

MDF Wood Products

JOHNSONPLASTICS
PLUS

MDF WOOD PRODUCTS - Rotary Engraving

HD105FW | HD104FW | HD103FW | HD101FW | HD106FW | HD107FW | HD109FW | HD110FW |
HD112FW | HD113FW | HD114W | HD115FW | HD116FW | HD125FW | HD126FW | HD127W |
HD129I | HD130FW | HD131FW | HD132FW | HD133FW | HD150W | HD151FW | HD154FW |
HD156FW | HD157FW | HD158FW | HD159FW | HD160FW | HD161FW | HD162FW | HD163FW



GENERAL ROTARY ENGRAVING PROCESS

Recommended Equipment & Accessories

- CNC Router or Rotary Engraver
- Tacky mat or cutting table
- Clean Towel
- Compressed air

Recommended Settings - Rotary Engraving	
Engraving Rate	0.4-1.5 in/sec.
Engraving Depth	0.006-0.010 in.
Spindle RPM	8,000-10,000 PRM
Bit Type and Size	FLX engraving bit- 0.005”-0.125” tip size

General Rotary Engraving Instructions

- Place the product onto the engraver bed and align to the zero point.
- Select the appropriate engraving bit for soft materials.
- Set the engraving depth, Spindle RPM, and engraving speed to the suggested settings.
 - Settings may need adjusted depending on the engraver/CNC settings scale for the desired engraved results.
- Send the job to the engraver/CNC.
- When finished, remove the product from the engraver/CNC bed. If cleanup is needed, blow out engraved areas with compressed air or wipe with a clean cloth lightly dampened with a light cleaner.

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/.
- Create or employ a jig to help hold the product for easier positioning and faster changeovers when engraving high volumes.

Troubleshooting

- The engraving is not clean.
 - Increase the spindle speed a small amount.
 - Decrease the feed (XY) speed.
 - Ensure the vacuum system of the engraver/CNC is adequately removing the engraved chips while engraving.
- The engraved area shows the tool marks.
 - Switch the engraving bit/tool to a smaller diameter tip.
 - Switch to a different style/shape engraving bit/tool.
 - Select product types may show light markings from the engraving bit within the engraved area.
- There is a ghosted image of the engraved area around the outside of the actual engraved area.
 - Remove the nose cone from the engraver/CNC spindle and lightly buff the surface of the nose cone with very fine grit sandpaper or emery cloth to help smooth out any nicks or scratched on the nose cone surface.

- Set a manual depth setting on the engraver/CNC so that the spindle does not press down as hard onto the surface of the product.
 - The engraving chips are being left behind in the engraved area.
 - Ensure the vacuum system of the engraver/CNC is adequately removing the engraved chips while engraving.
 - Change the filter on the vacuum unit so that suction of the vacuum system increases to be able to remove all of the chips.
-

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: <https://jpplusadvancedsupport.setmore.com/>