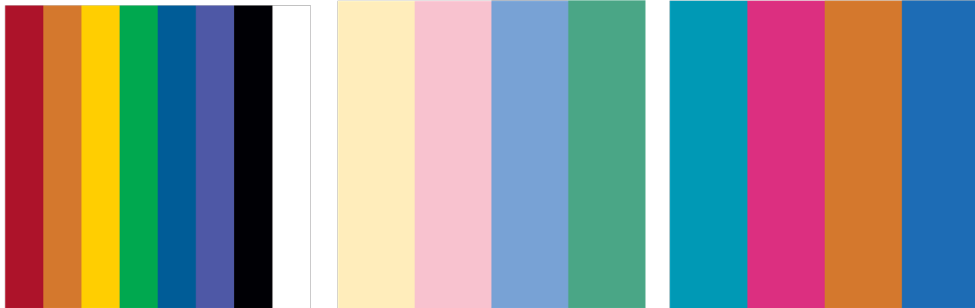


Craft Plastic



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.

Tips and Tricks

- To help with artwork placement, utilize the product template for this item, found on the item's product page on [jplusplus.com/..](http://jplusplus.com/)

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 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
- Email: ast@jpplus.com
- Schedule an appointment: <https://jpplusadvancedsupport.setmore.com/>