

DASTM

MULTI-DECORATION SYSTEM

Cutter Setup Guide

This guide will cover:

- ❑ Installing StoneCut or StoneCut Pro
- ❑ Accessing the StoneCut or StoneCut Pro Toolbar
- ❑ Configuring Your Cutter Driver
- ❑ The Setup Process for GCC Cutters
- ❑ Configuring Communication for GCC Cutters
- ❑ The Setup Process for other Cutters
- ❑ Tips for Popular Cutter Models
- ❑ Pressure and Speed Settings
- ❑ Adjusting Blade Depth
- ❑ Loading Material

Installing StoneCut, StoneCut Plus or StoneCut Pro

Installing the StoneCut, StoneCut Plus or StoneCut Pro Cutting Programs

You must install CorelDRAW before installing StoneCut, StoneCut Plus or StoneCut Pro. If you install new versions of CorelDRAW in the future, you can add a Toolbar by selecting **Install Autoimport Plugins** from the **Help** menu in **StoneCut, StoneCut Plus or StoneCut Pro**.

Important Information on the StoneCut Pro Dongle (Copy Protection Device):

StoneCut Pro requires the use of a copy protection device (dongle). The software will not operate unless this device is attached to a USB port on your computer. You can install the software on multiple computers, but this device must be attached in order for a computer to operate.



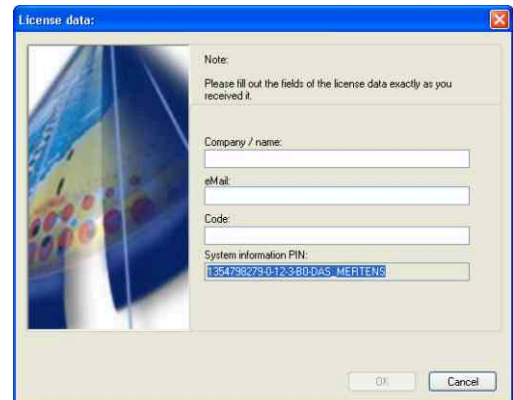
1. Verify that no other programs are running and that your dongle is not plugged into your computer. StoneCut does not require a dongle.
2. Insert the Installation DVD disk in your DVD drive. The installation window will appear on your screen.
3. If the installation window does not appear, you can start the installation program by running the setup program. Double-click on your **My Computer** icon to access your CD Drive. Right mouse-click on the CD-drive and select **Open**.
4. Click on the **.exe** file to start the installation.
5. After the installation Window appears, click on **Next** to start the installation.
6. Follow the instructions on screen.
7. You will be prompted to select an installation directory, we recommend the default installation directory. If you change the installation directory you must use the **Browse** button to select an alternative directory.
8. Select **Typical** when the Setup window appears and click on **Next**.
9. Follow the on screen prompts to complete the installation.



License Window

StoneCut Pro Users: Plug the copy protection device (dongle) into an open USB port on your computer. A red light on the dongle indicates that it is working.

10. The first time you launch the software, you will be prompted to enter your license data to activate the software. The License Window will appear. Click on the **License** button and follow the instructions on screen. Enter your **Company/User Name, Email Address**. Enter the your **Serial Number** and click on **Next**.



License Data Window

Accessing the StoneCut or StoneCut Pro Toolbar

The StoneCut, StoneCut Plus or StoneCut Pro Toolbar

After StoneCut or StoneCut Pro are installed, users of CorelDRAW X8 or higher will have access to the StoneCut Toolbar directly inside of CorelDRAW. This toolbar will enable you to transfer images and rhinestone text directly to StoneCut, StoneCut plus or StoneCut Pro.

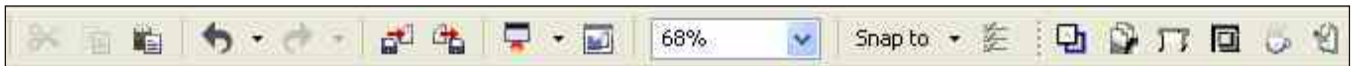


StoneCut Toolbar

This Toolbar also has additional features that add capabilities to CorelDRAW including Contouring, Multi-copy and Outlining features. The toolbar is the most efficient way to transfer images from CorelDRAW to StoneCut, StoneCut Plus or StoneCut Pro.

Docking the Toolbar

You can dock the Toolbar by dragging it onto a grey area on the right side of the CorelDRAW **Standard Toolbar**. You can turn a toolbar on or off by right mouse clicking on the grey area next to any bar at the top of the CorelDRAW workspace and checking or unchecking a toolbar. In CorelDRAW X8 or higher, you must uncheck **Lock Toolbars** before moving a toolbar. If you accidentally dislodge a toolbar, you can restore it to its home position by double-clicking on the blue title bar for the toolbar.



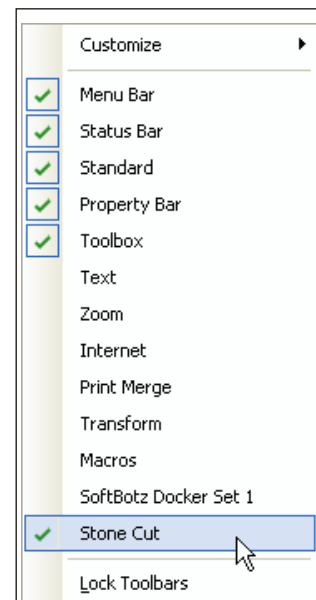
Standard Toolbar with Docked StoneCut Toolbar

Restoring the Toolbar if it Disappears

If you accidentally delete the Toolbar and it is not visible by right mouse clicking on the grey area next to any bar at the top of the CorelDRAW workspace, you can restore the toolbar by closing CorelDRAW and selecting **Install Autoimport Plugins** from the **Help** menu in StoneCut or StoneCut Pro. Choose your CorelDRAW version to reinstall the toolbar in CorelDRAW. You may need to reboot your computer.

Installing Additional Autoimport Plugins for CorelDRAW or Illustrator.

If you get a new version of CorelDRAW or Illustrator, you can install additional autoimport plugins and toolbars by selecting **Install Autoimport Plugins** from the **Help** menu in StoneCut, StoneCut Plus or StoneCut Pro.



Toolbar Options

Configuring Your Cutter Driver

StoneCut, StoneCut Plus and StoneCut Pro include drivers for most popular cutters. It is important to choose the correct driver and port settings for your cutter. Follow the instructions below to configure your cutter driver. We recommend using a USB connection.

Configuring Your Cutter Driver

Steps to Follow

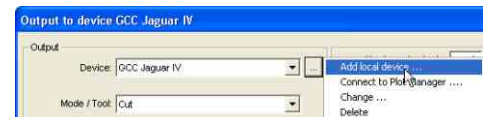
1. Launch the software by double-clicking on the desktop icon or by selecting the software from the StoneCut program group in Windows.
2. Import a clipart image by double-clicking on an image in the **Clipart Manager** on the right side of your screen.
3. Click on the cutter icon in the tool bar or Press **S** on your keyboard to open the **Setup Device** window.
4. When the **Setup Device** window opens, select your cutter model from the **Driver** drop down list.

Note on Cutter Drivers: If your cutter is not listed, please request technical support by filling out a support request on digitalartsolutions.com. In most cases, updated drivers are available for new cutter models.

5. Most new cutters use USB Printing Support. The cutter must be online, with material loaded ready to cut in order to establish communication with USB Printing Support. Once the cutter is online, click on the button for **USB/Firewire** and select your device from the drop down list. If your cutter is already communicating with another software, you will see the driver or **USB Printing Support** in the drop down list.

6. Most new cutters will use a USB port with USB Printing Support. If you are using an older cutter, you may use a serial port connection or a serial port to USB converter. To use a serial port connection with your cutter, select your COM port from the drop down list.

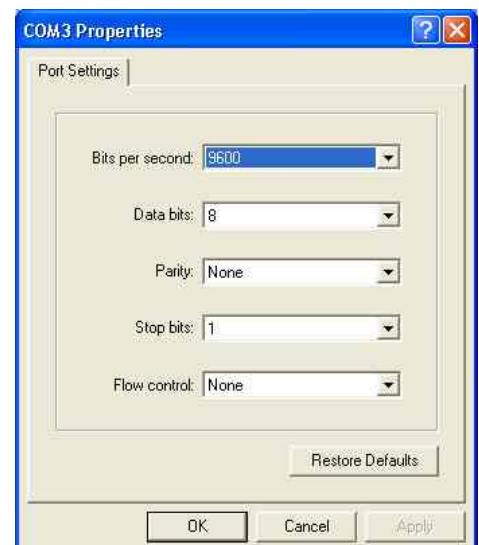
Note on COM Port Settings: If you are using a serial port connection, you will need to verify that you are using the correct COM port settings for your cutter. Please consult the manual for your cutter for the correct settings. Click on the **Settings** button next to the COM/LPT drop down list to adjust your COM port settings.



Add Local Device Option



Setup Device Window with Com Port



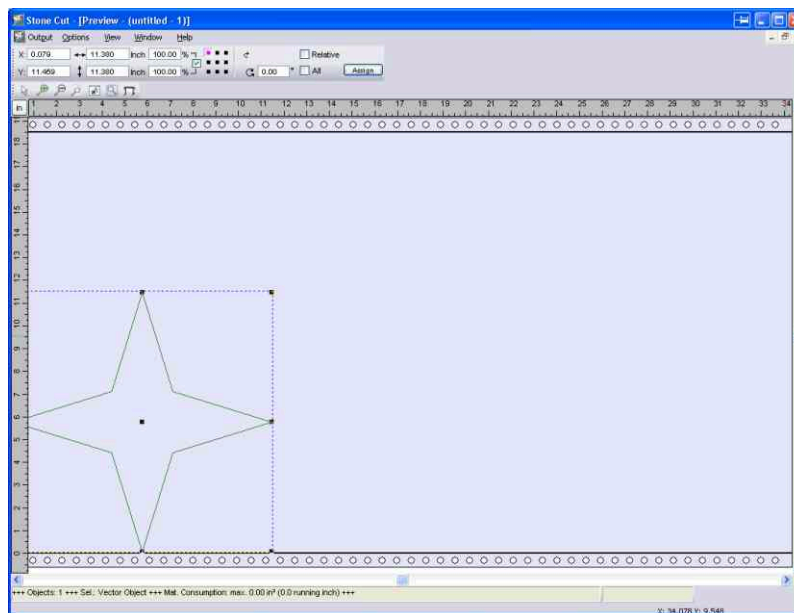
COM Port Settings for Serial Port Connections

Note on USB Printer Support: Windows 7, 8.1 and 10 support USB Printer Support. You do not have to install a USB driver with GCC cutters. You can select **USB Printer Support** from the drop down list provided the cutter is online. If the cutter is not loaded with material and online, this option will not be displayed. If USB Printer Support is compatible with your cutter, USB Printer Support should be listed in the USB device drop down list. If not, you will have to install a USB driver (see below). Please consult the manual for your cutter for instructions on installing drivers or configuring USB Printer Support.

Note on USB Drivers: If your cutter does not support **USB Printer Support**, you will have to install the USB driver that was included with your cutter. You will need to plug your cutter in and turn it on in order for your USB driver to appear. If your USB driver is properly installed, your cutter should be listed in the USB device drop down list. The USB driver will be provided by your cutter manufacturer. This driver is separate from the drivers that are included with StoneCut, StoneCut Plus or StoneCut Pro. You will need to consult the instructions for your cutter to properly install your USB driver. You will not be able to configure your cutter driver if your cutter's USB driver is not properly installed or compatible with your operating system.

7. Select **OK** to enter the **Output to Device** window.
8. You can now perform a test cut to determine if your cutter is configured properly.

Test Cutting: To test communication with your cutter, load some material in your cutter and make sure that the cutter is online and ready to cut. If you do not want to cut the material, remove the cutter blade from knife holder. Select the **Output** button to send a job to the cutter. If the cutter begins cutting, you have successfully set up your cutter. If not, check your port settings and verify that your cutter is online before contacting Digital Art Solutions technical support.



Cut Preview Window

The Set Up Process for GCC Cutters

It is critical that you follow these steps in the first 2 sections in this guide

Verify the settings on the cutter for GCC Cutters

- Verify that the cutter is assembled and placed on the optional stand.
- Adjust the blade depth of the cutter for cutting Wonder Flock.
- Verify that the cutter **Offset** function is set to **.400** (change on front panel)
- Verify that the cutter **Overcut** function is set to **.400** (change in Tool Select menu)
- Verify that the **Auto Enroll Media** function is disabled on the cutter. (change in Misc menu)

Adjust cutter blade depth and load material

- Adjust the blade depth of the cutter for ThermoFlex or sign vinyl.
- Adjust the pinch rollers on the cutter to properly load the material.
- Load material on the cutter.
- Set the cutter to the online position and reposition the cutter head so that it is in the proper location to cut the material.

Choose the communication settings for the cutter

- Launch StoneCut/StoneCut Plus/StoneCut Pro and verify that the cutter is online.
- Open the cutter set up window by pressing **S** on the keyboard.
- Select the model number of the cutter from the Device drop down list.
- Select the button for **USB/Firewire** and choose **USB Printer Support** from the drop down list.

Select the correct settings for the cutter and establish communication with a test cut

- Enlarge the **Macros** docker by selecting on the left border of the docker and dragging it.
- Import a start clipart image from **Rhinestone Shapes** group in the **Clipart Docker**.
- Select the **S** button on the keyboard to enter the **Output to Device** window.
- Uncheck all of the buttons on the right side of the window with the exception of **Weed Border** and **Sort before Output**.
- Change the **Weed Border** setting to **.20**.
- Save setting by selecting the **Save Settings** button.
- Verify that the correct cutter model is selected in the drop down list.
- Set up a material preset for Thermoflex with a pressure of **85** and a speed of **60**.
- Verify that the cutter is online and that the **Read Width** function is displaying the material width when selected.
- Enter the **Preview** mode.
- Demonstrate how to rotate an image by pressing **A** on your keyboard. **Y** mirrors an image.
- Output the file to the material and verify that the cutter is communicating.
- Adjust the blade depth to verify that the material is cutting and weeding properly.

Configuring Communication for GCC Cutters

GCC cutters use a different communication type depending upon your Windows Operating System. All new GCC cutters have upgraded firmware that enables communication with Windows 7, 8.1 and 10 using USB Printer Support. Older GCC cutters may require a firmware upgrade to function with Windows 7, 8.1 or 10.

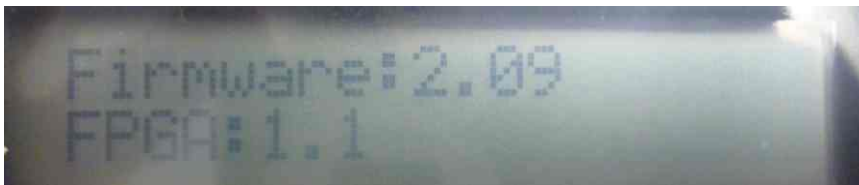
Configuring Your GCC Cutter to Cut Wonder Flock (Models equipped with an LCD)

Steps to Follow

1. You must first load material in the cutter.
2. Select the **Off/Online** button on the cutter LCD control panel.
3. The cutter will display **Offline**, select the **MISC** button.
4. Use the arrow button on the LCD panel to locate the firmware version for your cutter. Verify that this number is version **1.17** or higher. If the version is lower than **1.17**, you will need to upgrade your firmware for Windows 7 and Windows Vista compatibility (see below).
5. Use **Right** arrow button on the LCD panel to locate the menu setting for **USB Printer Type**.

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the **Enter** button to choose the **USB Printer Type**. If your firmware version is 1.17 or higher and this option is not available, you have a newer cutter that will automatically detect the communication type. You can bypass this step.

Note on Firmware Upgrades: If your firmware version number is lower than 1.17, you will need to upgrade the firmware on the cutter if you plan on using the cutter with Windows 7 or Windows 8. Contact Digital Art Solutions for details regarding firmware updates.

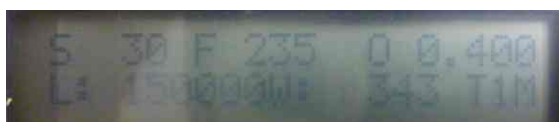
7. Select **Common USB Mode** if this option is available and press **Enter**.

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ce the cutter online by pressing the **Off/Online** button. If the cutter is online, it will display the values for Speed (S) and Force (F) the top line of the LCD panel.



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. The cutter is now configured and ready to cut.

The Set Up Process for other Cutters

These are the steps for your initial setup of your cutter in StoneCut or StoneCut Pro. It is critical that you follow these steps in the first 2 sections of the this guide.

Verify the settings on the cutter

- Verify that the cutter is assembled and placed on the optional stand.
- Adjust the blade depth of the cutter for cutting Wonder Flock.
- Verify that the cutter **Offset** and **Overcut** functions have been set for your cutter,
Note: Some cutters do not have **Offset** and **Overcut** settings, consult your cutter manual for instructions. The Roland GX 24 or Cameo cutters do not have an **Overcut** function.
- Verify that your cutter is communicating with your computer using the cutting software that as included with your cutter.

Adjust cutter blade depth and load material (Consult your cutter manual)

- Adjust the blade depth of the cutter for cutting Wonder Flock.
- Adjust the pinch rollers on the cutter to properly load the material.
- Load material on the cutter.
- Set the cutter to the online position and reposition the cutter head so that it is in the proper location to cut the material.

Choose the communication settings for the cutter

- Launch StoneCut/StoneCut Pro and verify that the cutter is online.
- Open the cutter set up window by pressing **S** on the keyboard.
- Select the model number of the cutter from the **Device** drop down list.
- Select the button for **USB/Firewire** if you have a USB connection or **COM/LPT** if you have a parallel port or serial port connection.
- For a USB connection, select **USB Printer Support** if available, otherwise select your cutter model from the **USB/Firewire** drop down list. The cutter must be online.
- For a serial port connection, select your **COM** port from the **Local Ports** drop down list.

Select the correct settings for the cutter and establish communication with a test cut

- Enlarge the **Macros** docker by selecting on the left border of the docker and dragging it.
- Import a rhinestone pattern from the **Rhinestone Shapes** group in the **Clipart Docker**.
- Select the **S** button on the keyboard to enter the **Output to Device** window.
- Uncheck all of the buttons on the right side of the window with the exception of **Weed Border** and **Sort before Output**.
- Change the **Weed Border** setting to **.25**.
- Save setting by selecting the **Save Settings** button.
- Verify that the correct cutter model is selected in the drop down list.
- Set up a material preset for Wonder Flock with a pressure of **155** and maximum speed.
- Verify that the cutter is online and that the **Read Width** function is displaying the material width when selected. The **Read Width** feature is not supported with all cutters.
- Enter the **Preview** mode and adjust the **Sort with Simulation** function so that the material is cutting right to left, top to bottom (5th icon in the list with the red arrow pointing up).
- Demonstrate how to rotate an image by pressing **A** on your keyboard. **Y** mirrors an image.
- Output the file to the material and verify that the cutter is communicating.
- Adjust the blade depth to verify that the material is cutting and weeding properly.

Tips for Popular Cutter Models

Roland Cutters including the GX/GS 24

- You must install the Roland Windows drivers before establishing communication with StoneCut, StoneCut Plus or StoneCut Pro. Once these drivers are installed, a print driver will show up in your **Windows Control Panel** under **Printers**.
- You would normally select a USB Connection when setting up your Roland cutter and choose the option for **USB Printer Support**. If you have other USB devices on your system, they should be turned off when cutting.
- Roland cutters may start cutting from the left side of the material (as you are facing the machine). There is a function in the control panel for Roland cutters that will enable you to Rotate the cutting axis so the cutter will begin cutting from the bottom right and will match the cut preview in StoneCut, StoneCut Plus or StoneCut Pro.
- The Roland GX 24 does not have an overcut function, but it is important that you set the offset function to .35 to optimize cutting for Wonder Flock.
- Consult your Roland manual for instructions on changing settings on your cutter.

Graphtec Cutters including the Craft Robo 2, CE Series and FC Series

- You must install the Graphtec Windows drivers before establishing communication with StoneCut, StoneCut Plus or StoneCut Pro. Once these drivers are installed, a print driver will show up in your **Windows Control Panel** under **Printers**.
- You would normally select a USB Connection when setting up your Graphtec cutter and choose the option for **USB Printer Support**. If you have other USB devices on your system, they should be turned off when cutting.
- All Graphtec cutter should be set to the command mode of **GP-GL** or **Auto Detect**. If you receive a port error message when cutting, it is likely that your command mode is set to **HP-GL**. Consult your Graphtec manual for instructions on changing to the **GP-GL** command mode. The **GP-GL** command mode is recommended because it supports advance features.
- Graphtec cutters may cut objects too large if the step size on the machine is not set to match the step size in the StoneCut/StoneCut Pro drivers. Please contact DAS technical support if you need help adjusting the scaling. We can configure the driver to adjust the scaling for your specific model.

Mimaki Cutters including the CG61

- Mimaki cutters may cut objects too large if the resolution on the machine is not set to match the resolution in the StoneCut/StoneCut Pro drivers.

Changing the Step Size/Resolution

Step 1: Press the < key on the LCD control panel on the cutter.

Step 2: After the initialization press the **Function** key until the menu **Step Size** appears.

Step 3: Change the value to **0.01** with the ^ key and confirm your selection with the **ENTER** and **END** keys.

Adjusting Blade Depth

Before you attempt to cut anything, you must set the proper blade depth for your material. Each material will have a different blade depth and pressure setting (Force). You will achieve the best results with the maximum recommended pressure setting for the material and the minimum blade depth that allows for proper cutting. You should be able to easily separate the material from the liner sheet without leaving deeply etched marks.

Setting the Blade Depth

Steps to Follow

1. Remove the cutter blade holder from the carriage assembly. The blade holder is a metal part that looks similar to a bullet.
2. You can set the blade depth by turning the threaded cap at the end of the blade holder.
3. Verify that you are using a 60 degree or 45 degree blade. The 45 degree blade will be used for most heat transfer materials and sign vinyl. The 60 degree blade will be used for Wonder Flock, heat transfer flock and glitter heat transfer films.



Blade Holder Assembly

Proper Blade Depth:

Wonder Flock: Approximately a third the thickness of a credit card with a 60 degree blade.

Heat Transfer Material or Sign Vinyl: Approximately one quarter the thickness of a credit card with a 45 degree blade



45 Degree Blade



60 Degree Blade

Tip for Adjusting Blade Depth: Back the blade completely out by rotating the blade holder cap counter-clockwise. Hold your finger at the tip of the blade holder and turn the blade holder until you feel the blade prick your finger. Turn it one quarter turn clockwise for sign vinyl or ThermoFlex. Turn the blade one complete revolution clockwise for Wonder Flock or glitter vinyl.



Correct Depth for Wonder Flock or Glitter



Correct Depth for ThermoFlex or Sign Vinyl

4. Once the blade depth is set, you must reseal the blade holder assembly in the carriage and tighten the set screw.

Note: If you put the blade out too far, it will cut through the material and may damage the blade. This may result in inconsistent cutting or triggering an error message on your cutter.

Pressure and Speed Settings

Each material will require a different speed, pressure and blade type.

Material	Force	Speed	Blade
Wonder Flock	150-155	60 - 153	60 degree blade
Heat Transfer Flock	120	60 - 153	60 degree blade
Glitter Flex	120	60 - 153	60 degree blade
Athletic Twill	180	30 - 60	60 degree blade
Heat Transfer Vinyl	85-90	60-153	45 degree blade
Sign Vinyl	85-90	60 - 153	45 degree blade
Rhinestone Decal Material	65	8	45 degree blade

Determining the Correct Blade Depth

You will need to determine the correct blade depth for any new material. It is generally best to use the recommended pressure setting for the material and only make the adjustment to the blade depth. The idea is to use maximum pressure and minimum blade depth. You want to cut through the material without cutting through the liner sheet or deeply gouging the liner sheet. If the sheet is slightly scored, this is OK. If your blade is dull, it may require more pressure. If you put the blade out too far, it will cut through the material into the white plastic cutting strip and damage the blade. This may result in inconsistent cutting. If the cutting strip is damaged with deep grooves, it will need to be replaced. There is a section in your training guide that covers resolutions to weeding problems.



*Maximum Blade Depth
for Wonder Flock*



White Cutting Strip

Loading Material

Material must be properly loaded in the cutter before configuring the driver and performing a test cut.

Loading Stone Stencil Material

Steps to Follow

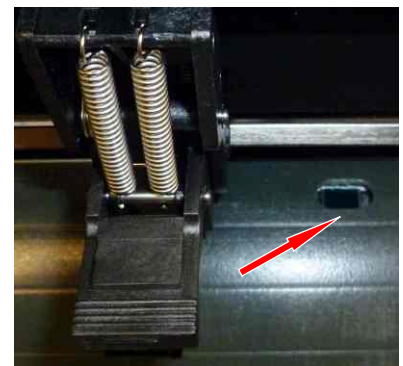
1. Make sure the material is not curling up. This may trip your rear media sensor and prevent the machine from cutting. You can cover this sensor with a piece of tape.
2. Lower the cam roller arm to take the pressure off the rollers.
3. Feed the material under the pinch rollers from the front or rear of the cutter.
4. Position the pinch rollers so that they are under the grit rollers. If your cutter has a middle pinch roller, it should be disabled unless you are cutting a very thin material that is buckling.
5. The left and right pinch roller should line up with the edge of the material. The circular roller should be offset from the edge of the material by approximately one half of an inch. You may need to try different locations for the pinch rollers to minimize material waste. It is important that right edge of the material is not to the left of the front media sensor or the cutter will not feed the material.
6. Raise the cam roller arm in preparation of cutting. The machine will now prompt you to select the cutting position for the material. Please consult the instructions for your cutter.

Note on GCC Cutters

Once you lower the cam roller, you will be prompted to select Roll, Edge or Single. Select roll, if you want to begin cutting at the location the material is currently loaded at. Press Edge to have the machine reposition the material to cut at the front edge. Press Single if you are loading a sheet.



Material Draped Behind Cutter



Rear Media Sensor



Cam Lever in Up Position



Left Pinch Roller in Correct Position