

## ROWMARK HARDWOOD COLLECTION FABRICATION TIPS

Rowmark's NEW Hardwood Collection is constructed of single-ply, high quality hardwood layers (or veneers) that are laminated together with their wood grains stacked at right angles to each other for added strength, stiffness and dimensional stability.

All species of the Hardwood Collection laminates is laserable on both sides and available in 1/8" and 1/4" thicknesses in stock sheet sizes of 12" x 24" and 18" x 24". These hardwoods are not sealed or lacquered, allowing users to stain the material to achieve the desired finish.

### Raster Engraving and Color Filling Hardwood Collection

Create precise, intricate laser engraving and vector cuts with Rowmark's Hardwood Collection. For best results, Rowmark recommends using a 2" or 2.5" laser lens. The lens will stay cleaner the further it is from the smoke and residue of the engraving. Rowmark recommends if your laser system has an air assist, set the air assist to a low setting when vector cutting. Too much air may spread the wood residue. Rowmark also recommends storing the Hardwood Collection laminate material at ambient room temperature and flat at all times. Sheets stored vertically may warp over time.

For best results **raster engraving** wood laminates

75 watt laser, 1/8" laminates: 50% to 60% power, 40% to 50% speed, 600 DPI.

75 watt laser, 1/4" laminates: 50% to 60% power, 40% to 50% speed, 600 DPI.

60 watt laser, 1/8" laminates: 85% to 100% power, 70% to 75% speed, 600 DPI.

60 watt laser, 1/4" laminates: 85% to 100% power, 70% to 75% speed, 600 DPI.

40 watt laser, 1/8" laminates: 90% to 100% power, 60% to 65% speed, 500 DPI.

40 watt laser, 1/4" laminates: 90% to 100% power, 60% to 65% speed, 500 DPI.

For best results **vector cutting** wood laminates

75 watt laser, 1/8" laminates: 90% power, 10% speed and 1000 frequency.

75 watt laser, 1/4" laminates: 90% power, 10% speed and 1000 frequency. (2 passes)

60 watt laser, 1/8" laminates: 60% power, 25% speed and 1000 frequency.

60 watt laser, 1/4" laminates: 60% power, 25% speed and 1000 frequency. (2 passes)

40 watt laser, 1/8" laminates: 60% power, 10% speed and 500 PPI.

40 watt laser, 1/4" laminates: 60% power, 10% speed and 500 PPI. (2 passes)

**Note:** Results may vary depending on material density, machine type and wattage.



### Fabrication Steps:

**Step 1:** Mask the material with “Medium Tack Paper Mask” to reduce smoke residue during the raster engraving and vector cutting process. Note: any smoke residue will wipe off with a damp sponge.

**Step 2:** Laser engrave/mark/vector cut the material.

**Step 3 and 4:** Optional for a color filled or enhanced engraved look: Airbrush or spray the engraved areas of the Hardwood Collection sheet with paint. For a warm brown or black look, try “Wildlife Colors” (2310 Warm Black or Brown) from Smith Paints located in Harrisburg, PA. (For more information about Smith Paints or their products, call 1-800-466-8781 or visit <http://www.smithpaints.com/colorcharts/wildlife-colors>.)

**Step 4:** Once the paint dries, remove the transfer tape. Airbrush paints will dry in matter of minutes.

**Step 5:** To stain your material, begin the optional “Finishing Process” outlined below. If you desire a more “natural look,” your finishing process is complete.

### Finishing Process for Hardwood Collection Wood Laminate:

If you wish to stain the Hardwood Collection, follow these simple steps.

**Step 1:** Stain the material with an oil base or water base stain and wipe clean.

**Step 2:** Seal the stained material with “wood sealer spray.”

**Step 3:** Sand sealed material with #220 grit sand paper.

**Step 4:** Spray sanded material with “clear” lacquer. Rowmark recommends 2-3 coats.

**Note:** For an “heirloom” or furniture grade finish, sand in between each lacquer coat.

