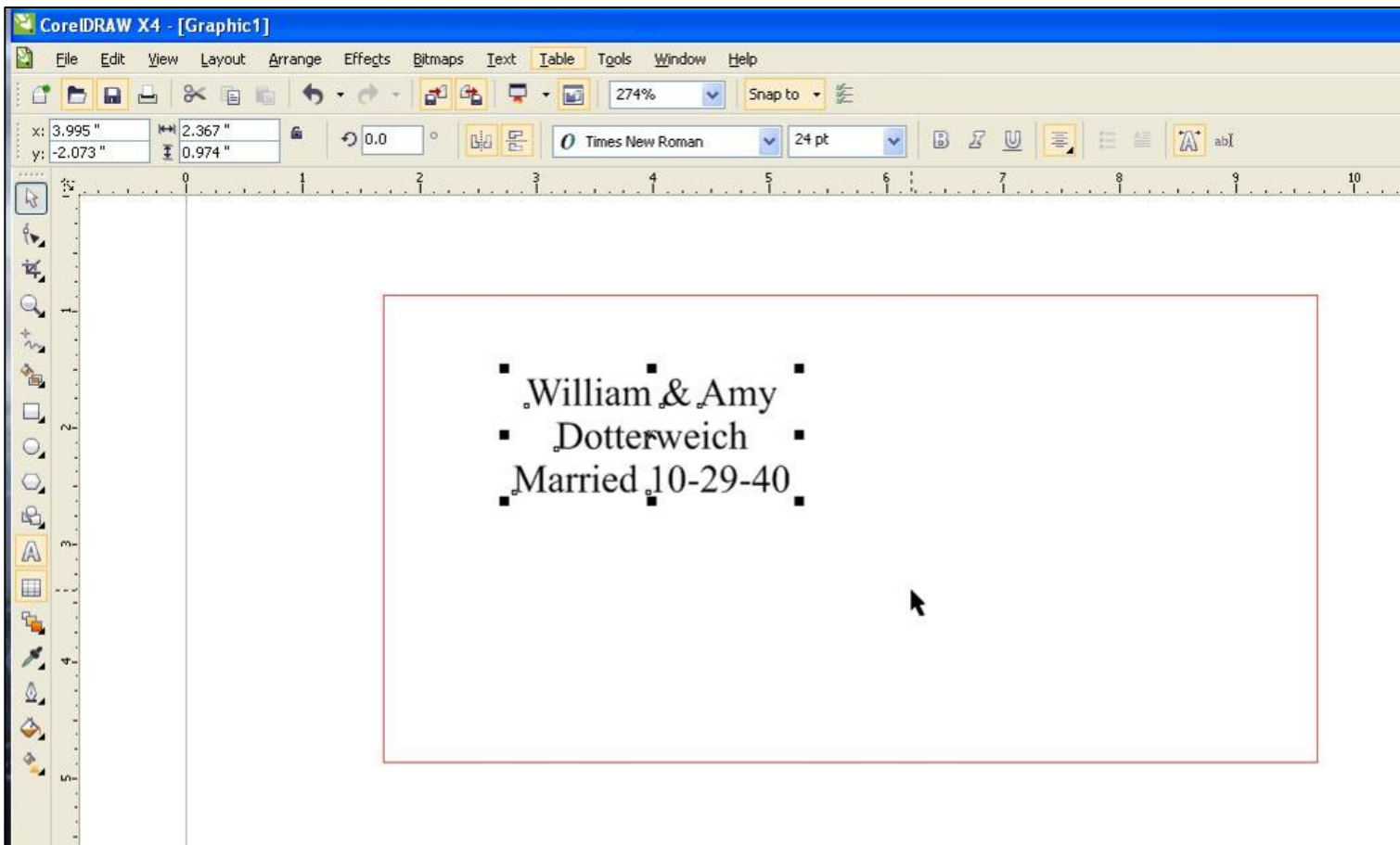




- Laser turns the clay to glass
- Only Clay Brick works with the laser
- Light color bricks do not give good contrast
- Images have to be vector-based graphics
- Air assist or the 4.0" lens is highly recommended

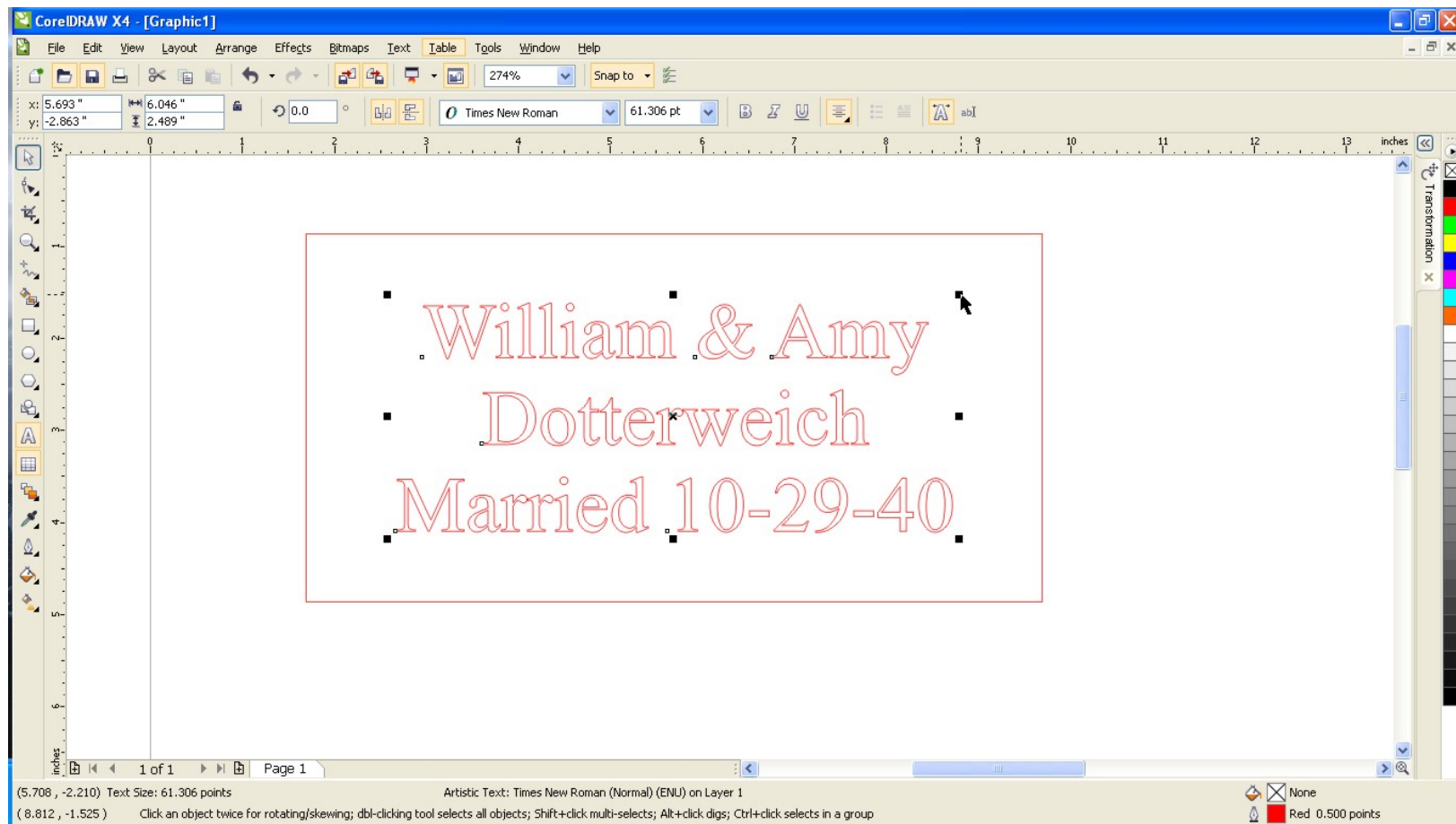


- Design your file



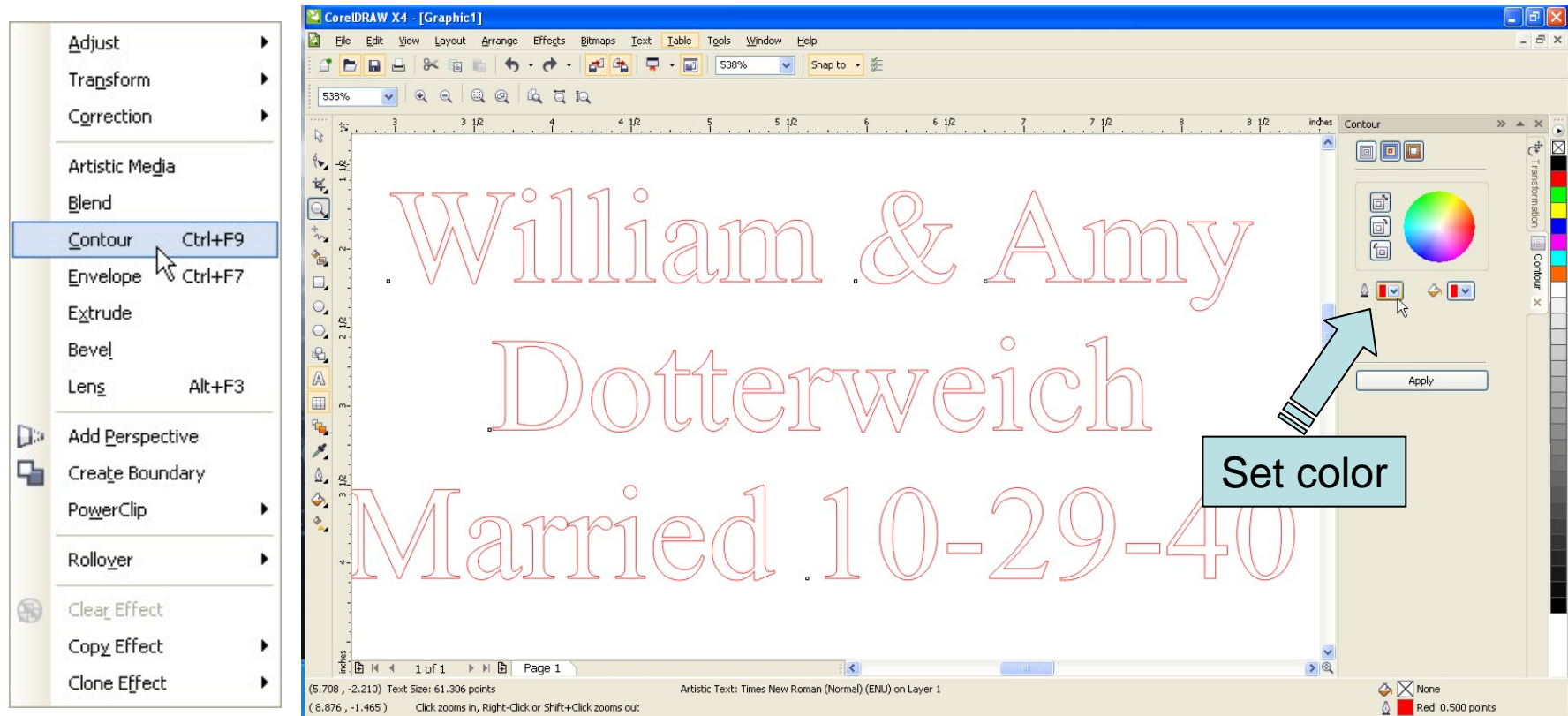


- Size & Create outline of your graphic



# Bricks

- Use the “Contour” feature in your drawing program & change outline color to match





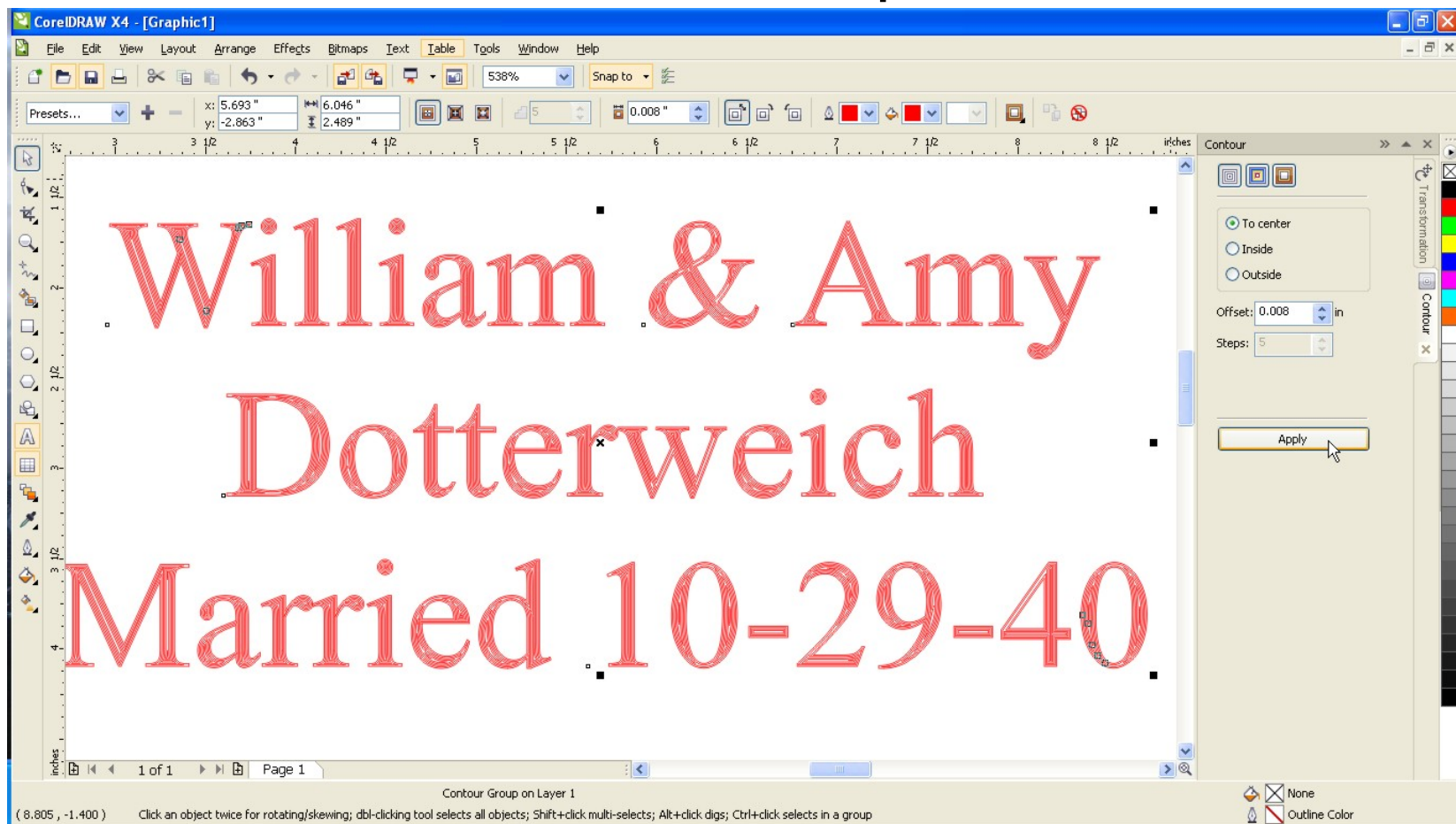
- Change the contour "To Center"
- Change the "Offset" to 1/3<sup>rd</sup> larger than the spot size diameter of your lens
- HPDFO and 1.5" lens not recommended

Offsets:

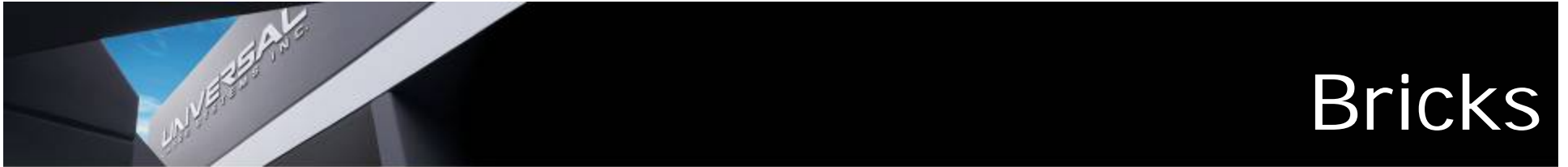
- 2.0" lens should be 0.008"
- 2.5" Lens should be 0.010
- 3.0" lens (ILS only) should be 0.012
- 4.0" lens should be 0.015
- Larger offsets can be accomplished by taking laser out of focus



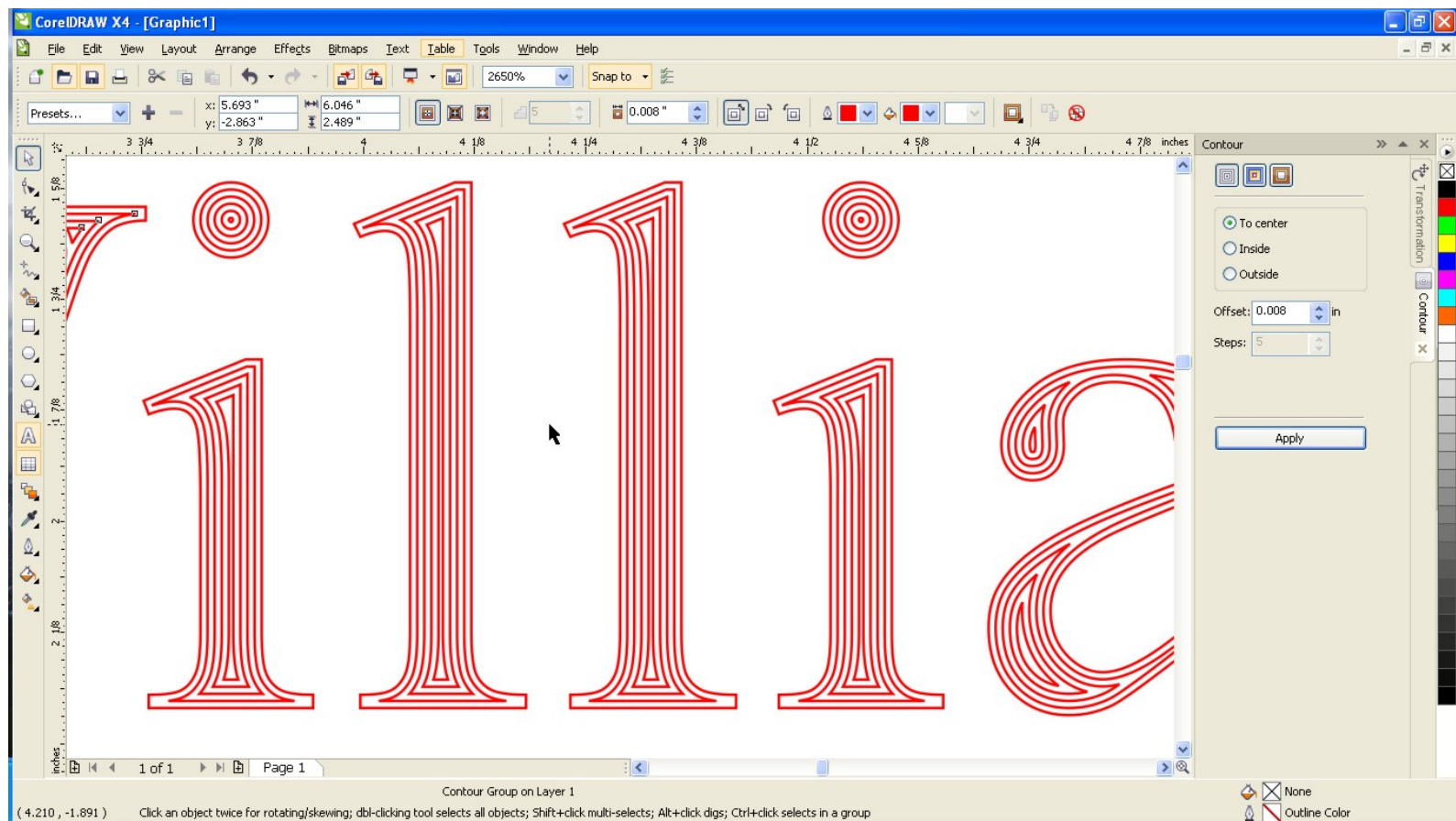
- Apply the contour - see lines automatically fill in toward the center per the offset







- Close-up of the file





- Run finished file
- High power, low speed on the laser
- No material-based setting for brick

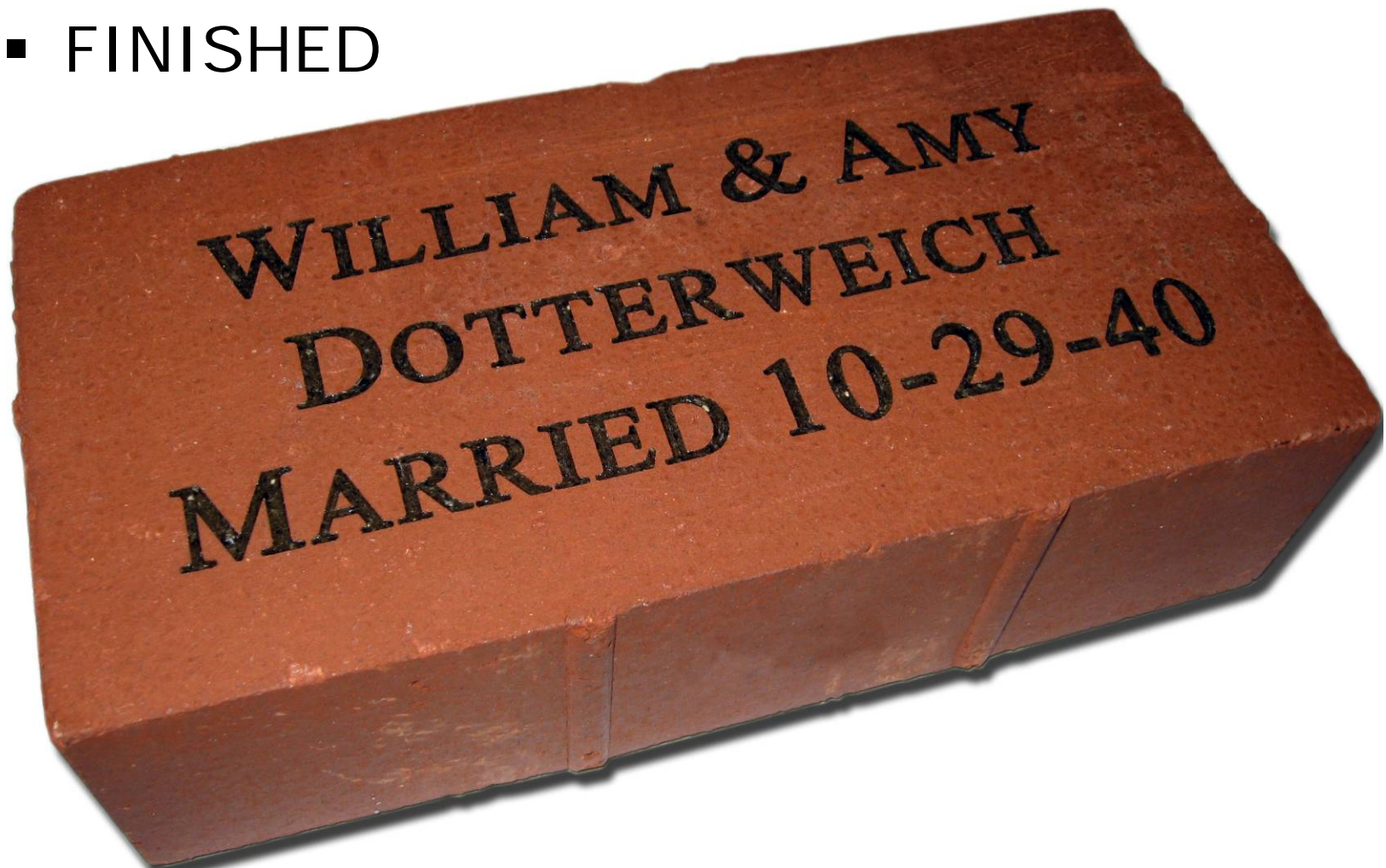
Example settings:

- 120 watts 100% power, 10% speed
- 60 watts 100% power, 6% speed
- 30watts 100% power, 3% speed





- FINISHED





# Bricks

- Examples

