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CUTTING WITH KONGSBERG SYSTEMS

Notes

The settings listed are ESKO's recommendation for this material.

Settings could vary depending on the geometry of the cut file.

Material Thickness: 16mm

Machine Models: C / X / X Starter

Toolheads:

- Kongsberg C: MP HF VibraCut / HD Unit / V-notch knife
- Kongsberg X: MultiCut / FlexiHead / PowerHead
- Kongsberg X Starter: MultiCut / FlexiHead

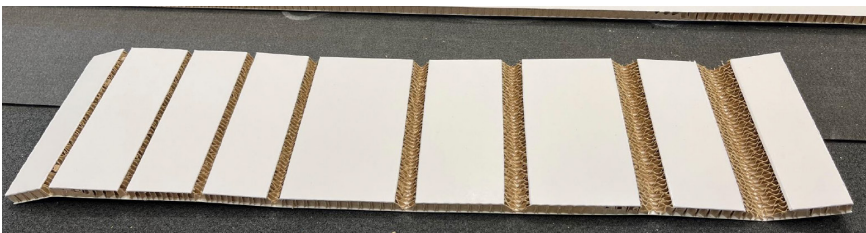
Standard Cuts on 16mm Sheets

Machine	Tool	Blade / Bit	Speed	Accel.	Passes
Kongsberg C Same for XP, XP Auto	HF VibraCut Knife	BLD-SR6307	10 m/min	10%	1
		BLD-SR6310	10 m/min	10%	1
	HD Knife 17**	BLD-TZ129	50 m/min	50%	1
	HD Knife 30**	BLD-TZ230	50 m/min	50%	1
Kongsberg X Same for XL, XN (Insert tools for FlexiHead, MultiCut, & PowerHead)	MP HF VibraCut Knife	BLD-SR6307	10 m/min	10%	1
		BLD-SR6310	10 m/min	10%	1
Kongsberg X Same for XI, XN (Tools for PowerHead HD Unit)	HD Knife 17* HD Knife 30*	BLD-TZ129	50 m/min	100%	1
		BLD-TZ230	50 m/min	100%	1
Kongsberg X Starter Same for Kongsberg VL and V Table (V-notch Insert tools for FlexiHead and MultiCut toolhead)	MP HF VibraCut Knife	BLD-SR6307	20 m/min	30%	1
		BLD-SR6310	20 m/min	30%	1

* only for PowerHead on Kongsberg X tables. This knife is limited to straight line only, longer than 50mm (2")

** HD knife for heavy duty unit on C is limited to straight line only, longer than 50mm (2")

**** It is possible to use the V-notch insert tools (VI45 and VI30 series) for V-cutting this material, but result will not be perfect due to thickness of the blades. Better V-notch result can be achieved with the HD V-notch tools for C or PowerHead, with thinner blades.



CUTTING WITH KONGSBERG SYSTEMS

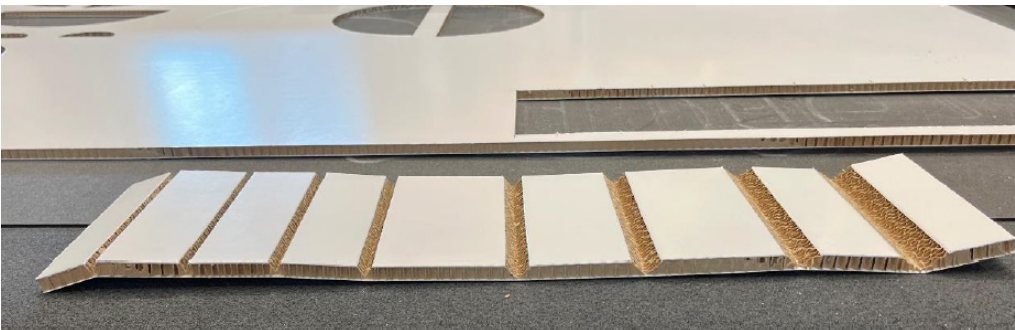
V-Notching 16mm Sheets

Machine	Tool	Blade / Bit	Speed	Accel.	Passes
Kongsberg C Same for XP, XP Auto	V-Notch Knife 45° V-Notch Knife 45° 10mm V-Notch Knife 30° V-Notch Knife 22.5° V-Notch Knife 15°	BLD-TZ511 / BLD-TZ192	50 m/min	50%	1
Kongsberg X Same for XL, XN (Insert tools for FlexiHead, MultiCut, & PowerHead)	V-Notch Knife 45° V-Notch Knife 45° 10mm V-Notch Knife 30° V-Notch Knife 22.5° V-Notch Knife 15°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
Kongsberg X*** Same for XI, XN (Tools for PowerHead HD Unit)	VI45-16 VI45-10 VI30-16	BLD-DF571 / BLD-DF572 BLD-DF561 / BLD-DF562 BLD-DF571 / BLD-DF572	25 m/min 25 m/min 25 m/min	50% 50% 50%	1 1 1
Kongsberg X Starter*** Same for Kongsberg VL and V Table (V-notch Insert tools for FlexiHead and MultiCut toolhead)	VI45-16 VI45-10 VI30-16	BLD-DF571 / BLD-DF572 BLD-DF561 / BLD-DF562 BLD-DF571 / BLD-DF572	30 m/min 30 m/min 30 m/min	100% 100% 100%	1 1 1

* only for PowerHead on Kongsberg X tables. This knife is limited to straight line only, longer than 50mm (2")

** HD knife for heavy duty unit on C is limited to straight line only, longer than 50mm (2")

*** It is possible to use the V-notch insert tools (VI45 and VI30 series) for V-cutting this material, but result will not be perfect due to thickness of the blades. Better V-notch result can be achieved with the HD V-notch tools for C or PowerHead, with thinner blades.



CUTTING WITH KONGSBERG SYSTEMS

Notes

The settings listed are ESKO's recommendation for this material.

Settings could vary depending on the geometry of the cut file.

Material Thickness: 10mm

Machine Models: C / X / X Edge

Toolheads:

- Kongsberg C: HF VibraCut / Viariangle / V-notch Tool / HD Knife
- Kongsberg X: HF VibraCut / RB / VI45 / HD Knife
- Kongsberg X Edge: HF VibraCut / VI45

Standard Cuts & V-Notching on 10mm Sheets

Machine	Processing	Tool	Blade / Bit	Speed	Accel.	Passes	RPM
Kongsberg C	Cut	HF VibraCut	BLD-SR6310	15 m/min	40%	1	0
	Partial Cut	HF VibraCut	BLD-SR6310	15 m/min	40%	1	0
	V-Notch	Variangle 30°	BLD-SF641	60 m/min	70%	1	0
	V-Notch	Variangle 45°	BLD-SF641	60 m/min	70%	1	0
	V-Notch	Variangle Short	BLD-SF620	100 m/min	90%	1	0
	V-Notch	V-Notch tool	BLD-TZ511	50 m/min	50%	1	0
	HD-Cut	HD Knife-17	BLD-TZ129	70 m/min	50%	1	0
Kongsberg X	Cut	HF VibraCut	BLD-SR6310	15 m/min	40%	1	0
	Cut	HF VibraCut	BLD-SR6224	20 m/min	20%	1	0
	Cut	RB-90	BLD-SF290	50 m/min	100%	1	0
	V-Notch	VI45-16	BLD-DF572	50 m/min	70%	1	0
	V-Notch	VI45-10	BLD-DF561	50 m/min	70%	1	0
	HD-Cut	HD Knife-17	BLD-TZ129	50 m/min	70%	1	0
Kongsberg X Edge	Cut	HF VibraCut	BLD-SR6310	15 m/min	30%	1	0
	V-Notch	VI45-16	BLD-DF572	30 m/min	100%	1	0

CUTTING WITH ZUND SYSTEMS

Through Cut

Tool: EOT-250 (Electrical Oscillating Tool)
Knife: Z201 (16mm) // Z202 (10mm)
Cutting Speed: 1000 mm/sec
Acceleration: 4

V-Cut

Tool: VCT (V-Cut Tool)
Knife: Z71
Cutting Speed: 600
Acceleration: 3

