

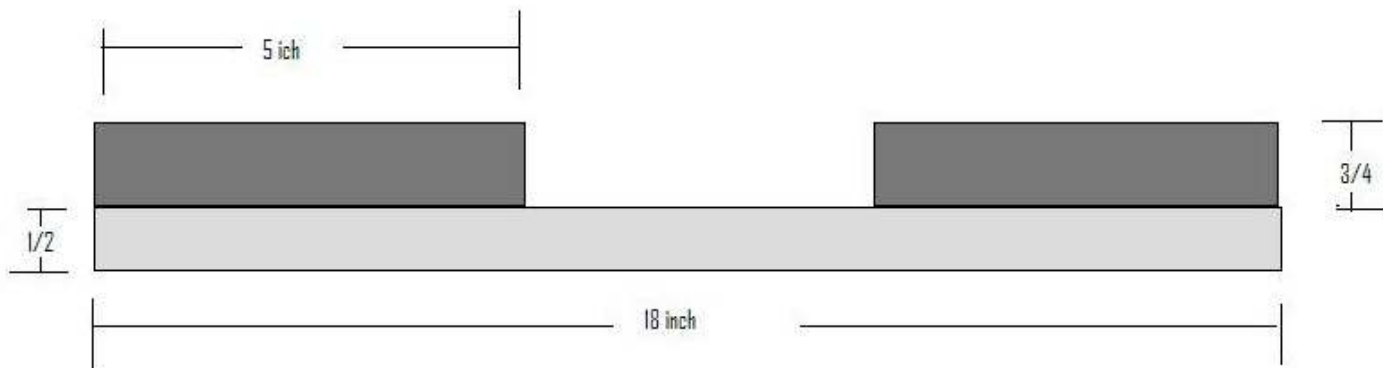
## 5 x7 Lithophane Tutorial

– Instructions by Troy –  
aka “CustomWestCoast” on the CarveWright User Forum

These instructions are how I make a 5X7 lithophane. You must make a carrier board to hold the  $\frac{1}{4}$  inch Corian you are going to carve. The way I made my carrier is also used to make the frame that will hold the Litho for you end product. I make my frame out of 1 inch Red Oak. You can use any type of wood but I prefer the Red Oak. Just remember that when you buy your wood, it will say 1 inch thick but in all reality it is closer to  $\frac{3}{4}$  inch thick.

For a 5x7 litho you will need a 6x8 piece of Corian. This will give you a  $\frac{1}{2}$  inch edge around the carved section.

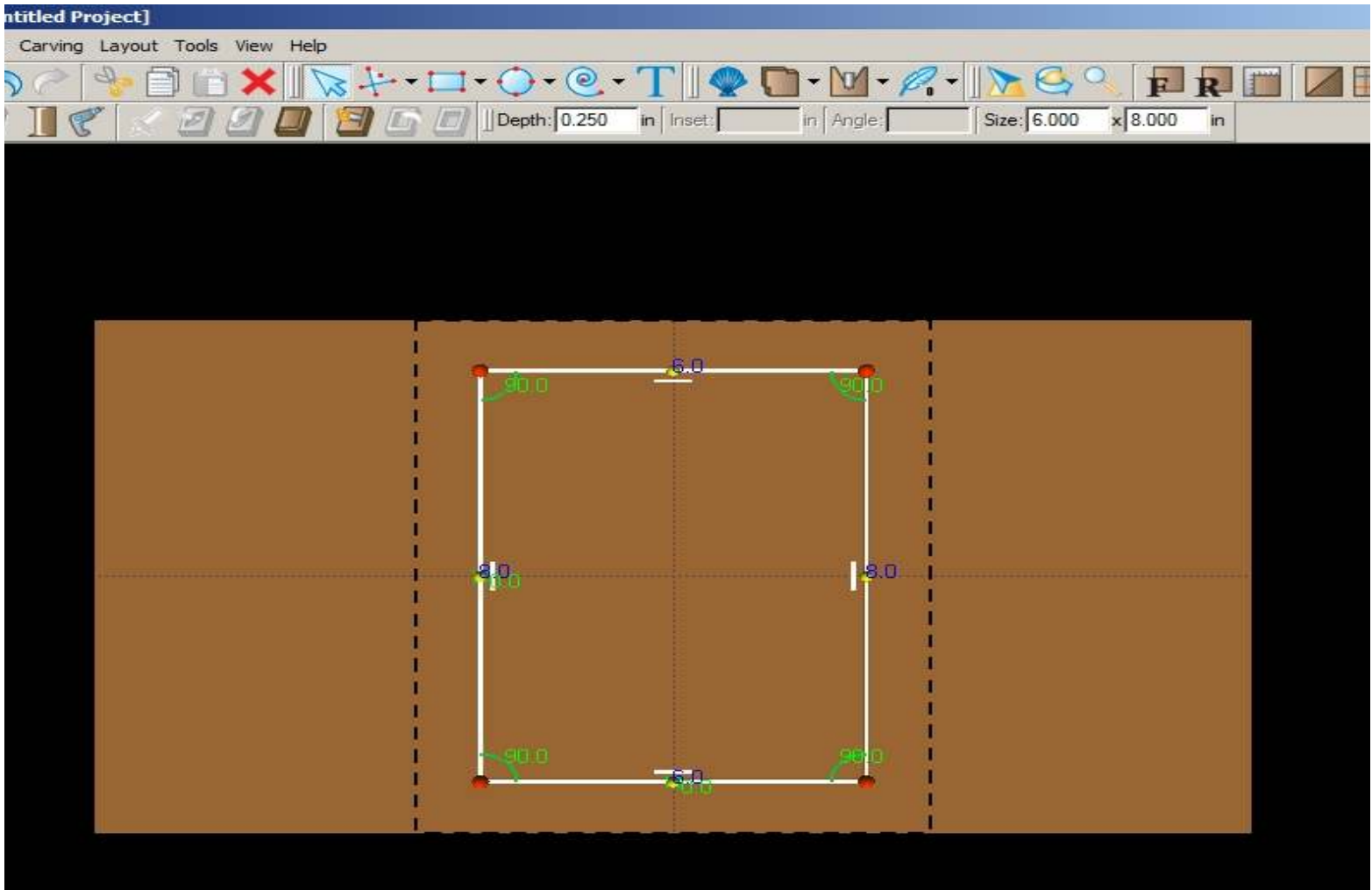
As for the carrier, you will need an 18x10x  $\frac{1}{2}$  bottom and (2) 5x10x $\frac{3}{4}$  for the top. See graphic.

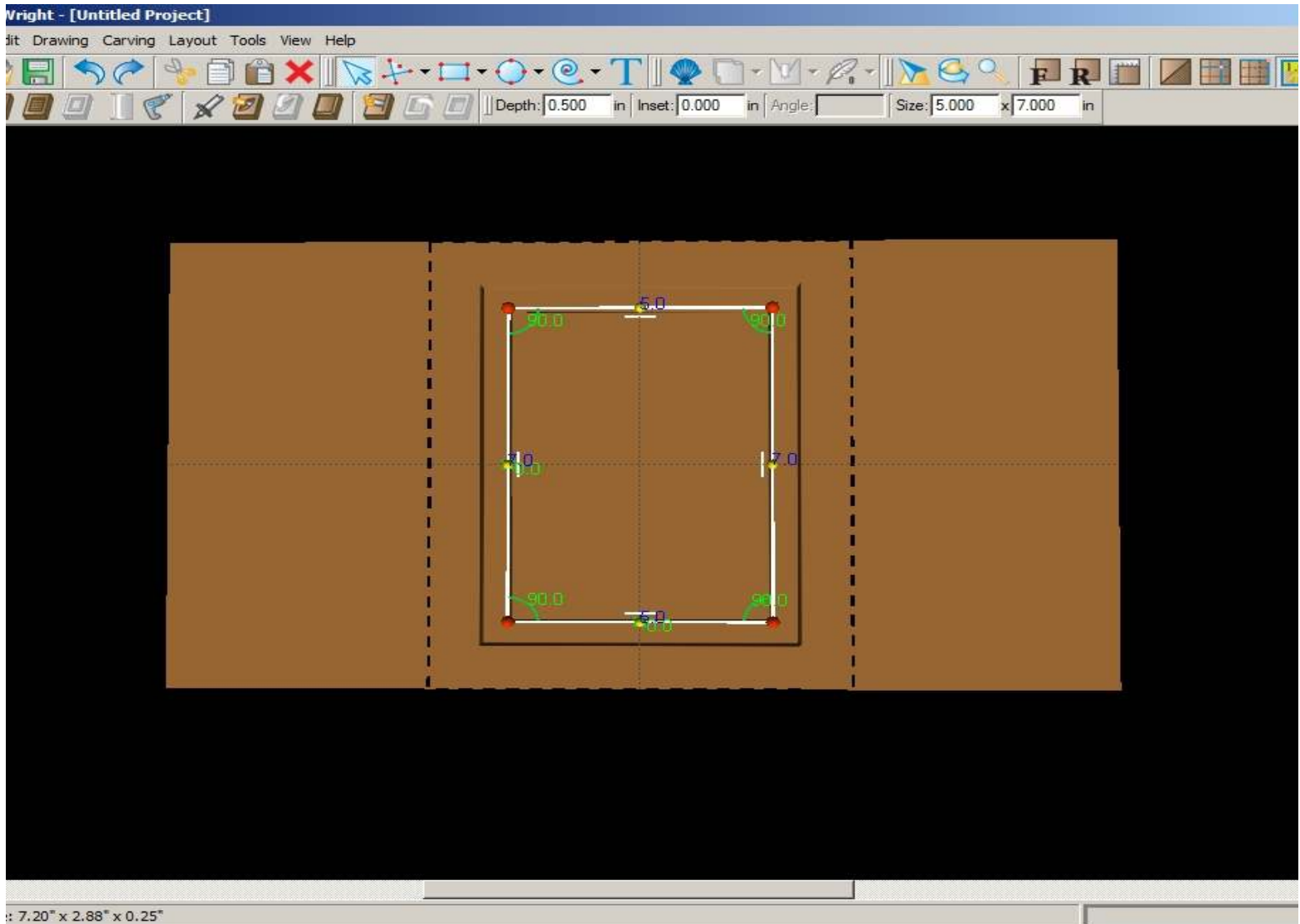


The white section in the middle of the carrier is where you will place your 10x8x  $\frac{3}{4}$  board. This will later become your frame for the finished litho.

You have to place a piece of double sided tape on the middle of your board. Now you can load your board on the carrier. The double sided tape is set on the board so you can carve out the picture window of the frame and avoid the cut out from flying out of the carrier. Be sure to keep that 5x7 carved out piece for later use.

Once in your CC program, set your board setting at 18x10x1. Now you have to program for a carve region which will hold your litho when it comes time to carve the litho. Your carve region should be set at 6x8 with a depth of 0.250 This depth will later hold your Corian in place. Then you want to program a square within the carve region at 5x7 with a depth of 0.500 This is your picture window of the wood frame. The dotted line outside the carve region is just for reference of where your actual frame located. Be sure to align center on all carvings.





Once that is complete you now have your picture frame and litho jig for carving your Corian. Be sure to save your MPC from the above graphic. It will make things a lot easier for future uses.

Now for importing photos and carving the litho. Make sure your photo is at least 300dpi. Any lower resolution photo will not carve well and blur.

Take your photo into a photo editor program. If you have Microsoft Office suite, it has a built in photo editor. The first thing you want to do is change the photo into grayscale.

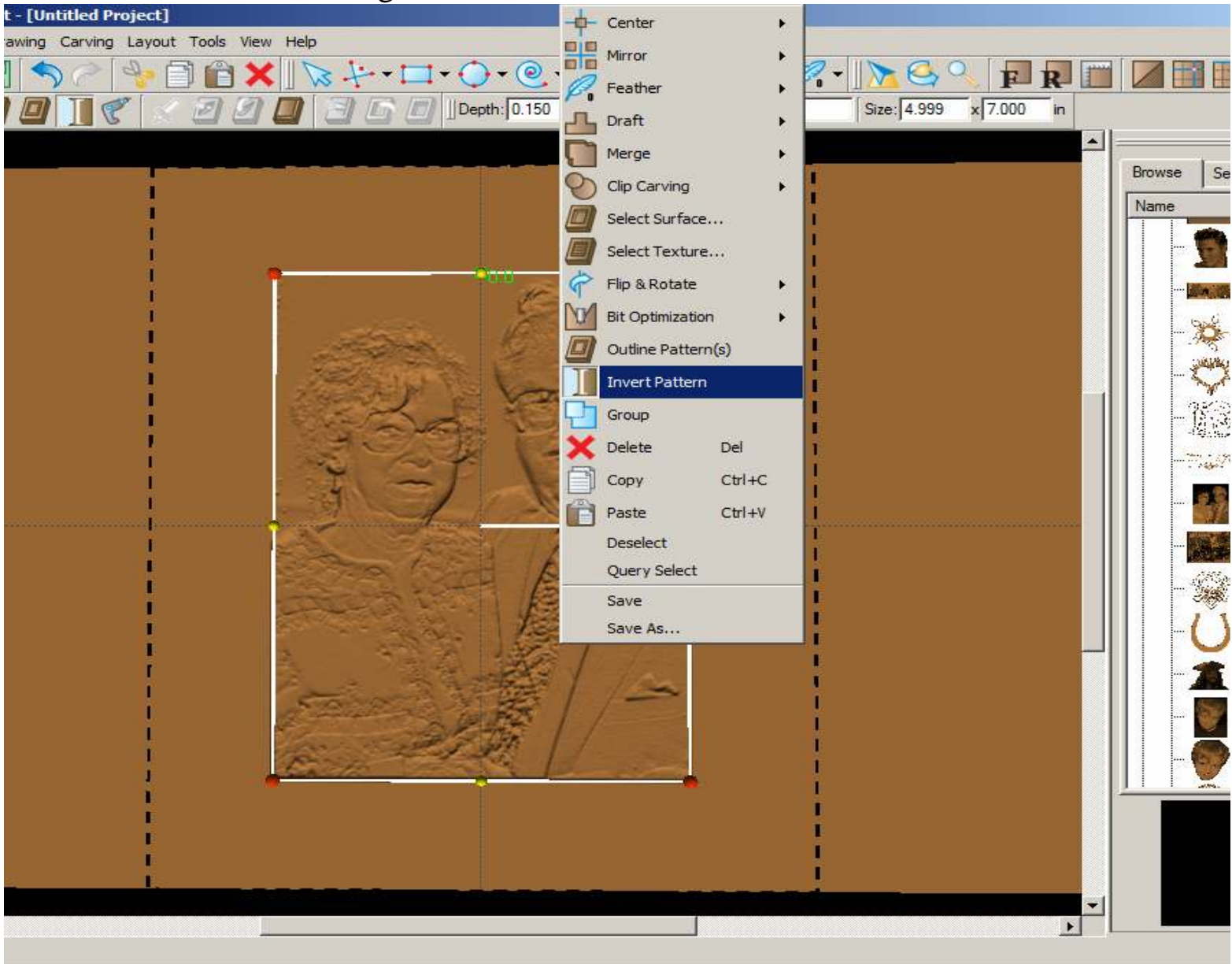
Here is where some people say you don't have to do the next step but I prefer to because it sharpens the photo when you carve it out. You take the grayscale photo and turn it into a negative or invert colors (depending on your photo software). Once that is done you save the photo with a file extension as .png. If you keep it as a jpeg or bmp you will have some bumps appear on your carving.



Now you can import the photo in your CC program. Go ahead and save it as a pattern so you can load it into your MPC.

The following section is going to show you how to carve the litho on an MPC file. Open up the file you saved from carving out the photo frame. Now you can delete the carve region and picture window of the saved MPC. Move your newly created PTN onto the board in the MPC. Even though your Corian is 6x8, you will

size your PTN as 5x7 and center align on the board. Set your depth at 0.150 and height at 400.



You are now ready to upload your MPC onto the card. When you do the upload make sure to save the quality as best. Then load your card.

Now place your Corian on your carrier where the carve region has but cut out. Load the card into the machine and select the MPC to

carve. When the screen asks to keep under rollers, just check “No”. The machine should ask for the 1/16” carve bit and then it should carve the litho within an hour or less depending on the detail of the carving. These instructions will make a litho with the carving on the front of the Corian. Some say that they want the carving on the back of the litho with the smooth part facing out. You lose a lot of detail with the smooth part facing out and more people are amazed when they can feel the 3D carving when it is facing out.

During the carving process, be sure to blow out the Corian shavings once every 5 minutes. If you do not blow out the shavings, they will get underneath the carving bit and cause unwanted lines.

Once your Litho is finished you can remove the entire frame and Litho. Remove the litho and face the carving towards the picture window. You now have a litho and custom frame. Later if you want you can rout the entire edge of the frame and/or carve lettering on the front of the frame.



< Actual Litho carved out from  
Above photos and directions.  
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