

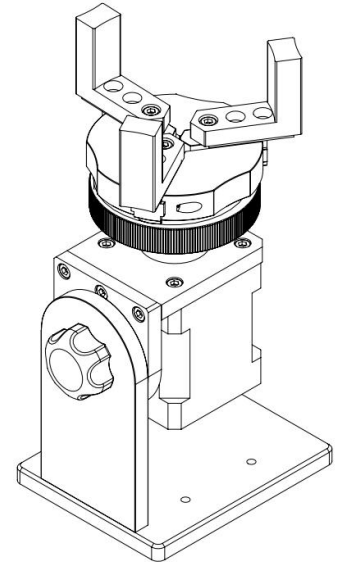
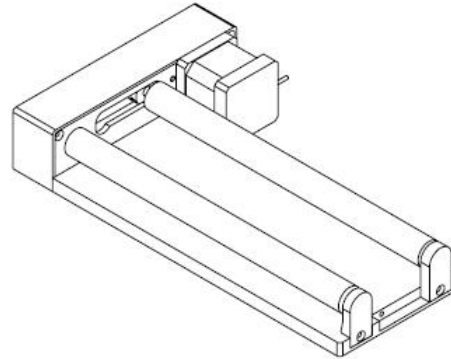


BJJCZ



BSL

Instructions for use of the rotating roller

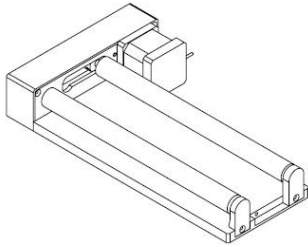


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M1 and M4 models can only use BSL software

RT5 Rotation axis introduction



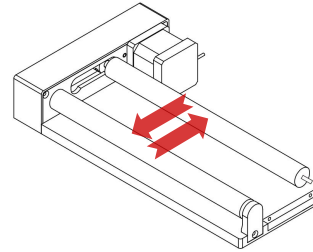
RT5

Used with laser engraving machine to engrave regular cylinders such as Coke cans

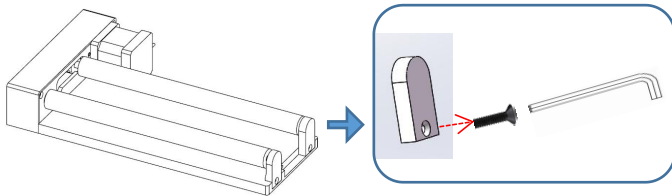
1. Spacing adjustment [to adapt to the load of regular cylinders with different diameters]

Note: Diameter 5-150mm, weight <3KG

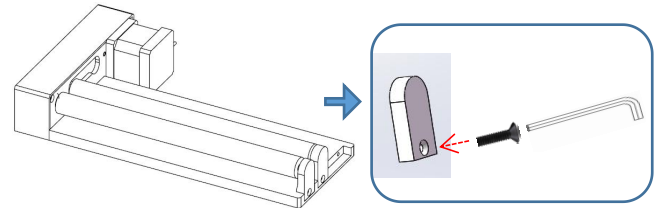
② Rotate the shaft closer to the left side



① Remove the right bearing support



③ Complete the roller fine pitch adjustment and lock the screws



RT5 BSL software setup

1. Rotate text marking

The screenshot shows the BSL software interface with the 'filling' dialog box open. The dialog box has the following settings:

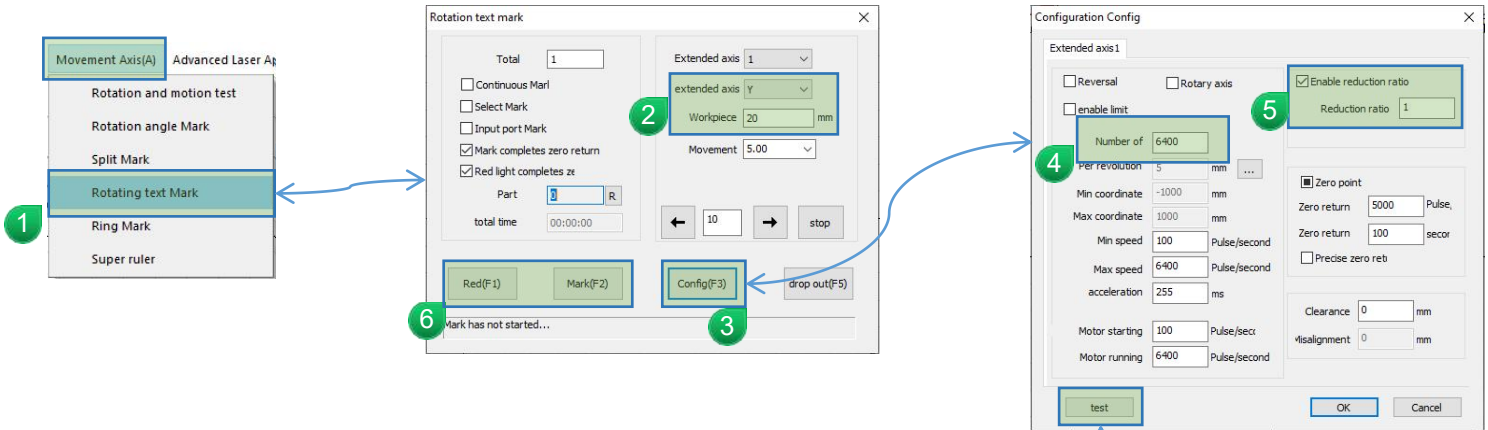
- Enabling contour
- Outline priority
- filling: 1
- Enable
- Object overall calculate
- Walk around
- cross fill
- quick fill
- Pen: 0
- angle: 0
- Line: 0.05 mm
- number: 1
- Average distribution
- Margins: 0 mm
- Start: 0 mm
- End offset: 0 mm
- Straight: 0 mm
- Boundary: 0 mm
- Ring: 0.5 mm
- Automatic rotation a 0
- delete
- Dismiss group when

The background shows the text 'TEXT' rotated 90 degrees. The 'Mark parameter' table on the right is as follows:

Pe...	swi...	name	Nur...
0	open	Default	
1	open	Default	
2	open	Default	
3	open	Default	
4	open	Default	
5	open	Default	
6	open	Default	

Below the table, there are checkboxes for 'Use default Configs', 'Pen number', 'Number of processing', 'Speed (mm/s)', 'power (%)', 'Frequency (kHz)', 'Pulse width (ns)', 'Opening delay (us)', 'Off light delay (us)', 'End delay (us)', and 'Corner delay (us)'. There is also an 'Advanced setup...' button and a 'set to default parameters' button.

- 1 Enter text and rotate it 90°
- 2 Text fill, do not check "Object overall calculate"



1 Follow the steps in the picture to enter the "Rotate Text Marking" interface

2 extended axis: Y
Workpiece: Fill in according to the actual engraving object diameter

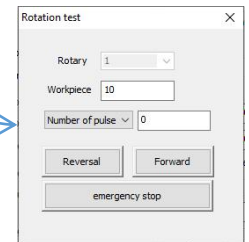
3 Enter the "Config" interface

4 Number of:
Method 1:
Workpiece x 500 = Number of;
Method 2:

Open the "test" window, fill in Workpiece, Number of pulse, for example, enter 16625, click "Reverse" or "Forward" to observe whether the roller drives the object (such as a cup) to rotate one circle. If it does not rotate one circle, increase the value of "Number of pulse". If it exceeds one circle, reduce it until it rotates exactly one circle. The value of "Number of pulse" is "Number of"
Finally, fill in the tested pulse value into "Number of".

5 Reduction ratio: 1

6 After the setting is completed, press "Red" to preview, press ESC to cancel the preview, and press "Mark" to start marking.



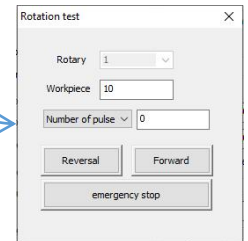
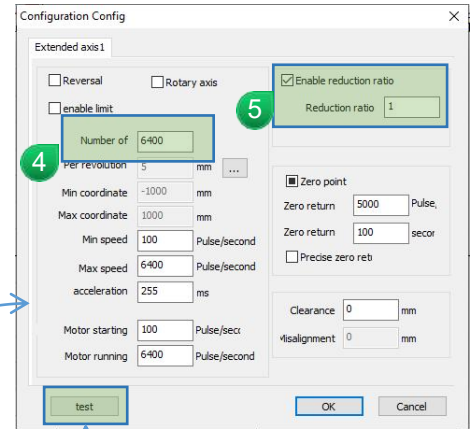
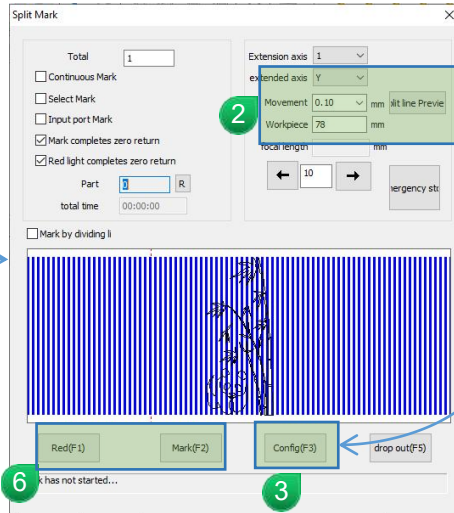
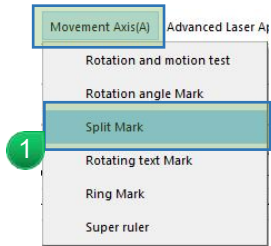
2. Split Mark

1 Insert the vector file and fill it

The screenshot shows the BslCAD1 software interface. A 'filling' dialog box is open, centered over a grid with a panda illustration. The dialog box has the following settings:

- Enabling contour: (checked)
- Outline priority: (unchecked)
- filling: 1 (selected), 2, 3, 4
- Enable: (checked)
- Object overall calculate: (unchecked)
- Walk around: (checked)
- cross fill: (unchecked)
- Quick fill: (unchecked)
- Pen: 0, angle: 0
- Line: 0.05 mm
- number: 1
- Average distribution: (checked)
- Margins: 0 mm
- Start: 0 mm
- End offset: 0 mm
- Straight: 0 mm
- Boundary: 0
- Ring: 0.5 mm
- Automatic rotation: (unchecked)
- delete: (unchecked)
- Dismiss group when: (checked)

The panda illustration is enclosed in a green rectangular box with a green circle containing the number '1' at the bottom center. The software interface includes a menu bar (File, Draw, Edit, Modify, View, Status bar, Movement Axis, Advanced Laser Applications, Galvanometer correction, Help), a toolbar, an Object list window, a text window, and a Mark parameter window on the right. The status bar at the bottom shows 'Ready', 'Capture: grid:turn off Auxiliary line. Device coordinates:171, 0, Draw coordinates: -45.21(Display multiple:0.758', and 'USB firmware type: Not NUM'.



1 Follow the steps in the picture to enter the "Split Mark" interface

2 Extended axis: Y

Movement: The smaller the value, the better the precision, but the slower the speed. 0.1 is recommended. Click "Split Line Preview" on the right

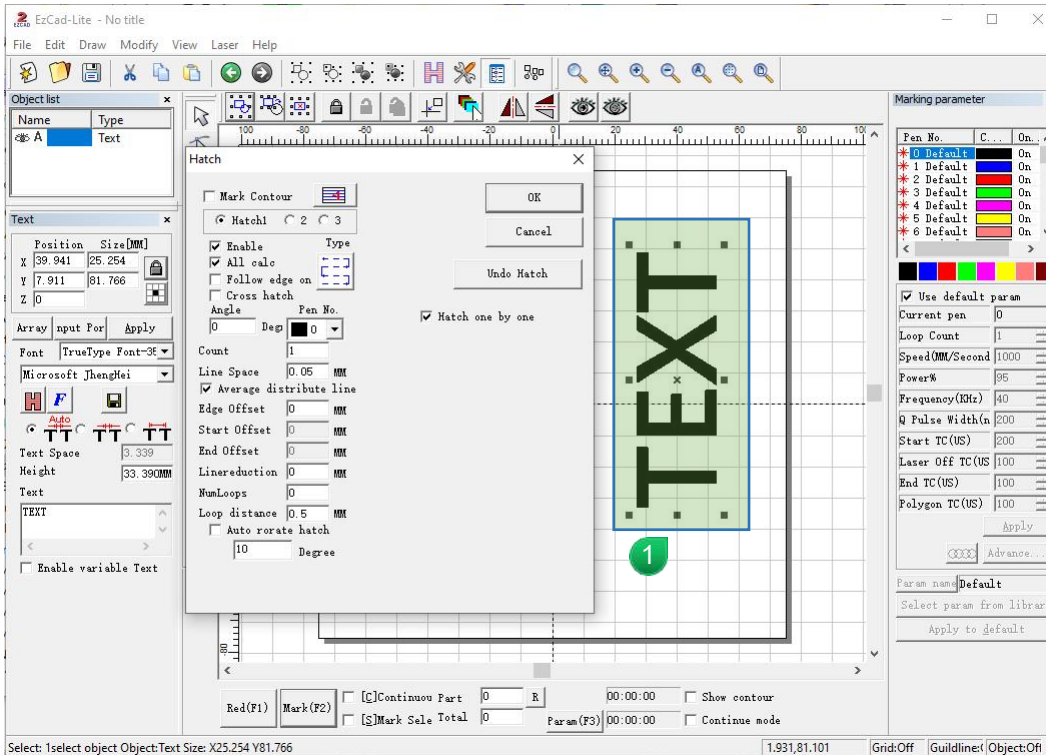
Workpiece: Fill in the value according to the actual diameter of the object being engraved

3 Enter the "Config" interface

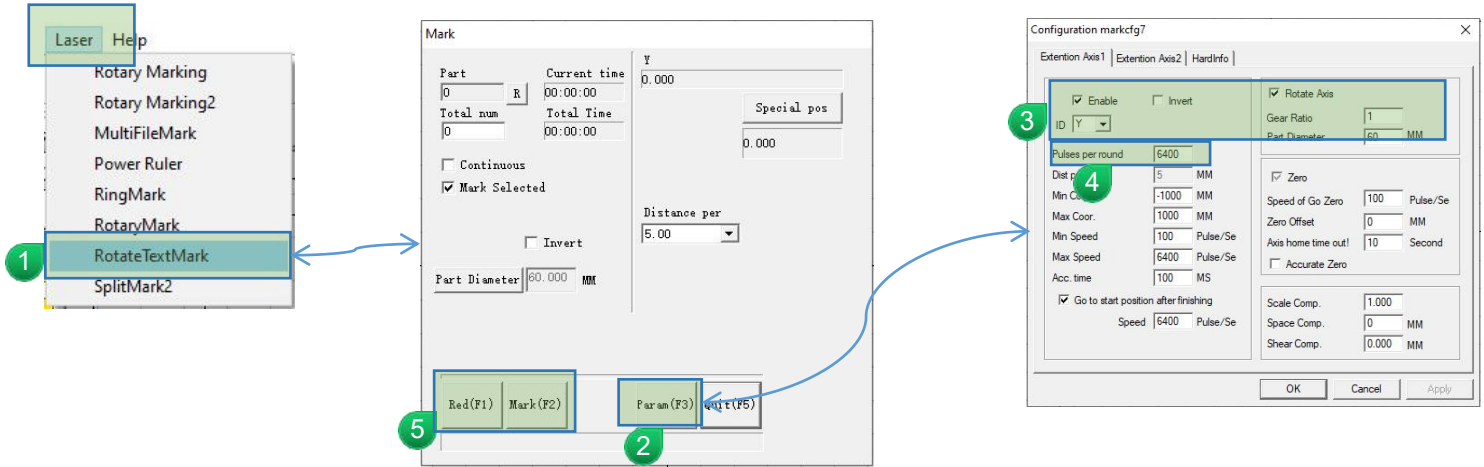
- 4 Number of:
Method 1:
Workpiece x 500 = Number of;
Method 2:
Open the "test" window, fill in Workpiece, Number of pulse, for example, enter 16625, click "Reverse" or "Forward" to observe whether the roller drives the object (such as a cup) to rotate one circle. If it does not rotate one circle, increase the value of "Number of pulse". If it exceeds one circle, reduce it until it rotates exactly one circle. The value of "Number of pulse" is "Number of"
Finally, fill in the tested pulse value into "Number of".
- 5 Reduction ratio: 1
- 6 After the setting is completed, press "Red" to preview, press ESC to cancel the preview, and press "Mark" to start marking.

RT5 BJJCZ software settings

1. Rotate text marking



1 Enter text and rotate it 90°



1 Follow the steps in the picture to enter the "Rotate Text Marking" interface

2 Enter the "param" interface

3 Check "Enable"; "Rotate Axis"

Gear Ratio: 1

ID selection: Y

Part Diameter: Fill in according to the actual engraving object diameter

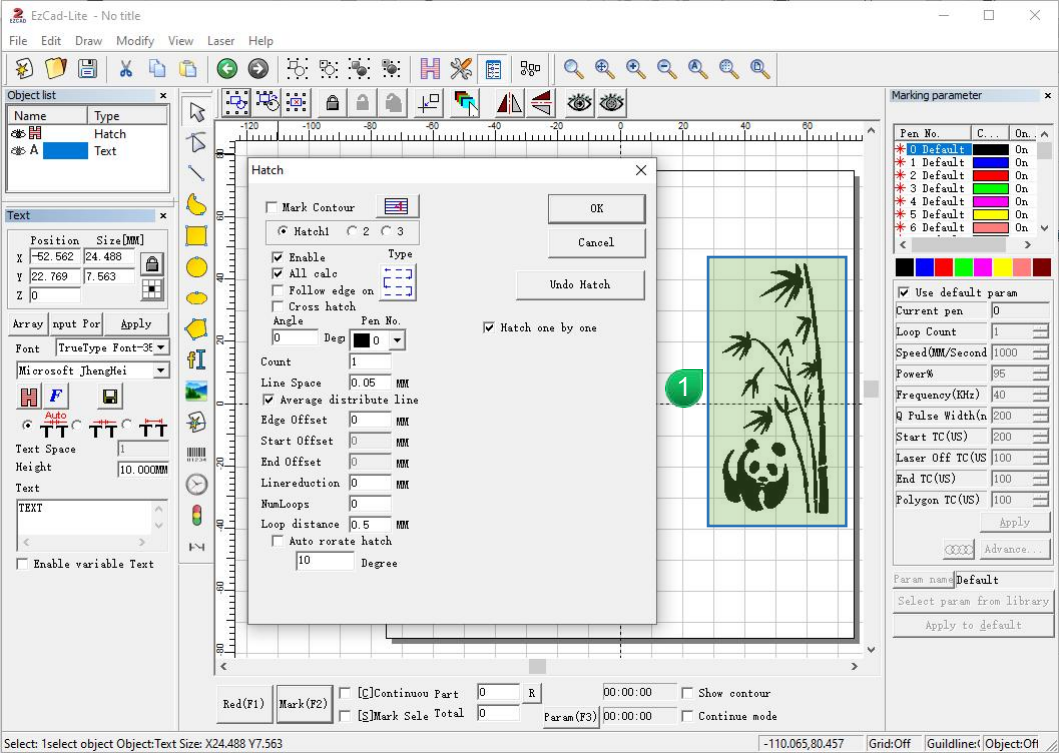
4 Pulses per round:

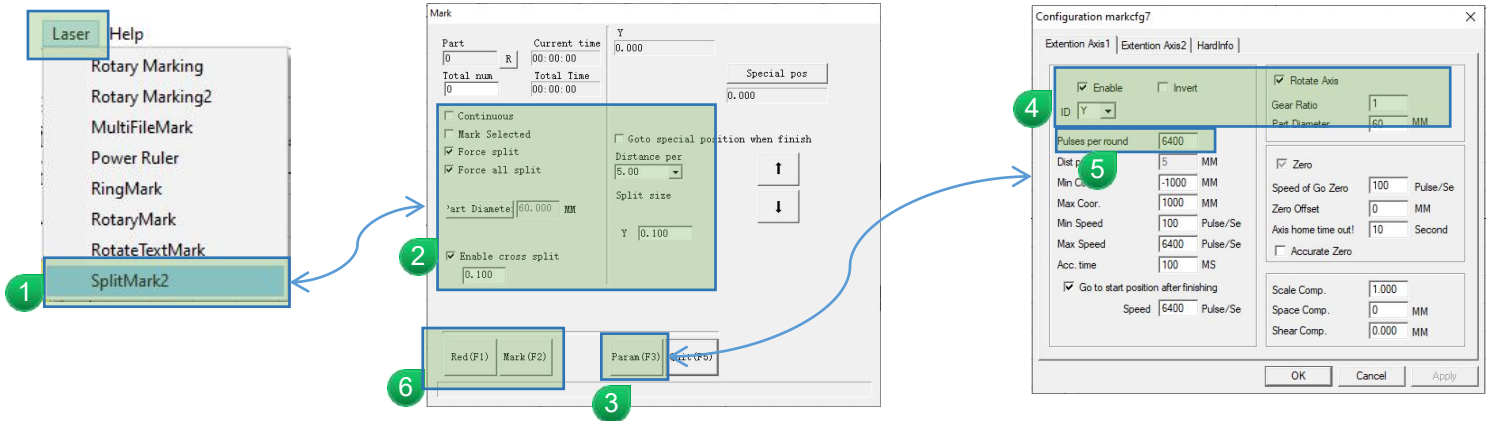
Part Diameter x 500 = Pulses per round;

5 After the setting is completed, press "Red" to preview, press ESC to cancel the preview, and press "Mark" to start marking.

2、SplitMark

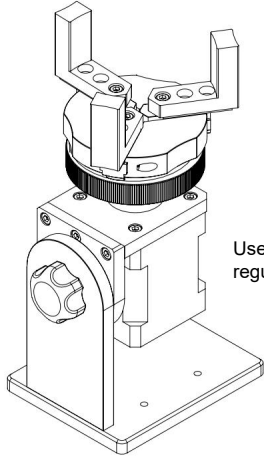
1 Insert the vector file and fill it





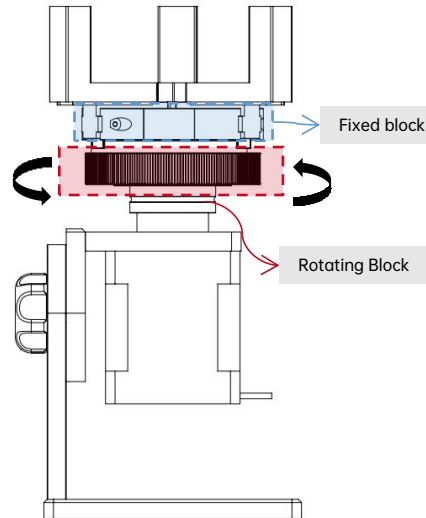
- 1 Follow the steps in the picture to enter the "Split Marking 2" interface
- 2 Check "Force split"; "Force all split"; "Enable cross split" value 0.1
Y value: 0.1
- 3 Enter the "Param" interface
- 4 Check "Enable"; "Rotate Axis"
Gear Ratio: 1
ID selection: Y
Part Diameter: Fill in according to the actual engraving object diameter
- 5 Pulses per round:
Part Diameter x 500 = Pulses per round;
- 6 After the setting is completed, press "Red" to preview, press ESC to cancel the preview, and press "Mark" to start marking.

RF2 Rotation axis introduction



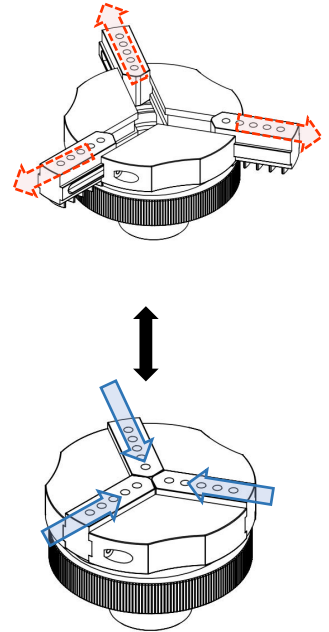
RF2

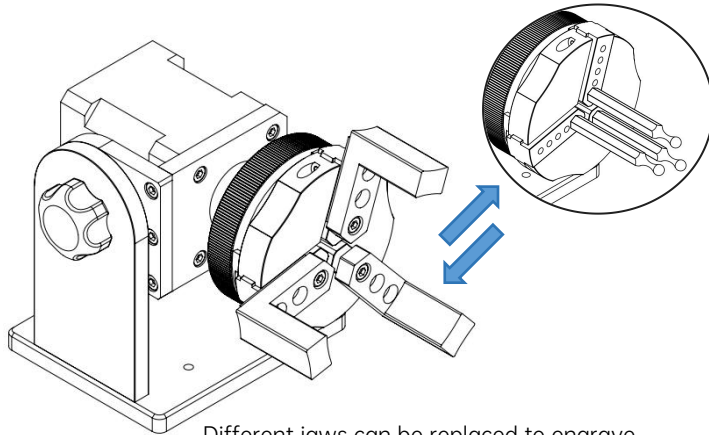
Used with laser engraving machine to engrave regular cylinders such as Coke cans



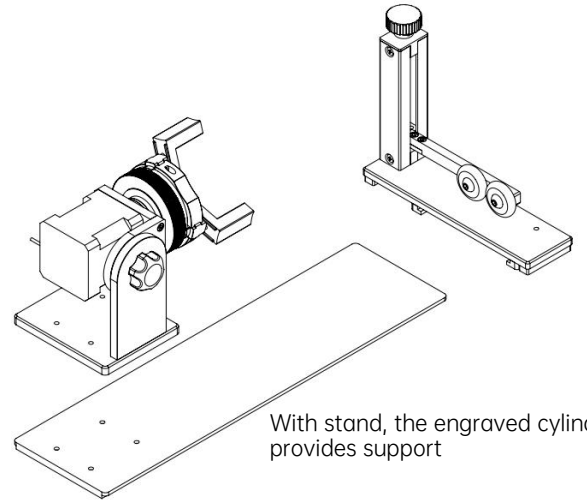
1. Clamp adjustment (claw size)

Turn the "rotating block" to adjust the size of the space where the object is placed.

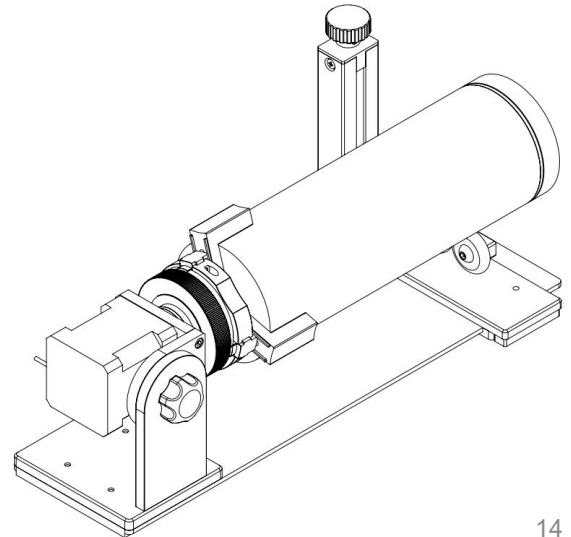




Different jaws can be replaced to engrave different objects

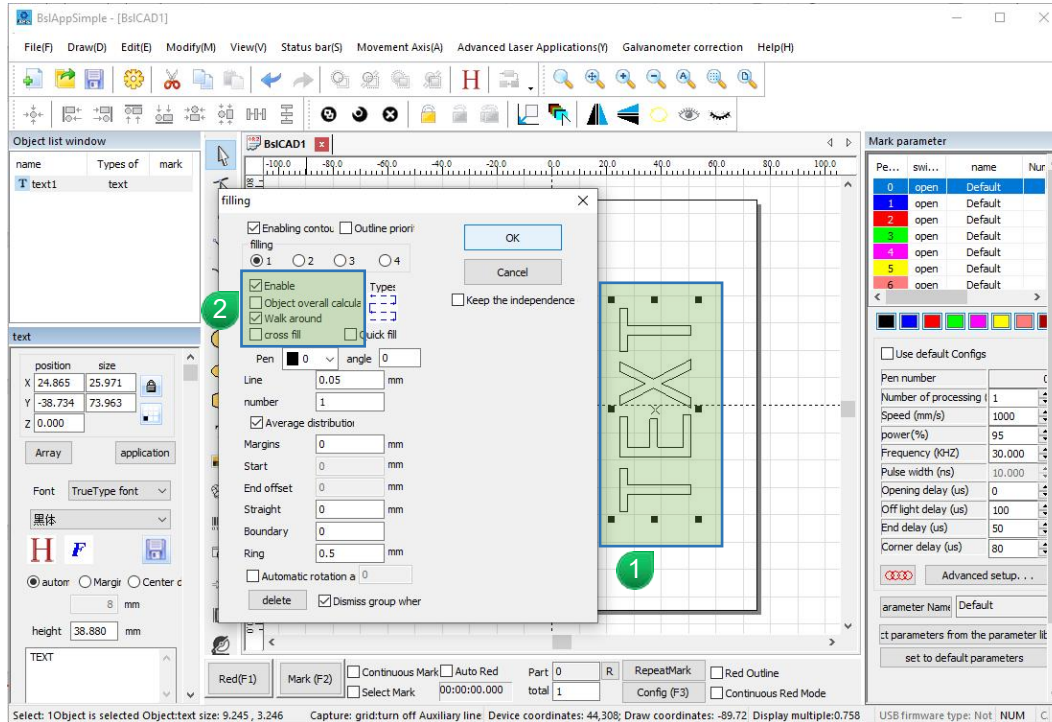


With stand, the engraved cylinder provides support



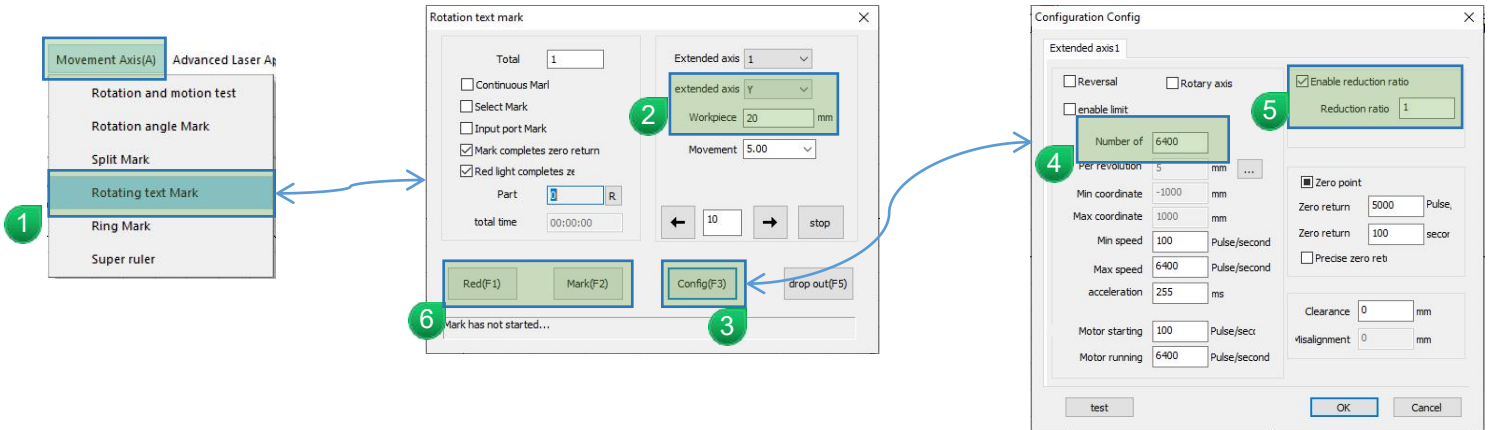
RF2 BSL software setup

1. Rotate text marking



1 Enter text and rotate it 90°

2 Text fill, do not check "Object overall calculate"



- 1 Follow the steps in the picture to enter the "Rotate Text Marking" interface
- 2 extended axis: Y
Workpiece: Fill in according to the actual engraving object diameter
- 3 Enter the "Config" interface
- 4 Number of: 6400
- 5 Reduction ratio: 1
- 6 After the setting is completed, press "Red" to preview, press ESC to cancel the preview, and press "Mark" to start marking.

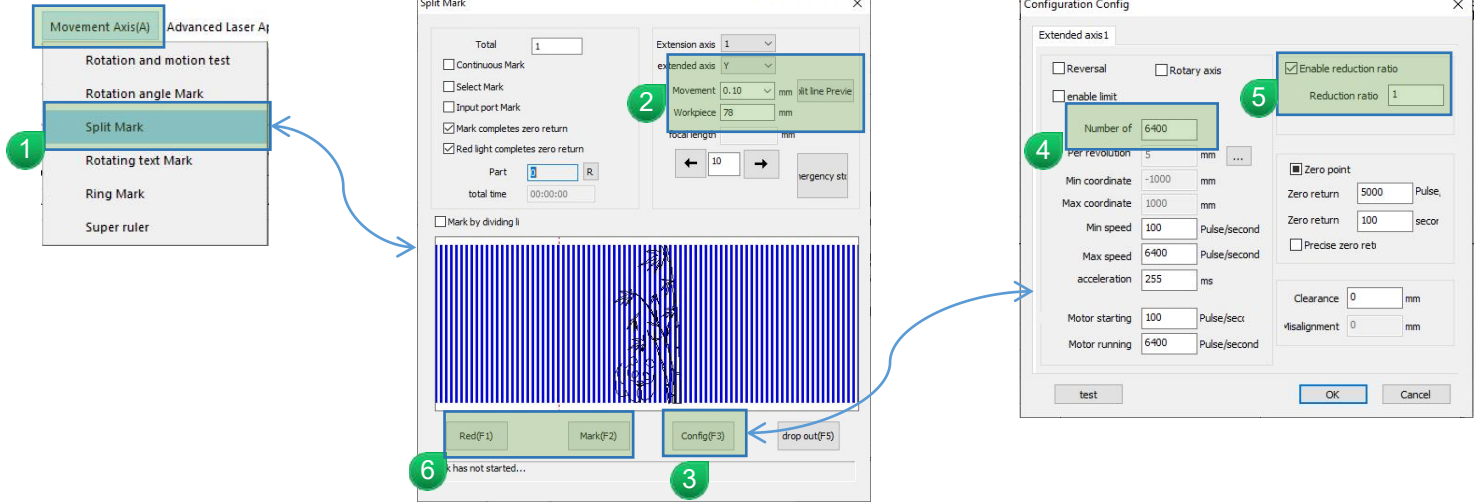
2. Split Mark

1 Insert the vector file and fill it

The screenshot shows the BscAD software interface with a 'filling' dialog box open. The dialog box contains the following settings:

- Enabling contour
- Outline priority
- filling: 1 2 3 4
- Enable
- Type: Object overall calc Walk around cross fill Quick fill
- Pen: Keep the independence
- Pen: 0, angle: 0
- Line: 0.05 mm
- number: 1
- Average distribution
- Margins: 0 mm
- Start: 0 mm
- End offset: 0 mm
- Straight: 0 mm
- Boundary: 0 mm
- Ring: 0.5 mm
- Automatic rotation a 0
- Buttons: delete, Dismiss group when

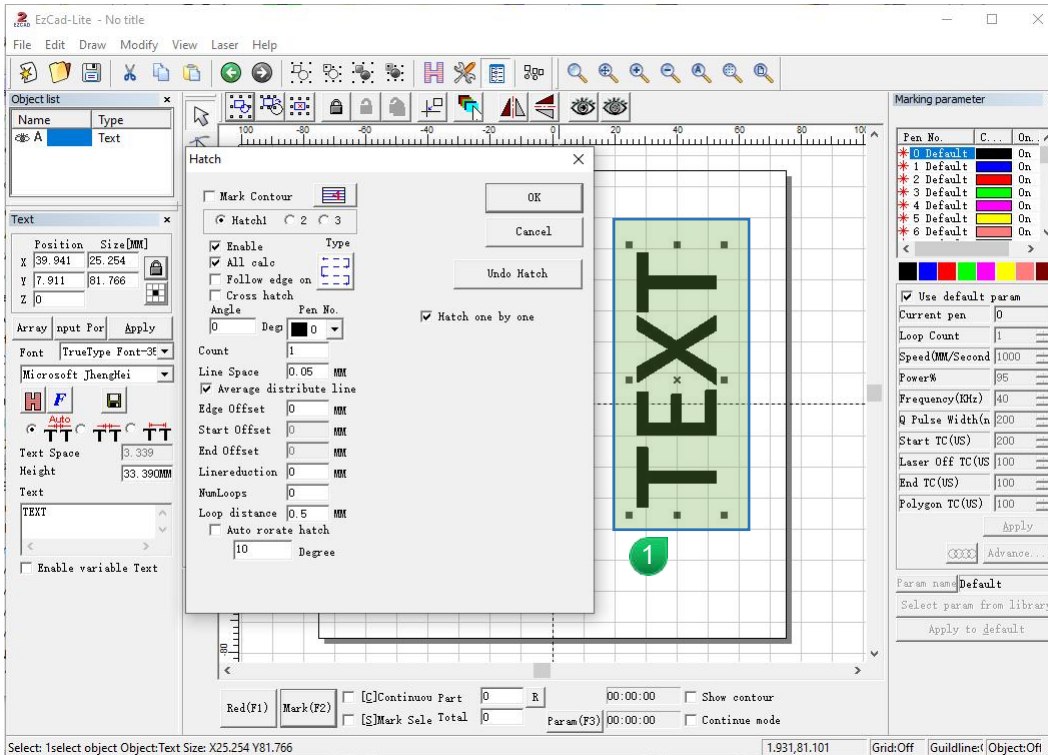
The background shows a grid with a panda illustration. A green circle with the number '1' is overlaid on the panda. The software interface includes a menu bar (File, Draw, Edit, Modify, View, Status bar, Movement Axis, Advanced Laser Applications, Galvanometer correction, Help), a toolbar, an Object list window, a text window, and a Mark parameter window.



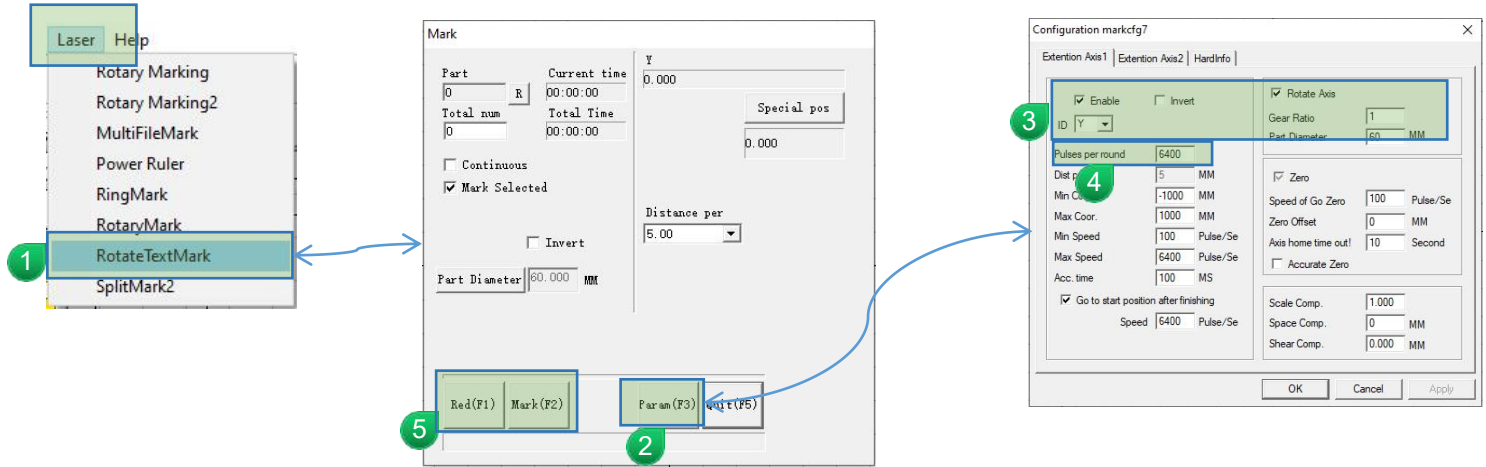
- 1 Follow the steps in the picture to enter the "Split Mark" interface
- 2 Extended axis: Y
Movement: The smaller the value, the better the precision, but the slower the speed. 0.1 is recommended. Click "Split Line Preview" on the right
Workpiece: Fill in the value according to the actual diameter of the object being engraved
- 3 Enter the "Config" interface
- 4 Number of: 6400
- 5 Reduction ratio: 1
- 6 After the setting is completed, press "Red" to preview, press ESC to cancel the preview, and press "Mark" to start marking.

RF2 BJJCZ software settings

1. Rotate text marking



1 Enter text and rotate it 90°



1 Follow the steps in the picture to enter the "Rotate Text Marking" interface

2 Enter the "param" interface

3 Check "Enable"; "Rotate Axis"

Gear Ratio: 1

ID selection: Y

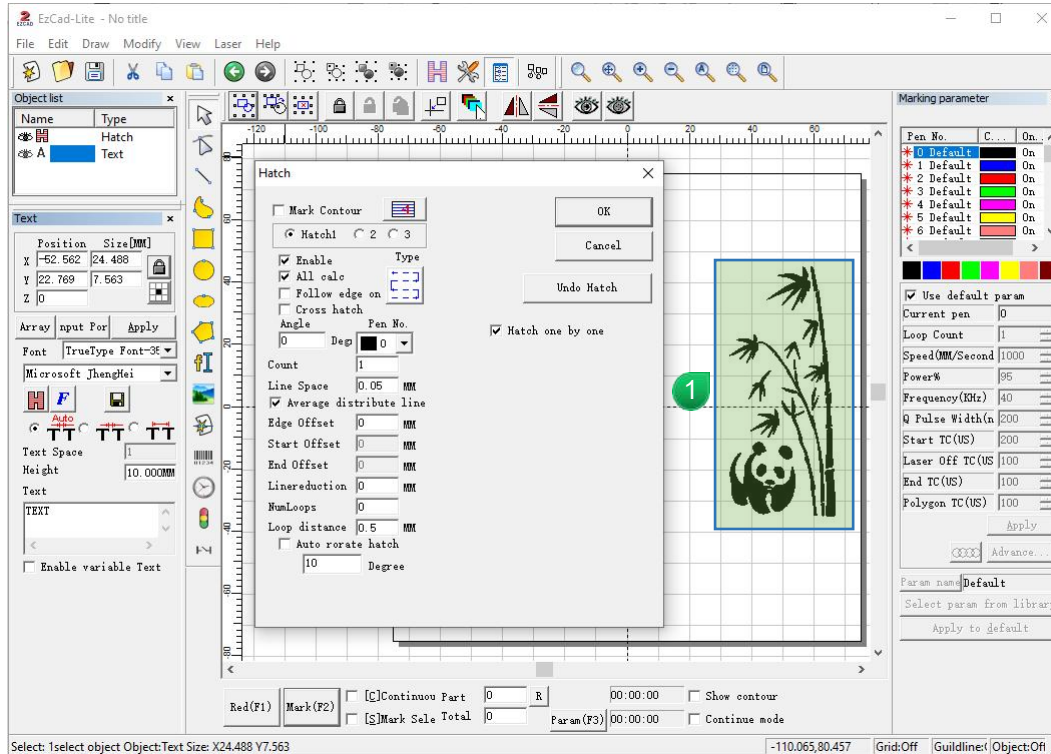
Part Diameter: Fill in according to the actual engraving object diameter

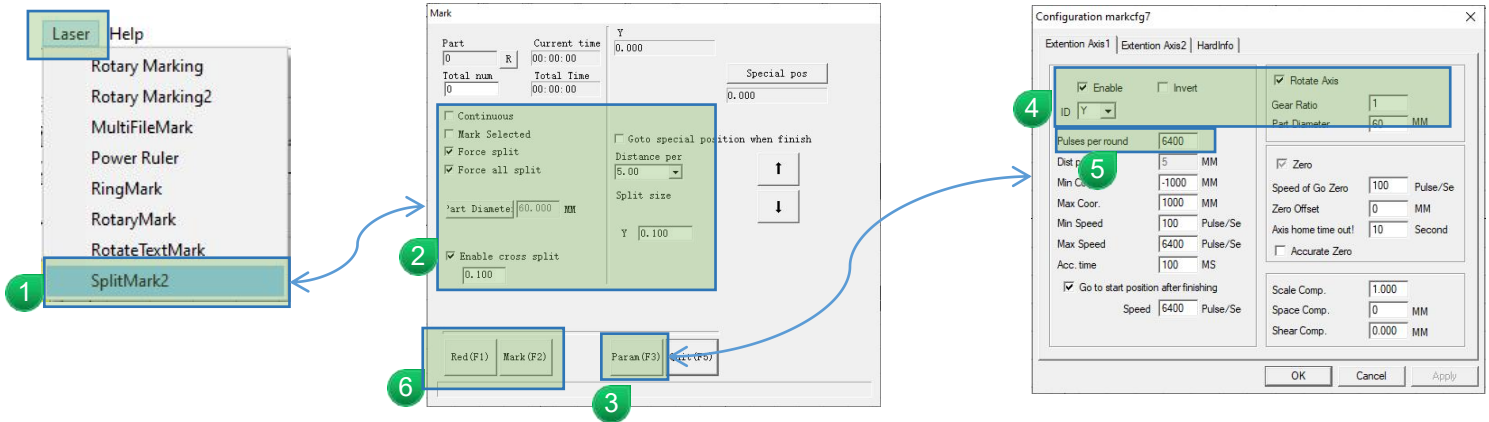
4 Pulses per round: 6400

5 After the setting is completed, press "Red" to preview, press ESC to cancel the preview, and press "Mark" to start marking.

2、SplitMark

- 1 Insert the vector file and fill it



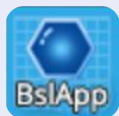


- 1 Follow the steps in the picture to enter the "Split Marking 2" interface
- 2 Check "Force split"; "Force all split"; "Enable cross split" value 0.1
Y value: 0.1
- 3 Enter the "Param" interface
- 4 Check "Enable"; "Rotate Axis"
Gear Ratio: 1
ID selection: Y
Part Diameter: Fill in according to the actual engraving object diameter
- 5 Pulses per round: 6400
- 6 After the setting is completed, press "Red" to preview, press ESC to cancel the preview, and press "Mark" to start marking.

Note: If there are any technical improvements to the product, they will be added to the new version of the manual without prior notice.
If there are any changes to the product appearance and color, the actual product shall prevail.

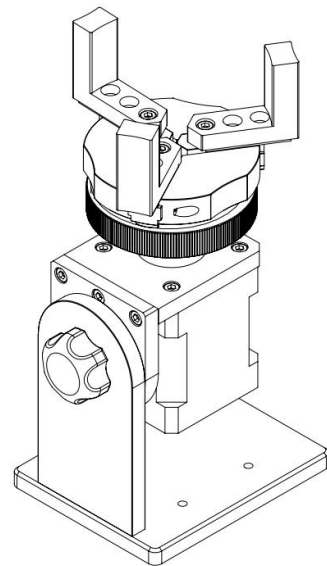
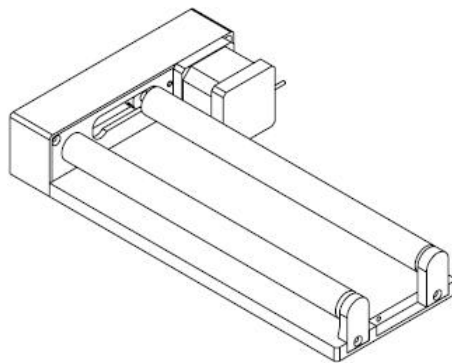


金橙子



八思量

旋转滚轴使用说明

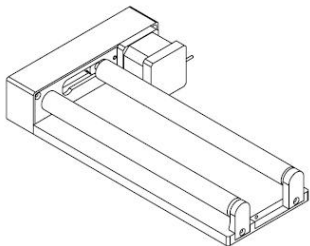


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M1、M4型号只能使用八思量软件

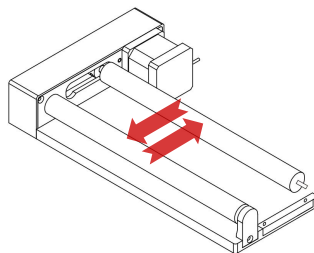
RT5 旋转轴介绍



RT5旋转滚轴

配合激光雕刻机用于雕刻可乐罐等规则圆柱体

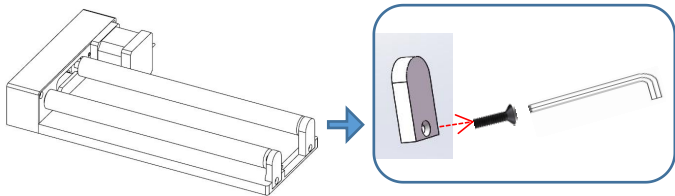
②转动轴体靠近左侧



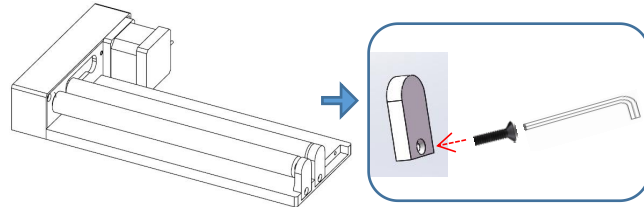
1、间距调整【适应承载不同直径的规则圆柱体】

注：直径5-150mm,重量 < 3KG

①取下右边轴承支撑

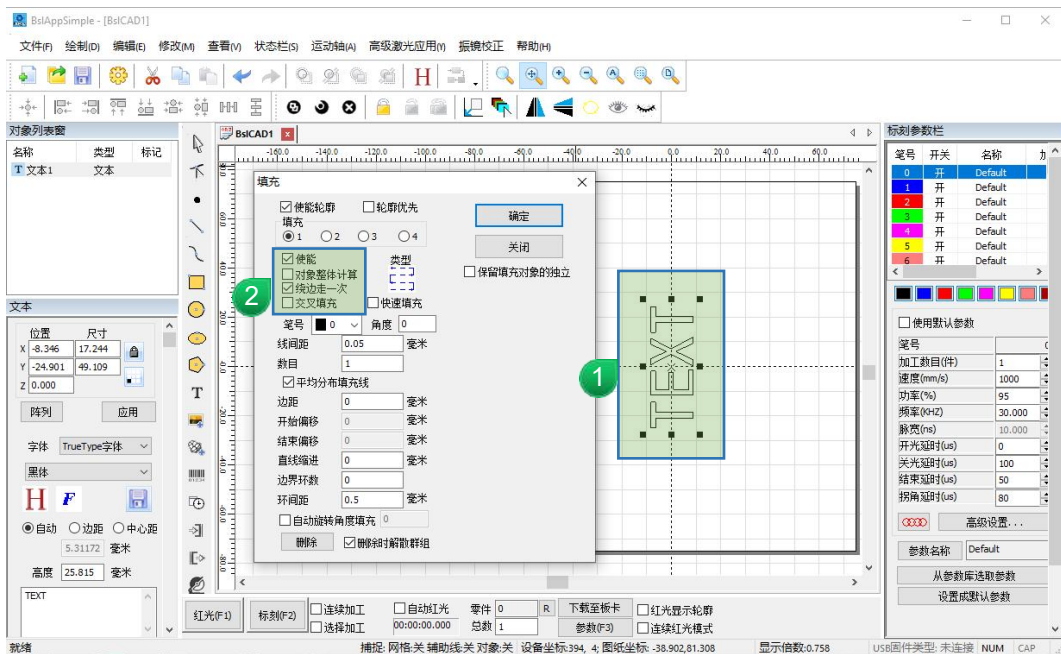


③完成滚轴小间距调整，锁好螺丝



RT5 八思量软件设置

1、旋转文本标刻



1 输入文本，并旋转90°

2 文本填充，请勿勾选“对象整体计算”

3

4

5

6

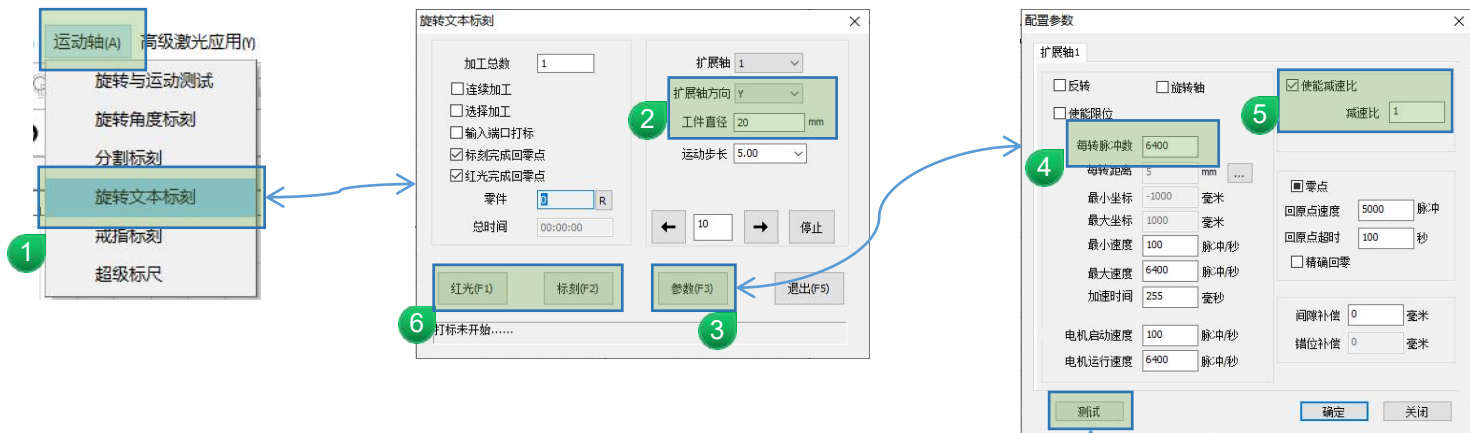
7

8

9

10

11



1 按照图示步骤进入“旋转文本标刻”界面

2 扩展轴方向：Y
工件直径：按照实际雕刻物体直径填写

3 进入“参数”界面

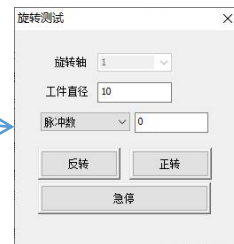
4 每转脉冲数：
方法一：
物体直径 × 500 = 每转脉冲数；

方法二：

打开“测试”窗口，填写工件直径，脉冲数比如输入16625点击“反转”或者“正转”观察滚轴是否带动物体（如杯子）转动一圈，如果没有转动一圈，把“脉冲数”的数值加大，如果超过一圈，就减小，直到刚好转动一圈转动一圈的“脉冲数”值，即是“每转脉冲数”最后，将测试好的脉冲值填写入“每转脉冲数”即可。

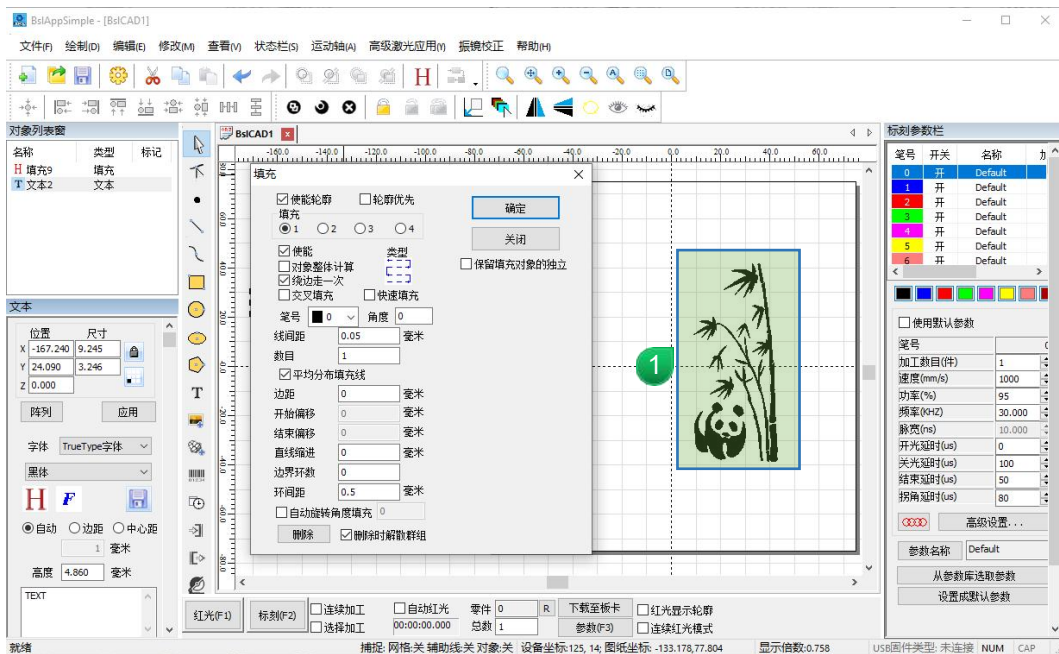
5 减速比：1

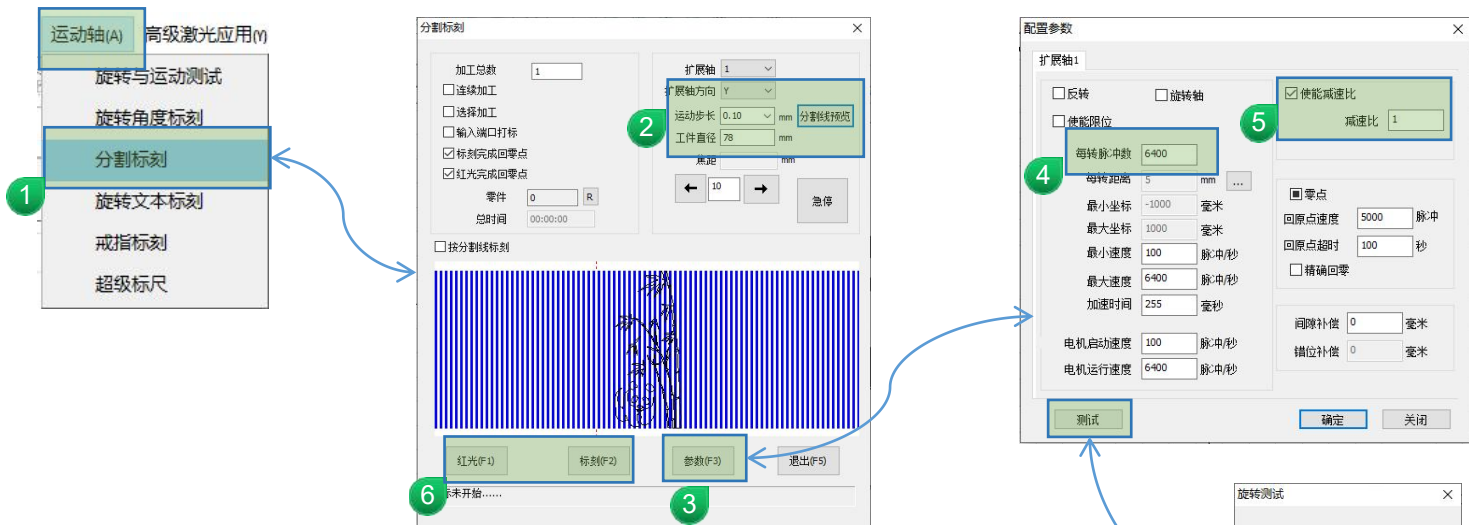
6 设置完成可以，按“红光”预览，键盘ESC取消预览，按“标刻”即可开始打标



2、分割标刻

1 放入矢量文件并填充





1 按照图示步骤进入“分割标刻”界面

2 扩展轴方向：Y

运动步长：越小精细度越好，速度也会慢，建议0.1；点击右侧“分割线预览”

工件直径：按照实际雕刻物体直径填写

3 进入“参数”界面

4 每转脉冲数:

方法一:

物体直径 \times 500 = 每转脉冲数;

方法二:

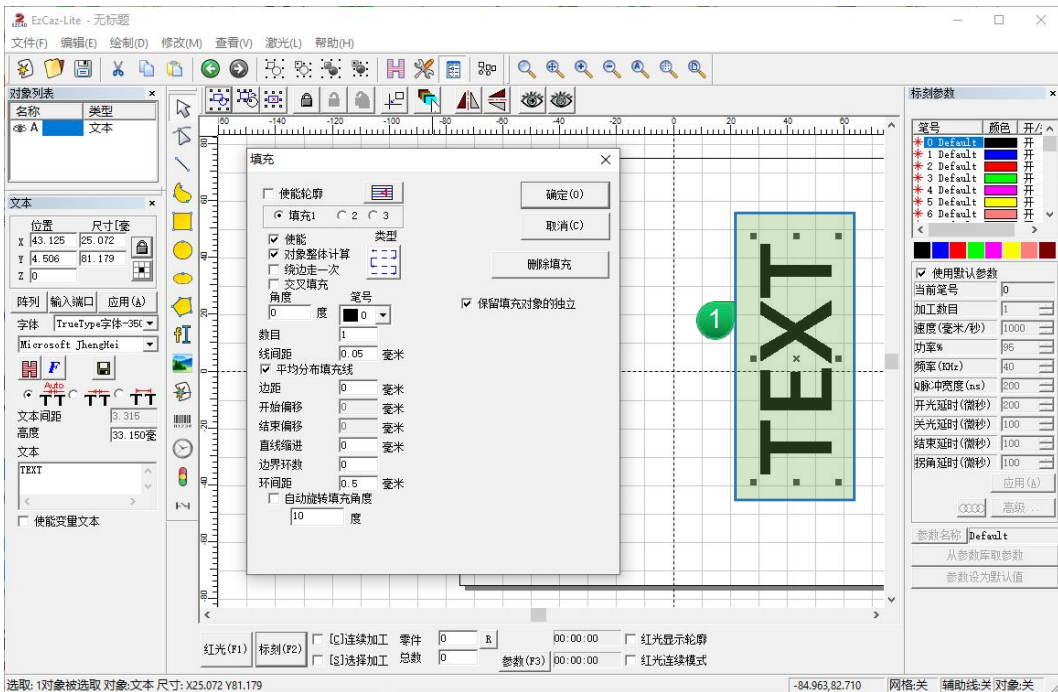
打开“测试”窗口，填写工件直径，脉冲数比如输入16625点击“反转”或者“正转”观察滚轴是否带动物体（如杯子）转动一圈，如果没有转动一圈，把“脉冲数”的数值加大，如果超过一圈，就减小，直到刚好转动一圈转动一圈的“脉冲数”值，即是“每转脉冲数”最后，将测试好的脉冲值填写入“每转脉冲数”即可。

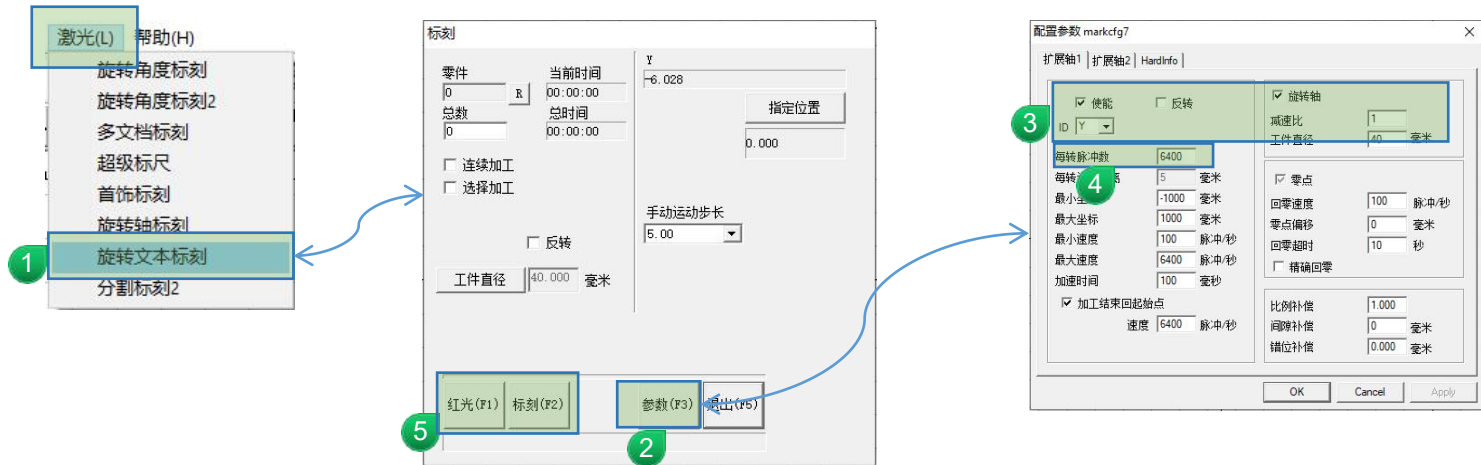
5 减速比: 1

6 设置完成可以，按“红光”预览，键盘ESC取消预览，按“标刻”即可开始打标

RT5 金橙子软件设置

1、旋转文本标刻





1 按照图示步骤进入“旋转文本标刻”界面

2 进入“参数”界面

3 勾选“使能”；“旋转轴”

减速比：1

ID选择：Y

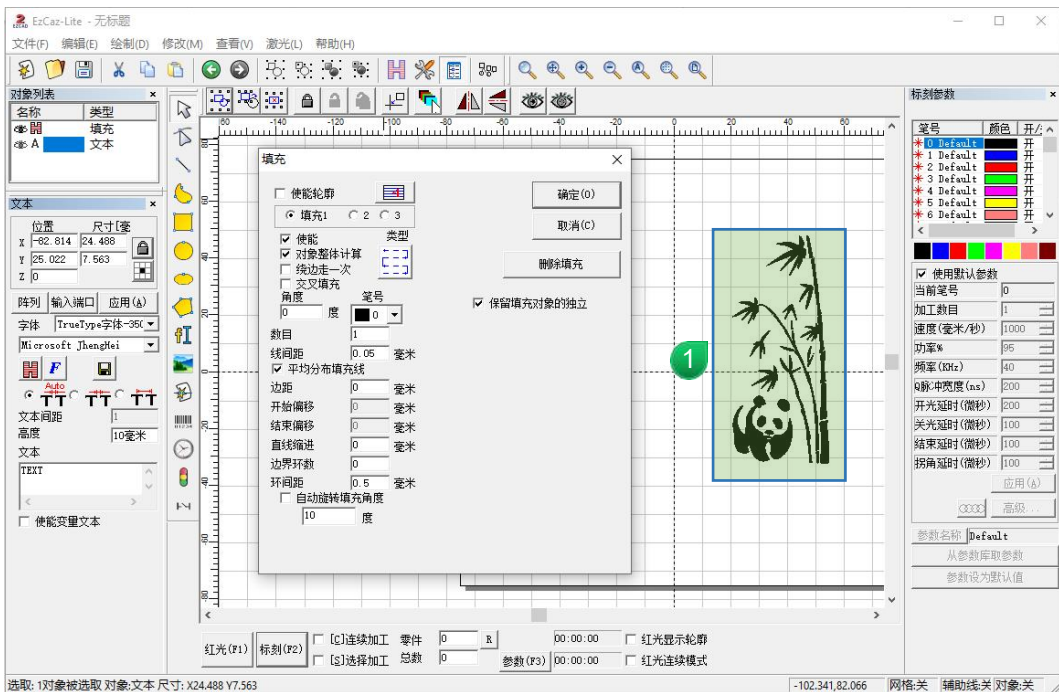
工件直径：按照实际雕刻物体直径填写

4 每转脉冲数：

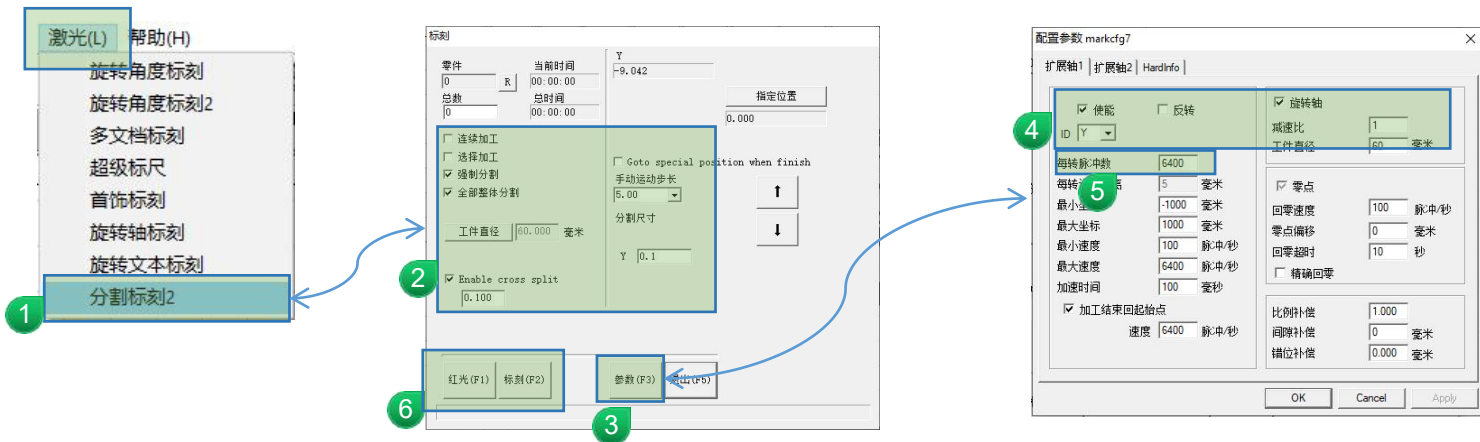
物体直径 × 500 = 每转脉冲数；

5 设置完成可以，按“红光”预览，键盘ESC取消预览，按“标刻”即可开始打标

2、分割雕刻

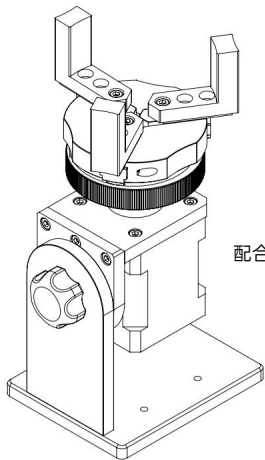


1 放入矢量文件并填充



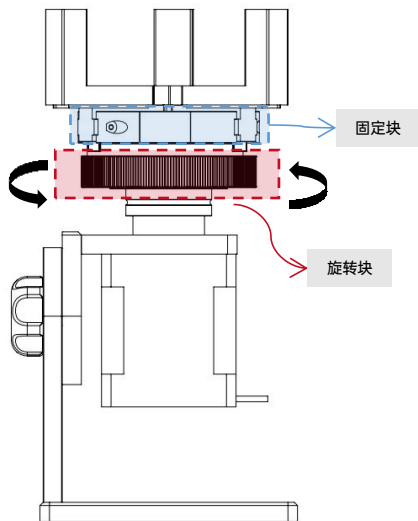
- 1 按照图示步骤进入“分割标刻2”界面
- 2 勾选“强制分割”；“全部整体分割”；“Enable cross split”数值0.1
Y数值：0.1
- 3 进入“参数”界面
- 4 勾选“使能”；“旋转轴”
减速比：1
ID选择：Y
工件直径：按照实际雕刻物体直径填写
- 5 每转脉冲数：
物体直径 × 500 = 每转脉冲数；
- 6 设置完成可以，按“红光”预览，键盘ESC取消预览，按“标刻”即可开始打标

RF2 旋转轴介绍



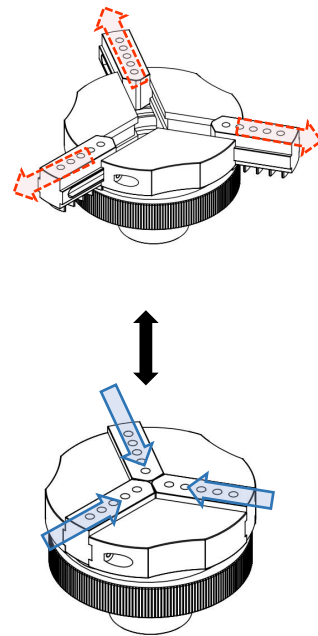
RF2旋转滚轴

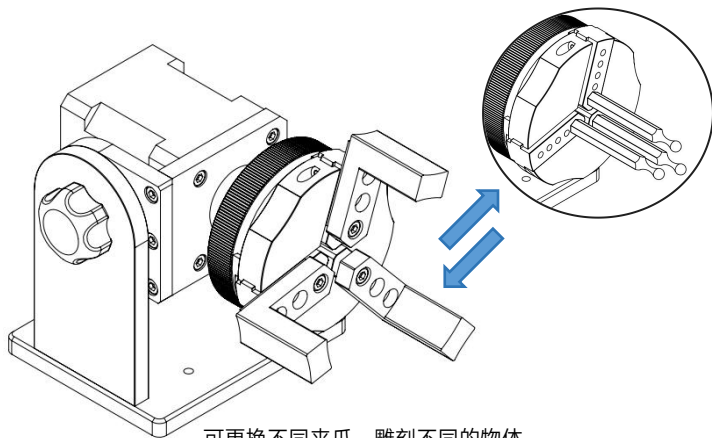
配合激光雕刻机用于雕刻可乐罐等规则圆柱体



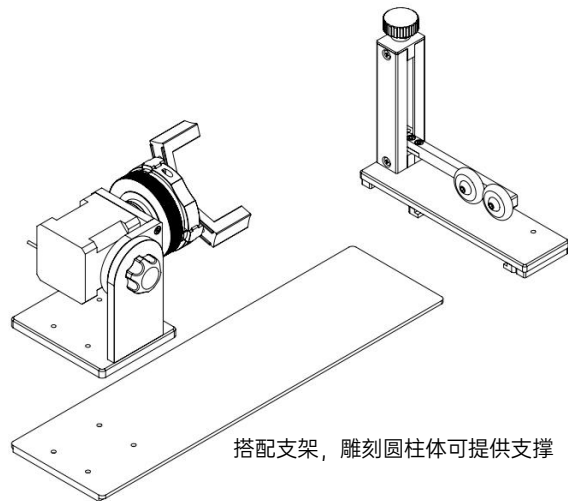
1、夹具调整（夹爪的大小）

转动“旋转块”，可以调节放置物体的空间大小

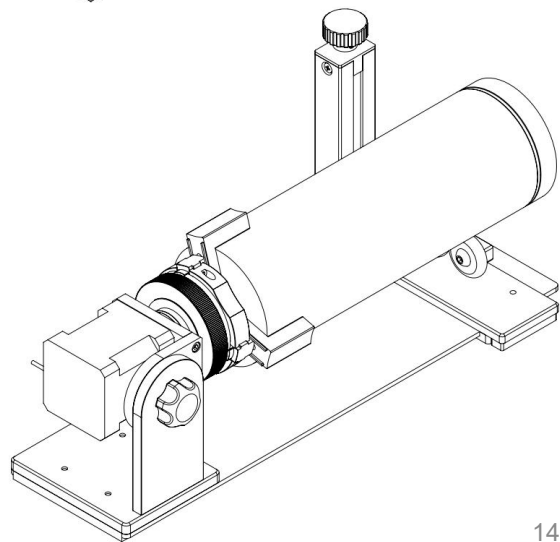




可更换不同夹爪，雕刻不同的物体

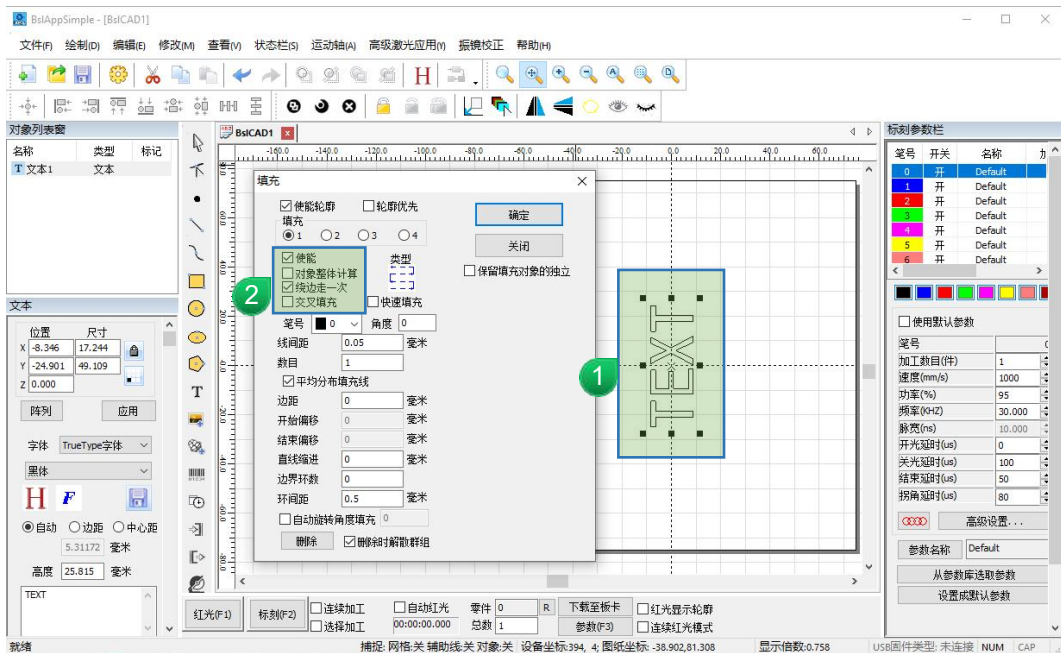


搭配支架，雕刻圆柱体可提供支撑



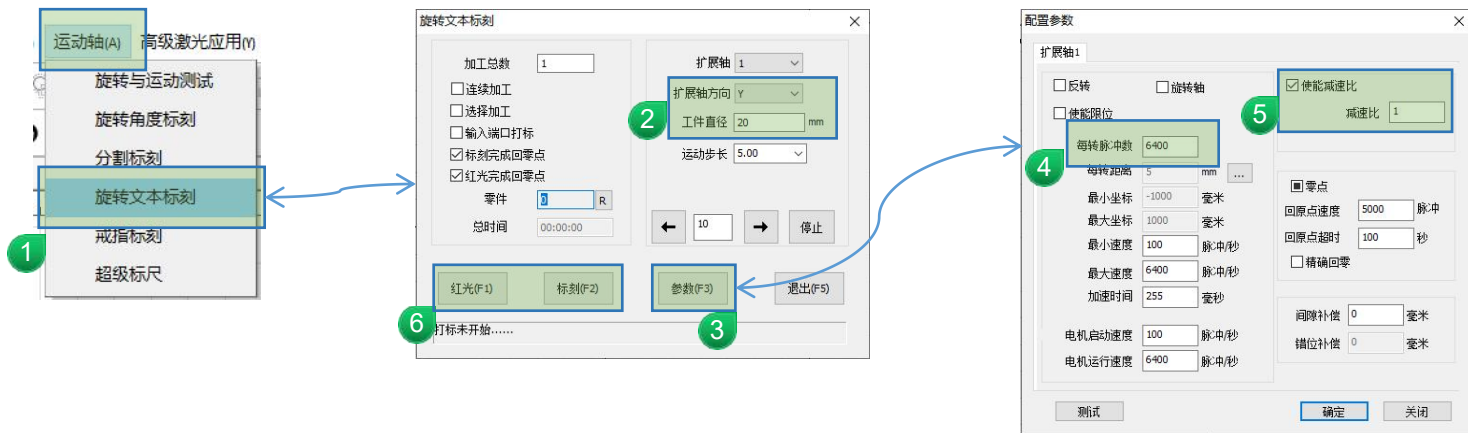
RF2 八思量软件设置

1、旋转文本标刻



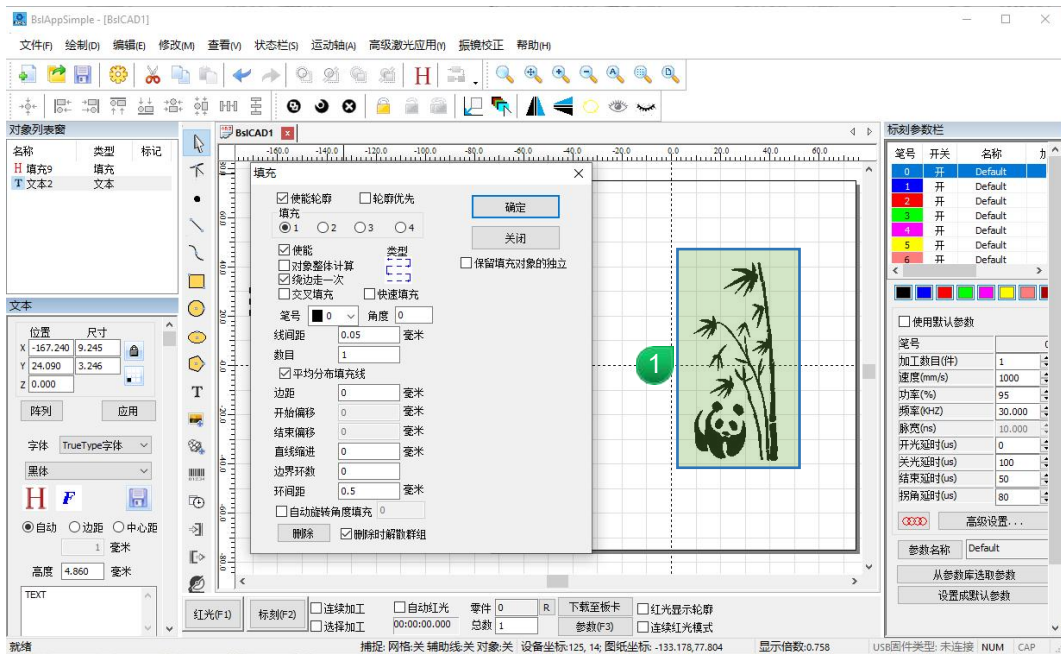
1 输入文本，并旋转90°

2 文本填充，请勿勾选“对象整体计算”

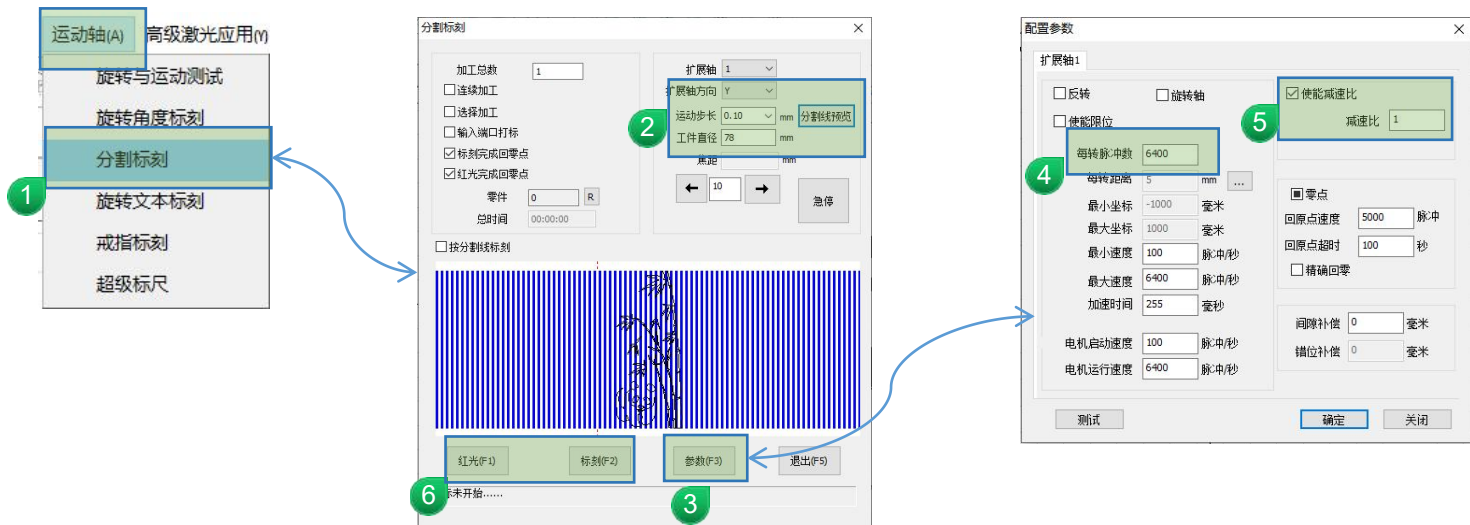


- 1 按照图示步骤进入“旋转文本标刻”界面
- 2 扩展轴方向：Y
工件直径：按照实际雕刻物体直径填写
- 3 进入“参数”界面
- 4 每转脉冲数：填写6400
- 5 减速比：1
- 5 设置完成可以，按“红光”预览，键盘ESC取消预览，按“标刻”即可开始打标

2、分割雕刻



1 放入矢量文件并填充



1 按照图示步骤进入“分割标刻”界面

2 扩展轴方向：Y

运动步长：越小精细度越好，速度也会慢，建议0.1；点击右侧“分割线预览”

工件直径：按照实际雕刻物体直径填写

3 进入“参数”界面

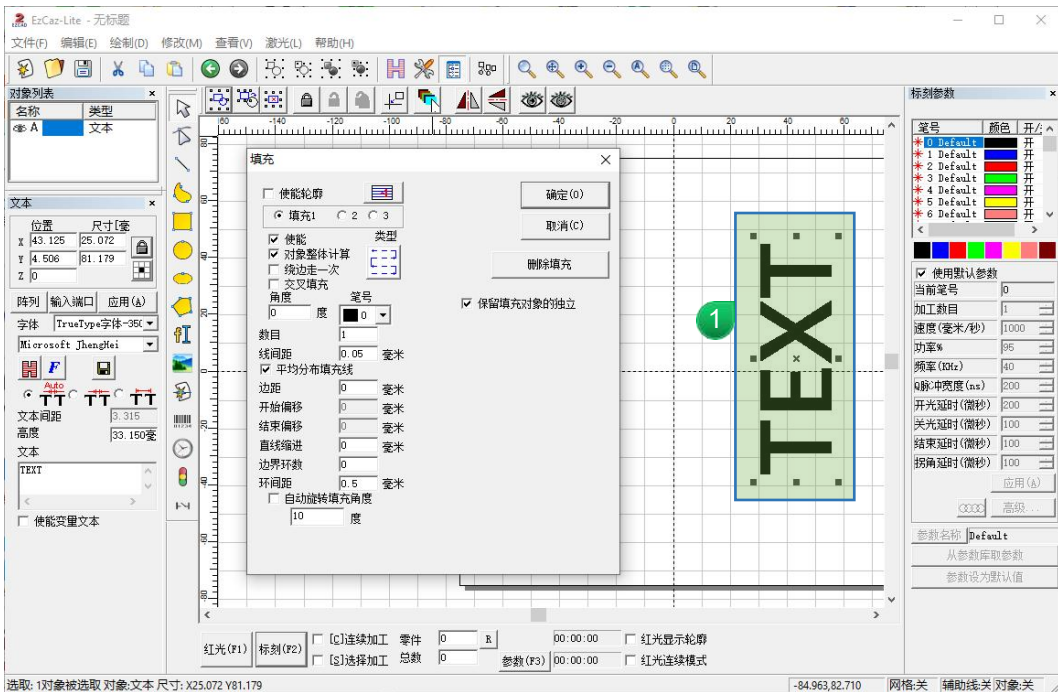
4 每转脉冲数：填入6400

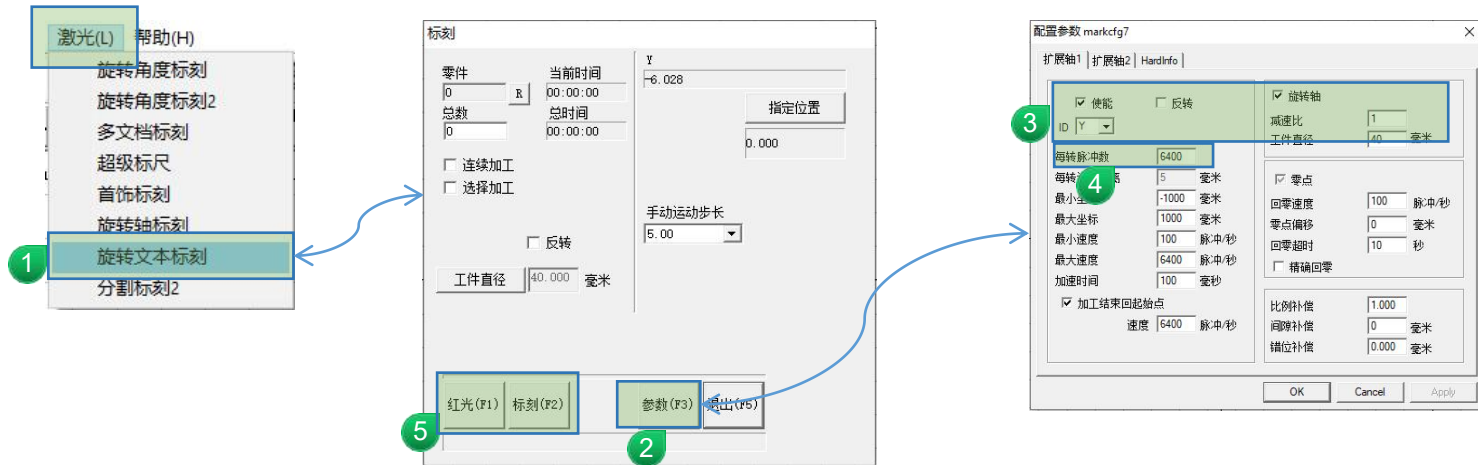
5 减速比：1

6 设置完成可以，按“红光”预览，键盘ESC取消预览，按“标刻”即可开始打标

RF2 金橙子软件设置

1、旋转文本标刻





1 按照图示步骤进入“旋转文本标刻”界面

2 进入“参数”界面

3 勾选“使能”；“旋转轴”

减速比：1

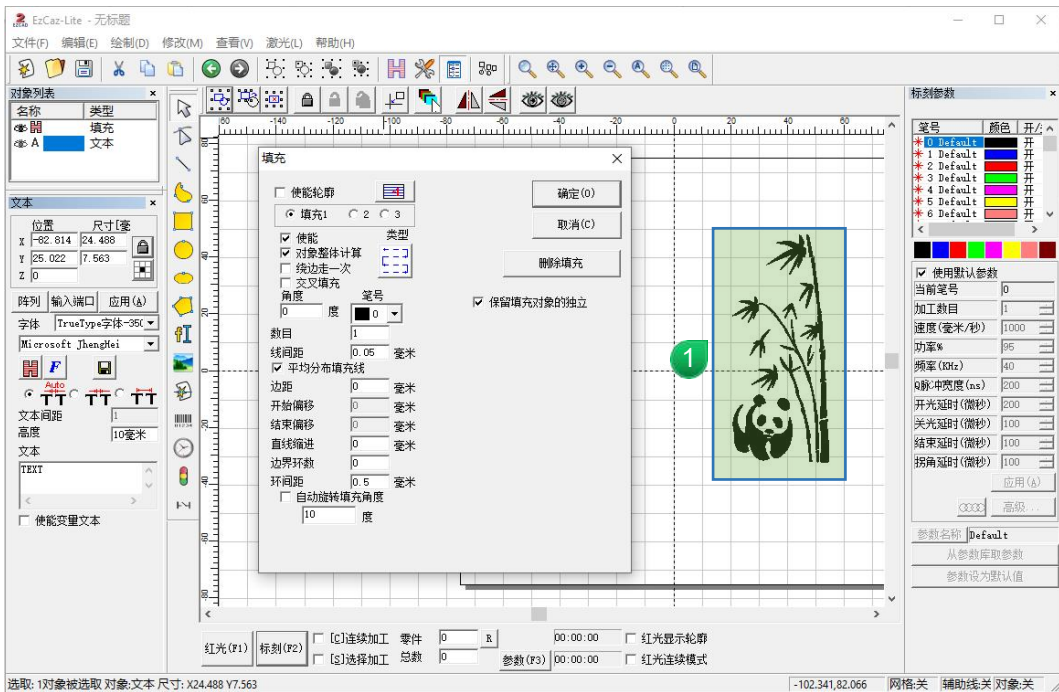
ID选择：Y

工件直径：按照实际雕刻物体直径填写

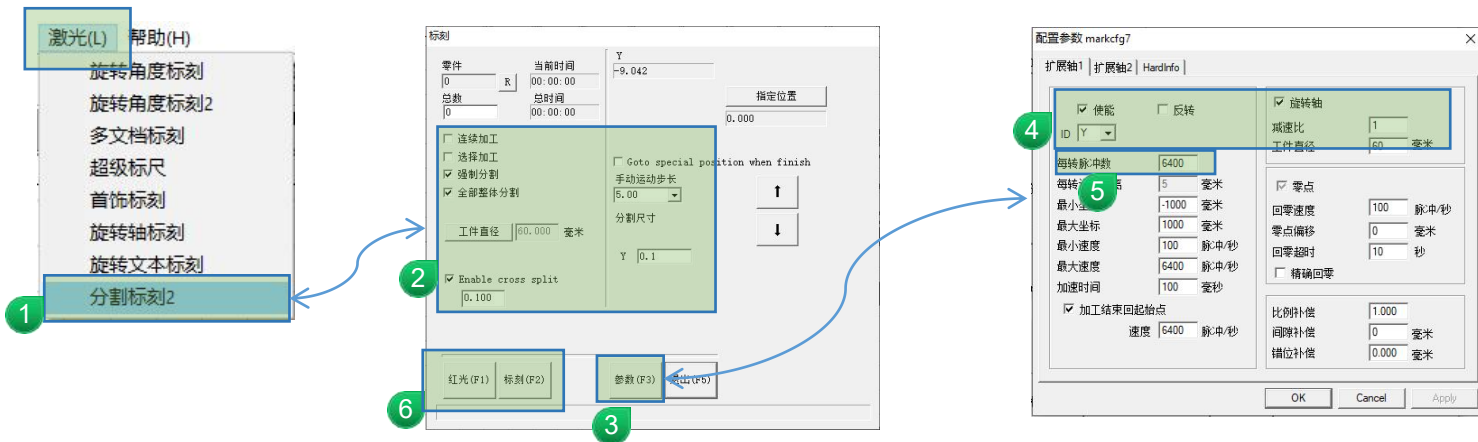
4 每转脉冲数：填入6400

5 设置完成可以，按“红光”预览，键盘ESC取消预览，按“标刻”即可开始打标

2、分割雕刻



1 放入矢量文件并填充



- 1 按照图示步骤进入“分割标刻2”界面
- 2 勾选“强制分割”；“全部整体分割”；“Enable cross split”数值0.1
Y数值：0.1
- 3 进入“参数”界面
- 4 勾选“使能”；“旋转轴”
减速比：1
ID选择：Y
工件直径：按照实际雕刻物体直径填写
- 5 每转脉冲数：填入6400
- 6 设置完成可以，按“红光”预览，键盘ESC取消预览，按“标刻”即可开始打标

注：产品若有技术改进，会增进新版手册中，恕不另行通知。产品外观，颜色如有改动，以实物为准。