



Milling & cutting Recommendation

VISCOM SIGN

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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.

Cutting and milling

Tested by Andreas Harmuth CNC-Frästechnik
with the machine type: Profi 3000-2.

HARMUTH
CNC-FRÄSTECHNIK

Cutting with oscillating blade:

Option 1:

- Feed motion of 800 rpm against the feed
- Tool: 25 mm knife
- Infeed angle: - 3 Grad
- Cutting underlay: MDF

Option 2

- Feed motion of 1.900 rpm with the feed
- Tool: 10 mm knife
- Infeed angle: - 3 Grad
- Cutting underlay: MDF



Contour milling EASYPRINT & SF:

- 20.000 rpm against the feed
- Feed motion of 2.000 mm/min*
- Tool: 6 mm polished cutter with a 22 mm flute
- Cutting depth equal to material thickness
- Cutting underlay: MDF

V-groove milling EASYPRINT:

- 15.000 rpm with the feed
- Feed motion of 2.000 mm/min
- Tool: V-groove-cutter
- Cutting depth: material thickness less ~1 mm
- Cutting underlay: MDF

*2.000 mm/min recommended for optimal contours, but faster feed motions are generally possible.

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