

Axiom AR8 PRO v5 (UK) / i2R A 24 / LAGUNA Controller [AXBB-E](#) + UCCNC

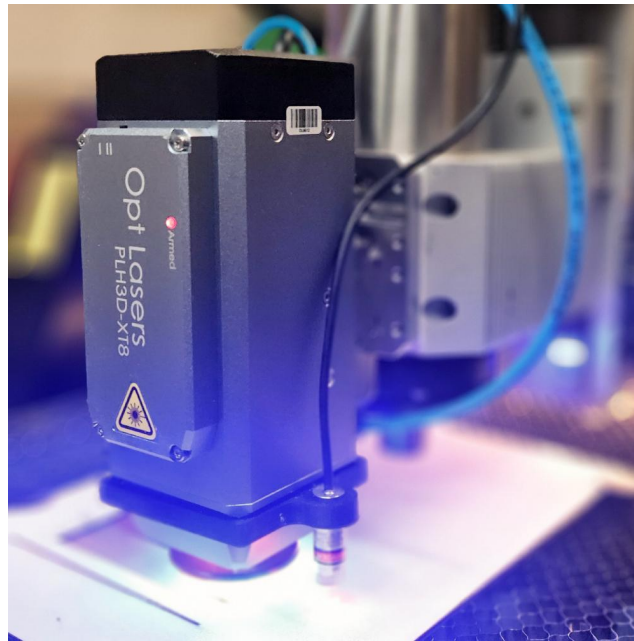


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INTRODUCTION:

This guide describes the wiring and installation of the XT8 45 W laser on a CNC machine. It provides step-by-step instructions for solving positioning and cable routing challenges and is intended as an addition to the existing Opt Lasers manuals, tailored specifically to this machine configuration. It is designed to support users without in-depth experience in CNC electronics or laser integration.

The wiring diagram and examples in this document refer to an AXIOM PRECISION AR8 PRO v5, which is also sold under several similar brands (including i2R A24 and LAGUNA) that share the CNCdrive AXBB-E controller board and UCCNC software. The final section of this guide covers the relevant AXBB-E connections and the basic UCCNC configuration for laser use.

The following sections describe the installation process in detail.

WHICH KIT SHOULD YOU CHOOSE FROM OPT LASERS?:

Use the kit for the i2A - “Plug&Play XT8 45 W Laser Kit for all CNC machines”. This kit contains all components required for the installation described in this guide.

WHAT TO ADD TO THE KIT:

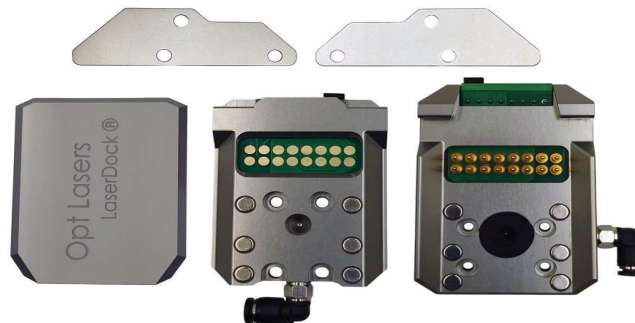
It is recommended to also purchase the “LaserDock PRO – Magnetic docking station from laser to CNC”. Since the machine is originally a milling machine, the docking station allows the laser head to be removed during milling operations, reducing the load on the spindle axis and avoiding mechanical interference.

The magnetic connection provides strong holding force; however, the mechanical fixing plates included in the kit should be installed as an additional safety measure to prevent accidental detachment in the event of a collision.



UNBOXING:

The package includes all components shown in the reference image and listed on the Opt Lasers website. The installation procedure described in this guide assumes that the optional LaserDock PRO quick-release docking system is also installed.



The image shows two small plates used to secure the laser head, the plate that mounts to the laser body, and the plate that remains on the CNC (these plates include the electrical contacts). The plate with the printed logo is a cover used to protect the contacts when the laser head is removed and stored. Refer to the official packing list from Opt Lasers to verify that all components are present.

ASSEMBLY:

I carried out the assembly in four steps:

- 1 - Routing the connection cables
- 2 - Positioning the “PLH3D-CNC Adapter PRO”
- 3 - Assembling the laser head
- 4 - How and where to position the quick-release docking station on the CNC

The steps below describe a recommended sequence; they may be carried out in a different order if required by your machine layout.

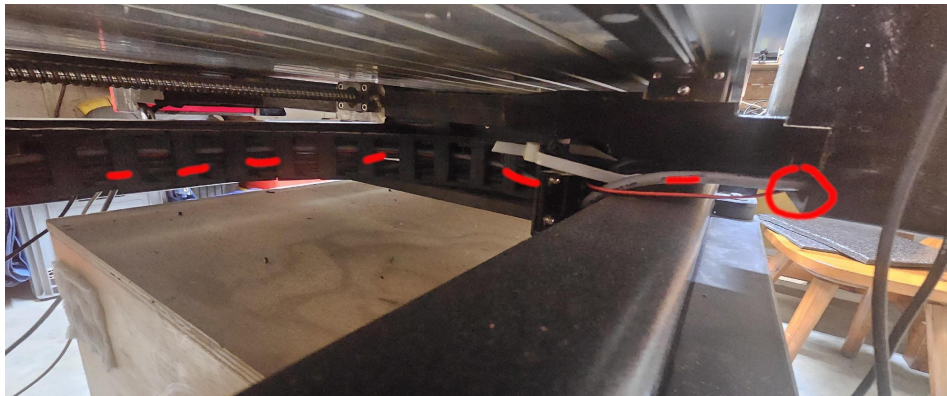
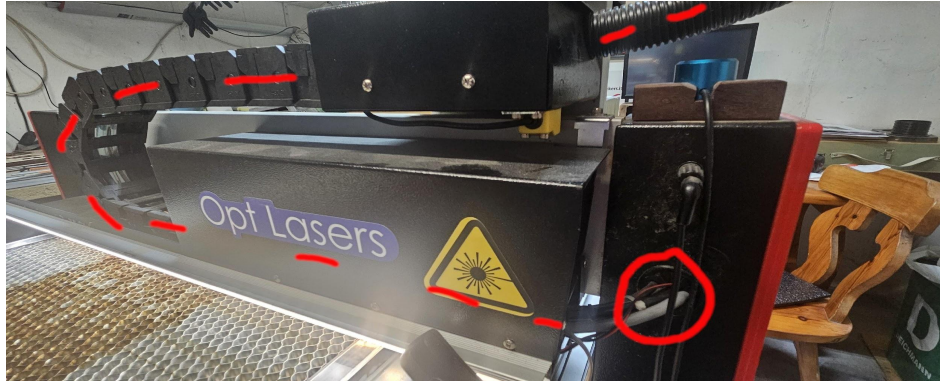
1 - Cable Routing

The KIT includes two cables, which become three if you purchase the quick-release docking station. The first cable, which is gray, has a 6-position terminal block on both ends and connects the Adapter PRO either directly to the laser head, or in our case, to the quick-release docking station.

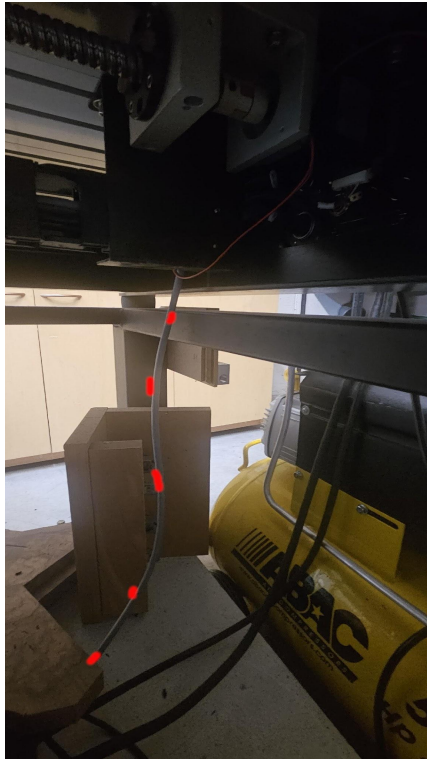
After removing the 6-position terminal block from one end of the gray cable and taping the tip to help it slide more easily, I started pushing the cable through the black corrugated tubing located above the spindle motor.



After running it through the black corrugated tubing and then through the X-axis cable chain, feed the cable into the gantry box through the existing holes and pull it out from the bottom. As shown in the picture.



Once it comes out from the bottom of the gantry box, route it along the internal path following the entire belt located underneath your CNC, until it exits on the opposite side.

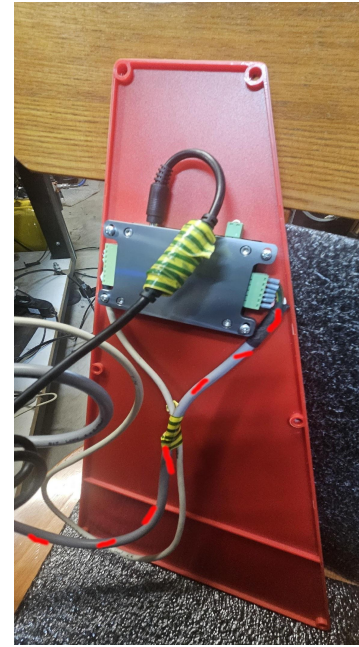
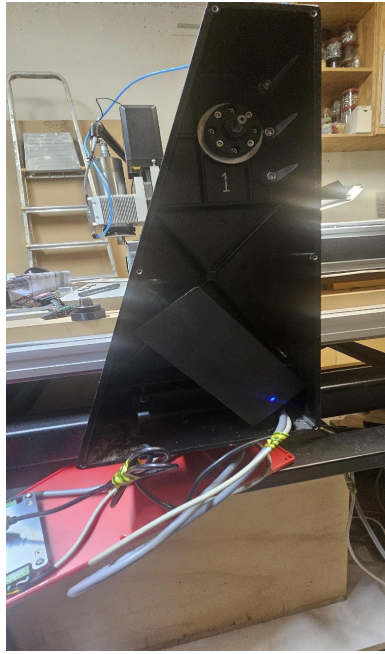


The cable is now free in the lower part of the CNC and outside the moving cable chains.

If you want, you can fasten it to the machine frame using electrician zip ties, but I haven't done that yet. At this point, I decided to run it underneath the machine so that it reaches the lower part of the "X" gantry box (the one on the right) on the opposite side, and insert it into the box from the bottom.

The "X" gantry box is empty inside and provides enough space to mount additional components. In this configuration, the power supply transformer is installed inside the box and a rectangular opening is made in the plastic cover to mount the Adapter PRO in an easily accessible position.

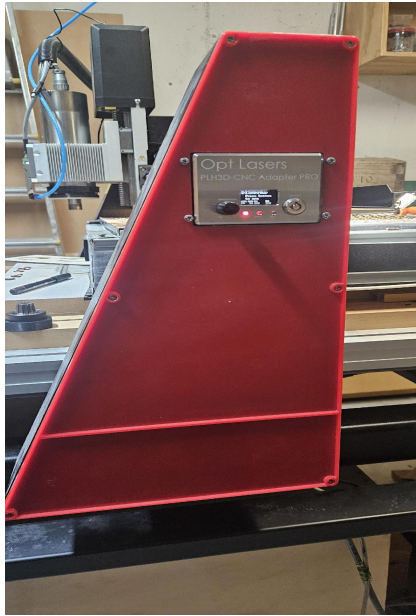
Refer to the installation photos for the exact location and orientation.



Now reinstall the 6-pin terminal block on the end of the gray cable that we routed through the chains, and fasten it to the Adapter PRO after mounting it on the cover panel. At this point, insert the power jack (the black cable), and then connect the white cable to the opposite side of the Adapter PRO. The white cable will later need to reach the rear side of your CNC's cabinet.

NOTE: both the black power cable and the white cable must exit from the bottom of the enclosure.

The Adapter PRO is installed in the position shown in the reference image.



At this point, in the lower part of the enclosure we have: the gray cable coming in, the black power cable exiting towards the power outlet, and the new white cable which will reach your CNC cabinet where it will plug into its socket.



The picture shows the rear side of your CNC cabinet, where you can clearly see the LASER input.

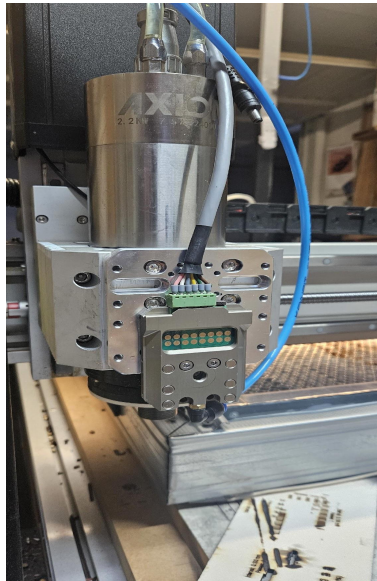
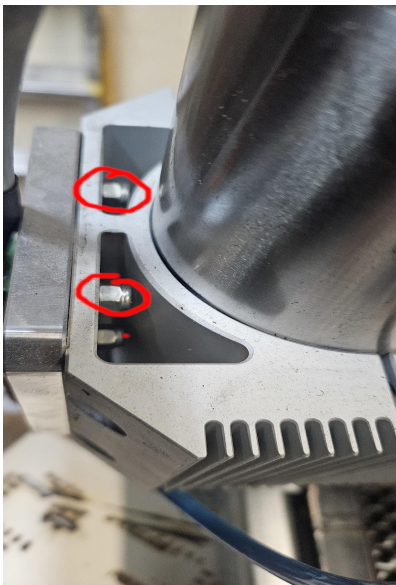
At this point all cables have been routed and connected, and the Adapter PRO has been mounted in its final position. This completes steps 1 and 2.

2 – Mounting the support plate on the CNC and installing the quick-release docking system

In our KIT we find two aluminum mounting plates with several pre-drilled holes for different needs. The plates are one small and one large - we will only use the large one.

Once mounted on our CNC in the most convenient position, this plate will support the quick-release docking system.

The next step requires a small amount of machining work: remove the clamp that holds the spindle motor and drill it to allow the supplied mounting plate to be bolted to it. The accompanying photos illustrate the required hole positions and mounting arrangement.



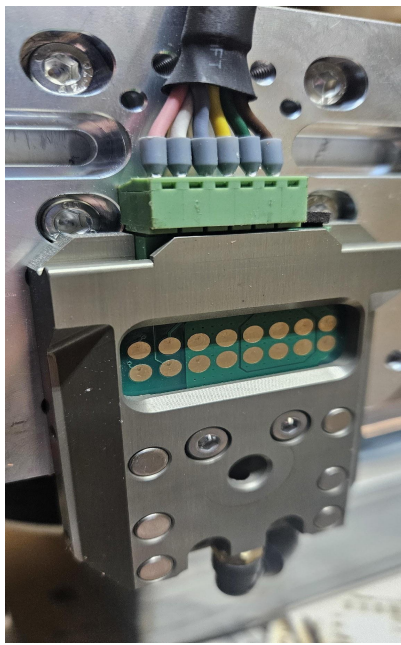
Note: The required nuts and bolts for fixing the plate to the spindle clamp are not included. Either reuse suitable fasteners from the kit or use appropriate hardware of matching size and strength class.

As for the exact positioning, you are free to choose - I set it up as shown in the picture.

At this point, we can plug our 6-pin gray cable into the Adapter PRO.

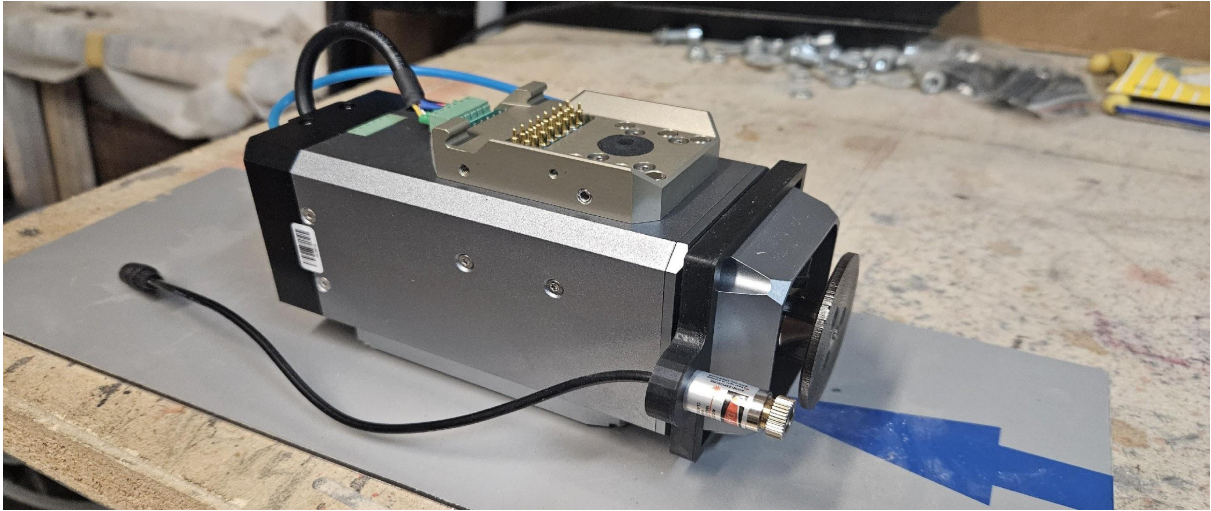
On the underside of the assembly, connect the compressed air inlet tube (the light

blue tube shown in the image) to the air fitting.



After completing these steps, the mechanical work on the CNC machine is finished. The next step is assembling the laser head.

LASER HEAD:



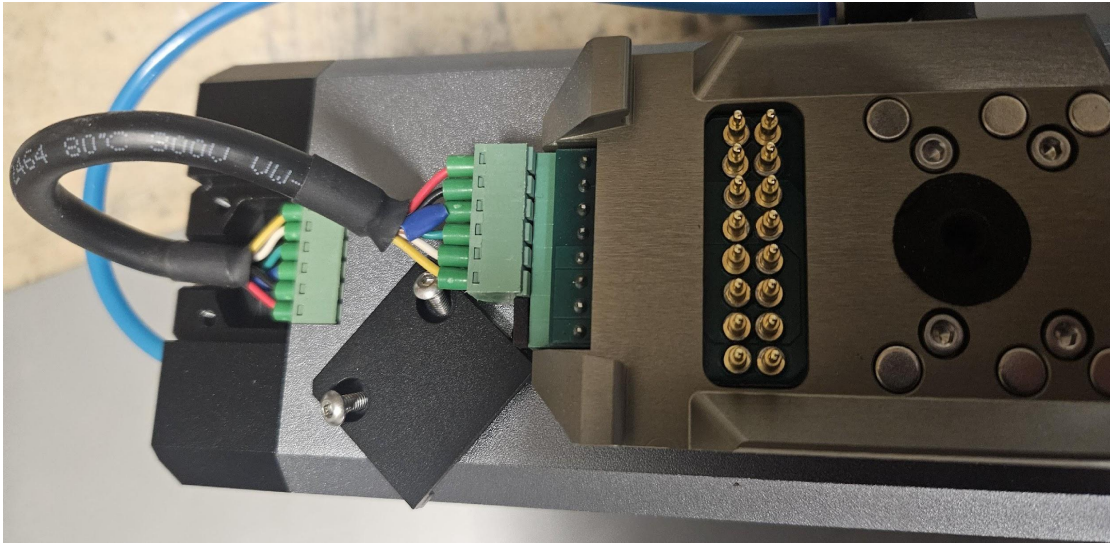
The assembled laser head should appear as shown in the reference image.

We can immediately notice the third (optional) black cable, which connects the laser head to the Adapter PRO quick-release system. If we had not chosen the quick-release docking system, the gray cable would have plugged directly into the laser head.

Without the Adapter PRO, the laser would always remain fixed on the CNC, eliminating the possibility of removing and storing it when not in use.

The small auxiliary laser pointer shown in the image is an optional addition and is not part of the standard Opt Lasers kit.

Once the Adapter PRO quick-release system is secured with the four small screws provided in the KIT, we can electrically connect the Adapter PRO to the laser body using the short 6-pin black cable. The cable port on the laser body is hidden under a small plastic cover secured with two screws.



Once the cable is secured, we can put the small plastic cover back in place.

AIR FLOW:

The first thing to do is install the air-flow nozzle on the tip of the Laser.

Slide it onto the brass laser collar and tighten the three screws with the supplied hex key, giving each screw the same number of turns. This ensures that the laser beam exits perfectly centered in the opening



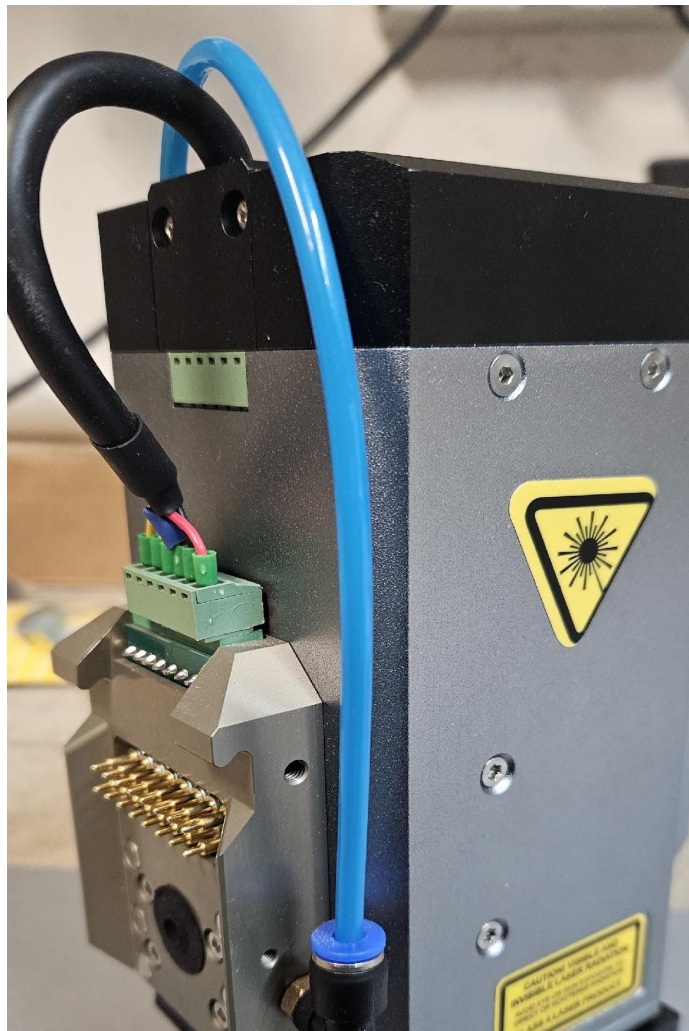
Now we install the air tube, which will connect the Adapter PRO to the laser tip. Feed it through the XT8 Laser body using the opening located at the top.



Once it comes out from the bottom, plug it into the fitting on the air-flow nozzle.



Finally, connect the 4 mm tube to the Adapter PRO, previously mounted on the XT8. This completes the pneumatic connection.



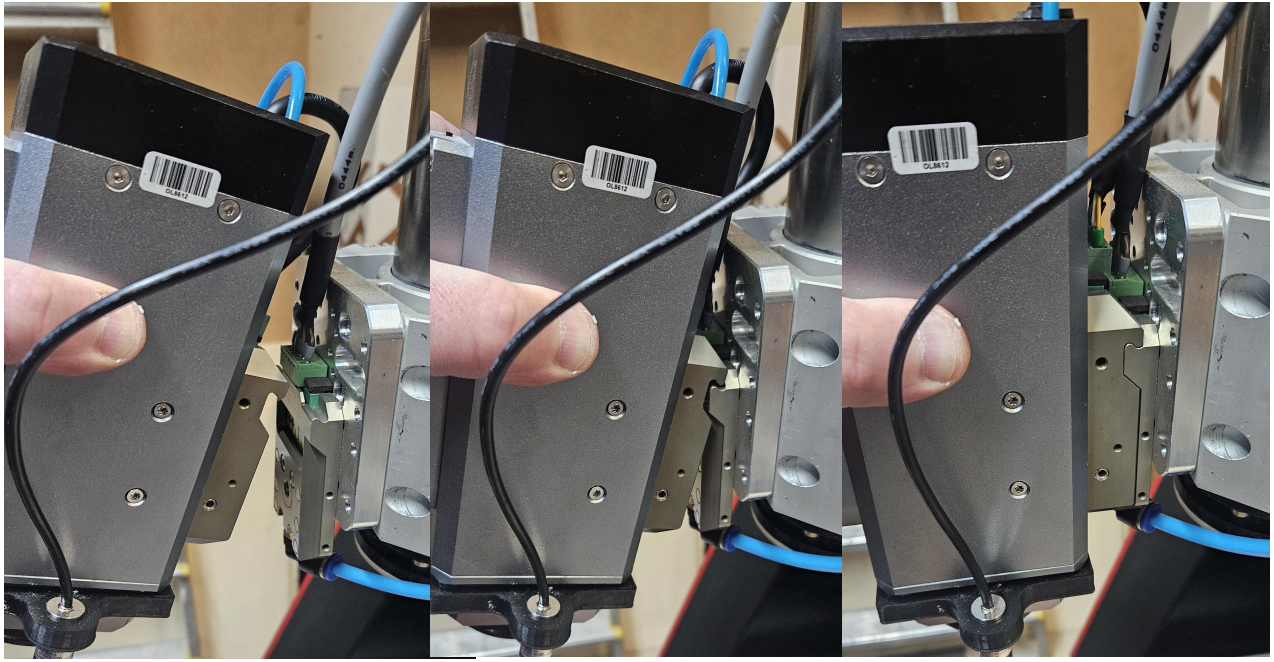
In the picture you can see the assembled XT8 Laser head.

For laser cutting, the airflow ranges between 5 and 15 liters per minute, while laser engraving requires a lower airflow, which we can estimate between 1 and 5 liters per minute. A compressor with a 5-liter tank is the minimum recommended size; a larger tank is preferable for stable airflow and reduced cycling. Don't forget to install a flowmeter between the compressor and the XT8, which will help you regulate the airflow.

To optimize air distribution, the KIT includes a plastic diffuser that can be mounted on the tip of the Laser.



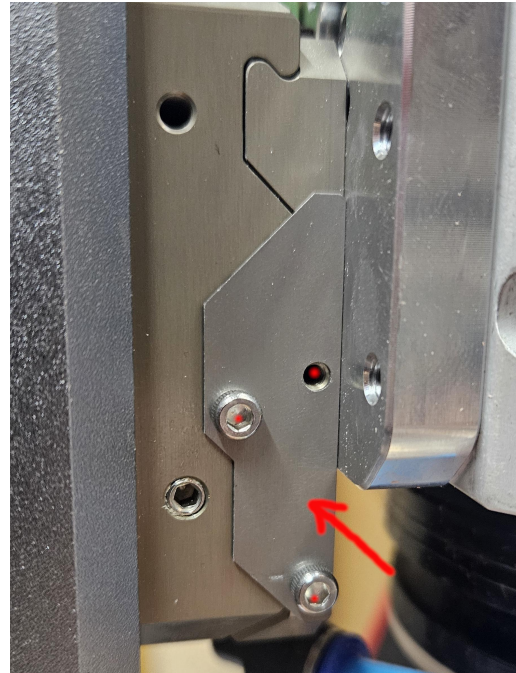
At this point, the Laser assembly on the CNC is finished - now all that's left is to attach it to our machine.



The laser head can be held in place by the magnetic system alone, which provides sufficient holding force for normal operation.

For additional mechanical safety, use the two small plates included in the kit. These plates secure the XT8 to the CNC with a few screws and prevent accidental detachment.

Before installation, mark the sides of the plates that will rest against the mounting surface to ensure correct and repeatable orientation.



The XT8 laser system is now ready for operation.

ELECTRICAL WIRING ON THE AXBB-E CONTROLLER AND UCCNC CONFIGURATION

The machine's cabinet is already equipped with a dedicated connector for the laser cable, with the AXBB-E controller wired internally and the cables connected to the appropriate pins.

For reference and verification, the following subsection describes the relevant connections.

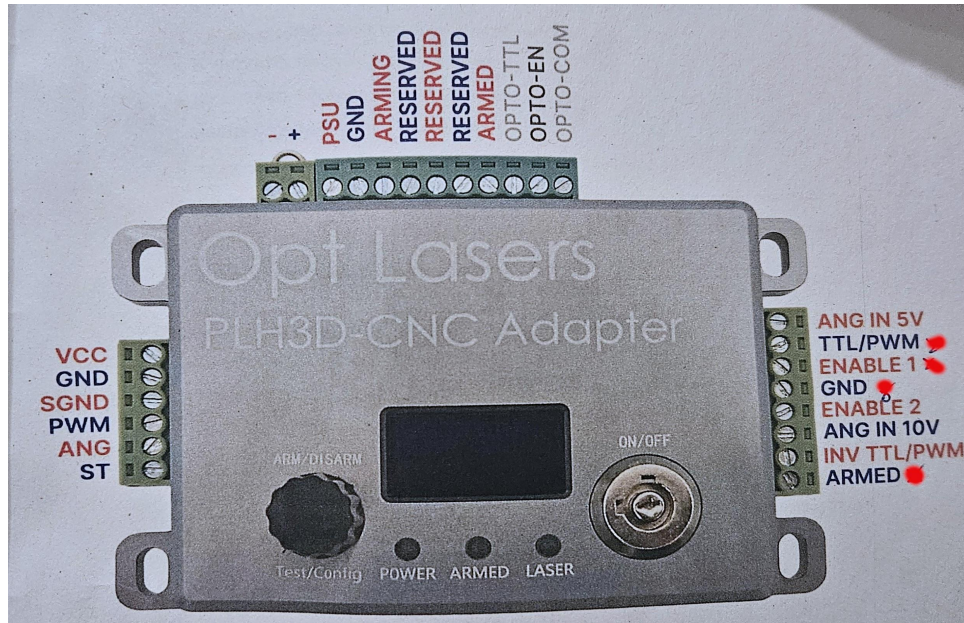
But since **I** am a curious person, I'll tell you what I found inside.



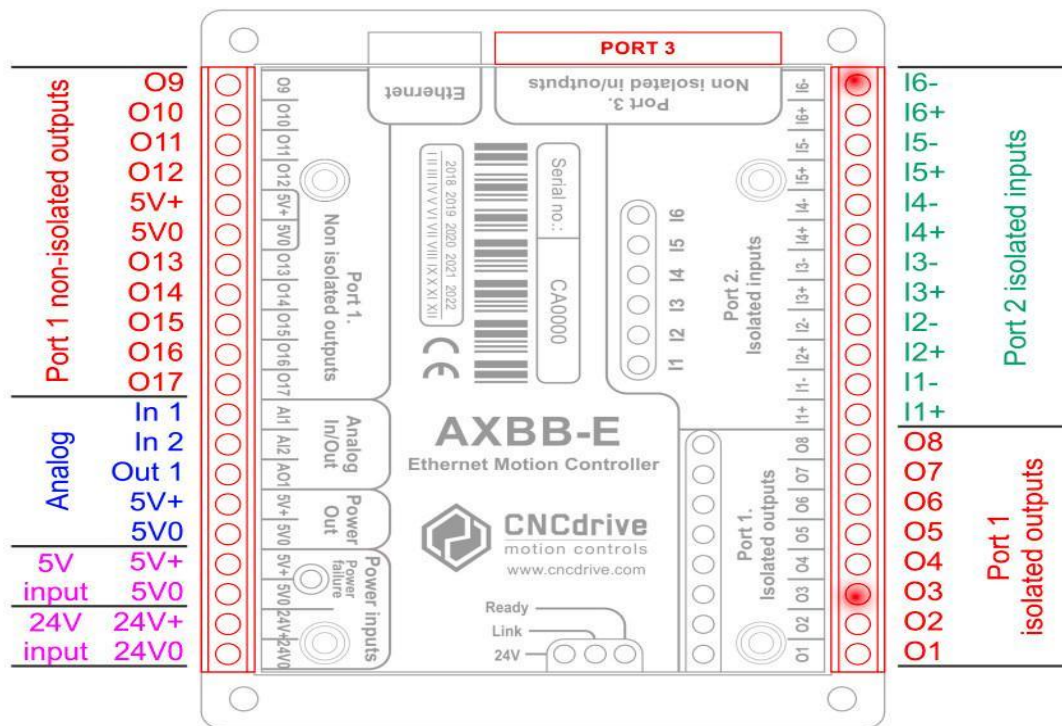
In the image above we can see where the AXBB-E Controller board is located inside the cabinet, while on the left side we can see four cables coming out for the Laser connector.

The cables are: **TTL/PWM, ENABLE 1, ARMED, GND**.

On the OPT LASER Adapter PRO control connector, these four cables correspond to: **PIN no. 8 (ARMED), PIN no. 3 (ENABLE 1), PIN no. 2 (TTL/PWM), PIN no. 4 (GND)**.



The **PIN no. 8 (ARMED)** cable is directly connected on the AXBB-E to **PIN (I16-)** on the **N2 inputs** port.



The **PIN no. 3 (ENABLE 1)** cable on the AXBB-E is instead connected to **PIN (3)** on the **N.1 outputs** port. This signal enables/disables the LASER control and is linked to the CNC activation relay when pressing **RESET** in the UCCNC interface.

Regarding the **TTL/PWM PIN no. 2** cable (with a maximum voltage of 24 volts), I can say that it is also connected to the main activation relay. Meanwhile, **PIN no. 4** is a **24-volt ground signal**.

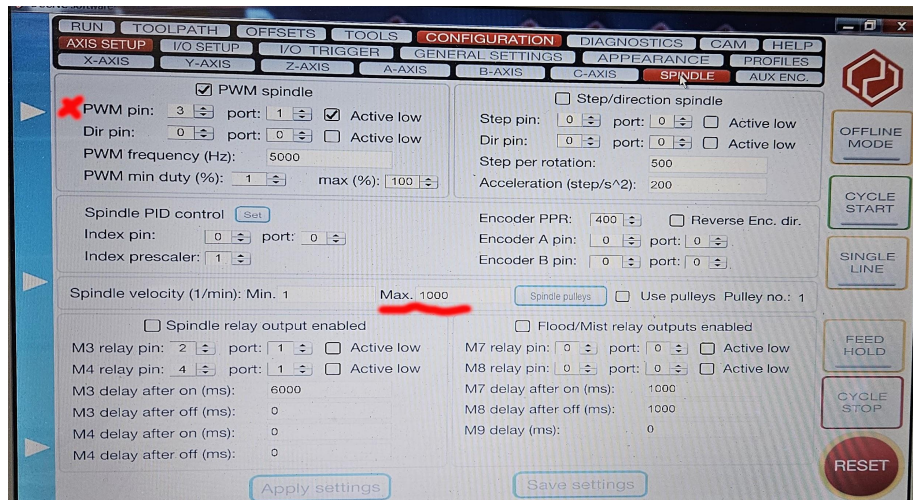
By looking at the wiring, it becomes clear that the 8-PIN control connector inserted into the **PLH3D-CNC PRO Adapter** actually uses only **4 connections**.

UCCNC:

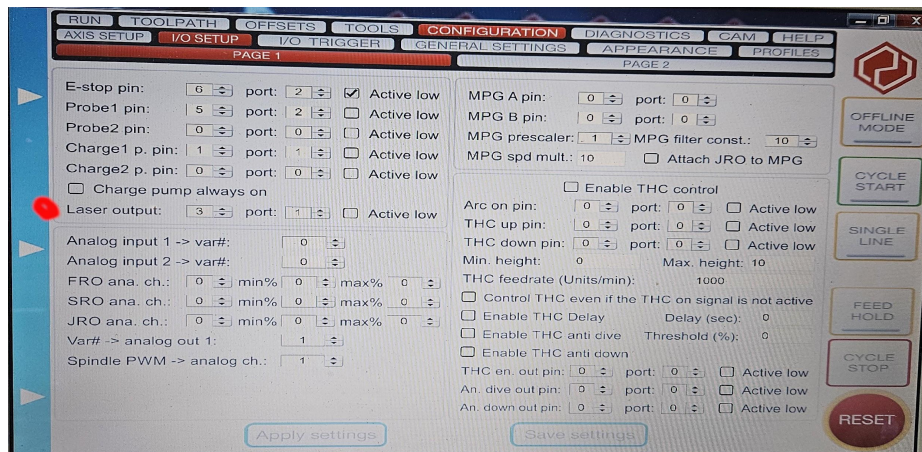
Configure UCCNC as follows:

- Open the configuration page and go to the **SPINDLE** subpage.
- Enable spindle control and enter the appropriate port number and PIN in the **PWM** section.

- Set the maximum speed value to **1000** to match the laser control range.



Next, open the **I/O PAGE 1** subpage and assign the correct port and PIN used for



the laser enable signal.

First Job: G-Code Example

```
;(Header)
M3
G0 X0 Y0
G90 ; absolute positions
G21 ; metric
;(Header end)
G0 X33.7441 Y21.5261 Z26.6000 F10000 M10 Q0
G1 X53.7441 Y41.5261 F1000 M10 Q255
```

G0 X33.7441 F10000 M10 Q0
G1 X53.7441 Y21.5261 F1000 M10 Q255
G0 X57.9859 Y31.5261 F10000 M10 Q0
G3 X77.9859 I10.0000 J0.0000 F1000 M10 Q255
G3 X57.9859 I-10.0000 J0.0000 M10 Q255
G0 X6.2419 Y15.5494 F10000 M10 Q0
G1 X6.7274 Y15.5345 F1000 M10 Q255
G1 X7.1987 Y15.4893 M10 Q255
G1 X7.6564 Y15.4144 M10 Q255
G1 X8.0986 Y15.3099 M10 Q255
G1 X8.5274 Y15.1749 M10 Q255
G1 X8.9407 Y15.0105 M10 Q255
G1 X9.3402 Y14.8158 M10 Q255
G1 X9.7250 Y14.5914 M10 Q255
G1 X10.0958 Y14.3366 M10 Q255
G1 X10.4515 Y14.0525 M10 Q255
G1 X10.7936 Y13.7377 M10 Q255
G1 X11.1137 Y13.4003 M10 Q255
G1 X11.4027 Y13.0495 M10 Q255
G1 X11.6622 Y12.6834 M10 Q255
G1 X11.8901 Y12.3043 M10 Q255
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G1 X12.2558 Y11.5029 M10 Q255
G1 X12.3932 Y11.0803 M10 Q255
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18
G1 X12.6214 Y9.7304 M10 Q255
G1 X12.6369 Y9.2524 M10 Q255
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G1 X12.4874 Y7.8106 M10 Q255
G1 X12.3709 Y7.3594 M10 Q255
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G1 X10.9757 Y4.9575 M10 Q255
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G1 X9.8881 Y4.0108 M10 Q255
G1 X9.4948 Y3.7609 M10 Q255
G1 X9.0876 Y3.5442 M10 Q255
G1 X8.6662 Y3.3614 M10 Q255
G1 X8.2301 Y3.2116 M10 Q255

G1 X7.7793 Y3.0949 M10 Q255
G1 X7.3129 Y3.0115 M10 Q255
G1 X6.8330 Y2.9616 M10 Q255
G1 X6.3398 Y2.9451 M10 Q255
G1 X5.8407 Y2.9616 M10 Q255
G1 X5.3574 Y3.0109 M10 Q255
G1 X4.8881 Y3.0935 M10 Q255
G1 X4.4342 Y3.2090 M10 Q255
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G1 X3.5707 Y3.5390 M10 Q255
G1 X3.1617 Y3.7532 M10 Q255
G1 X2.7659 Y4.0014 M10 Q255
G1 X2.3865 Y4.2813 M10 Q255
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G1 X1.6729 Y4.9391 M10 Q255
G1 X1.3554 Y5.3004 M10 Q255
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G1 X0.8194 Y6.0670 M10 Q255
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G1 X5.7146 Y15.5311 M10 Q255
G1 X6.2399 Y15.5494 M10 Q255

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19
G1 X5.7860 Y14.3516 F1000 M10 Q255
G1 X5.2980 Y14.2823 M10 Q255
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G1 X4.3936 Y14.0053 M10 Q255
G1 X3.9780 Y13.7979 M10 Q255
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G1 X7.8051 Y4.3123 M10 Q255
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G1 X80.8097 Y8.0345 M10 Q255
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G1 X81.5667 Y7.5215 M10 Q255
G1 X81.8474 Y7.2708 M10 Q255
G1 X82.0627 Y7.0242 M10 Q255
G1 X82.2591 Y6.7045 M10 Q255
G1 X82.3993 Y6.3654 M10 Q255
G1 X82.4834 Y6.0069 M10 Q255
G1 X82.5115 Y5.6293 M10 Q255
G1 X82.4733 Y5.1561 M10 Q255
G1 X82.3588 Y4.7174 M10 Q255
G1 X82.1679 Y4.3132 M10 Q255
G1 X81.9003 Y3.9429 M10 Q255
G1 X81.5619 Y3.6125 M10 Q255
G1 X81.1832 Y3.3527 M10 Q255
G1 X80.7679 Y3.1671 M10 Q255
G1 X80.3159 Y3.0557 M10 Q255
G1 X79.8279 Y3.0185 M10 Q255
G1 X79.3967 Y3.0457 M10 Q255
G1 X78.9767 Y3.1272 M10 Q255
G1 X78.5671 Y3.2631 M10 Q255
G1 X78.1719 Y3.4517 M10 Q255
G1 X77.8117 Y3.6841 M10 Q255
G1 X77.4907 Y3.9584 M10 Q255
G1 X77.2089 Y4.2745 M10 Q255
G1 X77.9266 Y5.0907 M10 Q255
G1 X78.2799 Y4.7354 M10 Q255
G1 X78.6420 Y4.4589 M10 Q255
G1 X79.0123 Y4.2614 M10 Q255
G1 X79.3911 Y4.1431 M10 Q255
G1 X79.7783 Y4.1035 M10 Q255
G1 X80.2047 Y4.1514 M10 Q255

G1 X80.5897 Y4.2949 M10 Q255
G1 X80.9378 Y4.5338 M10 Q255
G1 X81.2076 Y4.8442 M10 Q255
G1 X81.3716 Y5.1929 M10 Q255
G1 X81.4264 Y5.5798 M10 Q255
G1 X81.3469 Y6.0431 M10 Q255
28
G1 X81.1084 Y6.4529 M10 Q255
G1 X80.8992 Y6.6529 M10 Q255
G1 X80.5903 Y6.8772 M10 Q255
G1 X80.1814 Y7.1261 M10 Q255
G1 X79.6727 Y7.3992 M10 Q255
G1 X79.2234 Y7.6468 M10 Q255
G1 X78.8357 Y7.8928 M10 Q255
G1 X78.5094 Y8.1375 M10 Q255
G1 X78.2445 Y8.3810 M10 Q255
G1 X78.0410 Y8.6230 M10 Q255
G1 X77.8517 Y8.9356 M10 Q255
G1 X77.7165 Y9.2696 M10 Q255
G1 X77.6356 Y9.6250 M10 Q255
G1 X77.6085 Y10.0016 M10 Q255
G1 X77.6519 Y10.4893 M10 Q255
G1 X77.7821 Y10.9324 M10 Q255
G1 X77.9990 Y11.3317 M10 Q255
G1 X78.3027 Y11.6871 M10 Q255
G1 X78.6707 Y11.9776 M10 Q255
G1 X79.0829 Y12.1854 M10 Q255
G1 X79.5392 Y12.3098 M10 Q255
G1 X80.0392 Y12.3514 M10 Q255
G0 X27.8161 Y21.5261 F10000 M10 Q0
G1 X7.8161 F1000 M10 Q255
G1 Y41.5261 M10 Q255
G1 X27.8161 M10 Q255
G1 Y21.5261 M10 Q255
G0 X0.0000 Y0.0000 F10000 M10 Q0
;(Footer)
M5
M11 ; Disable laser
G21
G90
G0 X0 Y0
M30
;(Footer end)

