

# Lacy Edge Plywood Door Hanger

**JOHNSON**PLASTICS  
PLUS

LACY EDGE PLYWOOD DOOR HANGER - Laser Engraving/Cutting

HD2PW26



## 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	70-80
Resolution (DPI/PPI)	500-600

### General Laser Engraving Instructions

- Place the wood blank onto the laser bed and align to the zero point on the laser bed.
- Adjust the laser focus to the surface of the wood blank.
- 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 wood blank from the laser bed.
- If cleanup is needed, wipe the surface with a clean cotton cloth lightly misted with isopropyl alcohol.

## GENERAL LASER CUTTING PROCESS

Recommended Settings- Laser Cutting	
50-60W lasers	
Laser Power	60-70
Laser Speed	15-20
Frequency (Hz)	1000-1500

### General Laser Cutting Instructions

- Place the wood blank onto the laser bed and align to the zero point on the laser bed.
- Adjust the laser focus to the surface of the wood blank.
- Once the artwork is positioned, engrave using the suggested starting settings.
  - Settings may need adjusted depending on the laser tube wattage.
  - Paper masking can be applied to the front and back faces of the wood blank to help protect the wood surfaces along the cut lines.
- When finished, remove the wood blank 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/](http://jpplus.com/).
  - If cutting, paper masking can be applied to the front and back faces of the wood cover to help protect the wood surfaces along the cut lines.
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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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**To order more of this product, see similar products and much more, please visit [jpplus.com](http://jpplus.com).**

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/>