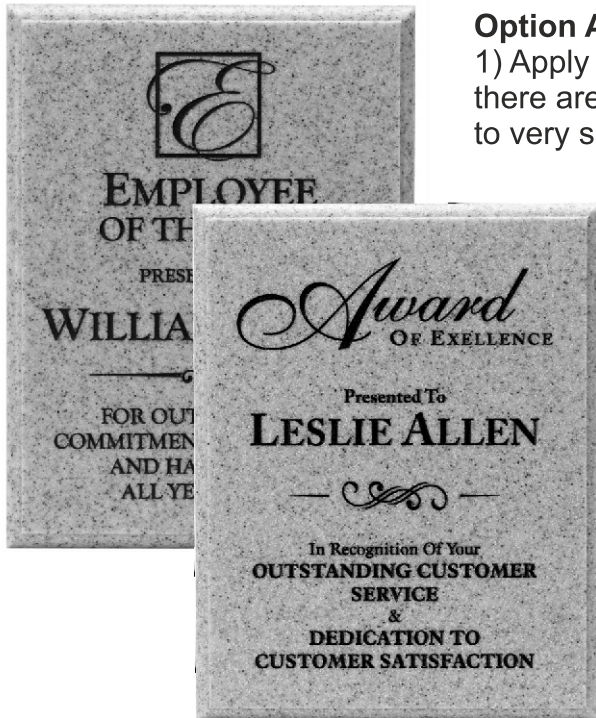




ACRYLSTONE ENGRAVING INSTRUCTIONS

Based on testing with a 40 watt Epilog Helix our recommend settings are: 40 speed / 100 power. You will need to adjust these settings based on the manufacturer and power of your laser engraver.



Option A: Engraving using paper mask.

- 1) Apply paper masking to the surface of the plaque. Make sure there are no air bubbles between the plaque and the mask. It is OK to very slightly overlap the mask if you are covering a larger plaque.
- 2) Engrave the plaque using a low speed / high power combination that is appropriate for your laser. To assure a good depth, you may want to run the plaque more than once.
- 3) After your design has been engraved, gently clean the dust and residue from the engraved area leaving the paper mask in place.
- 4) Choose a color of paint and apply it to the engraved areas. If this plaque will be displayed outdoors, an exterior based paint must be used as the color fill. In addition, you may choose to apply a coat of varnish over the painted areas for additional durability. Apply the paint and varnish before you remove the paper mask.
- 5) After the paint has dried, gently remove the paper mask to reveal your finished plaque.

Option B: Engraving without paper mask:

- 1) Engrave the plaque using a low speed / high power combination that is appropriate for your laser. To assure a good depth, you may want to run the plaque more than once.
- 2) Choose a color of paint and apply it to the engraved areas. If this plaque will be displayed outdoors, an exterior based paint must be used as the color fill. In addition, you may choose to apply a coat of varnish over the painted areas for additional durability.
- 3) After the paint has dried, sand the surface of the plaque using a random orbital palm sander and a 320 grit or higher sanding disk. This will remove the paint from the surface of the plaque, but not the engraved areas. Using 320 grit paper will result in a matte finish. Using 600 grit or higher will result in a more polished finish.



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