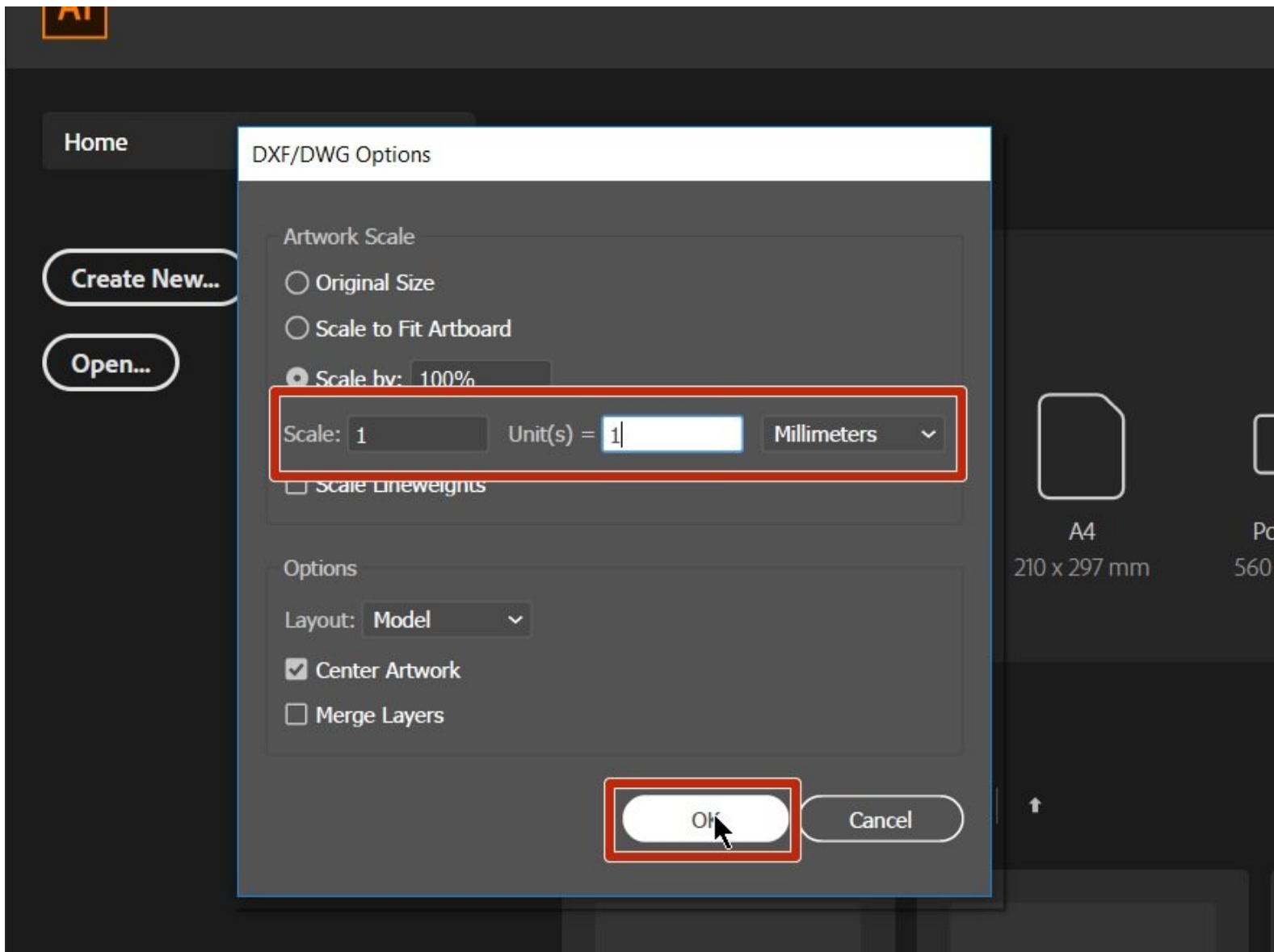




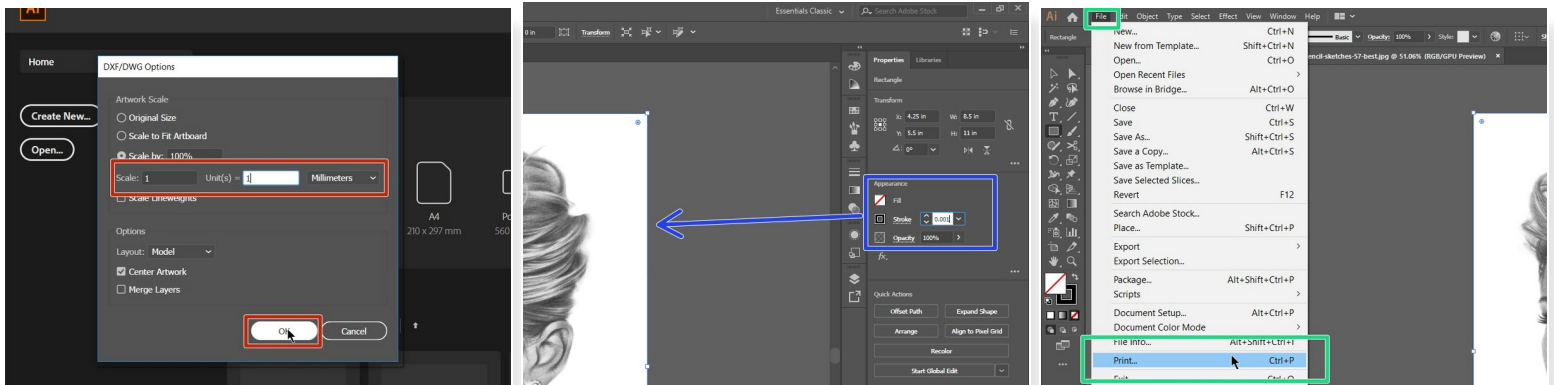
Adobe Illustrator: Preparing Files for the Epilog

Setup Adobe Illustrator to engrave and cut materials on the Epilog Fusion M2 Laser.

Written By: Andrew James Gregory

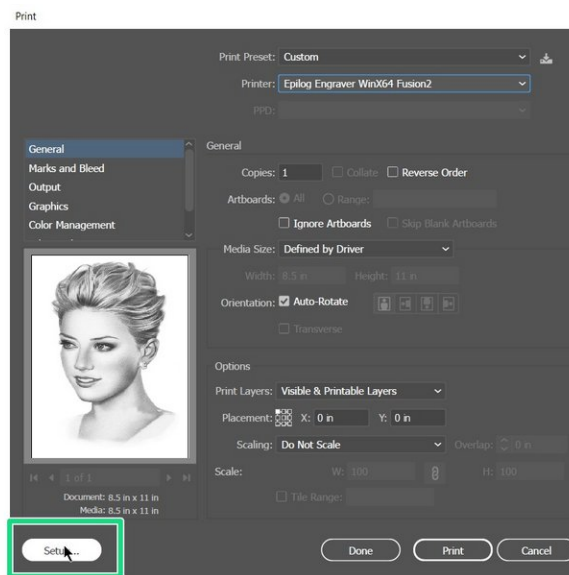
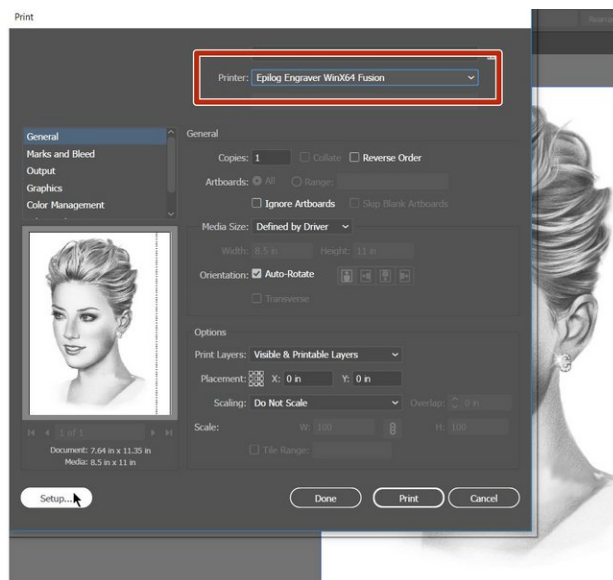


Step 1 — Adobe Illustrator set up for Epilog laser



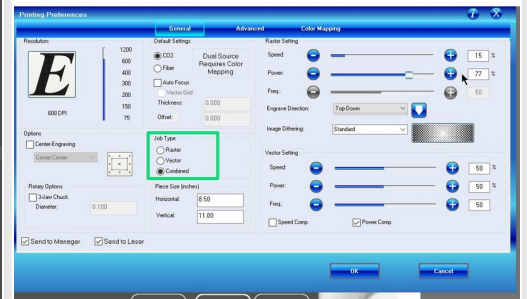
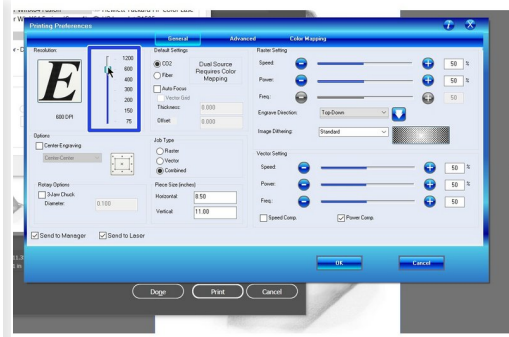
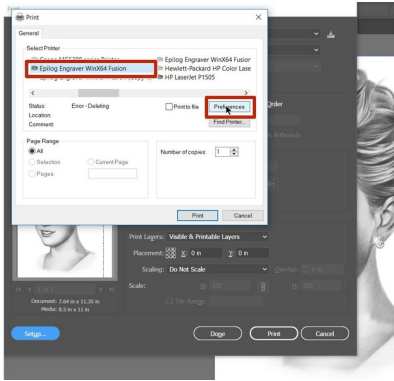
- Open your .dxf or .dwg file in Illustrator. Make sure you select the correct scale your file was drawn, inches, mm, and set the scale as **1=1**
- Select/click on any lines that are to be cut lines, and change the stroke to .001 . There should be no infill and the opacity should be 100%
- ❗ Anything that is not **.001** will be rastered/engraved
- In order to send your print to the printer. Select **File** then select **Print**

Step 2 — Selecting the Epilog as Printer



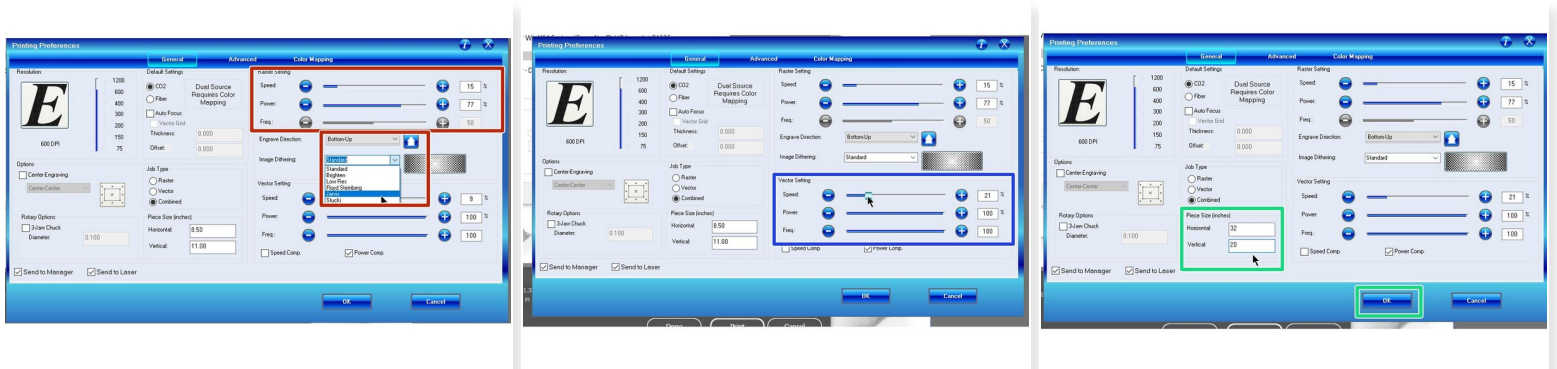
- When you are on the print screen be sure to select the **Epilog** as your printer
- Now select the **Setup** button in the lower left corner. This opens up an additional menu

Step 3 — Epilog Print Properties



- Double check that the Epilog printer is selected and click on the preferences button
- Epilog controls page will now be open. Select the Dpi for your project
- ① The higher the Dpi the better the resolution. This will also affect the print time. 600 Dpi is usually a good compromise
- Select the job type. **Raster** (engraving), or **Vector** (cutting), or **combined**

Step 4 — Printer Properties

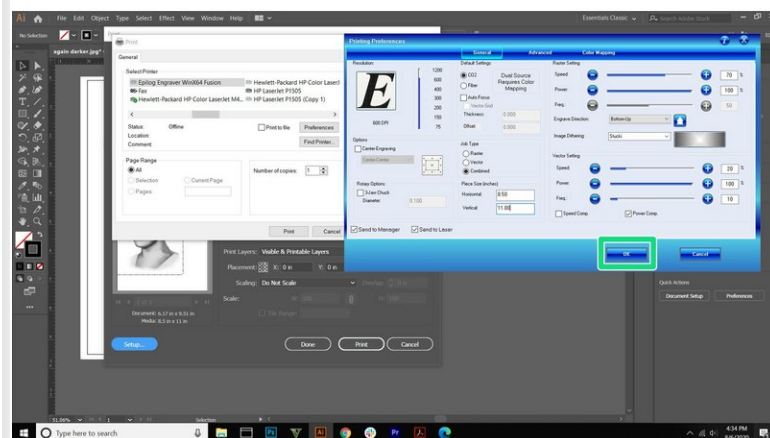


- If you are rastering your job, you will need to adjust the speed and power setting according to the chart. You should also adjust the image dithering to **Jarvis** or **Stucki** for best results.
- When cutting material you will need to adjust the speed, power and frequency according to the materials chart.
- Be sure to change the size to 32" horizontal and 20" vertical to match the cutting bed size of the Epilog.

Step 5 — Speed and Power Settings

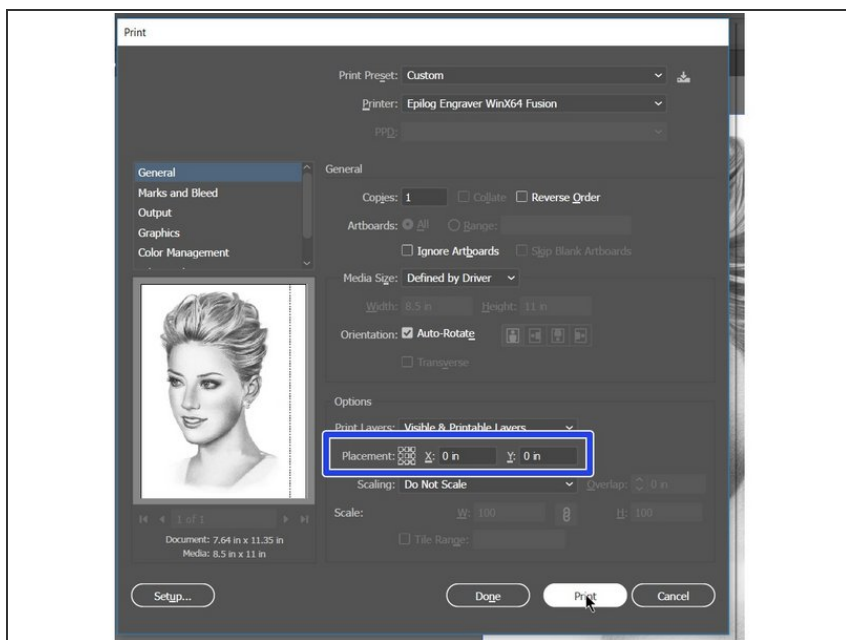
Fusion Series Suggested Material Settings (CO2)

Material	DPI/Freq.	75 watt	Material	DPI/Freq.	75 watt
Acrylic					
Photo Engraving	300 DPI	90s 40p	Photo Engraving	300 DPI	90s 35p
Text/Clipart Engraving	300 DPI	90s 60p	Text Engraving	600 DPI	90s 45p
Text/Clipart Engraving	600 DPI	90s 55p	Painted Brass		
Cutting 1/8" (3 mm)	100 f	10s 100p	Engraving	300 DPI	90s 25p
Cutting 1/4" (6 mm)	100 f	3s 100p	Engraving	600 DPI	90s 15p
Cutting 3/8" (9.5 mm)	100 f	1s 100p	Plastics		
Cutting 1/2" (13 mm)	100 f		Engraving	300 DPI	90s 20p
Alumamark					
Engraving	300 DPI	90s 20p	Plastic (2 Layer Laser Engraveable)		
Engraving	600 DPI	90s 10p	Engraving	300 DPI	90s 40p
Anodized Aluminum			Engraving	600 DPI	90s 25p
Photos/Clipart	400 DPI	90s 35p	Cutting 1/16" (1.5 mm)	100 f	10s 40p
Photos/Clipart	600 DPI	90s 30p	Rubber Stamps		
Text	600 DPI	90s 40p	Engraving	600 DPI	60s 100p
Cork			Cutting	100 f	25s 100p
Engraving	300 DPI	90s 30p	Stainless Steel w/Cermark		
Fleece			Engraving	600 DPI	45s 100p
Engraving	150 DPI	90s 15p	Twill		
Glass			Cutting	25 f	90s 80p
Engraving	300 DPI	35s 100p	Wood		
Leather			Photo Engraving	600 DPI	70s 100p
Photo Engraving	300 DPI	90s 20p	Clipart/Text Engraving	300 DPI	60s 100p
Text/Clipart Engraving	600 DPI	90s 25p	Clipart/Text Engraving	600 DPI	65s 100p
Cutting 1/8" (3 mm)	50 f	30s 100p	Deep Engraving	600 DPI	30s 100p
Mat Board			Thin Veneer (Cutting)	10 f	50s 80p
Cutting	50 f	30s 40p	Cutting 1/8" (3 mm)	10 f	20s 100p
			Cutting 1/4" (6 mm)	10 f	5s 100p
			Cutting 3/8" (9.5 mm)	10 f	1s 100p
			Cutting 1/2" (12 mm)	10 f	



- This chart should be used as a reference for speed and power for each material approved for use on the Epilog. Only materials on this chart can be used on the Epilog.
- ① For reference this chart can be found on page 197,198 in the Epilog manual.
<https://www.epiloglaser.com/assets/download...>
- ✎ There is a hard plastic copy of the recommended materials list with settings on the Epilog.
- ① Sometimes you will have to fiddle with the exact speed and power settings to get ideal results
- Click the **OK** button when all your setting are finalized

Step 6 — Placement of Print



- Check that the X=0 and Y=0 placement. You can also click the top left corner of the little hashtag pattern #.
- This will allow us to line up the top left corner of the file with the corner of the material