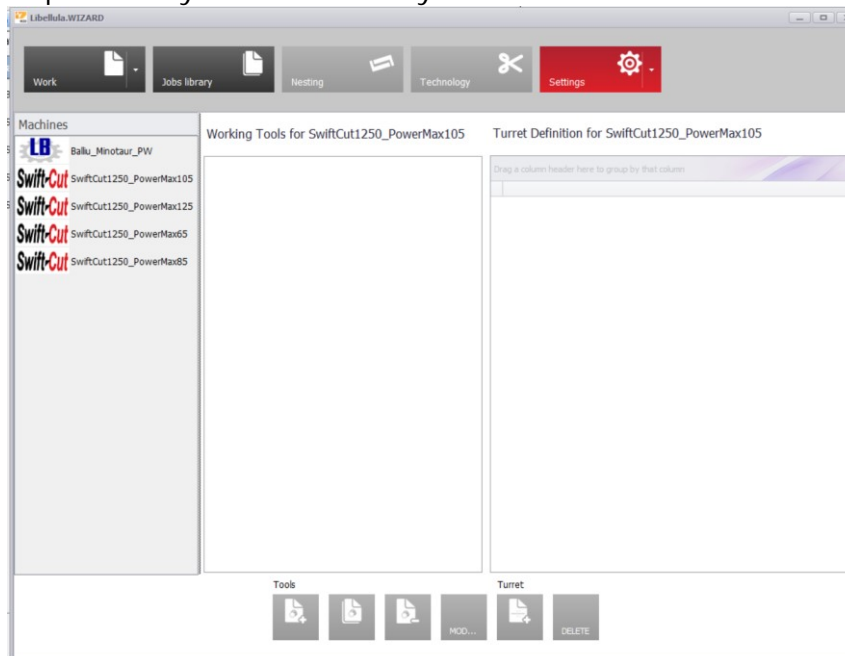
You can use the technology button only when you are on a work and have already created the nesting.

For all the details look in the previous descriptions: [II - Work -> New work -> PPR](#)

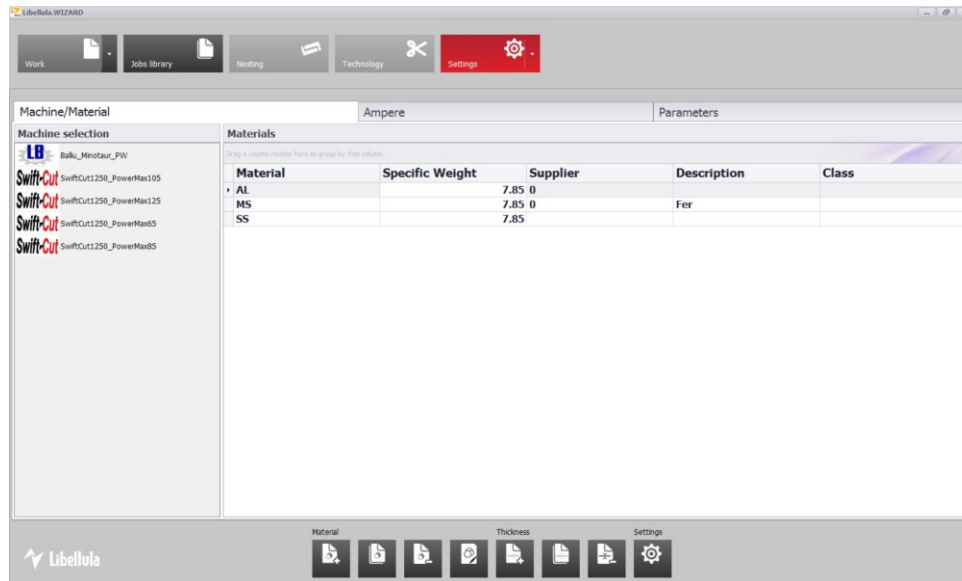
## VI. Settings



**Tools Button:** This part is only activated when you have the module.



**Main button: Settings of the machines**





The first page of the settings is separated in four parts:  
The machine list on the left, the materials on the right, above these, different menus in the tabs and under a list of use buttons

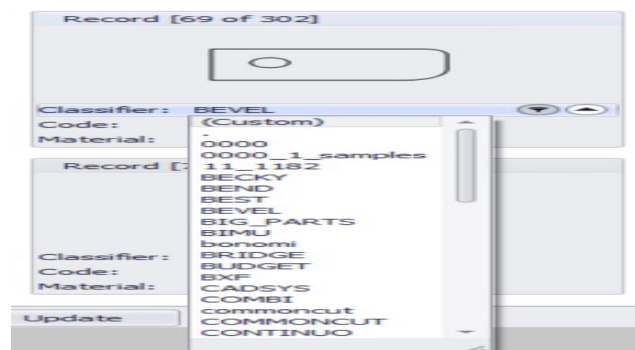
Info: When a work is open and you click on settings, you will go directly in the settings of the used machine. If you want to change settings of another machine, do work -> close.

## 1. Display

In this part of the application, each time you will find a table, you will be able to order the columns or to filter the columns by value.

- To order a column, simply click on the header of it, an arrow will appear saying if it is ascending or descending. 

- To filter, a button is available in the top left of the header of the table . When clicking on it, all the different names of the column you clicked will appear. When you choose one of them, only the lines with that value will be in the table. You can also choose to make a (Custom) filter, it is the first option in the list.



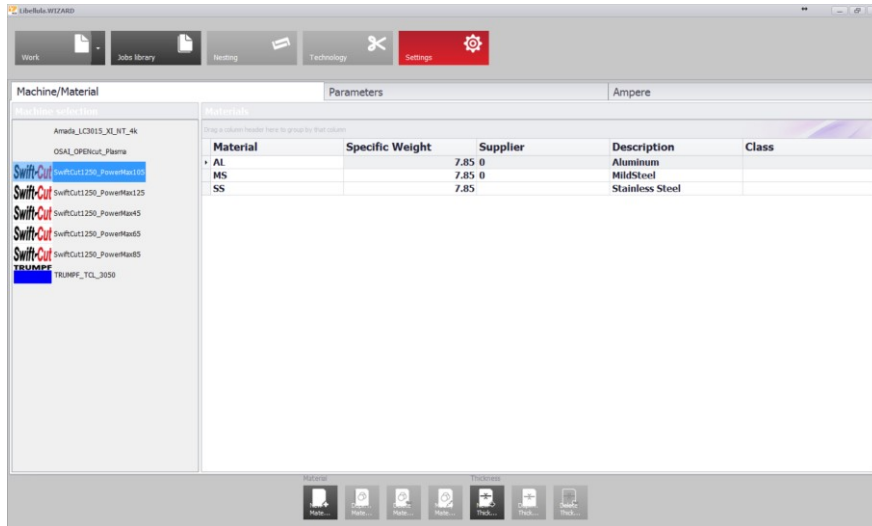
You can filter in many ways: if the part you choose, is equal, different, null, not null, greater, less... than a value you can put and / or something else. You have many different choices to make a filter.

Tip: in the cases: "Is Like" and "Is not Like" you can use "\_" to represent any single character or "%" to represent any series of characters.

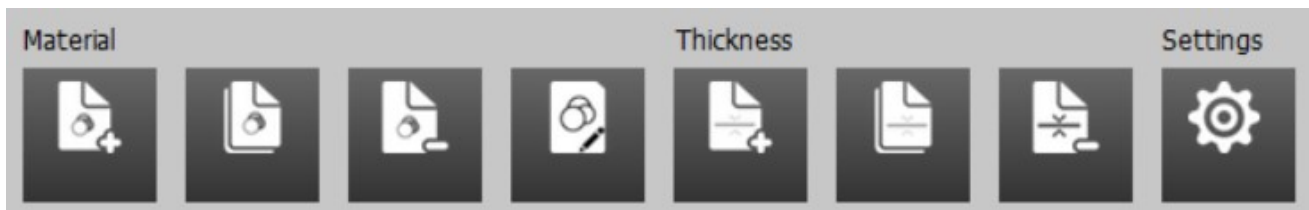
## 2. Tab Machine

First, choose a machine

After selecting a machine, the materials are presented on the right side.



After clicking on a material, the buttons are available:




### Material

#### New Material (1<sup>st</sup> button)



After clicking on the button, enter all the information required for the new material,


and then click the ok button.  You new material will appear in the list. You can always change the material (except for the name) with the fourth button "Modify


Material".

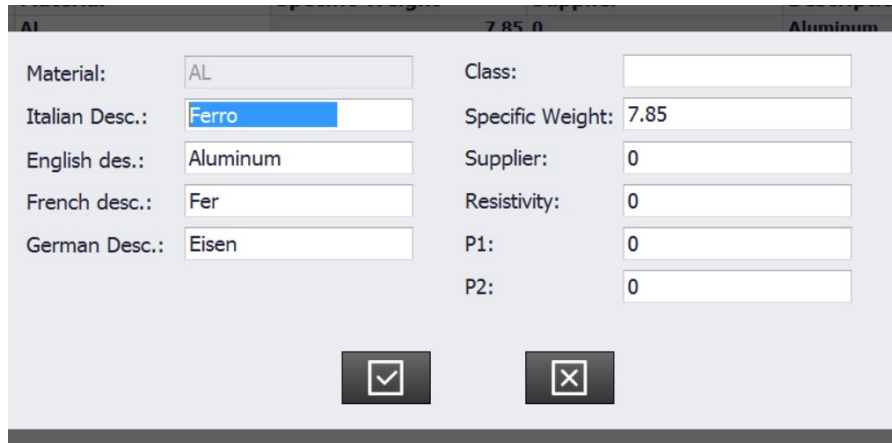
Material:	<input type="text"/>	Class:	<input type="text"/>
Italian Desc.:	<input type="text"/>	Specific Weight:	<input type="text"/>
English des.:	<input type="text"/>	Supplier:	<input type="text"/>
French desc.:	<input type="text"/>	Resistivity:	<input type="text"/>
German Desc.:	<input type="text"/>	P1:	<input type="text"/>
		P2:	<input type="text"/>

## Modify Material (4<sup>th</sup> button)



To modify a material click on the desired material and then click this button. You will be able to modify all the information, except for the name of the material, and then click the Ok Button. 

If you click on the cancel button, your modifications will not be saved. 

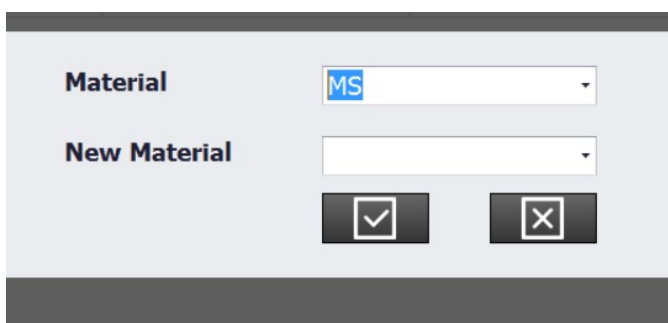
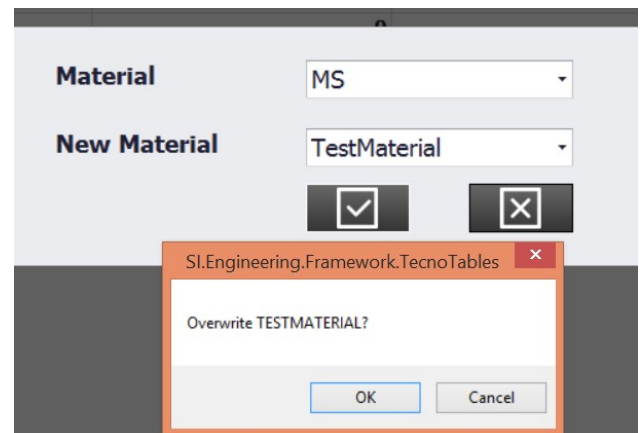


## Duplicate Material (2<sup>nd</sup> button)



To duplicate a material, click on this button. You will have to choose the Material to duplicate. From There two choices:

- Enter a new name for the new material : this new material will have all the descriptions et thicknesses of the duplicated material
- Choose a name in the list: it will set to that material only the thicknesses and not the descriptions of the material. If the material already have thicknesses, you will have to confirm you choice with the second window.

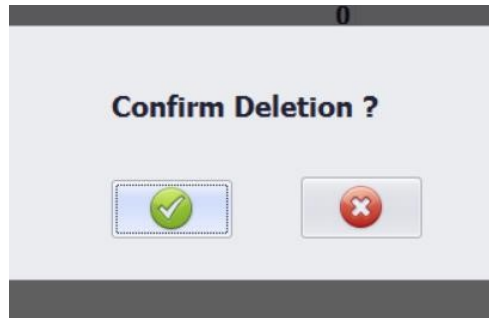



## Delete Material (3<sup>rd</sup> button)





Select a Material and then click on the Delete Button. It will ask you to confirm. Be careful, the material you choose and all his thicknesses will be definitely removed.



## Thickness

### New Thickness (5<sup>th</sup> button)



After selecting a material, click on the button, and then enter all the information required for the new thickness, and then click the ok button.  You will not be able to change the name after that.

Material: AL  
Thickness:   
Ampere:

### Duplicate Thickness (6<sup>th</sup> button)



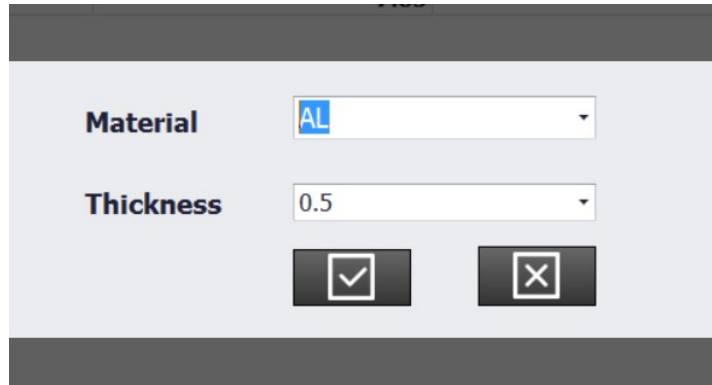
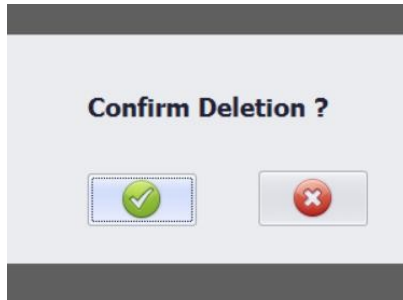
To duplicate a thickness, click on this button. You will have to choose the material and thickness (for some machine although Ampere) you want to duplicate and enter an existing material (if it do not exist, it will not be created) and then validate.


Material: MS  
Thickness: 0.5  
Ampere:   
New Material:   
New thickness:   
Ampere:

### Delete Thickness (7<sup>th</sup> button)



undo the deletion after validating.



To delete a thickness you will have first to validate and then choose the thickness of the material you want to delete. And validate with the Ok button . You cannot

### Settings (8<sup>th</sup> button)



This button is present on all the setting pages. It is used to open the Libellula.Config settings. See the appropriate document.

**WIZARD settings**

 Allow editing spin controls 

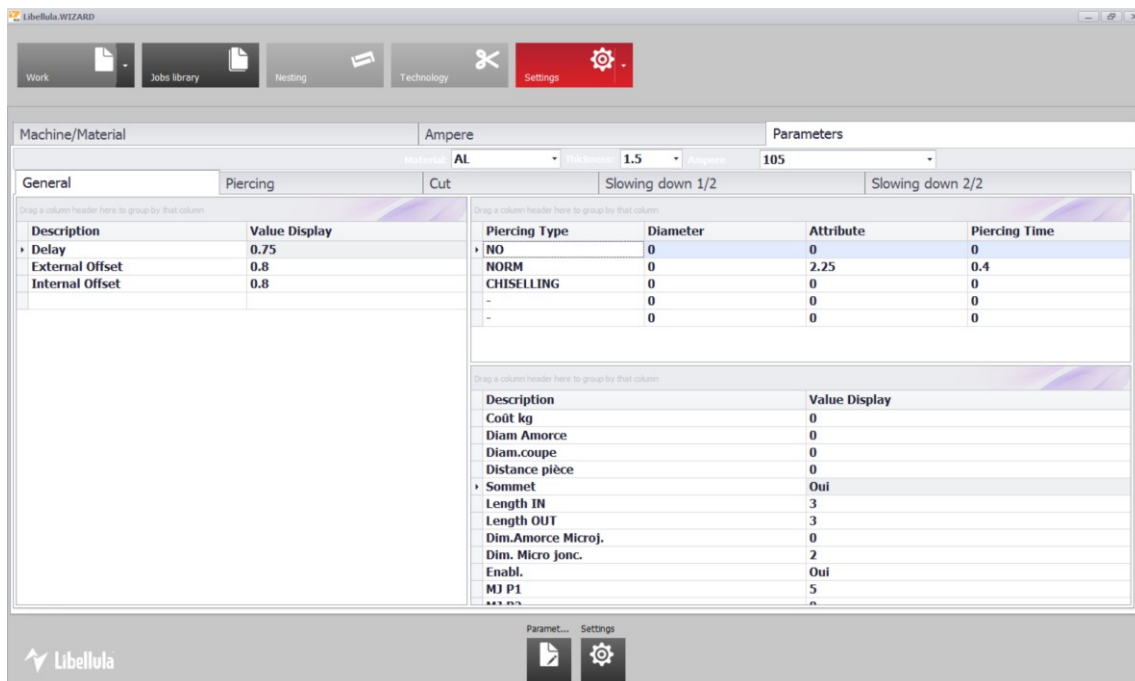
 Use Virtual Keyboard 

 Enable Print on PPR Stage 

Toolbar mode


 External ▼

### 3. Tab Parameters



After choosing a machine, you can modify the parameters by the tab "Parameters".

First choose the material, thickness (for some machine although Ampere) on the top right of the window.

Then you can change all the parameters of the machine in different tabs:

- General
- Piercing
- Cut
- Bevel
- Slowing down 1/2
- Slowing down 2/2


## Tab General



General		Piercing	Cut	Bevel	Slowing down 1/2	Slowing down 2/2
Drag a column header here to group by that column						
Description	Value Display	Drag a column header here to group by that column				
Voltage	0	Piercing Type	Diameter	Attribute	Piercing Time	
Current	0	NO	0	0	0	
Internal Offset	0	NORM	0	0	0	
External Offset	0	CHISELLING	0	0	0	
Delay	0	-	0	0	0	
		-	0	0	0	
Drag a column header here to group by that column						
Description	Value Display					
Price Kg	0					
Lead diam	0					
Cut Diam	0					
Parts distance	0					
Vertex	Yes					
Length IN	2					
Length OUT	1					
Microj. Leadin dim.	0					
Microj. bridge dim.	2					
Line Enable	Yes					
MJ A	5					
MJ B	0					

In this tab, you can find the general parameters of the machine

## Tab Piercing

General	Piercing	Cut	Slowing down 1/2	Slowing down 2/2
Material: <b>AL</b> Thickness: <b>1.5</b> Ampere: <b>105</b>				
<b>PIERCING</b>				
Line Type: PIERCING Lead In Feed: 0 Cut Height(mm): 0				




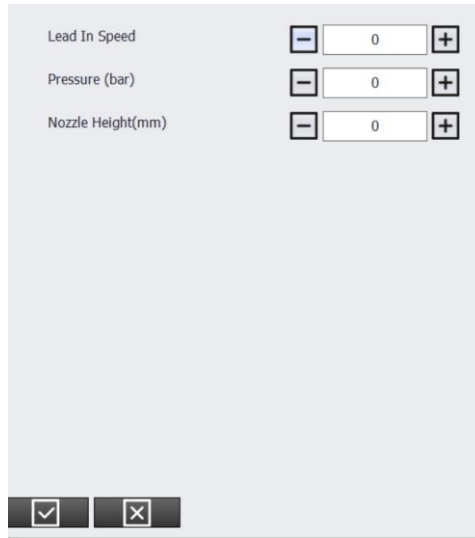
Paramet... Settings  
 

In this tab, you can modify the parameters of the piercing:

- Lead In Speed
- Pressure - Nozzle Height **Edit Button**

To use the Edit Button, first select a piercing type, and click on it.

Then modify all the values you want and validate with the Ok button 



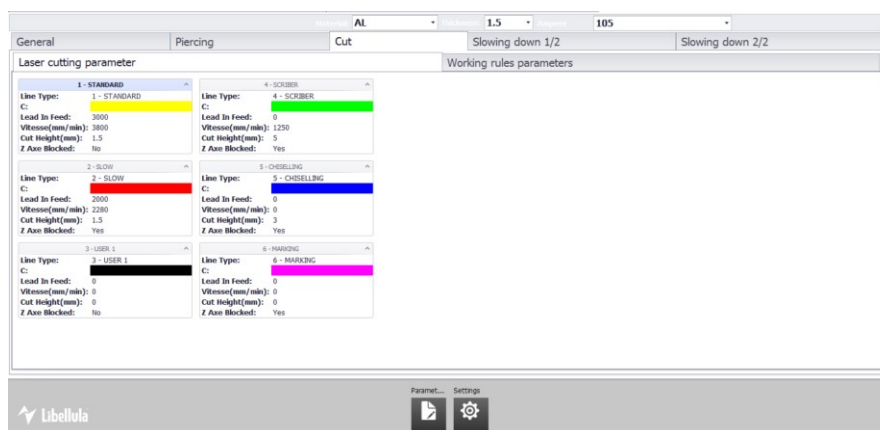
## Tab Cut

In the tab Cut, you have two other tabs: Laser cutting parameters and working rules parameters.

### Laser cutting parameter:

Here you can change the laser cutting parameters of each type of line:

- Color
- Lead In Speed
- Speed (mm/min)
- Pressure (bar)
- Nozzle Height (mm)
- Block of the Z Axe



You can modify the display of every Line type box. In the top right of every box you can find an arrow to reduce the box.



Here under an example of what can be done.

**Laser cutting parameter**

1 - STANDARD ▾

2 - SLOW ▾

**3 - USER 1** ▾

4 - SCRIBER ▾

5 - CHISELLING ▾

6 - MARKING ▾



To modify it click on the line type and use button Edit in the bottom.

There you can change the color, and all parameters and then click on the Ok button 

Lead In Speed [-] 2000 [+]

Speed (mm/min) [-] 3800 [+]

Pressure (bar) [-] 71 [+]

Nozzle Height(mm) [-] 1.5 [+]

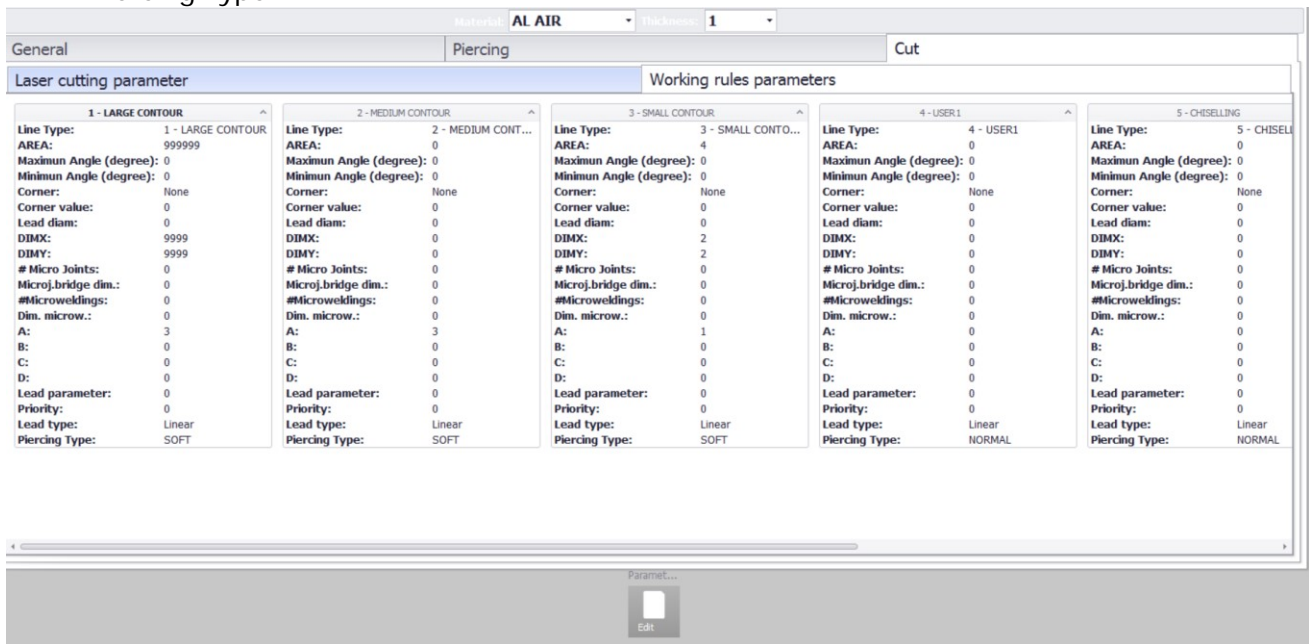
Z Axe Blocked No ▾

### Working rules parameter:

Here you can change the working rules parameters of each type of line:

- Area
- Maximum Angle
- Minimum Angle
- Corner
- Corner Value
- Lead diameter
- DimX
- DimY
- Micro Joints
- Microj.bridge dim
- Microweldings
- Dim Microw
- A
- B - C
- D
- Lead parameter
- Priority
- Lead Type

- Piercing Type



You can modify the display of every Line type box. In the top right of every box you can find an arrow to reduce the box.

Here under an example of what can be done.



To modify a line type click on it and use button Edit in the bottom.

There you can change and all parameters and then click on the Ok button 

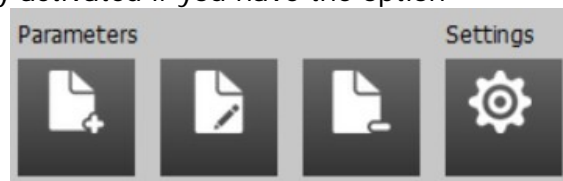
AREA	<input type="text" value="250"/>	# Micro Joints	<input type="text" value="0"/>	Lead parameter	<input type="text" value="0"/>
Maximun Angle (degree)	<input type="text" value="0"/>	Microj.bridge dim.	<input type="text" value="0"/>	Priority	<input type="text" value="0"/>
Minimun Angle (degree)	<input type="text" value="0"/>	#Microweldings	<input type="text" value="0"/>	Linear	
Corner	None	Dim. microw.	<input type="text" value="0"/>	Piercing Type	NORM
Corner value	<input type="text" value="0"/>	A	<input type="text" value="0"/>		
Lead diam	<input type="text" value="0"/>	B	<input type="text" value="0"/>		
DIMX	<input type="text" value="25"/>	C	<input type="text" value="0"/>		
DIMY	<input type="text" value="25"/>	D	<input type="text" value="0"/>		

## Tab Bevel

General	Piercing	Cut	Bevel	Slowing down 1/2	Slowing down 2/2
Drag a column header here to group by that column					
Angle	Offset	Feed	Delay(S.)	Voltage (Volts)	Shedding

Parameters  
New Edit Delete

The Bevel tab is only activated if you have the option



In this tab, you can enable the slowing down on arc with the check button in the top left and add the parameters:

- Angle
- Offset
- Feed
- Delay
- Voltage
- Shedding

## **New Button**

Then Click on the New button on the bottom, add all the values that are necessary and validate with the Ok button.  It will then be added to the list.



Angle	-	0	+
Voltage (Volts)	-	0	+
Delay(S.)	-	0	+
Feed	-	0	+
Offset	-	0	+
Shedding	-	0	+
		<input checked="" type="checkbox"/>	<input type="checkbox"/>

### Edit Button

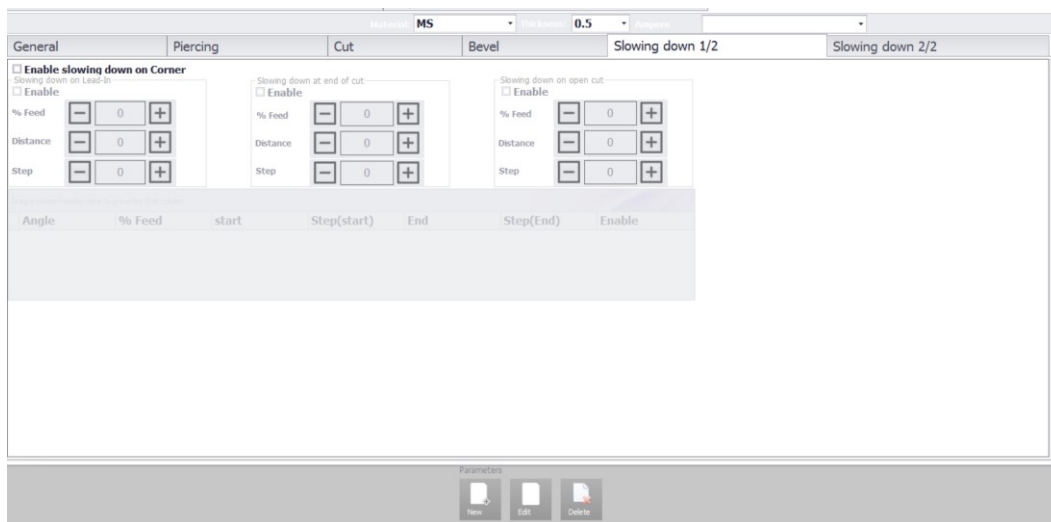
To use the Edit Button, first select a slowing down line, and click on it.

Then modify all the values you want and validate with the Ok button

### Delete Button

To use the Delete Button, first select a slowing down line, and click on it. Then you will have to confirm the deletion. After validating, you will not be able to undo it.

### Tab Slowing Down 1/2



Parameters		Settings	
			

In this tab, you can enable the slowing down on Corner with the check button in the top left and add parameters:

- Radius
- Step start
- Step end
- Start
- End
- % Feed

You can although enable and set the parameters:

- % Feed
- Distance
- Step

For three different slowing downs:

- Slowing down on Lead-in
- Slowing down at end of cut
- Slowing down on open cut

**Enable slowing down on Corner**

Slowing down on Lead-In

**Enable**

% Feed:  (with - and + buttons)

Distance:  (with - and + buttons)

Step:  (with - and + buttons)

Slowing down at end of cut

**Enable**

% Feed:  (with - and + buttons)

Distance:  (with - and + buttons)

Step:  (with - and + buttons)

Slowing down on open cut

**Enable**

% Feed:  (with - and + buttons)

Distance:  (with - and + buttons)

Step:  (with - and + buttons)

## New Button

Then Click on the New button on the bottom, add all the values that are necessary and validate with the Ok button.  It will then be added to the list.

Radius:  (with - and + buttons)

Step(start):  (with - and + buttons)

Step(End):  (with - and + buttons)

start:  (with - and + buttons)

End:  (with - and + buttons)


% Feed:  (with - and + buttons)

Enable:  Off

Angle	% Feed	start	Step(start)	End	Step(End)	Enable
90	80	3	1	3	1	<input checked="" type="checkbox"/>

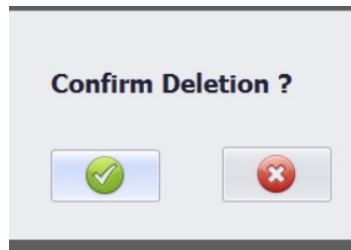
## Edit Button

To use the Edit Button, first select a slowing down line, and click on it.

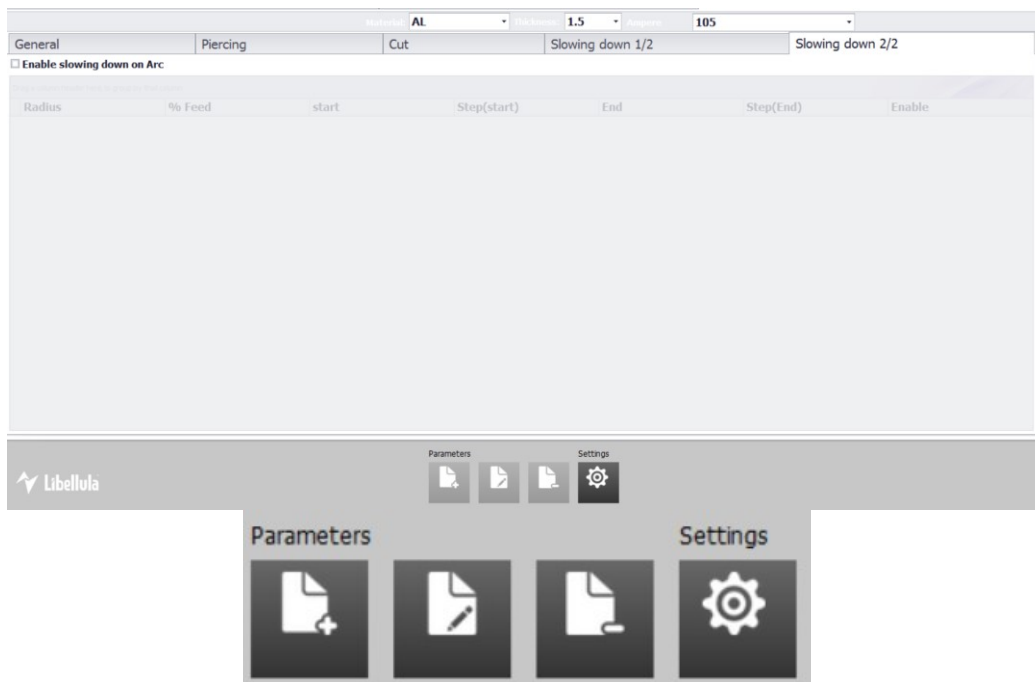
Then modify all the values you want and validate with the Ok button 

## Delete Button

To use the Delete Button, first select a slowing down line, and click on it. Then you will have to confirm the deletion. After validating, you will not be able to undo it.



## Tab Slowing Down 2/2



In this tab, you can enable the slowing down on arc with the check button in the top left and add parameters:

- Radius
- Step start
- Step end
- Start
- End
- % Feed



## New Button



Then Click on the New button on the bottom, add all the values that are necessary and validate with the Ok button. It will then be added to the list.

Radius	<input type="text" value="0"/>
Step(start)	<input type="text" value="0"/>
Step(End)	<input type="text" value="0"/>
start	<input type="text" value="0"/>
End	<input type="text" value="0"/>
% Feed	<input type="text" value="0"/>
Enable	<input type="checkbox"/> Off

General	Piercing	Cut	Bevel	Slowing down 1/2	Slowing down 2/2	
<input checked="" type="checkbox"/> Enable slowing down on Arc						
Drag a column header here to group by that column						
Radius	% Feed	start	Step(start)	End	Step(End)	Enable
50	50	1	1	1	1	<input checked="" type="checkbox"/>
90	80	2	2	2	2	<input type="checkbox"/>

## Edit Button



To use the Delete Button, first select a slowing down line, and click on it. Then modify all the values you want and validate with the Ok button

## Delete Button

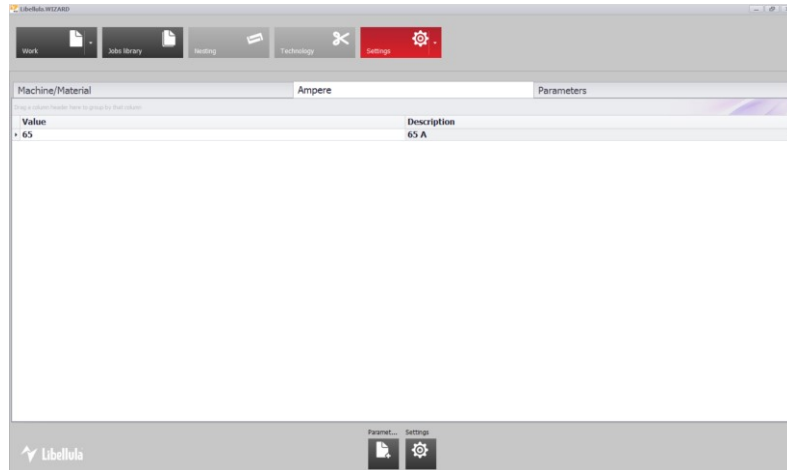


To use the Delete Button, first select a slowing down line, and click on it. Then you will have to confirm the deletion. After validating, you will not be able to undo it.

**Confirm Deletion ?**

## 4. Tab Ampere

For some sort of machines you can add here an ampere.



To add a new ampere use the New button. Add all the values that are necessary and validate with the Ok button.  It will then be added to the list.

Value

Description

Type :

## VII. Contact

### S.I. Engineering S.r.l.

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