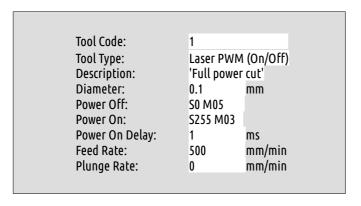
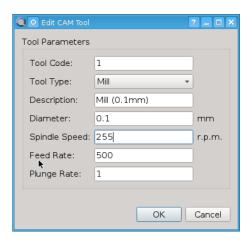
## QCAD/CAM 3.21.3

In the CAM application, when adding a tool, a Tool Type selection 'Laser PWM (On/Off)' is missing.

If the Tool Type 'Laser PWM (On/Off)' is choosen, the layout of the Edit CAM Tool, Tool Parameters window, should be changed to;



defined for different tasks, as engraving, cutting, a.s.o



The proposed fields are based on common used PWM laser-parameters. With these settings QCAD/CAM catches most PWM lasers at once when used in On/Off-mode (M3). The user can setup the whatever On- / Off-codes that should be used. The user can also define several 'laser-tools' used in different toolpaths, where different settings can be pre-

🏶 📵 Gcode Output

Laser On/Pen Down: M03 G1Z0 As for example the EleksMaker laser uses an "S(peed) M(iscel)" -Laser Off/Pen Up: M05 syntax to control the laser; Start Position X: 0 0 Laser On: S255 M03 Start Position Y: 0 Laser Off: S0 M05 Start Position Move To Center ; (M05 S0 switches to low power in Off mode) Jogging Speed (mm/min or in/min): J Tech Photonics Laser Tool X Engraving / Draw Speed (mm/min or in/min): 2500 \$ Laser Power / Pen Distance S# (0-1000): 0 Laser ON Command: M03 Delay (s): Laser OFF Command: M05 Repeat Speed (1-100): 1 Travel Speed (mm/min or in/min): 1000 -Repeat Distance(1-5) (mm or in): 1.0 0 Save Path: output + Laser Speed (mm/min or in/min): 500 File Name: output.nc -Laser Power S# (0-255 or 0-12000): 255 Add Num To File Name • Power-On Delay (ms or s): Unit (mm or in): mm V • Passes: 1 Settings Pass Depth (mm or in): 1.0 Unit of Measure Comment Characters Directory: C:\Gcode\ n e mm ○ Close Start Comment 7 Filename: Test.gcode Laser Commands End Comment Add numeric suffix to filename Laser Off M107 Speeds (mm/min) Laser On M106 S255 All Units (mm or in): mm V Laser Off 1500 Low Power M106 S15 Laser On 100 Live preview Travel At start of job (and at low power), per pixel 0.05 Close Apply Go to center and pause for Gcode Output 5000 milliseconds Optimized Draw outline of printing area True Raster

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