

## 20oz and 30oz Powder Coated Tumblers

**JOHNSON**PLASTICS  
PLUS

### 20OZ AND 30OZ POWDER COATED TUMBLERS - Laser Engraving

SRT-W20E | SRT-B20E | SRT-SF20E | SRT-W30E | SRT-B30E | SRT-SF30E



## GENERAL LASER ENGRAVING PROCESS

### Recommended Equipment & Accessories

- CO2 Laser Engraver
- Clean Towel
- Isopropyl Alcohol
- Degreaser cleaner
- Jig to hold drinkware in the laser bed
- Optional: Laser rotary attachment accessory

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

### General Laser Engraving Instructions

- Place the tumbler onto the laser bed and align to the zero point on the laser bed.
  - For best results, utilize a jig to help hold the tumbler level and in place during engraving.
- Optional: If available, utilize a laser rotary attachment device when engraving the tumbler to engrave wider areas on the tumbler surface and create full wrap-around engravings.
  - Depending on the rotary attachment model, raise the elevation adjustment to compensate for the taper of the tumbler (if applicable) and ensure the side surface of the tumbler is level with the laser head.
- Adjust the laser focus to the surface of the tumbler product.
  - If using a laser rotary attachment: focus the laser to the highest point of the tumbler side. (Some laser models may move the laser head to the focus point automatically.)
  - If using a stationary jig: With the tumbler on its side, focus the laser just off of the highest point of the tumbler side (usually approx. 1/4" 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 tumbler in order to accommodate more engraving width on the tumbler when the tumbler is engraved stationary (not using a rotary attachment).
- When finished, remove the tumbler 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.

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### 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/](http://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](http://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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For additional product support and troubleshooting, please contact JPPlus Advanced Support Team:

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