

Laguna ISO30 Marker Instructions

1. Attach marker tool to 3d printed part. **DO NOT OVER TIGHTEN M4 BOLTS**
2. Install part onto ISO30 tool holder and only hand tighten. **DO NOT CROSS THREAD**
3. In Vcarve pro setup job to size, Z zero will be top of material.
4. Toolpath by selecting Profile Toolpath.
5. Depth should be .005, tool should be a 1/16thin tool.
6. Machine vector should be on the line.
7. Calculate tool path.
8. Export to machine (select post processor)
9. Turn off spindle by editing gcode file.
10. Open gcode file in text editor. Edit spindle node (M03 S(RPM)). Delete this line and add M30 in replace of (M03 S(RPM)).
11. Save gcode.
12. Bring gcode file over to machine via USB.
13. Set XY0 according to origin. Remove plastic cover of marker and touch off top of the material where the marker makes minimal contact set Z0.
14. Run file.

Any questions email: Jacob_d@lagunatools.com