

UltraBoard Kongsberg Cutting Profile

For strait cuts, up to 30mm at high speed an HD 30 knife is the correct tool at full cutting speeds.

For strait cuts under 17mm the HD17 knife is the correct tool.

For contour cuts the MPH Vibe knife is the correct tool. For high quality cuts we recommend 200 in/min, for faster cutting we recommend up to 600 in/min.

For 0.25" board the BLD-SR6315 blade will cut with the highest detail. For lower detail and faster cuts use the BLD-SR6223 (i-7703) blade.

For board up to 19mm use the BLD-SR6310 (i-7702) blade.

If you have a milling head and would like to mill the boards here are the settings. We have 2 bits that work well for ridged foam, the BIT-MUD06-4016-64 4mm bit good for board up to .5" thick, and the BIT-MUD06-6025-64 6mm bit good for board up to 1" thick.

The recommended feed and speed for the 4mm bit is 400 in/min with up to 6mm passes at 45000 rpm

The recommended feed and speed for the 6mm bit is 600 in/min with up to 9mm passes at 45000 rpm

<https://store.esko.com/en/store/kongsberg-bits-blades/>

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