

## Saddle Collection Items- Laser Engraving

**JOHNSON**PLASTICS  
PLUS

### SADDLE COLLECTION ITEMS - Laser Engraving

SCF172 | SCF175 | SCF178 | SCF179 | SCF188 | SCF189 | SCF245 | SCF248 | SCF249 | SCF352 | SCF355  
| SCF358 | SCF358 | SCF359 | SCF772 | SCF775 | SCF778 | SCBT1 | SCBT2 | SCBT5 | SCBT8 | SCBT9 |  
SCR2 | SCR5 | SCR8 | SCR9 | SCPC1 | SCPC5 | SC011 | SC012 | SC015 | SC018 | SC019 | SCGT1 |  
SCGT2 | SCGT5 | SCP11 | SCP12 | SCP15 | SCP18 | SCP19 | SCF172 | SCF175 | SCF178 | SCF179 |  
SCF772 | SCF775 | SCF778 | SC071 | SC072 | SC075 | SC078 | SC079



## GENERAL LASER ENGRAVING PROCESS

### Recommended Equipment & Accessories

- CO2 Laser Engraver
- Clean Towel
- Alcohol

<b>Recommended Settings- Laser Engraving</b>	
<b>30-40W lasers</b>	
Laser Power	35-40%
Laser Speed	70-80%
Resolution (DPI/PPI)	500-600

<b>Recommended Settings- Laser Engraving</b>	
<b>50-60W lasers</b>	
Laser Power	25-30%
Laser Speed	70-80%
Resolution (DPI/PPI)	500-600

<b>Recommended Settings- Laser Engraving</b>	
<b>75W lasers</b>	
Laser Power	15-20%
Laser Speed	70-80%
Resolution (DPI/PPI)	500-600

### **General Laser Engraving Instructions**

- Place the saddle product onto the laser bed and align to the zero point on the laser bed.
  - For best results, some Saddle Collection items may work best with the use of a jig to help hold the engraving surface as flat as possible for optimal laser focus.
- Adjust the laser focus to the surface of the saddle product.
- Once the artwork is positioned, engrave using the suggested starting settings.
  - Settings may need to be adjusted depending on the laser tube wattage.
- When finished, remove the saddle product from the laser bed.
- If cleanup is needed, wipe the surface with a clean cotton cloth lightly misted with isopropyl alcohol.

## GENERAL LASER CUTTING PROCESS

### Recommended Settings- Laser Cutting (sheets only)

#### 35W lasers

Laser Power	25-30%
Laser Speed	20-25%
Frequency (Hz)	1000-2500

### Recommended Settings- Laser Cutting (sheets only)

#### 50-60W lasers

Laser Power	20-25%
Laser Speed	15-20%
Frequency (Hz)	1000-2500

### Recommended Settings- Laser Cutting (sheets only)

#### 75W lasers

Laser Power	15-20%
Laser Speed	15-20%
Frequency (Hz)	1000-2500

### General Laser Cutting Instructions

- Place the saddle product onto the laser bed and align to the zero point on the laser bed.
  - For best results, some Saddle Collection items may work best with the use of a jig to help hold the engraving surface as flat as possible for optimal laser focus.
- Adjust the laser focus to the surface of the saddle product.
- Once the artwork is positioned, engrave using the suggested starting settings.
  - Settings may need to be adjusted depending on the laser tube wattage.
- When finished, remove the saddle product from the laser bed.
- If cleanup is needed, wipe the surface with a clean cotton cloth lightly misted with isopropyl alcohol.

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### 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/](http://jpplus.com/).

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## 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](http://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](http://jpplus.com).**

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

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