

Milling & cutting Recommendation

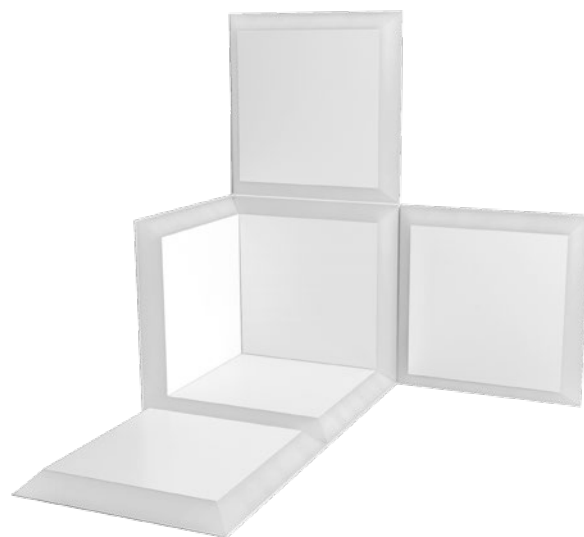
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Milling & cutting Recommendation

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All information is provided to the best of our knowledge, but without obligation or liability. We recommend testing the goods for their suitability for the planned purpose to achieve best results.

If „soft“ material is milled it has to be milled **against the feed**.



V-groove milling EASYPRINT 10 mm:

15,000 - 24,000 rpm against the feed with a V-groove cutter and a feed motion of 3 - 6 m/min.

Even better results can be achieved if the cutter „drives“ twice (e.g. cutting depth 9 mm = 1st infeed 7 mm, 2nd infeed 9 mm)
Optimum: 15.000 revolutions/min against the feed with a feed motion of 3 m/min

Contour milling EASYPRINT 10 mm:

24,000 rpm against the feed with an end mill cutter and a feed motion of 2 - 6 m/min.

Optimum: 24,000 revolutions/min against the feed with a feed motion of 2 m/min

Cutting with oscillating blade:

Tested by Zünd Systemtechnik AG.

A detailed overview of the results can be found on the following pages.

You can find a video of the cutting tests at the link below:

<https://youtu.be/G4BXLEb7Xw4>

ZÜND
swiss cutting systems





Material Name	EASYPRINT	EASYPRINT	EASYPRINT
Thickness	5.0	5.0	10.0
Cutter	G3-L2500	G3-L2500	G3-L2500
Module	UM-ZS	UM-ZS	UM-ZS
Tool	VCT	EOT 250	VCT
Knife / Bit Wheel / Punch	Z73	Z61	Z71
Speed	800.0	400.0	800.0
Glideshoe		Standard	
Accelleration Level	3	2	3
Z-lower	150.0	500.0	150.0
Cutting Underlay	Grey Conveyor Belt	Grey Conveyor Belt	Grey Conveyor Belt
Software	ZCC	ZCC	ZCC
Specifics	- Grooving angle 45 - Base depth -0.8 mm - V-Cut possible	- Knife compensation on - Base depth -1.2 mm	- Grooving angle 22.5 - Base depth -0.8 mm

Material Name	EASYPRINT	EASYPRINT	EASYPRINT
Thickness	10.0	10.0	19.0
Cutter	G3-L2500	G3-L2500	G3-L2500
Module	UM-ZS	UM-ZS	UM-ZS
Tool	VCT	EOT 250	EOT 250
Knife / Bit Wheel / Punch	Z71	Z61	Z68
Speed	800.0	400.0	400.0
Glideshoe		Standard	Standard
Accelleration Level	3	2	2
Z-lower	150.0	500.0	500.0
Cutting Underlay	Grey Conveyor Belt	Grey Conveyor Belt	Grey Conveyor Belt
Software	ZCC	ZCC	ZCC
Specifics	- Grooving angle 45 - Base depth -0.8 mm	- Knife compensation on - Base depth -1.2 mm	- Knife compensation on - Base depth -1.2 mm



Material Name	SF	SF	SF
Thickness	5.0	5.0	10.0
Cutter	G3-L2500	G3-L2500	G3-L2500
Module	UM-ZS	UM-ZS	UM-ZS
Tool	VCT	EOT 250	VCT
Knife / Bit Wheel / Punch	Z73	Z61	Z71
Speed	800.0	400.0	800.0
Glideshoe		Standard	
Accelleration Level	3	2	3
Z-lower	150.0	500.0	150.0
Cutting Underlay	Grey Conveyor Belt	Grey Conveyor Belt	Grey Conveyor Belt
Software	ZCC	ZCC	ZCC
Specifics	- Grooving angle 22.5 - Base depth -0.8 mm - V-Cut possible, fold with care	- Knife compensation on - Base depth -1.2 mm	- Grooving angle 22.5 - Base depth -0.8 mm

Material Name	SF	SF	SF
Thickness	10.0	10.0	19.0
Cutter	G3-L2500	G3-L2500	G3-L2500
Module	UM-ZS	UM-ZS	UM-ZS
Tool	VCT	EOT 250	EOT 250
Knife / Bit Wheel / Punch	Z71	Z61	Z68
Speed	800.0	400.0	400.0
Glideshoe		Standard	Standard
Accelleration Level	3	2	2
Z-lower	150.0	500.0	500.0
Cutting Underlay	Grey Conveyor Belt	Grey Conveyor Belt	Grey Conveyor Belt
Software	ZCC	ZCC	ZCC
Specifics	- Grooving angle 45 - Base depth -0.8 mm	- Knife compensation on - Base depth -1.2 mm	- Knife compensation on - Base depth -1.2 mm