



→ **Laser Engraving with the
Rotary Engraving
Attachment**

→ Rotary Attachment

→ 360° Laser engraving with the Rotary Engraving Attachment

The rotary engraving attachment is required for laser engraving of round, cylindrical and conical objects, such as glasses or bottles. When the rotary attachment is inserted, the movement of the axis in y-direction is replaced by a rotary movement. The Trotec JobControl software will provide you full support during the process. The following description shows the workflow with the rotary engraving attachment.

Tip: Engraving of glasses or cups with handle is more tricky than engraving objects without handle. This description therefore explains engraving of an object with handle. If engraving objects without handle, some steps are not required. Please refer to the respective section of this document.

1 → Prepare your Trotec laser

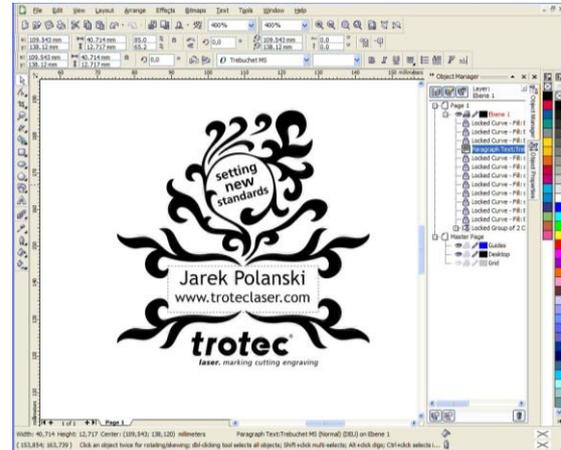
- Move the working table to the lower position, switch off the laser and open the top lid.
- Put the rotary engraving attachment onto the working table. Position the rotary attachment on the rulers using the brackets on the left and top side of the rotary attachment.
- Connect the rotary engraving attachment via the control cable with the connector of the motion system. The connector is located inside the left front of the engraving cabinet.
- Now switch the laser on again. The machine starts referencing and the cones of the rotary attachment move into the 0° position automatically.



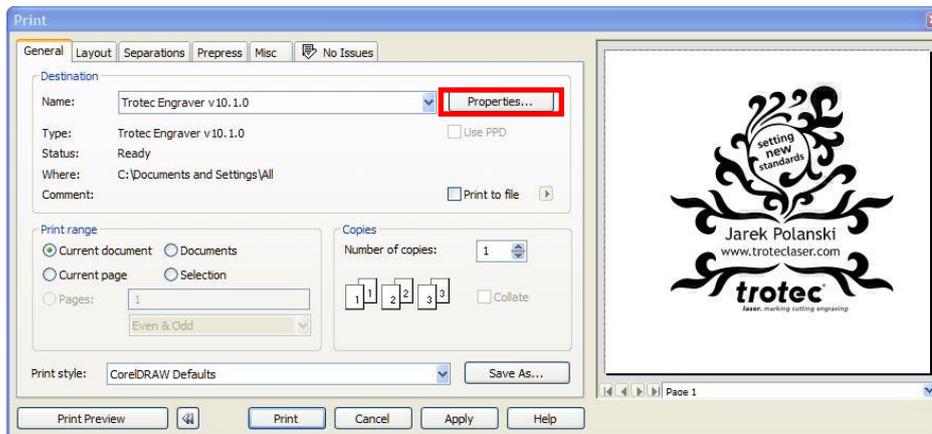
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2 → Prepare your artwork

- Create your artwork in your graphics software. You get best results when you position the artwork into the center of the page (Tab: Layout). Tip: Make sure that the height of the artwork fits onto the object to be engraved.

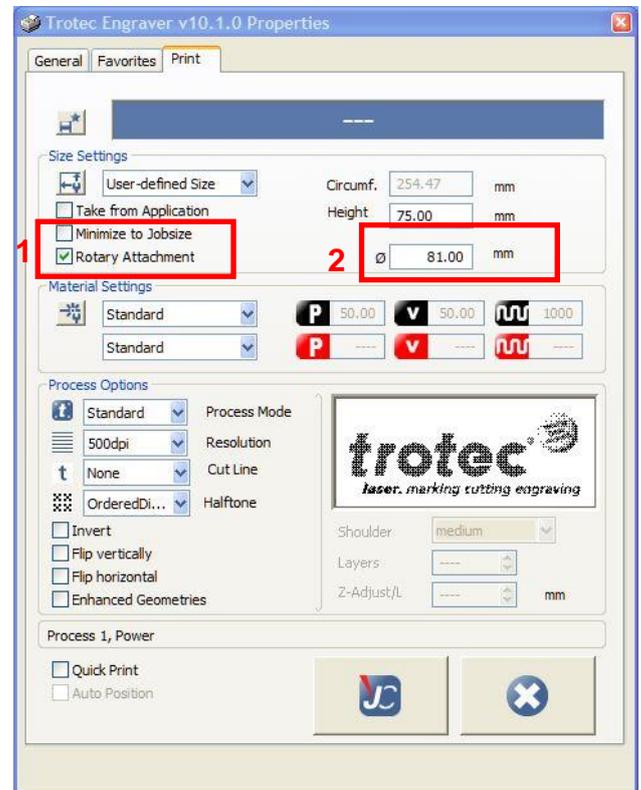


- Print your graphic, select Trotec Engraver as printer and open the Printing Properties



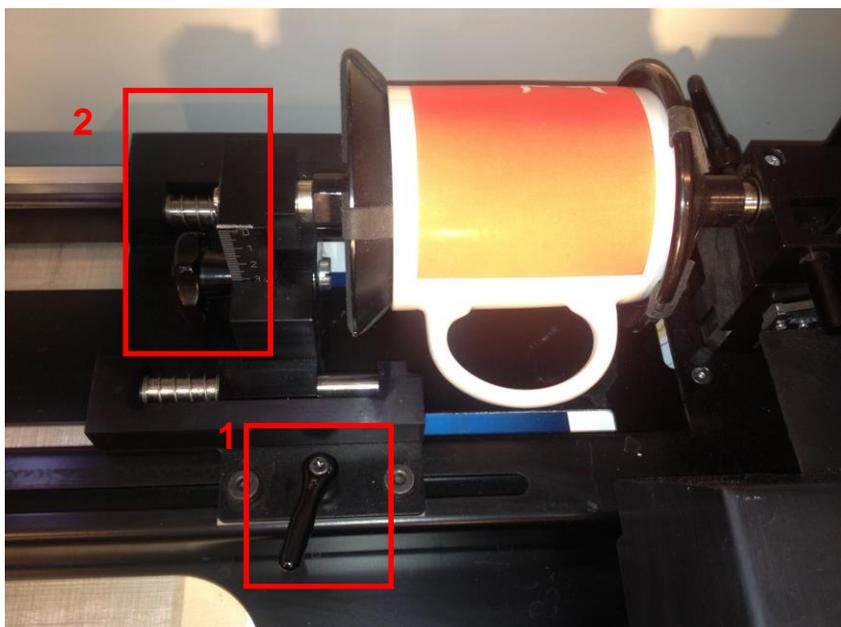
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- Activate the Rotary Attachment option (1) and enter the correct diameter of your object (2). Measure the object, where you want to engrave it. The JobControl software automatically calculates the circumference of the object and adjusts the job size.



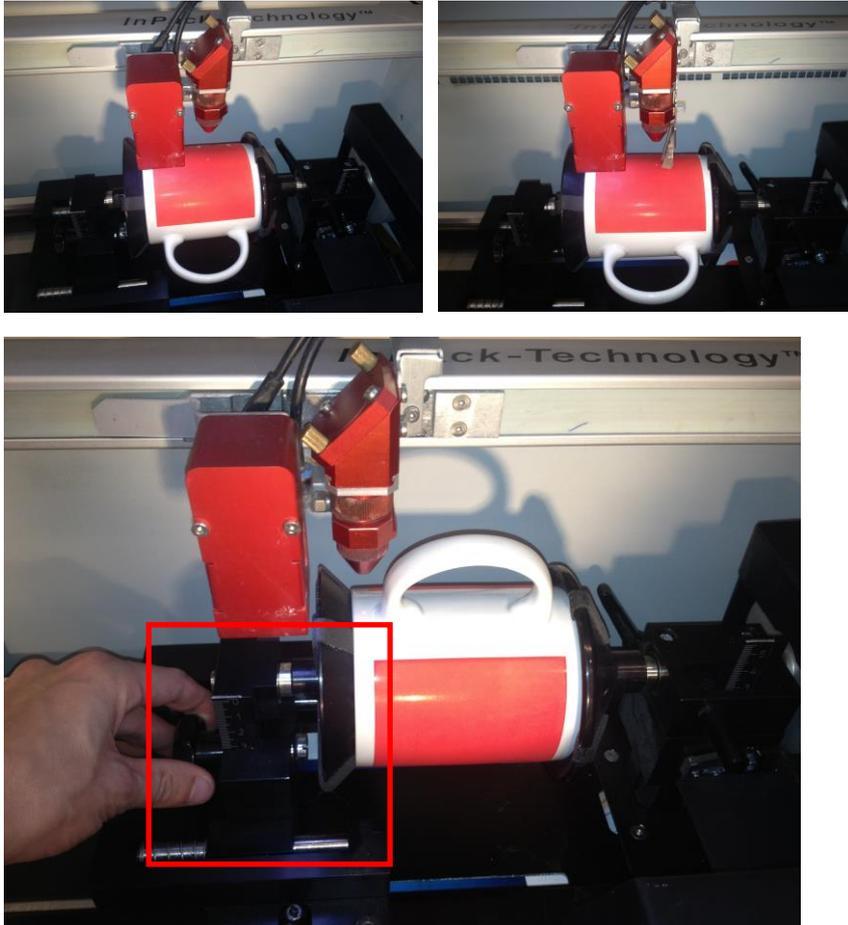
3 → Positioning and laser engraving

- Insert your object and fix it with the lever (1). The springs (2) should be tensioned only half way to be able to quick change the material. This also reduces the handling time during series production.



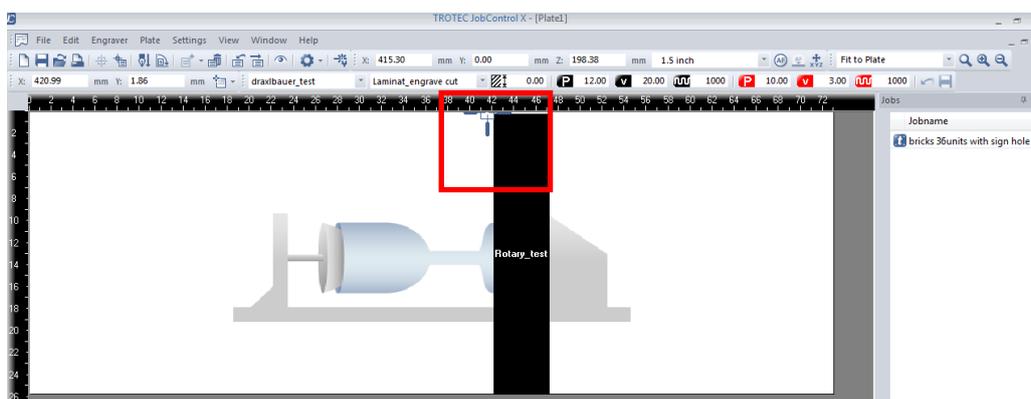
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- Now focus on the engraving area of your object.
- Gently loosen the springs on the left and turn the object so that the handle is in a vertical position (see graphic). This avoids a possible contact between engraving head and handle (not necessary if objects without handle are engraved).



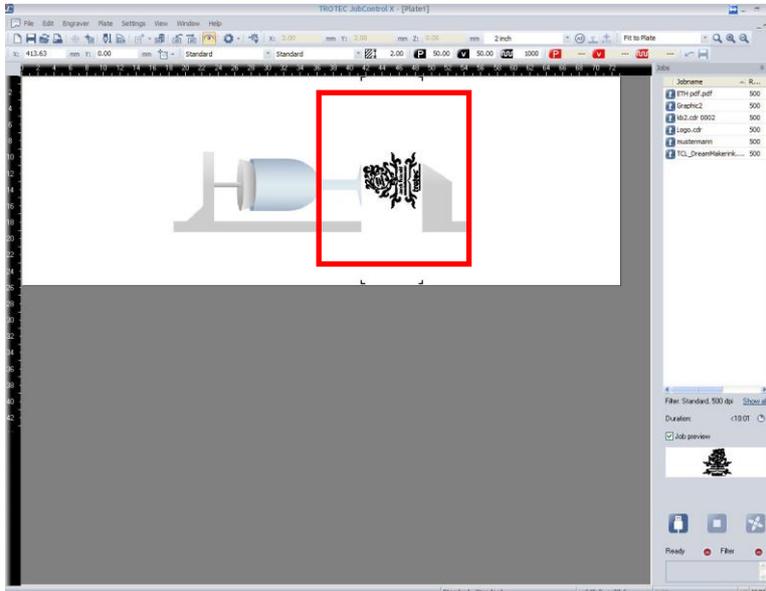
- Position the job from your job queue on the plate and let it snap into the bottom right edge of the cross-hair.

Tip: The virtual engraving table of JobControl automatically changes as soon as a rotary engraving job is positioned.



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The WYSIWYG („What you see is what you get“) function supports in double-checking the correct position of the engraving job.



- Now you can start laser engraving.

4 → More Tips and Tricks

- If you want to engrave conical objects, the engraving area needs to be parallel to the x-axis in order to ensure a constant focus position. Rotary attachments of Speedy 300, Speedy 360, Speedy 400 and SP 500 can therefore be tilted.
- Rotary attachments of Speedy 300, Speedy 360, Speedy 400 and SP 500 are available with cones, rollers or as a combined model.
- Make sure that the object can turn 360 ° without contact to the engraving head. You can check this using the y-axis arrow keys of your control panel of the laser. If you are using a Speedy 100 with air assist, the nozzle can easily be removed.

If you need further information or assistance, please contact your Trotec team.