

# TECH TIPS

## LaserMax Tri-Layer Engraving Sheet

### LaserMax TriLAYER

Rowmark's TriLAYER material is ideal for producing crisp, clear durable signage and identification without the additional labor and clean-up of paint filling.

This unique material can be rotary or laser engraved for many industrial applications including but not limited to safety signage, legend plates, control panels and name badges.

### Rotary Process

- Secure product to the rotary bed so it is flat and level. Rowmark recommends the use of the Seklema mat for secure hold. Remove protective masking from sheet.
- Insert engraving bit into rotary spindle. Zero bit to the micrometer.
  - FLX engraving bits and spiral fill pattern recommended.
- **Engraving Parameters:**
  - 1<sup>st</sup> layer engraving depth: 0.002"
  - 2<sup>nd</sup> layer engraving depth 0.008"
  - Spindle RPM: 15,000 – 20,000
  - Feed Rate: approx. 1"/sec.
- **Cutting Parameters:**
  - Feed Rate: approx. 0.60"/sec.
  - Spindle RPM: 15,000 – 20,000
  - Use a parallel cutter to achieve 90° cut edges.
  - Protective masking can be left in place to protect edges when cutting.

### Laser Process

- Place material on laser bed. Focus laser to sheet surface.
- Using a 75 watt laser, layers can be run as individual jobs or color mapped accordingly.
- **Raster Engraving Parameters:**
  - 1<sup>st</sup> layer raster engraving: 25% power | 75% speed | 600 DPI | In focus
  - 2<sup>nd</sup> layer raster engraving: 60% power | 65% speed | 600 DPI | .060" offset focus
- **Vector Cutting Parameters:** 30% power | 50% speed | 1000 Hz Frequency | In focus

Material yields optimal results using the above equipment and settings. When utilizing alternative equipment, fabrication parameters may vary. Minor adjustment may be needed to achieve optimal results. Rowmark recommends testing to determine optimal settings for your equipment.

