Acacia 3” Round Gift Box

Acacia 3” Round Gift Box - Laser Engraving/Cutting

PRODUCT # ACAWB3

GENERAL LASER ENGRAVING PROCESS

Recommended Equipment & Accessories

- CO2 Laser Engraver
- Clean Towel
- Isopropyl Alcohol

Recommended Settings- Laser Engraving	
50-60W lasers	
Laser Power	30-40
Laser Speed	50-60
Resolution (DPI/PPI)	500-600

General Laser Engraving Instructions

- Place the cutting board onto the laser bed and align to the zero point on the laser bed.
- Adjust the laser focus to the surface of the product.
- 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 cutting board 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.
- Higher perceived contrast can be created by increasing engraving depth with higher engraving power and/or lower engraving speeds.
- To create airbrushed or paint-filled color engraving, apply masking to the surface of the cutting board and engrave through the masking.
  - Laser settings may need to be increased to compensate for the extra masking layer.
  - Paint or airbrush the engraved areas first and let dry. Remove masking when dry.

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.

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.

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: jpplusadvancedsupport.setmore.com/