

1. **start\_** Begin focusing by turning on the laser cutter and opening the laser cutting software, UPC.

2. **material placement\_** Place your material on the bottom left-hand corner bed of the machine .

3. **zoom icon\_** On the main screen of the laser cutting software, press on the Z-icon located on the right side panel. This will bring up the focus window as shown here.

4. **x,y coordinates\_** Use the x,y coordinates to locate the laser directly over your material. Enter values within the following range  $x[0,32]$  and  $y[0,18]$  in the designated spots of the focus window.

5. **z-controls\_**