Premium No Odor/Low Odor Laser Rubber

PREMIUM NO ODOR/LOW ODOR LASER RUBBER - Laser Engraving/Cutting

RPO035 | RUS001

GENERAL LASER ENGRAVING PROCESS

Recommended Equipment & Accessories

- CO2 Laser Engraver (equipped with air assist recommended)
- Warm water and mild dish soap
- Small scrubbing brush, sponge or tooth brush
- Utility Knife

Recommended Settings- Laser Engraving	
50-60W lasers	
Laser Power	100%
Laser Speed	10-15%
Resolution (DPI/PPI)	500-600
Air Assist (if available)	Enable for Raster Engraving **(Important!!)**
Engraving Direction	Bottom-UP engraving **(Important!!)**

General Laser Engraving Instructions

- Place rubber stamp material onto laser bed at zero point.
- Focus laser to the surface of the rubber stamp material.
- Align artwork so that the engraving will be within the stamp material.
- Set artwork fill color to be RGB Black (R=0, G=0, B=0).
- Send the artwork to the laser using the recommended settings.
    - **IMPORTANT:** Running air assist for raster engraving and engraving in the "bottom-up" direction is very important for successful results!
    - If available, use the Stamp option/feature in the laser settings within the laser driver and/or laser setup software. Set the Shoulder to medium or mid-level threshold to give the graphics stability when pressing with the stamp. Set Widening to low or off.
        - Laser settings mentioned here are relative and may need adapted and/or tested on your laser to find best results.
        - Shoulder and Widening settings are used to create stability and maintain integrity of the graphic when the stamp is used. Shoulder/Widening settings may need to be increased to gain better stability, or decreased/turned off to maintain higher detail in the graphic. Testing may need to be done in order to find the best settings for your application.
        - During engraving, rubber material may "gum up" within the engraved area. This is normal and will wash off during the clean-up stage of fabrication.
    - Note: It is normal for the rubber material to "gum up" within the engraved area as the laser engraving progresses along.
    - Note: Recommended engraving depth for optimal stamp performance is 0.040".
- When finished, take the stamp sheet out of the laser.
- Use a utility knife, razor blade, or manual cutter to cut the stamp out of the rubber sheet.
    - Optional: A score line can be laser cut into the rubber sheet material to help start a cutout of the stamp from the rubber sheet. See "General Laser Cutting Process" below.

GENERAL LASER CUTTING PROCESS

Recommended Settings- Laser Cutting	
50-60W lasers	
Laser Power	50-60%
Laser Speed	15-20%
Frequency (Hz)	1,000-1,500

General Laser Cutting Instructions (Optional)

- Optional: Once stamp has engraved, send the cut/score lines to the laser. Settings 60P, 20S.
  - In most cases, the laser will not cut completely through the rubber. This step is optional and intended to create a score line, which serves as a cutting guide for the stamp to then be cut out with a razor blade or manual cutter.
- Take stamp sheet out of the laser.
  - If the stamp did not cut through all the way, use a razor blade or manual cutter to cut the stamp out the rest of the way.

GENERAL CLEANUP PROCESS

- Use a dish sponge, brush, and dish soap with warm water to clean out the debris from the engraved areas of the stamp. Dry off stamp with a paper towel.
- If available, use compressed air to dry out water completely from small crevices in the engraved areas and to blow out any remaining debris.

GENERAL STAMP MOUNTING PROCESS

- Use a glue or double-sided adhesive that is rated for rubber stamp use to adhere the stamp to the handle.

GENERAL STAMP TESTING PROCESS

- Press the stamp into an inkpad several times until all artwork is coated evenly with ink.
- Press the inked stamp onto a clean piece of white copy paper with even pressure to test functionality of the stamp.

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 graphic appears smeared or misshapen in the small/thin parts of the graphic when the stamp is inked and pressed onto a surface.
- The small/thin parts of the graphic may be too small/thin to allow proper integrity of the stamp material with under pressure during the pressing process.
- If possible, widen the small/thin areas of the graphic manually within the artwork to help add structural integrity to the rubber, so that it will better handle pressure while the stamp is being used.
- If available, use the Rubber Stamp feature/function of the laser driver or laser software to create or set up a Shoulder width to be incorporated into the engraving.
  - Using a Shoulder setting will taper the rubber material gradually wider after the initial small/thin portion of the graphic is engraved. This process automatically adds structural integrity to the stamp surface, so that it will better handle pressure while the stamp is being used.

Templates and Images

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