

Ruida RDEMarkVision Engraving Machine Software

E-Mail: support@rd-acs.com

1. Parameter setting of relevant machine manufacturer and camera installation. Reference 6442 visual cutting instructions. (the software is 6442 visual cutting assistant software). After debugging the equipment, if you want to use it quickly, you can jump directly to "three. Main stream of software operation".

2. Detailed description of software function

2.1 menu bar

RdMarkVisionCutV1.00.42
 File(F) Edit(E) Draw(D) Processing(W) Help(H)

2.1.1 file suboptions Introduction to

File(F)	Edit(E)	Draw(D) Process
0	pen	Ctrl+O
Sa	ive	Ctrl+S
Import		Ctrl+I
Export		Ctrl+E
Se	et parame	eter F6

- Open the project: open the template saved before, the format can only be.Rvm
- Save engineering: save template file, format can only be.Rvm
- Import vector diagram: import graphic format can be.Ai.Dxf.Pltt three formats. Choose the right format, click



ai ai			
查找范围(I); 🛛 🔮 文档	· + € *	₽ Preview	
名称 ^	修改日期	类型 ▲	
360js Files	2018/7/9 9:19	文件	
Axure	2018/7/10 9:04	文件	
BasedCam2 Files	2018/5/31 9:50	文件	
Corel	2018/3/28 11:37	文件	
EVEREST Reports	2018/6/8 11:47	文件	
Fiddler2	2018/3/28 15:05	文件。	
		>	
2件名(N):		打开(0)	
(件类型(T): Supported file	•	取消	
Supported file		-Mira	
Ai Files (*.ai)			
PLI Files (*.plt)			

• Export vector diagram: import graphics format can be.Ai.Plt two formats. The dialog box is as follows:

存在(1): 圕 文档					
<u>م</u>	修改日期	类型	大小		
360js Files	2018/7/9 9:19	文件夹			
Axure	2018/7/10 9:04	文件夹			
BasedCam2 Files	2018/5/31 9:50	文件夹			
Corel	2018/3/28 11:37	文件夹			
EVEREST Reports	2018/6/8 11:47	文件夹			
Fiddler2	2018/3/28 15:05	文件夹			
Inventor Server for AutoCAD 2019	2018/7/27 14:29	文件夹			
QQEIM Files	2018/8/24 8:40	文件夹			
Tencent Files	2018/8/23 11:14	文件夹			
Visual Studio 2008	2018/3/28 11:04	文件夹			
Machat Ellas	2010/0/22 10.22	\` 7//+=+=			
‡名(<u>N</u>):					保存(S)
序类型(I): Ai Files (*.ai)				•	B D212

2.1.2 user parameters

Click on the file and click the parameter settings as follows:



dor sectory [User para] Fi	ie para Page si	ecung	
Axis parameters		^	
Axis	Х		
Direction polarity	Negative		
Limiter polarity	Negative		
Keying direction	Negative		
Contrl Mode	Pulse+Dir		
Enable Limit trigger	Yes		
Enalbe home	Yes		
Step length(um)	0.35000		
Max speed(mm/s)	1000.000		Read
Jump-off speed(mm/s)	5.000		Write
Acceleration(mm/s2)	8000.000		Open
Breadth(mm)	1000.000		
Start speed of keying(m	n 5.000	~	Save

Before the operation of user parameters, the motherboard parameters must be read.

Null speed: the highest speed of all non sculpted straight lines during the movement of a machine. If the user sets the parameter illegally, the controller will automatically put it in the above range; if the airway speed is set larger, the working time of the whole graph can be shortened, but the settings are too large, which may cause the trajectory to shake. Move.

Airway acceleration: corresponds to the speed of acceleration when walking, airway acceleration and airway speed to match, if set too slowly the actual airway speed may not reach the set value, if set too fast, the mechanical structure may not be able to bear, resulting in jitter. The general acceleration is slightly higher than the acceleration.

Turning speed: Corresponding to the lowest speed in the process of carving when turning down, when there are a lot of sawtooth, the turning speed can be reduced appropriately.

Turning acceleration: it should match the turning speed.

Cutting acceleration: corresponds to the speed of cutting (cutting speed is the layer speed in the layer parameters).

Idle time delay: when a machine is not sculpted, it needs waiting time before movement.

Acceleration ratio: the coefficient corresponding to the cutting speed, the greater the rate, the greater the cutting speed.

Null acceleration ratio: the coefficient of velocity corresponding to the empty travel time, the greater the rate, the greater the speed of the empty path.

Turning coefficient: the greater the turning speed, the greater the turning factor.

Delay before feeding: Delay before a single feeding when using a feeding device, the user can arrange such processes as picking at this time.

Delayed feeding: refers to the feeding device will be delivered to the material in place after a stable period of time before processing.

Line by line feeding: the feeding device sends materials one by one to the place in a way of feeding.

Progressive feed compensation: there may be some errors in the use of feeding devices for progressive feed.

Reset speed: When the machine starts, return to the original speed, if the machine is larger, can be set reset speed on the high side, but not too large.

X, Y, Z, U boot reset: you can set up whether each single shaft is reset during boot.

Array processing mode: two way array and one way array can be selected. Bidirectional walk array: that is, cutting the array back and forth in sequence; one-way walk array: cutting the array from one direction to another all the time. When the one-way walking array is selected, the action mode of each array unit is exactly the same, and the action fluency is completely consistent, but it takes a little time than the two-way walking array. The default choice is bidirectional array.

Location of return: mechanical origin, location and non return position. This parameter determines the position where the carving head stops after each work.

Focal length: corresponding panel auto focus operation.

Reverse gap X, Y: used to compensate for the reverse gap caused by machine transmission.

Knife lifting position: the position of the cutter head when the machine starts carving.

Location of the cutter: the position of the cutter head when the machine is finished.

Docking position: the position of the carving head after machine carving.

Cutting speed: the speed of the cutting head of the carving head when the machine is engraving.

Pre processing delay: waiting time before machining.

2.1.3 information

Click on the file, click the parameter settings, click the system information as shown below:

Set parameter			×
Vendor settting Us	er para File par	a Page setting	System information
	Please input pas	isword	
	Confir	m	

View motherboard version number and upgrade motherboard



2.1.4 parameter settings

Click on the file, click the parameter settings, click the file parameters as shown below:

endor settting User para	File para	Page setting	System i	nformatio
Import Setting				
Smooth curves				
Auto close curves		Close error(mm): 0.1	
Combine lines	Co	mbine error(mm): 0.1	
Import Dxf text info				
DXF Unit:			MM	-
✓ Import image in AI file	es			
Export Precision(%): 8	0			

Parameter settings for importing files: set the imported graphics.

2.1.5 manufacturer's parameters

Click on the file, click parameters and click the manufacturer's parameters.

dor settting User para Fi	le para Page s	etting	System informati
Axis parameters	1	^	
Axis	X		
Direction polarity	Negative		
Limiter polarity	Negative		
Keying direction	Negative		
Contrl Mode	Pulse+Dir		
Enable Limit trigger	Yes		
Enalbe home	Yes		
Step length(um)	0.35000		
Max speed(mm/s)	1000.000		Read
Jump-off speed(mm/s)	5.000		Write
Acceleration(mm/s2)	8000.000		Open
Breadth(mm)	1000.000		
Start speed of keying(m	n 5.000	~	Save

The parameter significance is consistent with the ordinary motion control card.

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2.1.6 2.1.6 page setup

Click on the file, click parameter settings, and click the page settings page.

Page width((mm):	000		
Page height((mm): 1	000	_	
Speed	unit: m	ım/s	•	
Size	unit: n	IM	•	
	Oł	۲.		

Set page width, interface speed and interface size.

2.2 toolbar

2.2.1 commonly used toolbars



The icons are newly built, opened, saved, imported, exported, revoked, and restored. The first 4 have been introduced above. The last two are revocation and recovery.

Cancellation: cancel the previous step. If the graph is deleted, it can be revoked. (up to 10 steps can be cancelled). **Resume**: repeat the previous operation.

2.2.1 Drawing toolbar

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Select mobile: used to select graphics, line segments, etc. Generally, graphics must be selected before graphics related operations can be performed.

Polygon: used to draw polygons. Click to draw the line segment and double-click to form a closed area.

Rectangle: used to draw rectangles.

Ellipse: used to draw ellipses. Press the Ctrl key to draw circles.

Horizontal mirror: mirror the original image along the Y axis.

Vertical mirror: mirror the original image along the X axis.

Rotation: for graphics rotation. After clicking, you can set the rotation angle in the dialog box.

Array: click on the interface graph to click on the array to appear the following dialog boxes

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Interval(mm):	0.000
Interval(mm):	0.000
ows:	1
ols:	1
	Auto-ful

Input the corresponding parameters, you can copy "row number, column number" of the same graphics on the screen. The distance between each figure is determined by spacing.

2.2.2 operation toolbar

(7) 🔍 🔍 🎋 🏠 🗔 🖬 🖶 🐌 🔜 // 🔄
Mobile: movement of the whole workspace.
Frame selection view: box to select a region to enlarge view.
Page scope: click the page scope, and the interface is back to the set range.
Data range: select graphics, click output range, maximize graphics rendering.
Path display: shows the processing sequence of graphics.
Display node : node displaying graphics
Curve closure: select the unclosed graph click icon to appear in the following dialog box:
Setting close error X
Close error(mm): 0.1
Force to dose
Ok Cancel

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Can close closed graphics.

Delete the overlap line: click the icon to display the following dialog boxes:

elete overlap	3
✓ OnOverlap	
Overlap error (n	ım): 0.001
ок	Cancel

Delete overlap line settings

1		
ė	2	÷
	-	7

Merge linked lines: click the icon to display the following dialog boxes:

ang combine en	
Combine error	(mm): 0.1
	Capital

Set the value and merge the two lines into one.

•

Lead settings: click the icon to display the following dialog boxes and set the lead.

Lead In/out			×
Import rdt	s file <mark>autoa</mark>	iddin	
Lead-in line	e	Lead-out li	ine
Linetype Length(mm	Line -	Length(mm	Line
Radio(mm) Angle(°)	0 45	Radio(mm) Angle(°)	45
C Interna		xternal C A	uto cut
Knire compensi		Ok	Cancel

000

Manual sorting: click the icon to display the following dialog boxes:

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Edit the cutting path.

Curve fitting: the following dialog boxes are selected in the click Icon:



Curve fitting		×
SmoothError	0.0	ОК
Coefficient	— 10.0	Cancel

Smooth smoothness of image is processed.

Image processing: click the icon to display the following dialog boxes:



-

RDEMarkVision Operation Manual

Jaiog	×
tatic	Open Preview GetContour Expand: 1.0 mm Elaboratio
	Threshold
	Manual Auto ImageProcess
	□ Del-Imp: 1 Pix □ Close 19 Pix
	Del-small 40 Pix Del-fill DeleteEdge 0.00 mm Mark size 5.00 mm
	Sel-Contour CoutourW 0.0 3000.0 mm Sel-WH
	Couldurn: 0.0 3000.0 mm Reset
	Smooth Edge 3
	ОК

Import the picture, extract the outline of the picture, get the contour cutting line, and cut.

The specific procedures are as follows:

Click to open the picture and import the picture.

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Channel setting

When the material is first lifted, the pretreatment channel is set up first, and different channels are selected first, and the effect is different. We try to choose a channel with the strongest contrast, as shown in the figure above.

Parameter adjustment

After setting up the passageway. There are some parameters that can be adjusted. It can display the effect of adjustment in real time. As shown in the following figure.

Dialog	×
Static	Open Preview GetContour Expand: 1.0 mm Elaboratio Preprocessing
VEER by iStock	ImageProcess ImageProcess
	DeleteEdge 0.00 mm Mark size 5.00 mm Sel-Contour

Contour extraction

After reaching the desired effect, point the edge, and the result is shown in the following figure.



Dialog	×
Static	Open Preview SetContour Expand: 1.0 mm Elaboratio
	Preprocessing
	Channel Gray ColorImg
	Threshold
	V Whitel
	I▼ Manual [46]
	□ Auto
	- ImageProcess
	□ □ □ □ □ □ □ □ □ □ □ □ □ □ □ □ □ □ □
	□ Close
	□ Del-gap 1 Pix
by iSlock	□ Disconne □ □ Pix
	Del-small 40 Pix Del-fill
	DeleteEdge 0.00 mm Mark size 5.00 mm
	Sel-Contour
	CoutourW 0.0 3000.0 mm Sel-WH
	CoutourH: 0.0 3000.0 mm Reset
	Smooth
	Edge 3
	ОК

Then click the original drawing to check the details of the edge lifting. As shown in the following figure.

Dialog	×
	Open Preview GetContour Expand: 1.0 mm Elaboratio Preprocessing
	Threshold Image: Manual 46 Image: Auto 46
A MARKEN	ImageProcess I Pix I Del-imp: Pix I Close Pix I Del-igap I
by IStock	Disconne I pix Del-small 40 Pix Del-fill DeleteEdge 0.00 mm Mark size 5.00 mm
	Sel-Contour 3000.0 mm Sel-WH CoutourH: 0.0 3000.0 mm Reset CoutourH: 3000.0 mm CoutourH:
	Smooth Edge 3 OK

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Figure 3-3File processing parameter settings

3.2Model Parameter Settings



Figure 3-4 Model parameters

3.2.1 Mark point parameters

Choose the required Mark point types to make Model, respectively supporting circle, cross, rhombus, ellipse, circular ring, rectangle, square, triangle, and 8 kinds of Mark point style.

When making Model, please specifying different styles respectively according to the chart corresponding parameters (such as diameter, width).

3.2.2 Model matching parameters

Smoothing coefficient: the higher smoothing coefficient, the less extracting characteristics of scattered points.

Similarity: matching score between Model and the actual pattern, the higher the score, the more like of graphics. Similarity setting, will affect the match quality directly.

Overlapping: the overlapping percentage of two envelope rectangles of target graphics. This parameter controls the target graphics overlapping whether to identify or not.

Matching angle: the allowing model revolving and searching angle range. Such as: its value is set to 180 degrees, in the process of model matching, the range of angle searching is: $-180 \sim 180$ degrees. The match angle should be set up according to the actual requirements, the wider the angle, the more the match time required. If the user does not need to set this parameter, can remove the option directly

Match overtime: this parameter controls the match time. To adjust the parameters when the target graphics matching failed due to lacking of time or to avoid waiting too long time in search process. This parameter is mainly affected by the model characteristics of complexity.

Matching test: The current model matches with the current target graphics in camera view range, test results will

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be back in results interface. You can know the mark point elated parameters from test results.

3.2.3 Enable Secondary Positioning

After searching the target, not set this location coordinates as criterion, but moved to the target automatically, take photos again, and repositioned target location coordinates.

Distance offset / **Angle offset**: When two-point positioning, such as you might find more features when searching feature 2, according to the distance between feature 1 to feature 2, if found multiple features in the circle arc of feature 1 as origin, then as angle to distinguish them.

Note: But when the offset is set too small, missing cut will be happened. Generally distance offset can be set within 2mm, angle offset within 5°, such as the workpiece requires more accurately, you can set smaller.

3.2模板参数设置	-
	-
4	

3.3 output setting

Layer	Speed	MinPower	MaxPower	Output	
					Up
					Down
ath optimi: Origina	ze I or edit path		Block	handle — leight:	50
Order of Inside	of layer to outside	t point and di	-	Dir:	Up to bott
Auto fir	nd start point	:		Enable Angle	2
Backlas	h reapy optir Ingle	nize		Angle	90.000 o
	1.2				

Layer parameters: set the layer cutting sequence, speed and power.

Optimization of road strength: setting the graphic output path.

Block processing: select the height of the graph and cut the partition area.

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牧 数,	弹出用户参数对话框,	如下图:	-
•		F	

3.4 user parameters

Click on the user parameters to display the user preferences dialog box.:

Idle speed(mm/s) 20 Idle Acc(mm/s2) 30 Start speed(mm/s) 20)0.000)00.000		C C	•
Idle Acc(mm/s2) 30	000.000		С	C
Start speed(mm/s) 20				
Start speeu(mm)s/ 20).000		Small circle speed l	
Min Acc(mm/s2) 40	0.000		Discustor	
Max Acc(mm/s2) 30	000.000		Diameter	5peed(m
Idle Delay(ms) 0.	000		2.100	20.000
Acc factor(0%-200% 10	00		3.100	25.000
GO Acc factor(0%-20 10)0		4.100	30.000
Speed factor(0%-20(10	00		8.100	40.000
Key setting		~		

Origin location: this setting is mainly for single head machines. The setting of the origin must be consistent with the actual origin of the machine.

Small circle speed limit: when cutting small circle, it will be cut at the specified speed.

Feeding settings: after carving, feeding can be carried out to achieve continuous automatic processing.

Before the operation of user parameters, the motherboard parameters must be read.

Null speed: the highest speed of all non sculpted straight lines during the movement of a machine. The minimum can not be less than the X/Y shaft take-off speed of the small person, the maximum speed can not exceed the maximum speed of the two axes, if the user setting is illegal, the controller will automatically put this parameter in the above range; the space speed setting is larger, can shorten the working time of the whole figure, but the setting too large may cause the trajectory to shake. Move.

Air distance acceleration: the acceleration and slow speed corresponding to the air travel time, the air distance acceleration to match the air distance speed, if the set too slow actual space speed may not reach the set value, if set too fast, the mechanical structure may not bear, and cause jitter. The general air range acceleration is slightly higher than the carvings acceleration.

Turning speed: corresponding to the minimum speed of falling speed during the carving process, when the machining pattern has many sawtooth, the turning speed can be reduced properly.

Turning acceleration: it should match the turning speed.

Cutting acceleration: corresponds to the acceleration speed of cutting (cutting speed is layer speed in layer

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parameter).

Idle time delay: when a machine is not sculpted, it needs waiting time before movement.

Acceleration ratio: the coefficient corresponding to the cutting speed, the greater the rate, the greater the cutting speed.

Null acceleration ratio: the coefficient of velocity corresponding to the empty travel time, the greater the rate, the greater the speed of the empty path.

Turning coefficient: the greater the turning speed, the greater the turning factor.

Feed parameters -

The delay before feeding: when the feeding device is used, the time is delayed before the single feed. Users can arrange such processes as picking and picking up at this time.

Delay after feeding: it means that the feeding device will send the material to the place, and it needs to be stabilized for a period of time before processing.

Line by line feeding: the feeding device sends materials one by one to the place in a way of feeding.

Progressive feed compensation: there may be some errors in the use of feeding devices for progressive feed. Reset parameters --

Reset speed: when the machine is turned on, it will return to the original point. If the machine is larger, the reset speed can be set, but not too large.

X, Y, Z, U boot reset: you can set up whether each single shaft is reset during boot. Other parameters -

Array processing mode: two way array and one way array can be selected. Two way array: cut the array in sequence; one way array: cut the array from one direction to another. When one way array is chosen, the operation mode of each array unit is exactly the same, and the action fluency is exactly the same, but it takes less time than the bidirectional array. A two-way walk array is selected by default.

Location of return: mechanical origin, location and non return position. This parameter determines the position where the carving head stops after each work.

Focal length: corresponding panel auto focus operation.

Reverse gap X, Y: used to compensate for the reverse gap caused by machine transmission.

Z axis parameter

Knife lifting position: the position of the cutter head when the machine starts carving.

Location of the cutter: the position of the cutter head when the machine is finished.

Docking position: the position of the carving head after machine carving.

Cutting speed: the speed of the cutting head of the carving head when the machine is engraving.

Pre processing delay: waiting time before machining.

3.5 information

Click the information and pop-up the information dialog box as follows:



Set parameter		×
Vendor settling	User para File para Page setting Syste	m information
	Confirm	

Look at the motherboard version number and upgrade the motherboard 3.6 configuration

Manual	Camera param	Model Set Export User I	nfo Con	fig
-Impo	rt Setting Smooth curves			
	Auto close curves	Close error(mm):	0.1	
	Combine lines	Combine error(mm):	0.1	
DXF	Unit: Import image in Al	I files	MM	•
	Vendor param	Export Precision(%):	80	_
	venuor param			
_	Page setting	」 语言/Language:	English	•

Parameter settings for importing files: set the imported graphics.

Factory parameters

Click on the manufacturer's parameters, pop up the manufacturer's toolbox dialog box, and select the factory parameter page.

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-	Axis parameters		^	
	Axis	Х		
	Direction polarity	Negative		
	Limiter polarity	Negative		
	Keying direction	Negative		
	Contrl Mode	Pulse+Dir		
	Enable Limit trigger	Yes		
	Enalbe home	Yes	_	
	Step length(um)	0.35000		
	Max speed(mm/s)	1000.000	_	Read
	Jump-off speed(mm/s)	5.000		
	Acceleration(mm/s2)	8000.000	_	Write
	Breadth(mm)	1000.000		Open
	Start speed of keying(m	5.000		Save

3.7 main process of software operation

The first step is to connect the motherboard and click the configuration button to set up the reading parameters.

Set parameter				×
Vendor settting	User para	File para	Page setting	System information
	ł.			
	Please i	nput passw	ord	
		Confirm		

The second step: click the debug button to debug the parameters of the Z axis lifting tool and knife (or click the

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parameters of the user, Z axis, and adjust the specific parameters).



"Contrast", "gain" are both to deal with image data. So when image is in dim, firstly adjust the light source (lamp on the camera) and **[Exposure]**, if still cannot get the desired effect, to adjust brightness, contrast, gain.

Camera Calibration:

[Speed] : In the process of camera calibration, laser head moving speed or when cutting cross or dotting.

[Power **]** : The processing power when camera calibration.

Cutting a circle as appointed, press "cut circle", the system will cut a circle on the platform and then matching test the circle size in the model parameters as below showed:

Mark point p	param						
т	Type: [D:	Cirde 5.000	mm				1
Sir	mlar:	30.0	%	Smooth:	80.0	%	
A	ngle:	5.0		Overlap:	20.0	%	
Time	eout:	100	ms	Match	test	0	
Length e	error:	1.0	mm	Angle error:	1.0	0	
	1	Ena	ble second p	osition			
	x		Y				
tart point:	-430.	108	653.939	Stand time:	200	ms	吉果数=1,耗时:0.219秒圆形 [0=10.235; (-0.001,-0.121), deg=0.000
Num:	2		3				
Space:	-250.	000	-185.000				确定

Picture 2-1 matching test to measure diameter

Click "<<<" to correct the pixel precision, fill the matching test result into Measuring Length Bar, then click "confirm", the system will confirm the proportionality coefficient automatically.





Picture 2-2 pixel precision ratio

[Cut Cross] : Click the "cross cutting", the laser will quickly cut a cross.



Picture 2-3 Cut Cross

【Camera Distance Calibration】: Cut a cross, then move the camera view cross center to coincide with the cross center, click "camera calibration". System will calculate the offset from camera view center to the center of the laser head.



Picture 2-4 Camera Distance Calibration



3 Import Graphics

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查找范围 (I): 🞯 桌面	S 🖉 🗁 🛄 -
 予約立档 予約中期時 PDL 年期 2014-11-1从化游 ccc. ai mark point. ai mt01-2 ai mt012. ai mt02. ai mt02. ai Mt02 HB; 2014-11-24 9:58 xin. ai 大小: 11.4 XB 	The second s
文件名 @): tt01-2. ai	😂 ग्रम
文件类型 ①: Supported file	1 取消

3.1User clicks the imported icon, the following dialog will be appeared.

Figure 3-1 import processing file preview

Select the imported graphics, click "open". The waiting processing graphics will appear in the main view area.



Figure 3-2 import processing files

The imported graphics output as the already made layer color, you can define the output cutting contour.



Layer	velocity	Enable	Blow
	100.000	NO	Blow 1
	100.000	YES	Blow 1

Figure 3-3File processing parameter settings

第四步	_
	-
•	•

Fourth steps: Mark point identification settings



As shown in Figure 3-6, select the Mark point in the view area and click the III Icon to set the starting point.

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3.8. Mark point searching path

Click the starting point to confirm the starting point coordinate, also can choose the mark point in the view area to click to se \bigoplus : starting point.

The system will search the marking points starting from the closest other marking points.

3.9 Processing Settings



Move the axis, the camera will find the first Mark points, then match testing and check the matching result.

Figure 4-6 Mark point matching test

After the testing, click the "start" button on the control panel to proceed processing.

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