

## Stainless Steel Drinkware

JOHNSON PLASTICS  
PLUS

### STAINLESS STEEL DRINKWARE- Laser Engraving with Cermark

PSS20 | DW251SS | SSCK-S | SSMJ-S | DW249SS | DW2SS28 | DW2SS23 | XP8251 | DW718 |  
DW251SS | SSL10S | DWC12-SS | SSSC12 | SSWTVST | XP8221 | XP8400S | DW2SS25 | SSTV22S |  
DW71 | BGSS20 | XP8262 | XP8262 | SSG32SS | DW712 | DW74 | PSS24 | DW723 | PSS18 | DW79 |  
DW720 | SDW20SS | SST-SS20E | XP8256 | SSG34 | SSWB25 | SSG64SS | DW247SS | SSG64SS



## GENERAL LASER ENGRAVING PROCESS

### Recommended Equipment & Accessories

- CO2 Laser Engraver
- Cermark Spray or Paste
- Stationary jig to help hold drinkware
- Optional: Rotary attachment
- Clean dry cloth
- Soap and water

Recommended Settings- Laser Engraving	
50-60W lasers	
Laser Power	90-100%
Laser Speed	10-15%
Resolution (DPI/PPI)	500-600 DPI/PPI

### Laser Engraving with Cermark Instructions

- Follow the directions for applying the Cermark spray or paste to the surface of the drinkware product.
- Allow the Cermark to dry completely before proceeding.
- 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.
- Wash the remaining unused Cermark material off of the drinkware product using a sponge or cloth with soap and water.

---

### 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/).
- 

### Troubleshooting

- 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 Cermark marking appear very light or are extremely faint with little to no black coloring adhering to the drinkware surface.
    - The drinkware product may have a coating on the outside of the metal, preventing the Cermark material from adhering properly to the metal surface. Cermark material must be adhered to uncoated surfaces to work properly.
    - Check that the laser is in proper focus to the surface of the drinkware.
    - Check that the laser beam alignment is correct in the laser bed.
    - Increase the laser engraving power and/or decrease the laser engraving speed.
    - The laser power rating may not be sufficient to adhere Cermark marking material to the surface of the drinkware. Cermark products are recommended for use in higher power lasers, such as 50W and up.
    - If using Cermark spray, ensure that the can is shaken for the recommended time frame before spraying onto the drinkware product. See directions on the side of the spray can for further details and instructions.
    - If using Cermark paste, ensure that the paste is diluted with preferably denatured alcohol, or water can also work. Ensure that the dilution ratio is approximately 1:1. The paste should have the consistency of wet paint before applying to the drinkware product surface.
    - Make sure the Cermark material is completely dry before laser engraving.
- 

### **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.
- 

**To order more of this product, see similar products and much more, please visit [jpplus.com](http://jpplus.com).**

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

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