

MDF Wood Products – Fabrication Options

JOHNSONPLASTICS
PLUS

MDF Wood Products - Laser Engraving

HD105FW | HD104FW | HD103FW | HD101FW | HD106FW | HD107FW | HD109FW | HD110FW |
HD112FW | HD113FW | HD114W | HD115FW | HD116FW | HD125FW | HD126FW | HD127W |
HD129I | HD130FW | HD131FW | HD132FW | HD133FW | HD150W | HD151FW | HD154FW |
HD156FW | HD157FW | HD158FW | HD159FW | HD160FW | HD161FW | HD162FW | HD163FW



GENERAL LASER ENGRAVING PROCESS

Recommended Equipment & Accessories

- CO2 Laser Engraver
- Clean Towel
- Isopropyl Alcohol

Recommended Settings- Laser Engraving	
50-60W lasers	
Laser Power	35-50%
Laser Speed	70-80%
Resolution (DPI/PPI)	500-600

General Laser Engraving Instructions

- Place the wood blank onto the laser bed and align to the zero point on the laser bed.
- Adjust the laser focus to the surface of the wood blank.
- Once the artwork is positioned, engrave using the suggested starting settings.
 - Settings may need adjusted depending on the laser tube wattage.
- When finished, remove the wood blank from the laser bed.
- If cleanup is needed, wipe the surface with a clean cotton cloth lightly misted with isopropyl alcohol.

Tips and Tricks

- To help with artwork placement, utilize the product template for this item, found on the item's product page on jpplus.com/.

Troubleshooting

- The engraving is too shallow.
 - Laser power setting and/or resolution may need to be increased.
 - Laser speed setting may need to be decreased.
 - Check laser focus.
 - Check and clean laser lenses and mirrors.
 - Check laser alignment. (see laser users manual on how to check and adjust laser beam alignment)
- The engraving is too deep.
 - Laser power setting and/or resolution may need to be decreased.
 - Laser speed setting may need to be increased.

- The engraved area is charring/melting.
 - Laser power setting and/or resolution may need to be decreased.
 - Laser speed setting may need to be increased.
 - The edges along the laser cut line are curling.
 - Laser power setting may need to be decreased.
 - Laser speed setting may need to be increased.
 - Use a laser cutting ("honeycomb") grid insert to set the product up off of the solid metal laser bed.
 - Use air assist if available.
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Templates and Images

- Visit jpplus.com to find the product page for this item. The product template may be found under the Tech Docs and Downloads area of the page.
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To order more of this product, see similar products and much more, please visit jpplus.com.

For additional product support and troubleshooting, please contact JPPlus Advanced Support Team:

- Phone: 419-500-4877
- Email: ast@jpplus.com
- Schedule an appointment: <https://jpplusadvancedsupport.setmore.com/>