






Cutting recommendation | Esko Kongsberg XP/C

ELEKTRISCH ANGETRIEBENES OSZILLIERENDES TOOL




TOOL	BLADE	UNDERLAY
<p>We recommend oscillating cutting, especially for 3.0 mm and 5.0 mm KATZ DISPLAY BOARDS with the HF VibraCut Knife.</p> <p>· Compatible with Kongsberg XP/C</p> 	<p>Oscillating knife for cutting fine structures.</p> <p>· BLD-SR6224</p> 	<p>Grey standard cutting felt in 3.0 mm thickness for optimum cutting quality with Kongsberg cutting machines.</p> <p>· Dicke: 3,0 mm</p> 

KATZ DISPLAY BOARDS thickness	Blade type	Blade length	Speed m/min				Underlay	Acceleration
			20	30	50	60		
1.2 mm	BLD-SR6224	12 mm		X	X		Felt: 3 mm	50
1.6 mm	BLD-SR6224	12 mm		X	X		Felt: 3 mm	50
2.0 mm	BLD-SR6224	12 mm		X	X		Felt: 3 mm	50
3.0 mm							Felt: 3 mm	50
5.0 mm							Felt: 3 mm	50

All values are based on our experience and may differ from machine to machine.

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STATIC KNIFE TOOL:



TOOL	BLADE	UNDERLAY
<p>For the normal trough cut in the KATZ material you get best result with the coated rigid material knives. They are compatible with the rigid material cutting tool and the corruspeed tool.</p>  <p>Schneidwerkzeug für steifes Material</p> <p>CorruSpeed TOOL</p>	<p>These coated static knives perform best in recycled, natural materials.</p> <ul style="list-style-type: none"> · BLD-SR8171A (asymetric): for high detailed cutting. It ploughs all burr's and waste to one side. It is very important to control the cutting direction! · BLD-SR8160: for general use · BLD-SR8170: for general use · BLD-SR8184: for general use and long straight edges. Rounded corners should have a radius larger than 20 mm  <p>BLD-SR8184 BLD-SR8170 BLD-SR8171A BLD-SR8160</p>	<p>Grey standard cutting felt in 3.0 mm thickness for optimum cutting quality with Kongsberg cutting machines.</p> <ul style="list-style-type: none"> · Thickness: 3.0 mm 

KATZ DISPLAY BOARDS thickness	Blade type	Speed m/min			Underlay	Acceleration
		Kongsberg C 60	Kongsberg X 50	X Starter 30		
1.2 mm	BLD-SR8171A BLD-SR8160 BLD-SR8170 BLD-SR8184	X	X	X	Felt: 3 mm	80
1.6 mm	BLD-SR8171A BLD-SR8160 BLD-SR8170 BLD-SR8184	X	X	X	Felt: 3 mm	80
2.0 mm	BLD-SR8171A BLD-SR8170 BLD-SR8184	X	X	X	Felt: 3 mm	80
3.0 mm	BLD-SR8171A BLD-SR8170 BLD-SR8184	X	X	X	Felt: 3 mm	80
5.0 mm	BLD-SR8184 BLD-SR8170	X	X	X	Felt: 3 mm	80

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CREASING TOOL

TOOL	BLADE	UNDERLAY
<p>Crease adapter / tools: HPU, Power Head Crease tool XE, Crease Tool 26 mm</p> 	<p>Recommended for solid board like KATZ DISPLAY BOARD and corrugated board. Best creasing results, without breaking the liner, are experienced with a matrix. Use a crease wheel diameter depending on the thickness of the material and length of the crease line in the cut file.</p>  <p>Crease Wheel Ø 150 mm 6-point</p>  <p>Crease Wheel Ø 26 mm Triple wall (i-662)</p>  <p>Crease Wheel Ø 26 mm 12-point</p>  <p>Crease Wheel Ø 26 mm 14-point</p>	<p>Grey standard cutting felt in 3.0 mm thickness for optimum cutting quality with Kongsberg cutting machines.</p> <p>· Thickness: 3.0 mm</p> 




KATZ DISPLAY BOARDS thickness	Rillwerkzeug	Speed m/min			Underlay	Accelera- tion
		Kongsberg C 100	Kongsberg X 50	X Starter 30		
1.2 mm	Crease tool / adapter	X	X	X	Felt: 3 mm	100
1.6 mm	Crease tool / adapter	X	X	X	Felt: 3 mm	100
2.0 mm	Crease tool / adapter	to be tested				
3.0 mm	not recommended					
5.0 mm	not recommended					

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V-NOTCH / BEVEL CUTTING TOOL

TOOL	BLADE	UNDERLAY
<p>This tool is used for producing KATZ DISPLAY BOARD with V-Cut. V-Cut allows folding of different board thicknesses.</p> <p>HD Bevel knife tool 17 for solid board</p> 	<p>A special tungsten carbide knife blade for cutting V-notch folding lines in solid board.</p> <p>V-Cut double and single cut with 45° angle.</p> <p>Double cut dW-setting: Along and Across -0.5 mm</p> <p>·BLD-SF245</p> 	<p>Grey standard cutting felt in 3.0 mm thickness for optimum cutting quality with Kongsberg cutting machines.</p> <p>· Thickness: 3.0 mm</p> 

KATZ DISPLAY BOARDS thickness	Blade type	Speed m/min				Underlay	Acceleration
		20	40	60	80		
1.2 mm	BLD-SF245	X				Felt: 3 mm	20
1.6 mm	BLD-SF245	X				Felt: 3 mm	20
2.0 mm	BLD-SF245	X				Felt: 3 mm	20
3.0 mm	BLD-SF245	X				Felt: 3 mm	20
5.0 mm	BLD-SF245	X				Felt: 3 mm	20

* Acceleration for Kongsberg X Starter is 40%

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Contact



Philipp Reuter

Junior Sales Manager KATZ Display Board

Phone +49 7224 647-206

Fax +49 7224 647 10-206

philipp.reuter@thekatzgroup.com