

Round Whiskey Decanter Set



Round Whiskey Decanter Set - Laser Engraving/Cutting

PRODUCT # EWDS299



GENERAL LASER ENGRAVING PROCESS

Recommended Equipment & Accessories

- CO2 Laser Engraver
- **Recommended:** Blazer Orange Laser Mask – OL6X100ROLL or OL12X100ROLL
- Clean Towel
- Isopropyl Alcohol
- Optional: Normal copy paper or paper towel
- Water or Window Cleaner
- Mild abrasive cleaning pad (ex. 3M Scotch-brite scouring pad)

Recommended Settings- Laser Engraving	
50-60W lasers	
Laser Power	70-80%
Laser Speed	20-30%
Resolution (DPI/PPI)	500-600 DPI

General Laser Engraving Instructions

- Use a clean cloth lightly misted with isopropyl alcohol or window cleaner to wipe down the surface of the glass product to ensure any dust, oils, grease, etc. are removed.
- Cut a piece of masking material to size to fit over the engravable area of the glass.
 - For best results, it is recommended to utilize the Blazer Orange Laser Masking-OL6X100ROLL or OL12X100ROLL.
 - As an alternative to using the Blazer Orange Laser Mask, apply a piece of wet paper towel or paper to the surface of the glass that will be engraved on.
 - Gently run your finger over the wet paper/towel to remove any air bubbles that may be underneath the paper/towel.
 - It is important to work efficiently to get the paper/towel set up and engraved quickly to prevent the paper/towel from drying out before the laser engraving is complete.
- Place the glass product with masking applied onto the laser bed and position to the zero point/starting point on the laser bed.
- Adjust the laser focus to the surface of the glass product.
 - Be careful not to move the masking while focusing the laser to prevent air bubbles or wrinkles forming underneath the masking.
- When setting up the artwork for engraving in the layout software, make sure to set the color fill of the engraved areas to “RGB 70% Black”.
- Once the artwork is set up and positioned, engrave using the suggested starting settings.
 - Settings may need adjusted depending on the laser tube wattage.
 - **IMPORTANT:** If a wet paper/towel is used as masking, the masking must stay wet during the entire engraving process.
- For large engraved areas, ensure that the paper/towel layer does not dry out while the engraving is still running. If the paper/towel dries before the engraving is finished, the engraving job may need to be paused so that the paper/towel can be wet again with water or window cleaner.
- When finished, remove the glass product from the laser bed.
- Remove the masking from the surface and discard.
- Wipe off the engraved areas using a mild abrasive cleaning pad (ex. 3M Scotch-brite scouring pad).
- If window cleaner was used to spray the paper/towel, run the glass product under water to rinse of any residual window cleaner and then dry with a clean cloth or towel.

- To realize the full contrast/brightness of the engraved area, allow the engraved area to air dry for several minutes.
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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.
 - 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.
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Troubleshooting

- The engraving is too light.
 - The laser power may need to be increased.
 - The laser speed may need to be decreased.
 - Check to ensure that the laser is focused properly to the surface of the wet paper/towel.
 - Make sure that the fill color of the artwork is set to 80% RGB Black. Engraving using the traditional 100% RGB Black will not produce enough micro-fracturing of the glass surface and therefore will not create as much contrast in the frosted appearance of the engraving.
 - The engraving looks good, but glass chips are flaking off of the surface of the engraving.
 - Make sure that the paper/towel is wet the entire time the engraving is running.
 - The paper/towel may not be wet enough. The paper/towel needs to be soaked almost to the point that the window cleaner or water pools up on top of the glass product.
 - The engraving power may be too high and need to be decreased.
 - The engraving speed may be too low and need to be increased.
 - There are inconsistencies within the engraving of the glass.
 - The glass may be chipping in tiny areas within the engraving due to the glass micro-fracturing too heavily, therefore the laser power may need to be decreased and/or the laser speed increased.
 - The paper/towel layer may be drying out during the engraving and need to be wetted again.
 - The paper/towel layer may have small air bubbles trapped underneath that were not smoothed out before engraving began.
 - Ensure that the glass is completely dry before examining the engraving quality. Any residual moisture, skin oils, etc. can migrate into the micro-fractures of the engraved glass surface and reduce the perceived contrast or frosted appearance of the engraving.
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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.
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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
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