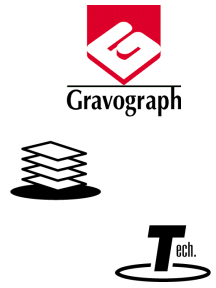




GRAVOSTRAT

ENGRAVING TIPS



Updated : 17/11/00

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°

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

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

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

MACHINE PARAMETERS:

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



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.

Examples :



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