FC2250 Keys, Functions, and Operations

Arrow Keys: For any position changes and values increase/decrease

Copy: To cut, "copy" the last job in the memory buffer without sending from the computer again.

Condition: Setting change, force, speed, etc, are done by press Condition key.

Next: To advance to the next page or next set of submenus.

Pause: when pressed, cutter will put in hold once the last set of instruction has been executed.

Enter: To confirm the changes made to take effect.

Test: Used for testing the appropriate force, speed, and other conditions for materials before final work start.

Origin: To reset the origin position anywhere other than the home position.

F1, F2, F3, F4: Access keys, depending on where you are on the menu tree, those four keys mean different things.
Each key also has two conditions assigned, press once shows one condition, press second time shows the 2nd condition setting.
By default, conditions 1 to 4 are assigned to use Pen1, conditions 5 to 8 are assigned to use Pen2, which has 1000g of force.

Before you start:
Set the blade length and cutting force first:

Blade length: Turn the green knob clockwise (or counter clockwise) to extend (or retract) the blade, make sure the blade only comes out far enough to match the thickness of the material, but not too far out.

Cutting force: Position the material flat on the table, turn the vacuum on, move the Pen to within the material, keep in mind what the force setting is on the LCD, press TEST key on the control panel, then press Test 1 to perform a test cut. Inspect the cut, if it didn't cut through, or if it didn't cut to the depth you want, then increase the force from the current setting. Press Next to exit, press Condition key then use UP arrow key to increase the force. Again, depending on how deep the test cut is, you may have to increase just a little in force, or may have to increase to a lot higher number for the next test cut.

Repeat these steps until the cutting force is cutting at the depth you want. There is no need to press origin key at this time.

I usually increase the cutting force by 1 or 2 during final cut, say force at 24 is cutting correctly, for final cut, I will increase it to 25 or 26 to ensure even and smooth cut through out. I will also turn the green knob about 1/5th clockwise during final cut too for the same purpose.

Cutting Material:
Position the material toward the lower left corner of the table and relatively perpendicular to the table. Make sure the blade is within the media. Press Origin key before start sending cutting data to the cutter.

Inspect the job without turning off the vacuum so you won't loosing the position of the material, if it didn't cut to the depth you want, then send the job over again to finish the cut.

10 mil chipboard

Force	X = 35 Y = 35	Offset	0
Speed	10	Quality	2
Cutter Blade	CB15U	Thick mode	Yes,
		Over Cut	0.3mm start, 0.3mm end

20 mil chipboard

Force	X = 66	Y = 66	Offset	0
Speed	10		Quality	2
Cutter Blade	CB15U		Thick mode	Yes
			Over Cut	0.4mm start, 0.4mm end

30 mil magnet

Force	X = 70	Y = 70	Offset	0
Speed	10		Quality	2
Cutter Blade	CB15U		Thick mode	Yes
			Over Cut	0.3mm start, 0.3mm end

5 mil calendar vinyl

Force	X = 12	Y = 12	Offset	0
Speed	25		Quality	2
Cutter Blade	CB15U		Thick mode	No

tackle twill

Force	X = 68	Y = 68	Offset	0
Speed	10		Quality	2
Cutter Blade	CB15U		Thick mode	Yes
			Over cut	0.2mm start, 0.2mm end

To Print and Cut:
Once finished the design work, draw a rectangle around the design, then turn it into reg. marks by check "convert rectangle to registration marks." Print it out with any printer.

Position the print toward the lower left corner on the table so the reg. marks is about 1" away from the edges of the table, use arrow keys to move the blade towards the lower left corner reg. mark. Keep in mind that conditions 1 to 4 are assigned to Pen1, 5 to 8 are assigned to Pen2, if on the display showing 1 to 4, make sure Pen1 is at the lower left corner reg. mark, other wise Pen2. there is no need to press any other key at this point.

Send cut data from the computer, depending on what software is used, anything other than CorelDraw or Illustrator with Cutting Master 2, the command set has to be GP-GL, any other software package the command set has to be HP-GL. Press PAUSE >> NEXT >> INTERFACE >> COMMAND, press ENTER key to confirm the change.