

Kongsberg Esko Cutter Profile for UltraBoard

For straight cuts up to 30mm at high speed an HD 30 blade holder with blade BLD-TZ230 is the correct tool at full cutting speeds.

For straight cuts under 17mm the HD 17 blade holder with blade BLD-TZ511 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/>

8535 Gander Creek Drive

Miamisburg, Ohio 45342 (USA)

Tel.: +1 937-454-1721