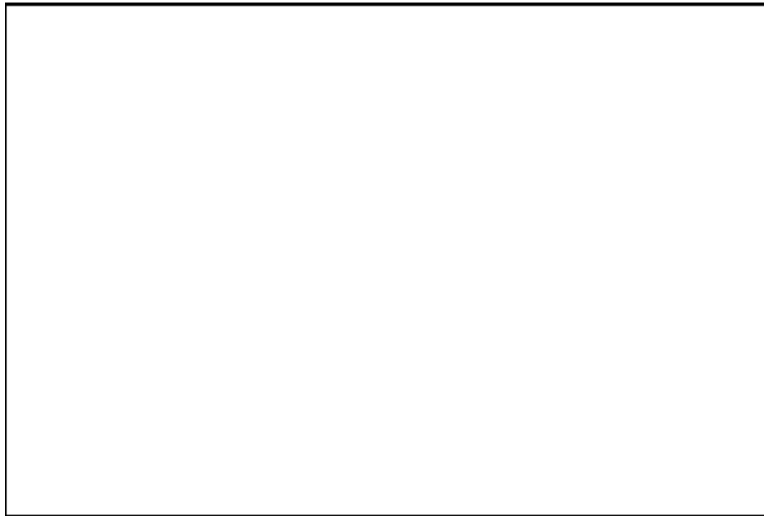


# Sublimation Cast Acrylic Sheet



**SUBLIMATION CAST ACRYLIC SHEET - HOBBY Laser Cutting**



## GENERAL LASER CUTTING PROCESS

### Recommended Equipment & Accessories

- Hobby CO2 Laser Engraver/cutter
- Clean Towel
- Plastic Cleaner

Recommended Settings- Laser Cutting- Glowforge	
30-40W lasers	
Laser Power	100% (max)
Laser Speed	125
Passes	1

### General Laser Cutting Instructions

- **For best results, it is recommended to sublimate first and then laser cut after sublimation.**
- Place the acrylic sheet with image layer face up onto the laser bed, and if needed align to the zero point of the laser bed.
  - For best results, leave protective masking on the clear side of the acrylic sheet.
  - Optional: Attach paper masking to the image side of the sheet before laser cutting to help protect the material along the cut edges.
- Adjust the laser focus to the surface of the sheet.
  - Some hobby laser systems automatically autofocus. In such cases, manual focus of the laser is not required.
- Align the laser cut artwork to the desired cutout position on the acrylic sheet.
- Once the artwork is positioned, send the cut job to the laser using the suggested starting settings.
  - Settings may need adjusted depending on the laser tube wattage.
- When finished, remove the sheet and cutout(s) from the laser bed.
- If cleanup is needed, wipe the surface with a clean cotton cloth lightly misted with a plastic cleaner.

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### Tips and Tricks

- To help reduce flame up, utilize air assist during laser cutting if the laser is equipped with this feature.
- To help protect the clear surface of the acrylic, utilize a laser cutting grid insert on the laser bed when vector cutting.

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### Troubleshooting

- 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](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.

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