

Vink PET-Felt

Advice on machine-cutting Vink PET-Felt 9mm

Machine	Kongsberg X24
Tools	<p>Standard reciprocating knife tool BLD-SR6320</p>  <p>Description:</p> <ul style="list-style-type: none"> • A more slender tungsten carbide blade producing less overcut. Good blade for cutting materials like soft foam board. • This knife has 0mm lag, and results in very little overcut. <p>Specifications:</p> <ul style="list-style-type: none"> • Shank diameter: 6mm (D) • Maximum cutting thickness: 14mm - 1/2" (C)  <p>Other possible knife blades: BLD-SR6317, BLD-SR6317, BLD-SR6315 (little more overcut, 3 mm lag)</p> <p>Other possible tools: Multi Purpose High Frequency (MP-HF) Knife Tool</p>
IPC settings	<ul style="list-style-type: none"> • Speed: 25 m/min (or lower) • Acceleration: 30% • Knife overcut: 0,1 mm • For circles, a circle adjustment value may be necessary
Remarks	<ul style="list-style-type: none"> • For a clean result, mirror the design and cut from the backside (no overcut on frontside) • PET-Felt is a porous material - to obtain best vacuum on the table, for smaller material sheets, cover the open vacuum areas with another material.
Result	

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Machine	Zund
Tools	EOT250 - Z21
ZCC settings	<ul style="list-style-type: none">• Search for Polyester Fiber Board - Acoustic Panels• Change the thickness to 9mm• Acceleration, tool lowered: 2• Acceleration, tool lifted: 4• Speed, tool lowered: 70 mm/s• Speed, tool lifted: 1000 mm/s• Speed, lowering tool: 100 mm/s• Auto lift-up angle: 15°• Auto lift-up clearing distance: 1 mm• Clearing distance: 5 mm• Base depth: 0,8 mm• Overcut: Off• Knife compensation: On• Knife compensation Multiplier X: 95%• Knife compensation Correct Y: 0 mm• Generic parameter: cr4

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Machine	Summa				
Method	Tool	Blade	Speed	Blade compensation	Acceleration
Crease	-	-	-	-	-
Kiss-cut	-	-	-	-	-
Thru-cut	EOT	500-9815	100mm/s	-	Auto
	POT	500-9830	150-200mm/s		
		500-9832			
		500-9834			
V-cut 0°	Standard & HM	800mm/s			
V-cut 45	Bevel Cut	500-0546	100-300mm/s	-	Auto
	V-45°	Standard & HM	400mm/s		
V-cut 30	V-30°	Standard & HM	400mm/s	-	Auto
V-cut 22.5	V-22.5°	Standard & HM	400mm/s	-	Auto
V-cut 15	V-15°	Standard & HM	400mm/s	-	Auto
Bevel-cut 45	V-45°	Standard & HM	400-800mm/s	-	Auto
Bevel-cut 30	V-30°	Standard & HM	400-800mm/s	-	Auto
Bevel-cut 22.5	V-22.5°	Standard & HM	400-800mm/s	-	Auto
Bevel-cut 15	V-15°	Standard & HM	400-800mm/s	-	Auto
Engrave	-	-	-	-	-

General information

POT can be used if you like to cut more small curves because the knives are stronger. You can go a little bit faster with the POT as well compared to the EOT.

EOT can be used perfectly on this 9mm material. If you like to cut small radius curves, make sure not to go too fast because the knives may snap. Depending on the radius of the curves, you may need to change the blade compensation.

When using the bevel-cut or v-cut tools it is important to set them up correctly and have perfect ADC values. Doing a manual ADC calibration is advised especially with the Bevel-cut tool. For Bevel cut V-cut you get the perfect result with a down position offset of 6mm and a V-cut gap of -0,10mm. Going deeper is possible, but you need to keep an eye on the finish and play with the V-cut gap.

With the **V-cut tools** you can only cut straight lines, **not for curves!**

Because of the longer knives there is a possibility they will bend/flex while cutting this material. All V-cut tools can be used for bevel cut applications as for creating V-cuts. V-cuts can be made with different depths when needed.

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Results on Summa

