

Cutting instruction of SB Material with ESKO

Material thickness

- 16 mm

Special info

- The settings in this list are ESKO's recommendation settings for this material.
- Settings could vary depending on the geometry of the cut file.

Alternative materials

- SB Fibre is a rigid paper board, SB Composite is a foam board with expanded polystyrene

Machine model

- C / X / X Starter

ESKO Kongsberg Application Sheet

Swedboard material

SB Fibre and SB Composite

SB Composite
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SB Fibre PREMIUM
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Toolhead

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

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PROCESSING TYPE	MACHINE	TOOL	BLADE/BIT	SPEED	ACCEL	PASSES
CUTTING STANDARD	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 and PowerHead)	MP HF VibraCut Knife	BLD-SR6307	10 m/min	10%	1
			BLD-SR6310	10 m/min	10%	1
	Kongsberg X Same for XL, XN (Tools for PoweHead HD unit)	HD Knife 17 *	BLD-TZ129	50 m/min	100%	1
		HD Knife 30 *	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

V - NOTCHING	Kongsberg C Same for XP, XP Auto	V-notch Knife 45°	BLD-TZ511 / BLD-TZ192	50 m/min	50%	1
		V-notch Knife 45° 10mm	BLD-TZ511 / BLD-TZ192	50 m/min	50%	1
		V-notch Knife 30°	BLD-TZ511 / BLD-TZ192	50 m/min	50%	1
		V-notch Knife 22.5°	BLD-TZ511 / BLD-TZ192	50 m/min	50%	1
		V-notch Knife 15°	BLD-TZ511 / BLD-TZ192	50 m/min	50%	1
	Kongsberg X Same for XL, XN (For PowerHead HD unit)	V-notch Knife 45°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
		V-notch Knife 45° 10mm	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
		V-notch Knife 30°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
		V-notch Knife 22.5°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
		V-notch Knife 15°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
	Kongsberg X**** (V-notch Insert tools for FlexiHead, MultiCut and PowerHead)	VI45-16	BLD-DF571 / BLD-DF572	25 m/min	50%	1
		VI45-10	BLD-DF561 / BLD-DF562	25 m/min	50%	1
		VI30-16	BLD-DF571 / BLD-DF572	25 m/min	50%	1
	Kongsberg X Starter**** Same for Kongsberg VL and V table (V-notch Insert tools for FlexiHead and MultiCut toolhead)	VI45-16	BLD-DF571 / BLD-DF572	30 m/min	100%	1
		VI45-10	BLD-DF561 / BLD-DF562	30 m/min	100%	1
		VI30-16	BLD-DF571 / BLD-DF572	30 m/min	100%	1

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

** Tooling insert for Kongsberg X tables. This knife is limited to straight line only)

*** 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 the result will not be perfect due to the thickness of the blades.

Better V-notch result can be achieved with the HD V-notch tools for C or Powerhead, with thinner blades.

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