

# Glow Craft Plastic



## GLOW CRAFT PLASTIC- HOBBY Laser Cutting

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## GENERAL LASER CUTTING PROCESS

### Recommended Settings- Laser Cutting

30-40W lasers	
Laser Power	40-50
Laser Speed	15-25
Frequency (Hz)	1000 Hz

### Recommended Settings- Glowforge

Laser Power	40
Laser Speed	170
Passes	1

### General Laser Cutting Instructions

- Place the sheet onto the laser bed and align to the zero point on the laser bed.
  - For best results, leave protective masking on the sheet when laser cutting.
- If needed, adjust the laser focus to the surface of the product.
  - Some hobby laser systems automatically autofocus. In such cases, manual focus of the laser is not required.

- 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 cut pieces and sheet from the laser bed.
  - Remove the protective masking from the surface of the cut pieces.
  - If cleanup is needed, wipe the front and/or back surfaces of the cut pieces with a clean cotton cloth lightly misted with isopropyl alcohol.
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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/](http://jpplus.com/).
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### **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.
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### **Templates and Images**

- Visit [jpplus.com](http://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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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/>