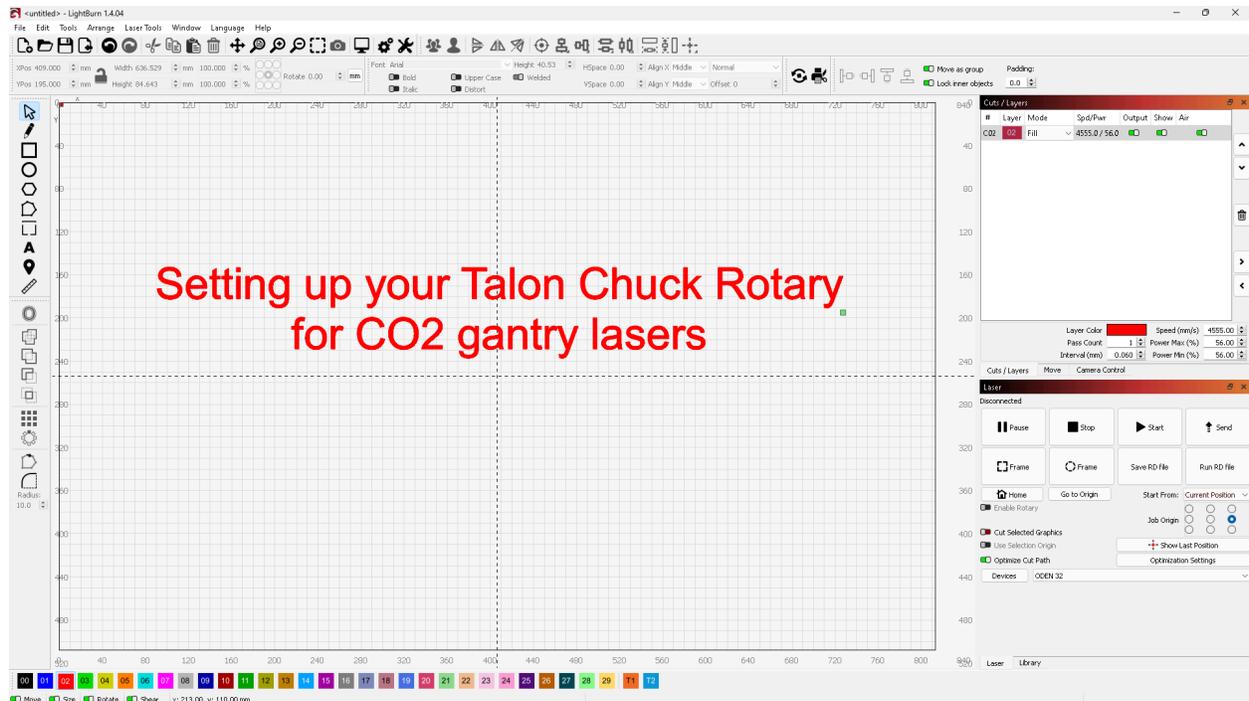


# ROTOBOSS

## ROTARY ATTACHMENTS

### TURN N' BURN

## Setting up your Talon Chuck Rotary in Light Burn for CO2 Gantry Lasers

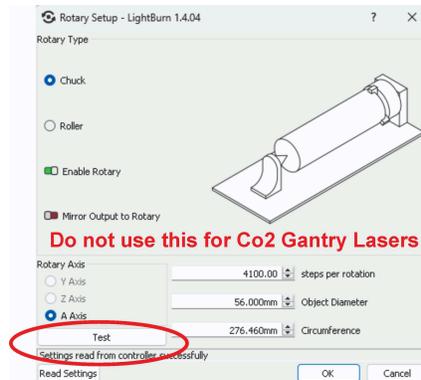


# ROTOBOSS

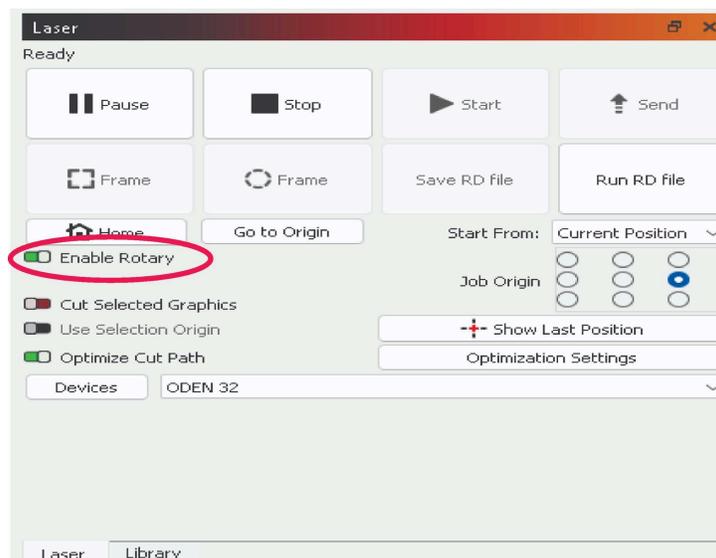
## ROTARY ATTACHMENTS

### TURN N' BURN

**\*\*For CO2 Gantry Lasers one thing of note is to note use the test button in lightburn. Most gantry lasers this function will not work properly and potentially cause a head crash. To do you setup you will use the 1in setup as outlined later in this article.**



**First step after you get your laser and rotary setup and positioned (Chuck head and motor on the right hand side as you look into the machine) is to go through light burn and make sure you have the “Rotary enabled” switch on your light burn desktop.**



# ROTOBOSS

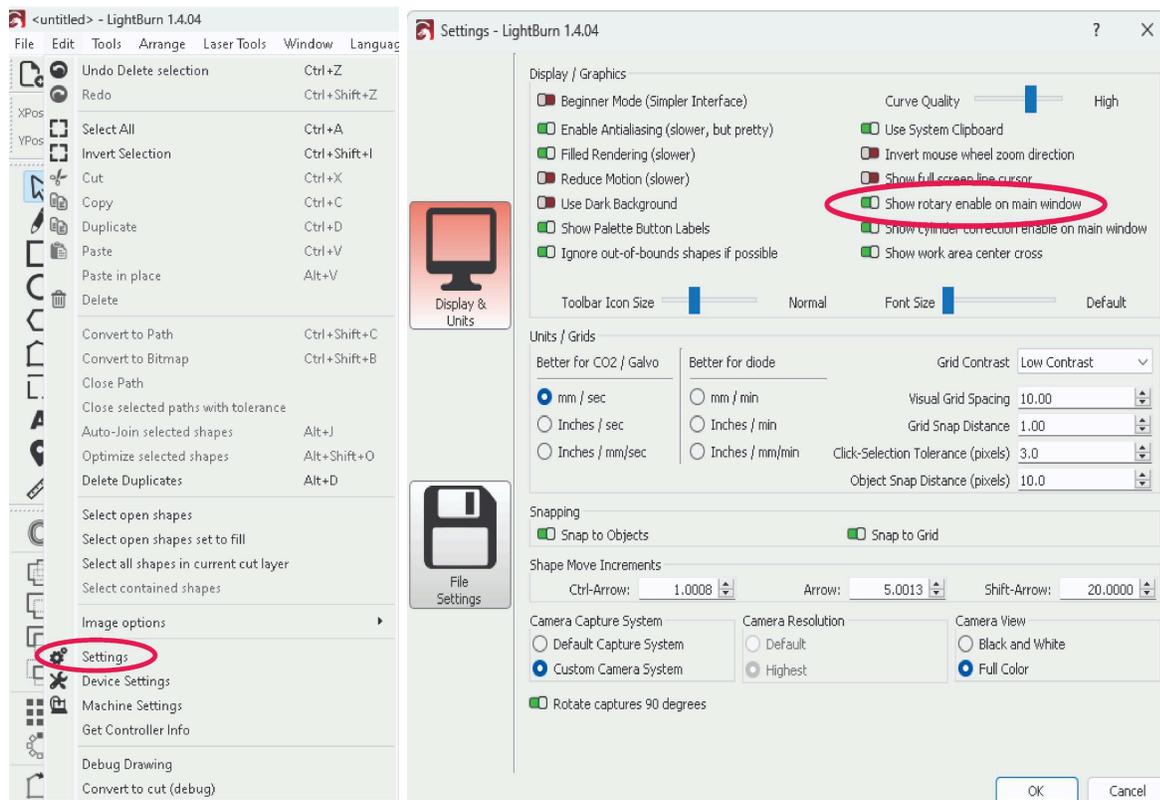
## ROTARY ATTACHMENTS

### TURN N' BURN

You can set this up as follows:

\*Open up the edit tab: and go to the settings tab (6th from the bottom)

\*With the popup you will see on the top right hand side, "Show rotary enable on main window" is checked/highlighted, then hit ok. You will then have it on the main screen.



Now that we have Light Burn home screen setup we will now move on to the rotary setup. You should see the symbols below on your light burn desktop.



# ROTOBOSS

## ROTARY ATTACHMENTS

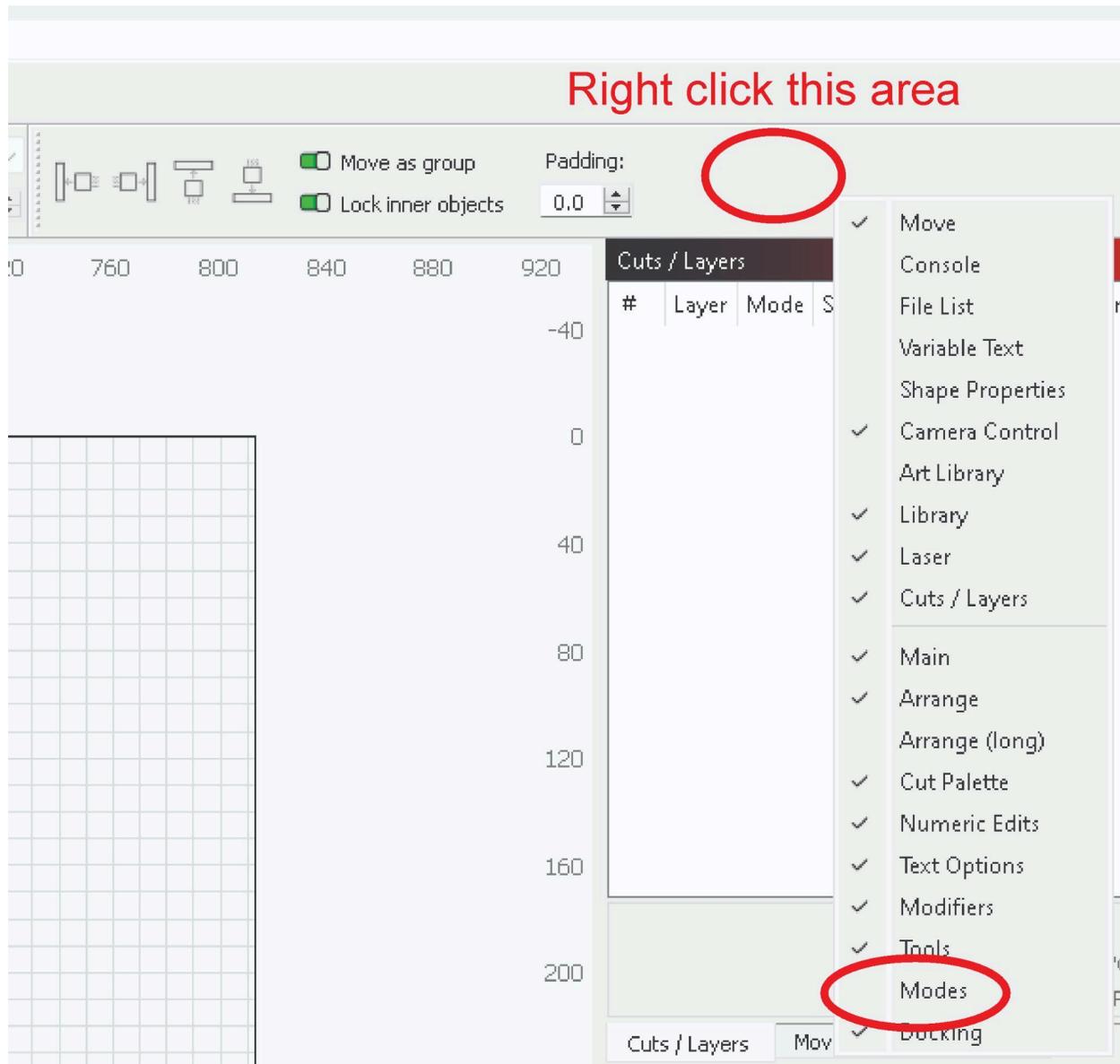
### TURN N' BURN

If you do not see the symbol above you can do the following, pictured below:

\*You can right click the area next to "padding"

\* Then make sure "Modes" is checked

Once this is done you will see the Rotary Tab as shown above



# ROTOBOSS

## ROTARY ATTACHMENTS

### TURN N' BURN

Now that you have this part setup we can move on to setting up the rotary by clicking on the rotary button you had or just added.



Now you will see the screens below. In these screens we will setup and make adjustments to dial in your rotary

**Rotary Setup - LightBurn 1.4.04**

Rotary Type

- Chuck
- Roller

**Make sure Chuck is selected.**

Enable Rotary

Mirror Output to Rotary

Rotary Axis

- Y Axis
- Z Axis
- A Axis

4100.00 steps per rotation

56.000mm Object Diameter

276.460mm Circumference

Test

Settings read from controller successfully

Read Settings OK Cancel

---

**Rotary Setup - LightBurn 1.4.04**

Rotary Type

- Chuck
- Roller

Enable Rotary

Mirror Output to Rotary

Rotary Axis

- Y Axis
- Z Axis
- A Axis

**These Axis will vary based on your machine, but you want to see Y or A Axis**

4100.00 steps per rotation

56.000mm Object Diameter

276.460mm Circumference

Test

Settings read from controller successfully

Read Settings OK Cancel

---

**Rotary Setup - LightBurn 1.4.04**

Rotary Type

- Chuck
- Roller

Enable Rotary

Mirror Output to Rotary

Rotary Axis

- Y Axis
- Z Axis
- A Axis

**Steps may vary from 8k to 13k depending on your machine. General starting point is 10k for initial setup test.**

4100.00 steps per rotation

56.000mm Object Diameter

276.460mm Circumference

Test

Settings read from controller successfully

Read Settings OK Cancel

---

**Rotary Setup - LightBurn 1.4.04**

Rotary Type

- Chuck
- Roller

Enable Rotary

Mirror Output to Rotary

Rotary Axis

- Y Axis
- Z Axis
- A Axis

**Object diameter is critical for the setup and use of the rotary.**

4100.00 steps per rotation

56.000mm Object Diameter

276.460mm Circumference

Test

Settings read from controller successfully

Read Settings OK Cancel



**\*\*Note: The Circumference is calculated based on the numbers you input for Steps and Object diameter and this is used for creating a template for wraps or other similar engravings.**

Once you have completed the above setup for your initial test you will now hit ok and go back to the Main screen for Light Burn. Once you have gotten back to the main screen you will now set up your test square to start dialing in your settings to get a perfect square.

**\*\*The type and size of the object is not important, but knowing the Diameter of the item is very important for the following steps.**

These buttons should not be used to operate the laser when using a rotary besides the "SEND" button as they most often do not work or work properly when used. All files should be sent to the laser and carried out from the laser.

# ROTOBOSS

## ROTARY ATTACHMENTS

### TURN N' BURN

The image shows a screenshot of the RotoBoss software interface. The top panel is titled "Cuts / Layers" and contains a table with the following data:

#	Layer	Mode	Spd/Pwr	Output	Show	Air
C02	02	Fill	4555.0 / 56.0	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>

Below the table are several control fields:

- Layer Color:
- Speed (mm/s): 4555.00
- Pass Count: 1
- Power Max (%): 56.00
- Interval (mm): 0.060
- Power Min (%): 56.00

The bottom panel is titled "Laser" and contains a grid of control buttons:

- Pause
- Stop
- Start
- Send
- Frame
- Frame
- Save RD file
- Run RD file
- Home
- Go to Origin
- Start From: Current Position
- Enable Rotary
- Job Origin (3x3 grid)
- Cut Selected Graphics
- Use Selection Origin
- Optimize Cut Path
- Show Last Position
- Optimization Settings
- Devices: ODEN 32

A red oval highlights the "Pause", "Stop", "Start", "Send", "Frame", "Frame", "Save RD file", and "Run RD file" buttons.

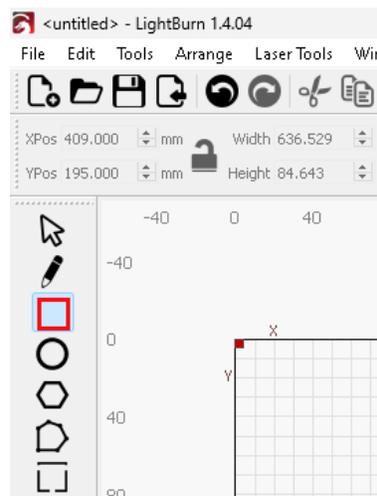
# ROTOBOSS

## ROTARY ATTACHMENTS

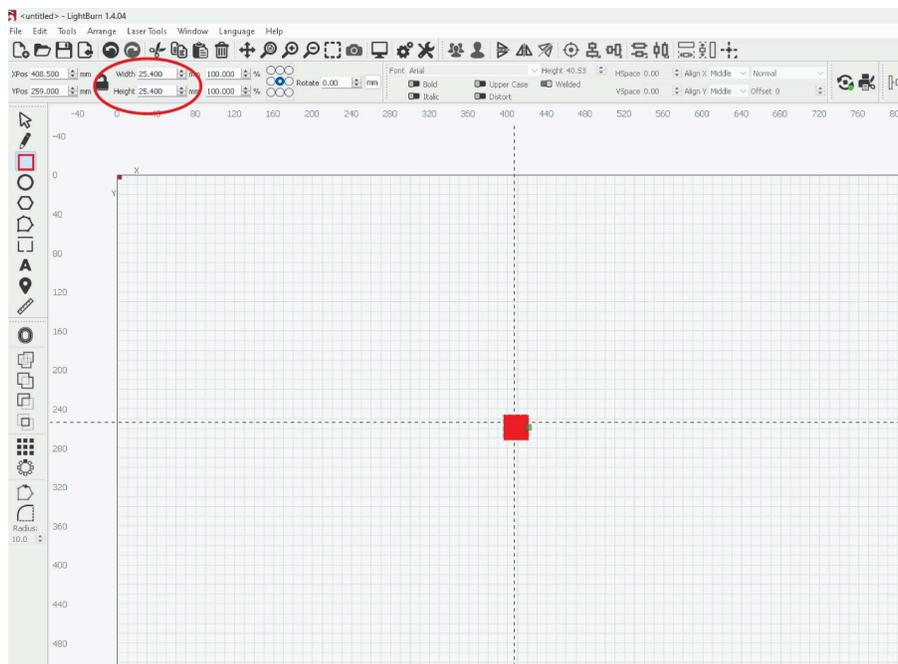
### TURN N' BURN

Now in Light Burn we will create a 1in or 25.4mm square on the screen (placement of the square in Light Burn is irrelevant to this)

You will select the square tool to create a box.



Verify your size in the X/Y boxes next to the lock button ( make sure the lock button is unlocked so you can change both independently)



# ROTOBOSS

## ROTARY ATTACHMENTS

### TURN N' BURN

Now we will set up Line intervals, start from and Job origin.

**Any selection besides Absolute Coordinates. Absolute Coordinates will not work for a rotary.**

Layer Color  Speed (m/min) 4555.00  
Pass Count 1 Power Max 56.00  
Interval (mm) 0.060 Power Min 56.00

Start From: **Current Position**

Job Origin

**Job Origin is recommended to be Right Center so the design starts at the top of the cup and in the center of the design.**

Layer Color  Speed (m/min) 4555.00  
Pass Count 1 Power Max 56.00  
Interval (mm) 0.060 Power Min 56.00

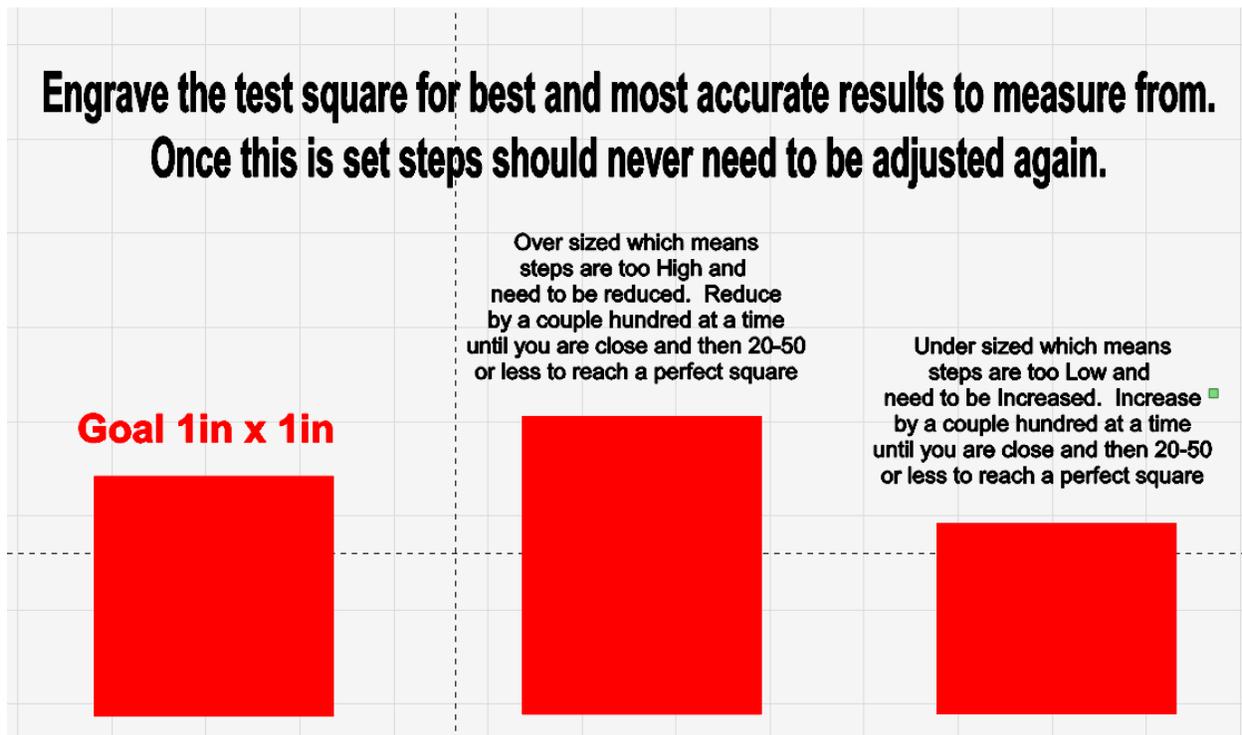
Start From: **Current Position**

Job Origin



## Calibrating steps to get the perfect 1in box.

**\*\*Recommended starting point is 10k steps. The end results may differ by up to 2-3k (or more) steps depending on your machine.**



**Now that you are all set up, let's have fun!**

**Place your design in Light Burn and rotate it 90 Deg ( to the right ) , scale it to the size needed, set your power and speed, send it to the laser and watch it work.**

**Any questions or problem you can reach out to us at [support@rotaryattachments.com](mailto:support@rotaryattachments.com) or call 904-701-8655**