

Simply Drinkware

JOHNSONPLASTICS
PLUS

SIMPLY DRINKWARE- Laser Engraving

SST-W20E | SST-B20E | SST-RB20E | SST-SF20E | SSC-W10E | SSC-B10E | SSC-RB10E | SSC-SF10E |
SDW20W | SDW20B | SDW20BR | SDW20LC | SDW20NB | SDW20OG | SDW20O | SDW20PG |
SDW20P | SDW20R | SDW20RB | SDW20SF | SDW30W | SDW30B | SDW30BR | SDW30LC |
SDW30NB | SDW30OG | SDW30O | SDW30PG | SDW30P | SDW30R | SDW30RB | SDW30SF



GENERAL LASER ENGRAVING PROCESS

Recommended Equipment & Accessories

- CO2 Laser Engraver
- Stationary jig to help hold drinkware
- Optional: Laser rotary attachment
- Clean dry cloth
- Kitchen Degreaser for cleaning

Recommended Settings- Laser Engraving	
50-60W lasers	
Laser Power	30-40%
Laser Speed	70-80%
Resolution (DPI/PPI)	500-600 DPI/PPI

General Laser Engraving Instructions

- Place the drinkware product onto the laser bed and align to the zero point on the laser bed.
 - For best results, utilize a jig to help hold the drinkware level and in place during engraving.
- Optional: If available, utilize a laser rotary attachment device when engraving drinkware to engrave wider areas on the drinkware surface and create full wrap-around engravings.
 - Depending on the rotary attachment model, drinkware items that have handles may not be able to have full wrap-around engravings.
- Adjust the laser focus to the surface of the drinkware product.
 - If using a laser rotary attachment: focus the laser to the highest point of the drinkware side.
 - Some laser models may move the laser head to the focus point automatically.
 - If using a stationary jig: With the drinkware on its side, focus the laser just off of the highest point of the drinkware side (usually approx. ¼" to the left or right of the highest point of the side of the drinkware).
- Once the artwork is positioned, engrave using the suggested starting settings.
 - Settings may need adjusted depending on the laser tube wattage.
 - Laser focus may need to be slightly offset from the highest point of the curvature of the drinkware in order to accommodate more engraving width on the drinkware product when the drinkware is engraved stationary (not using a rotary attachment).
- When finished, remove the product from the laser bed.
- If cleanup is needed, wipe the engraved areas with a clean cotton cloth lightly misted with isopropyl alcohol or a kitchen degreaser cleaner.

Tips and Tricks

- To help with artwork placement, utilize the product template for this item, found on the item's product page on jpplus.com/.
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Troubleshooting

- The engraved area is charring/melting.
 - Laser power setting and/or resolution may need to be decreased.
 - Laser speed setting may need to be increased.
- The engraving is fading on the edges of the graphic.

- The laser focus may need to be adjusted or calibrated to ensure the laser is focusing properly to the drinkware surface.
 - If the drinkware is being engraved stationary in the laser (not using a rotary device), the laser focus may need to be offset slightly to help accommodate more engraving width on the drinkware surface.
 - If possible, use a rotary attachment to allow the drinkware to rotate while the engraving is running, to prevent the laser from dropping out of focus.
 - The laser engraving is very dirty or appears tarnished within the engraving areas and will not clean off.
 - This can often occur when engraving powder-coated drinkware. Use a kitchen degreaser to help clean out of the engraved areas.
 - In situations where cleaning is difficult, lightly wiping with a Magic Eraser sprayed with a kitchen degreaser can help clean difficult areas. **CAUTION:** Using a Magic Eraser on the drinkware can ruin the surrounding color coating around the engraved areas if it is scrubbed too hard or for too long. Wipe lightly with as few passes as possible to clean the area to avoid damaging the color coating.
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Templates and Images

- Visit jpplus.com to find the product page for this item. The product template may be found under the Tech Docs and Downloads area of the page.
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To order more of this product, see similar products and much more, please visit jpplus.com.

For additional product support and troubleshooting, please contact JPPlus Advanced Support Team:

- Phone: 419-500-4877
- Email: ast@jpplus.com
- Schedule an appointment: <https://jpplusadvancedsupport.setmore.com/>