

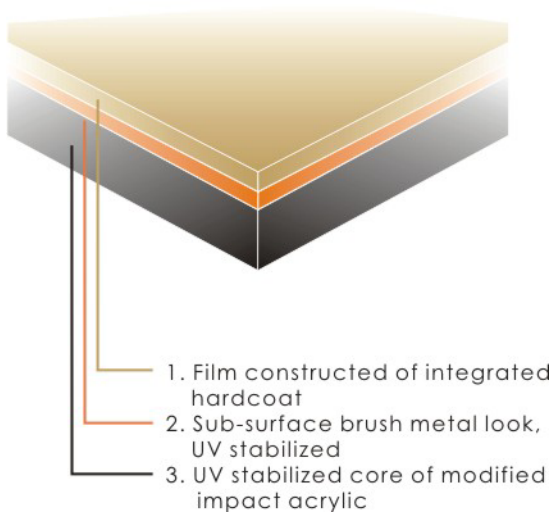
Rowmark[®]

Great people. Great plastic.

Working with Metalgraph Plus



Sheet Construction



Key Product Features

- Formulated to provide protection against abrasion and weathering
- Specially engineered for exterior use, but suitable for all interior applications
- Integrated hardcoat protection
- Deep brush pattern with “real” metal finish
- Resists corrosion and oxidation in high moisture environments
- Fingerprint resistant
- Easily cleaned without surface marring
- Excellent laser and rotary engraving properties

General Product Specifications:

Material:	Modified Impact Acrylic
Finish:	Sub-surface brushed
Sheet Size:	24" x 48" (610 x 1219mm)
Thickness 2 ply	1/16" (1.6mm) 1/8" (3.2mm)
Engraving method	Laser Rotating Carbide Router
Cutting Depth	.003" (.08mm)
Usage	Interior signage, Exterior signage, Personal Identification, Industrial tags, Trophies and awards, Directory Signage, Laser Photo Engraving

Metalgraph Plus is offered in four colors:



METALGRAPH PLUS STORAGE AND MASKING:

Metalgraph Plus should be stored in flat stacks of no more than 50 sheets at room temperature. The masking used for Metalgraph Plus is traditional Rowmark masking and should not pose any unique challenges when fabricating or storing.

LASERING METALGRAPH PLUS:

Vector Cutting Metalgraph Plus:

Metalgraph Plus' construction makes it extremely laser friendly. Rowmark

internal testing has determined that there are no unique challenges when lasering Metalgraph Plus and performance is similar to other Rowmark laserable materials, such as LaserMax® and LaserMark®. If engraving is required, do the vector cut out first while leaving the plate in place and then do the raster-engraving step.

Vector Cutting Settings

For best results, leave masking on the material when vector cutting.

Rowmark has achieved favorable vector cutting results at high power and low speed. The settings provided are meant as a guide only. Your settings will need to be adjusted to achieve optimal results.

Settings on a 60 Watt Trotec laser: 100 Power 5 Speed for 1 Pass.

Settings on a 40 Watt Universal laser: 100 Power 6 Speed for 1 Pass.

Raster Lasereng Settings

Rowmark has achieved favorable raster engraving results at high power and medium speed. The settings provided are meant as a guide only. Your settings will need to be adjusted to achieve optimal results.

Settings on a 60 Watt Trotec laser: 80 Power 100 Speed.

Settings on a 40 Watt Universal laser: 60 Power 90 Speed.

ROTARY ENGRAVING METALGRAPH PLUS:

The engraving depth for Metalgraph Plus is .003". Rotary engraving Metalgraph plus provides clean, crisp edges and sharp graphics. *Unlike other metallic finish products, the integrated hardcoat of Metalgraph Plus means the top surface is resistant to scratches and marring and, under typical use, should resist scratching from a plastic nose cone.*

Like all rotary engraving, it is recommended that a vacuum system be used to remove debris. This will ensure that the engraving depth is consistent and that there is less chance of scratching of the surface during engraving.

Cleaning Metalgraph Plus:

The following cleaning agents should be used to clean Metalgraph:

- *Dish Soap (non citrus)*
- *Furniture Polish (Pledge®)*
- *Novus Plastic Polish Level 1*
- *Rubbing Alcohol*
- *Formula 409®*
- *Window Cleaner*
- *Bleach Cleaner (Clorax®)*
- *PineSol® Cleaner*
- *Lysol® Spray*
- *Lighter Fluid*

1. As a general rule, Rowmark recommends using mild soap and water whenever possible.
2. Test a piece of scrap or small area of the material before cleaning entire piece.
3. Use only soft cloths or sponges for cleaning. Do not use Brillo®/S.O.S.® pads or steel wool.
4. Use a Q-Tip® to clean small areas
5. Rinse with warm water.
6. Ultrasonic cleaning is NOT RECOMMENDED for any Rowmark product.
7. To remove dust from engraved areas, try compressed air before any solvent cleaner.
8. Cleaners with abrasives, such as Comet® brand cleaner, are not recommended.

For a complete list of recommended/non-recommended cleaning agents, please visit http://www.rowmark.com/MARK/techhelpdocs/working_with_sheet/sheet.asp and click on the link: "How to Clean Rowmark Products."