

REFERENCE GUIDE

Knife Cutting Applications



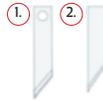
P/N	Name	Description
12-00121-FLO-024	KH1	Flat Shaft 0.65 x 5.6 mm Offset Blades
12-00121-FLO-024-4MM	KH2	Flat Shaft 0.65 x 4 mm Offset Blades
12-00121-FLC-060	KH3	Flat Shaft 1.5 x 8 mm Centered Blades
12-00121-FLO-060-5.5MM	KH4	Flat Shaft 1.5 x 5.5 mm Offset Blades
12-00121-KC-6MM	KH6	Round 6mm Shaft (Kiss Cut or Osc. Blades)
12-00121-CR-12MM	KH12	Creasing Wheels
12-00121-CB	KH13	Circular Blade 1 x 60 mm
12-00121-PW	KH15	Perforating Tool 1 x 60 mm
12-00121-ANG	KH20	Cut Multi Angle 0 (LSK), 15, 22.5, 30, 45°
12-00121-QC-DRT	KH21	Driven Rotary Wheel
12-00121-ANG-5-10	KH24	Multi-Angle 5°, 10°

KH1	KH2	KH3	KH4	KH6	KH12	KH13	KH15	KH20/ KH24
K18 (10 PK)	K66 (5 PK)	K24 (3 PK)	K20 (SINGLE)	INCLUDES (1) K28 & (2) K32 VINYL KNIVES	K40 (SINGLE)	K45	K54 (SINGLE)	K71 (SINGLE)
KH1 INCLUDED WITH MACHINE								



KH1

The KH1 is included with your MultiCam and is designed to fit **Flat Shaft 0.65 x 5.6 mm Offset Blades.**



1.) K18 - HSS Straight Back Blade - 50° - Shank 5.6mm Wide x 0.65 Thick - Flat Shank - 5.5mm Depth of Cut - Single Edge General Purpose Knife Blade 10 Pack (Included with Machine)

These single edge cutout blades are designed for general cutting through materials up to 5.5mm in depth. General Purpose - Banner - Cardstock - Corrugated - Styrene and other similar materials.

2.) K16 - Solid Carbide Straight Back Blade - 55° - Shank 5.6mm Wide x 0.65 Thick - Flat Shank - 5.5mm Depth of Cut - Single Edge - Flat - 5 Pack

These single edge cutout blades are designed for general cutting through materials up to 5.5mm in depth. This solid carbide blade is designed to retain its sharp edge 2-3x longer than High Speed steel K18. General Purpose - Banner - Cardstock - Corrugated - Styrene and other similar materials.

KH2

The KH2 is designed to fit **Flat Shaft 0.65 x 4 mm Offset Blades.**



1.) K68 - Solid Carbide Straight Back Blade - 65°/85° - Shank 4mm Wide x 0.65 Thick - 13mm Depth of Cut - Single Edge - 5 Pack

Fine drag blade with nominal overcut; designed to cut small radii and intricate detail. Corrugated Boards - Rubber Fabric - Soft & Hard Foams - Corrugated & Flexible Plastics

2.) K64 - Solid Carbide Straight Back Blade - 65°/85° - Shank 4mm Wide x 0.65 Thick - 10mm Depth of Cut - Single Edge - 5 Pack

Fine drag knife with minimal overcut; designed to cut small radii and intricate detail. Corrugated Boards - Rubber Fabric - Soft & Hard Foams - Corrugated & Flexible Plastics

3.) K66 - Solid Carbide Straight Back Blade - 65°/85° - Shank 4mm Wide x 0.65 Thick - 13mm Depth of Cut - Single Edge - 5 Pack (K66 - 5 pack included with KH2 purchase)

Very fine drag knife with least overcut; K66 is a very thin blade that provides the least amount of overcut when compared to the K68 which is a physically larger blade. Backup support is provided by Multicam direct. designed to cut small radii and intricate detail. Corrugated Boards - Rubber Fabric - Soft & Hard Foams - Corrugated & Flexible Plastics

KH3

The KH3 is designed to fit **Flat Shaft 1.5 x 8 mm Centered Blades.**



1.) K22 - Solid Carbide Dual Edge Widia Blades - 50° Cut Angle - 20° Wedge - Shank 1.5mm x 8mm - 4.8mm Depth of Cut - 3 Pack

Dual edge allows for twice the amount of cutting than a single blade and with this 50° angle of cut the K22 can aggressively slice through a wide variety of materials at high feed rates. Folding Carton - Plastics - Foil - PVC - Textile Fabrics

2.) K24 - Solid Carbide Dual Edge Widia Blades - 60° Cut Angle - 20° Wedge - Shank 1.5mm x 8mm - 6.9mm Depth of Cut - 3 Pack (K24 - 3 pack included with KH3 purchase)

Dual edge allows for twice the amount of cutting than a single blade and with this 60 degree angle not only adds to depth of cut from K22 but still can aggressively slice a wide variety of materials at high feed rates. Folding Carton - Plastics - Foil - PVC - Textile Fabrics

3.) K23 - Solid Carbide Straight Back Blade - 35mm Overall Length x 50° - Shank 1.5mm x 8mm - 4.8mm Depth of Cut

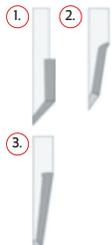
Same great cutting ability as K22 but straight back allows for cut back operations where no overcut is needed. Film - Soft Plastics - Polypropylene - PVC - Banner - Folding Carton - Foamed PVC - PS - Polyester Fabric

4.) K25 - Solid Carbide Straight Back Blade - 35mm Overall Length x 60° - Shank 1.5mm x 8mm - 6.9mm Depth of Cut

Same great cutting ability as K24 but straight back allows for cut back operations where no overcut is needed. Film Tarpaulin - Polypropylene - PVC - Vinyl Banner - Folding Carton - Foamed PVC - Polyester Fabric

KH4

The KH4 is designed to fit **Flat Shaft 1.5 x 5.5 mm Offset Blades.**



1.) K20 - Solid Carbide 1.5mm x 5mm Flat Shaft - Straight Back Blade - Combo Profile 45°+90° - 20mm Depth of Cut

This combination profile and thickness of blade is one of the best all around drag blades for cutting thicker than 6mm materials. Foamed PVC - PS - Soft Foam Board (PUR)

2.) K26 - Solid Carbide 1.5mm x 5mm Flat Shaft - Straight Back Blade - Combo Profile 55° x 2.8mm Tip/81.5° - 16.5mm Depth of Cut

Similar to K68 for fine drag blade cutting with nominal overcut but with 1.5mm blade thickness provides K26 with rigidity from flexing in denser materials. Folding Carton - Solid Cardboard - Rubber - Soft Foam Board (PUR) - Foam Material - Foam Rubber - Felt - Leather - Polyester Fabric - Composite Panels - Sandwich Panel - Thin Wall Sheet

3.) K27 - Solid Carbide 1.5mm x 5mm Flat Shaft - Straight Back Blade - Combo Profile 5° x 2.8mm Tip/81.5° - 20mm Depth of Cut

Similar to K26 with 1.5mm blade thickness and fine drag blade cutting but blunt tip provides better bottom cutting on thick fibrous materials. Folding Carton - Solid Cardboard - Rubber - Soft Foam Board (PUR) - Foam Material - Foam Rubber - Felt - Leather - Polyester Fabric - Composite Panels - Sandwich Panel - Thin Wall Sheet

KH6

The KH6 is designed 6 mm Kiss Cut Adapter & 6 mm Round Shank Blades.

Accuracy in the cutting depth is essential. The variable pressure of this Kiss-Cut Holder/Blade permits precise cutting of foils without damaging the liner material. This insert can easily be set up to be a dual cutter of top liner and then using a different Z depth will also do cutout shapes of both liner and backing material.



1.) K28 - Solid Carbide - Type 1 - 3mm Round Shank (Fits in Insert, 6mm Shank) - 40°/40° - Single Edge Blade - 10 Pack
Kiss cut applications in vinyls. For detailing work, like small letter cut outs.

2.) K32 - Solid Carbide - Type 3 - 3mm Round Shank (Fits in Insert, 6mm Shank) - 40°/30° - Dual Edge Blade - 10 Pack
For thinner adhesive vinyl on letters 1 inch and taller.

3.) K34 - Solid Carbide - Type 4 - 3mm Round Shank (Fits in Insert, 6mm Shank) - 26°/54° - Single Edge Blade - 10 Pack
Stencil blade for thicker material.

4.) K36 - Solid Carbide - Type 5 - 3mm Round Shank (Fits in Insert, 6mm Shank) - 30°/30° - Dual Edge Blade - 10 Pack
For thinner adhesive vinyl on letters 1 inch and taller.

All blades 1-4 are used with Foils & Vinyls.

Vinyl knife adapter with starter pack of vinyl knives and accessories included with KH6 purchase.



KH6 holder can also use 6mm round shank blades that come in a large variety of lengths and multiple styles. See Oscillating Cutting Knife Blades section on the MultiCam website, visit <https://www.multicamtooling.com>.

KH12

The KH12 is designed to fit Creasing Wheel Options.

This creasing wheel holder is designed for processing double and triple-wall corrugated cardboard. This holder and its creasing wheel options provides high-quality creases with and against the corrugation.



1.) K42 - Creasing Wheel - For 4pt. Folded Carton

2.) K40 - Creasing Wheel
For Corrugated Cardboard. R 1.5, F and E-Flute. One (1) K40 wheel included with KH12 purchase.

3.) K41 - Creasing Wheel
For Corrugated Cardboard. R 3.3, B and BC-Flute

4.) K39 - Creasing Wheel
For Corrugated Cardboard. R 7.0, C-Flute

5.) K43 - Creasing Wheel
100° Double Crease Wheel, 0.6mm

KH13

The KH13 is designed to fit Rotary Blade Options.

This Rotary wheel holder is an ideal holder/ rotary blade combination, and is excellent for cutting medium density foams and insulation. The driven rotary blade permits high processing speeds.



1.) K46 - Solid Carbide Rotary Blade - 45mm Diameter x 8mm Bore x 1mm Kerf. 16mm Depth of Cut

2.) K45 - Solid Carbide Rotary Blade - 60mm Diameter x 8mm Bore x 1mm Kerf. 24mm Depth of Cut
One (1) K45 wheel included with KH13 purchase.

KH20

The KH20 is V-Cut Holder designed to utilize Angled Blade types.

The V-Cut holder is an excellent tool for producing complex 3D structural designs with materials such as corrugated/honeycomb display board and foamcore. The tool's well thought-out design makes for quick tool changes and simple, precise angle settings.



1.) K71 - Solid Carbide 0°, 15°, 30°, 45° Blade for VCut Holder - 1mm x 8mm Flat Shaft - 50mm Overall Length - Max cutting depth based on angle.
One (1) K71 blade included with KH20 purchase.

KH15

The KH15 is designed to fit **Perforating Wheel Blade Combinations.**

This Perforating wheel holder is the ideal holder/perforating blade combination, and is excellent for creating precise perforations. Perforating Blades are 1mm x 60mm x 8mm Bore x various teeth per inch.



- ①  **1.) K50** - Solid Carbide Perforating Wheel Blade
25 TPI. For Vinyls
- ②  **2.) K51** - Solid Carbide Perforating Wheel Blade
17 TPI. For Vinyls
- ③  **3.) K52** - Solid Carbide Perforating Wheel Blade
13 TPI. For Solid Board - Cardstock
- ④  **4.) K53** - Solid Carbide Perforating Wheel Blade
8 TPI. For Solid Board - PP - Cardstock
- ⑤  **5.) K54** - Solid Carbide Perforating Wheel Blade
4 TPI. For Corrugated Fiberboard - (1) One K54 included with KH15 purchase
- ⑥  **6.) K55** - Solid Carbide Perforating Wheel Blade
3 TPI. For Corrugated Fiberboard
- ⑦  **7.) K56** - Solid Carbide Perforating Wheel Blade
2 TPI. For Corrugated Fiberboard
- ⑧  **8.) K57** - Solid Carbide Perforating Wheel Blade
1.5 TPI. For Corrugated Fiberboard