

## MDF HEART SHAPE DESK DECOR - RM-150351E1

### Laser Engraving

If your laser system has an air assist, we recommend setting the air assist to a low setting when engraving woods as too much air may disperse excess wood residue.

- 75 watt laser | 35% power | 75% speed | 600 DPI | Lens sz. 3"

Place frame and align to the zero point on the laser bed. Adjust the laser focus to the surface of the frame. Engrave using the suggested starting settings. When finished, remove from the laser bed. If cleanup is needed wipe the surface with a clean cotton cloth lightly misted with isopropyl alcohol. Avoid saturating the engraved surface.

### Rotary Engraving

- Rate – 0.8-1"/sec. | Depth –.006 -.008" | Spindle – 8000-12,000 RPM  
Bit - .005 -.125" FLX

Secure frame to the engraving bed at the zero point of the engraver. Adjust engraving depth to within the recommended depth range. Engrave the graphic using recommended parameters. If cleanup is needed, blow off the surface with compressed air or wipe with a lightly dampened clean cotton cloth.

### UV-LED Printing Recommendations

- UV Lamp – 30% | Do not use adhesion promoter on painted surface.

To prepare product for printing, wipe down surface with 70% isopropyl alcohol and a clean cloth. Ensure frame surface is dry with no dirt or debris present.

Place frame on print bed. Adjust print head height to the frame surface. Print.

When finished, remove frame from printer. Print should be dry to touch. Allow 24 hours for ink to fully cure.

**Note:** Due to variances in equipment and shop conditions, these settings are offered as a safe starting point. Minor adjustments may be needed to achieve optimal results.

