Acrylic Piece and Cut Summary   SERB   *(DEC 22 08)*

Arduino Controlled Servo Robot

Files

Root:	\Current\CCCC - Final Files For Projects\SERB Final Files\00-Production Files		
T-Square:	**(V 1.0) SERB 9.5X9.5 T SQUARE.ecp**	Time:	
Square 1:	**(V 1.0) 1-SERB LASER CUT LAYOUT (SIMPLIFIED)(9.ecp**	Time:	
Square 2:	**(V 1.0) 2-SERB LASER CUT LAYOUT (SIMPLIFIED)(9.ecp**	Time:	

Settings

Engrave:	Speed: 300	Power: 5	Orange	
Cut	Speed: 9	Power: 100	Black	
Do Not Cut:			Pink	

Steps

SETUP

1.	Reset Laser	
2.	Tape down foundation (to bed not machine)	
3.	Tape down t-square blank	
4.	Jog Machine (300 mm left 270 mm down)	
5.	Focus Machine	
6.	Load T-Square pattern	
7.	Cut T-Square pattern (origin lower left)	
8.	Jog Machine (242 mm right 242 mm up)	
9.	Set Origin to top right	

SERB SQUARE 1 REPEAT (be careful to monitor placement as thie square uses entire sheet)

1.	Load Square one file	
	REPEAT	
2.	Insert Acrylic Square	
3.	Start Cutting	
4.	Push down sticker on just removed piece	
5.	Prep sticker lift sheet	
6.	Wait to finish	
7.	Remove clear keyring and insert a coloured one (readable side up)	
8.	Apply lift sticker (pieces that are left behind pick up) (unless small hole center)	
9.	Put down and go to repeat	

SERB SQUARE 2 REPEAT

1.	Load Square two file	
	REPEAT	
2.	Insert Acrylic Square	
3.	Start Cutting	
4.	Push down sticker on just removed piece	
5.	Prep sticker lift sheet	
6.	Wait to finish	
7.	Apply lift sticker (pieces that are left behind pick up) (unless small hole center)	
8.	Put down and go to repeat	

Acrylic Summary.

Sheet: SERB-SQ-01

SERB-03	Wheel	4	

Sheet: SERB-SQ-02

SERB-01	Base	1	
SERB-02A	Servo Side Left	1	
SERB-02B	Servo Side Right	1	
SERB-05	Servo Brace	1	
SERB-06	Caster Bearing Holder	1	
SERB-07	Caster Bearing Squeezer	1	
SERB-08	Caster Top	1	
SERB-09	Caster Side	2	