

## MDF Wood Products

**JOHNSON**PLASTICS  
PLUS

### MDF WOOD PRODUCTS - UVLED Printing

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 UVLED PRINT PROCESS

### Recommended Equipment & Accessories

- UVLED printer
- Clean Towel
- Glass cleaner
- Optional: Tacky mat

Recommended Settings	
Ink Type	Hard Ink
UV Lamp	100%

### General UVLED Printing Instructions

- Place the product on the printer bed. If necessary, use of a jig or tacky mat is recommended to help hold the product.
- Focus the print head to the surface of the product.
- Place the printer into print-ready position and send the job to the printer.
- When finished, remove the product from the printer bed.
- Allow 24 hours for the UV ink to fully cure.

**Note:** Products are not recommended for use with food after the image has been printed.

---

### 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/).
- Create or employ a jig to help hold the product for easier positioning and faster changeovers when UV printing high volumes.

---

### Troubleshooting

- The image scratches off easily.
    - Printing white only, or printing white with color will usually not have as high of an adhesion strength as printing color-only, even with the use of adhesion promoter.
    - Allow 24 hours for the UV ink to fully cure and to achieve maximum adhesion strength.
    - Increase the UV lamp setting if it is not already set to 100%.
    - Some materials used on components of some products may not be well-suited for high adhesion strength on UVLED print technology.
  - The image is fuzzy, has fuzzy edges, or appears blurry.
    - The print head may be slightly out of focus with the surface of the product.
    - If printing on a curved product surface, the curvature of the product may be out of focus of the print head.
    - Run a nozzle check on the printer to ensure that all print nozzles are firing properly during printing.
-

### **Templates and Images**

- Visit [jpplus.com](https://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.
- 

**To order more of this product, see similar products and much more, please visit [jpplus.com](https://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/>