

→ **LMC-6044P Aerosol** Instructions

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setting
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standards

→ **LMC-6044P Usage**

LMC-6044P is our laser marking material for glass and ceramics. LMC-6044P is ethanol based which allows for a fast drying time. The product can be used on a variety of materials such as ceramic, tile, dinnerware, mugs, sanitary ware, glasses and porcelains including automotive glass, spandrel, container glass and the like. It offers improved handling characteristics, will not dust off of the substrates it is applied to, and has smoother, blacker marks.

→ **Using LMC-6044P**

LMC-6044P is ready to use in aerosol can form. For best results, use when can is between 70 and 90 degrees F.

IMPORTANT: Shake can well before using. Allow the agitator ball to rattle for at least 2 minutes. Failure to shake thoroughly will result in spitting and clogging of the nozzle.

→ **Applying**

Clean the surface to be marked so that it is free of any lubricants or oils. The LMC series must be applied with an even coat to ensure a consistent mark and color. Hold can approximately 8-12 inches from substrate to be sprayed. Depress valve fully during spray. For optimum mark quality, an even coat of the LMC-6044P should be applied around 3 wet mils thick. If the material is applied too thin, the marks will not be as dark. If the material is applied too thick, more power will be required to make the mark and bonding may be incomplete. Applying LMC-6044P will require some practice to achieve a correct and even coverage. After use, the can nozzle should be cleaned by inverting the can and spraying until mist becomes clear. Any excess material on the nozzle should be cleaned off with water.

We recommend that all CerMark products be applied in a well ventilated area or spray booth designed to pull air away from user.

→ **Drying**

It is important that the LMC-6044P is allowed to dry thoroughly. It will air dry in about 5 to 10 minutes. This process can be sped up by using an oven, hair dryer or a heat lamp.

→ **Marking Notes**

Marking may require some trial and error to optimize your laser with a particular substrate. Keep in mind that all lasers react differently depending on the substrate. Best results are obtained when marking at lower powers and slower speeds. High powers tend to damage glass substrates and should be avoided whenever possible. Experimentation should be performed to find settings that produce an acceptable mark without glass damage. For more information regarding power and speed settings please refer to the "LMC Series Products, Typical Marking Settings" Technical Bulletin.

→ **Starting Point Settings**

CO2 - 30W - 18 - 30% Power, 10 - 25% Speed, 500 DPI / 500 PPI
YAG - 10 - 20W - 10 - 20 inches / sec speed

→ **Clean Up**

Wash with water or a wet towel. After use, the can nozzle should be cleaned by inverting the can and spraying until mist becomes clear. Any excess material on the nozzle should be cleaned off with water. Nozzle can be removed and soaked in warm water if spraying difficulty is encountered.