



VISCOM Milling Recommendation

The following parameters can be given.

The specifications are without engagement and are based on experienced or recommended data. In general we recommend that tests have been made in order to achieve ideal results.

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

V-shaped groove EASYPRINT 10 mm:

15.000 - 24.000 rpm against the feed with a V cutter head

Feed motion 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)

Optimal: 15.000 rotation/min against the feed with a feed motion of 3 m/min

Contour groove EASYPRINT 10 mm:

24.000 rpm against the feed with an end mill cutter

Feed motion 2 - 6 m/min

Optimal: 24.000 rpm against the feed with a feed motion of 2 m/min

Cutting of EASYPRINT with oscillating blade:

Is not recommended for achieving optimal results because the compact facing of the EASYPRINT panels could be obstructive for the blades.

We ask for making test.

In this case VISCOM SIGN SF is more appropriated.

Straight cuts: 25 m/min

Contour: 9000 swings at 2-6 m/min