GRAVOSTRAT

ENGRAVING TIPS

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Gravostrat, commonly named Melamine is a stratified phenolic , recognised for its rigidity and resistance to chemical and mechanical wearing.

CUTTING GRAVOSTRAT

Use a Saw. Ensure you check the blade quality and not to move the saw carriage too quickly in order to avoid chips.

Circular saw
VA 1 : # 68 000 000
VA 11 : # 68 001 000

ENGRAVING GRAVOSTRAT

Always work on a clean surface.

- CLAMPING GRAVOSTRAT : the material can be clamped according to its shape and dimension on a **clamping table** or a **vacuum table** or else on a vice with **celoron or aluminium jigs** (for a small piece of material).

- ENGRAVING WITH A CUTTER : with a regulating nose and a swarf extractor.
  (Engraving Gravostrat produces small powder like particles)
  you can chose your regulating according to the engraving width, the tools and the letter to be engraved.
  A standard spindle is used :
  - engraving with a pantograph : apply a constant average pressure on the spindle
  - engraving with an electronic machine : we advise you to release the spindle spring half way

NB : you can use a collet spindle.

TOOLS

Cutter :

- In carbide (steel cutters can break)

Grinding	
Cutting angle	**40°**
Half-taper angle	**18°**
Tip angle	**7°**
Clearance angle	**15°**

Caution : these parameters are only valid with Gravograph's standard cutters.

Type of tools	Carbide
∅ 3.17	05 410 xxx
∅ 4.36	58 101 xxx
TwinCut® Insert	B7 300 xxx

NB : The size of the tip depends on the engraving width you wish to obtain.

MACHINE PARAMETERS:

Speed (mm/s)				Dwelling time	Engraving depth
	Z	X-Y	Rotation (Revolution / mn)		
CUTTER	**24**	**18**	**20 000**	**0**	**0.3 mm**

Professional tip

Number of passes : 1

FINISH

❖ **BEVELLING** : we can use the B4 or B6 machines to enhance the finish of the plate, to obtain different types of bevelling according to your requirement.

B4 : # 00 014 001
B6 : # 00 014 101

Examples :