



HP Latex R series printers Zünd cutting systems: Your choice cutting rigid substrates





Cutting PVC foam

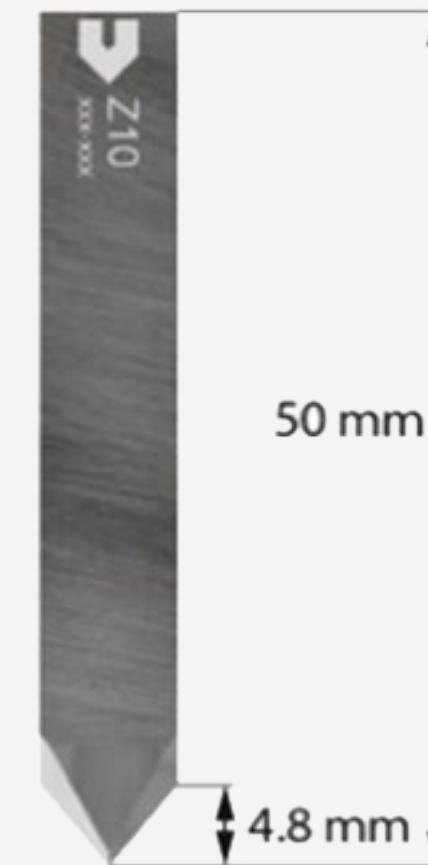


Cutting PVC foam



Recommended settings to cut sheets up to 5 mm

Head:	Universal Cutting Tool (UCT)
Cut type:	Continuous
Knife:	Z10
Cutting speed:	800 mm/s
Speed down tool:	500 mm/s
Speed up tool:	500 mm/s
Elevation angle:	40°
Acceleration down:	10 m/s
Acceleration up:	10 m/s



Cutting PVC foam

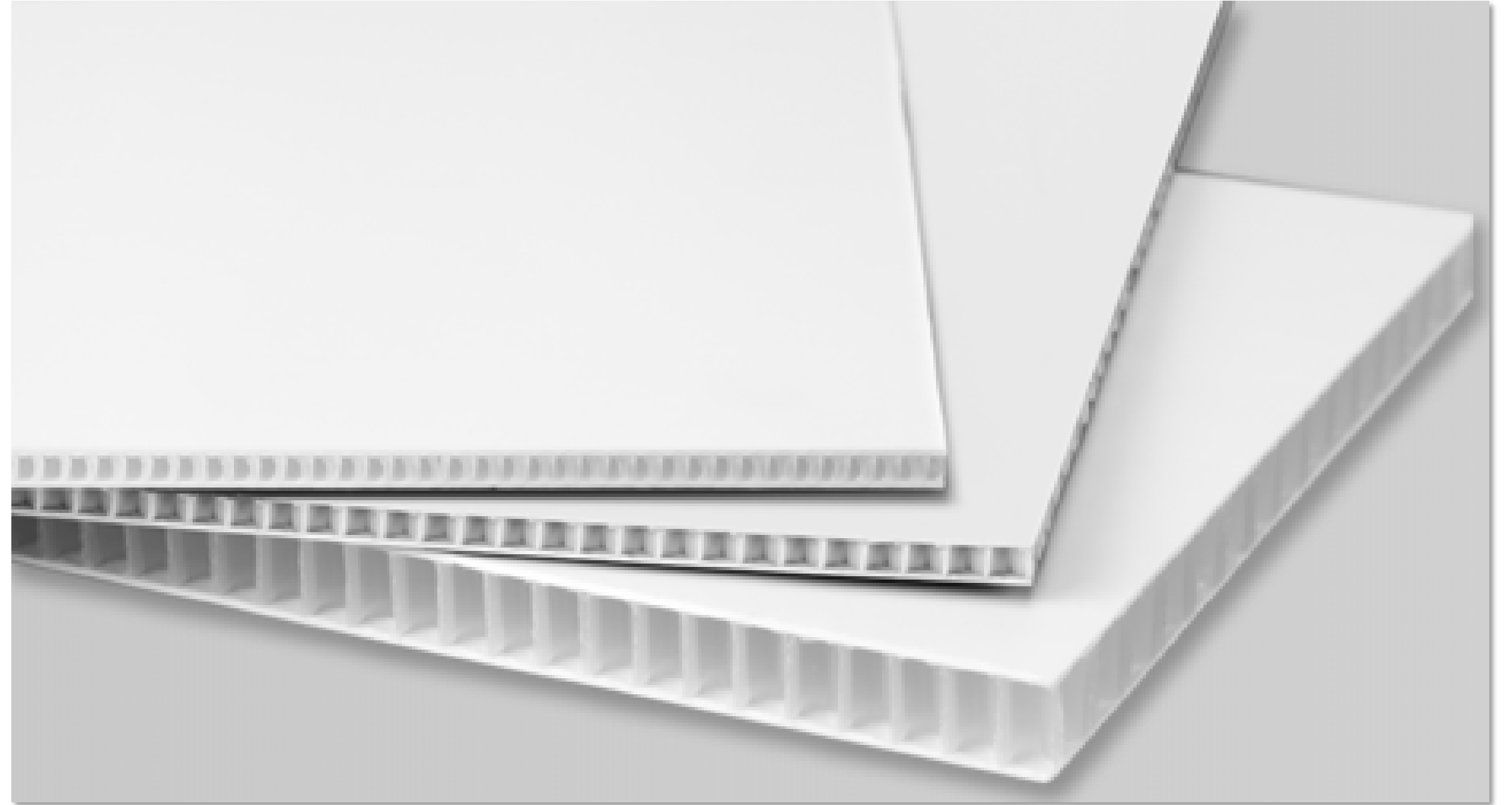
Recommended settings to cut sheets thicker than 5 mm

Head:	Router Module RM-A QC
Cut type:	Drill
Drill:	R204 (4 mm diameter)
Cutting speed:	200 mm/s
Rotational speed:	46600 rpm
Max. depth:	0,20 mm
Speed down tool:	45 mm/s
Max. cutting depth per pass:	4 mm





Cutting corrugated plastic



Cutting corrugated plastic



Recommended settings to cut sheets up to 6,9 mm

Head:	Universal Cutting Tool (UCT)
Cut type:	Continuous
Knife:	Z11
Cutting speed:	800 mm/s
Speed down tool:	200/500 mm/s
Acceleration down:	10 m/s

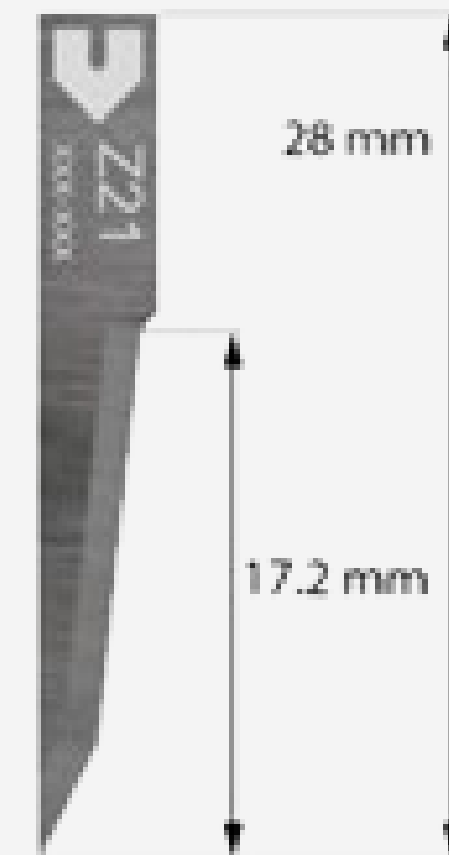


Cutting corrugated plastic



Recommended settings to cut sheets up to **16 mm** or **17 mm**

Head:	Electric Oscillation Tool (EOT)
Cut type:	Oscillating
Knife:	Z21 (17 mm) / Z60 (16 mm)
Cutting speed:	150 mm/s
Speed down tool:	200/500 mm/s
Acceleration down:	2.5 m/s



Cutting corrugated plastic

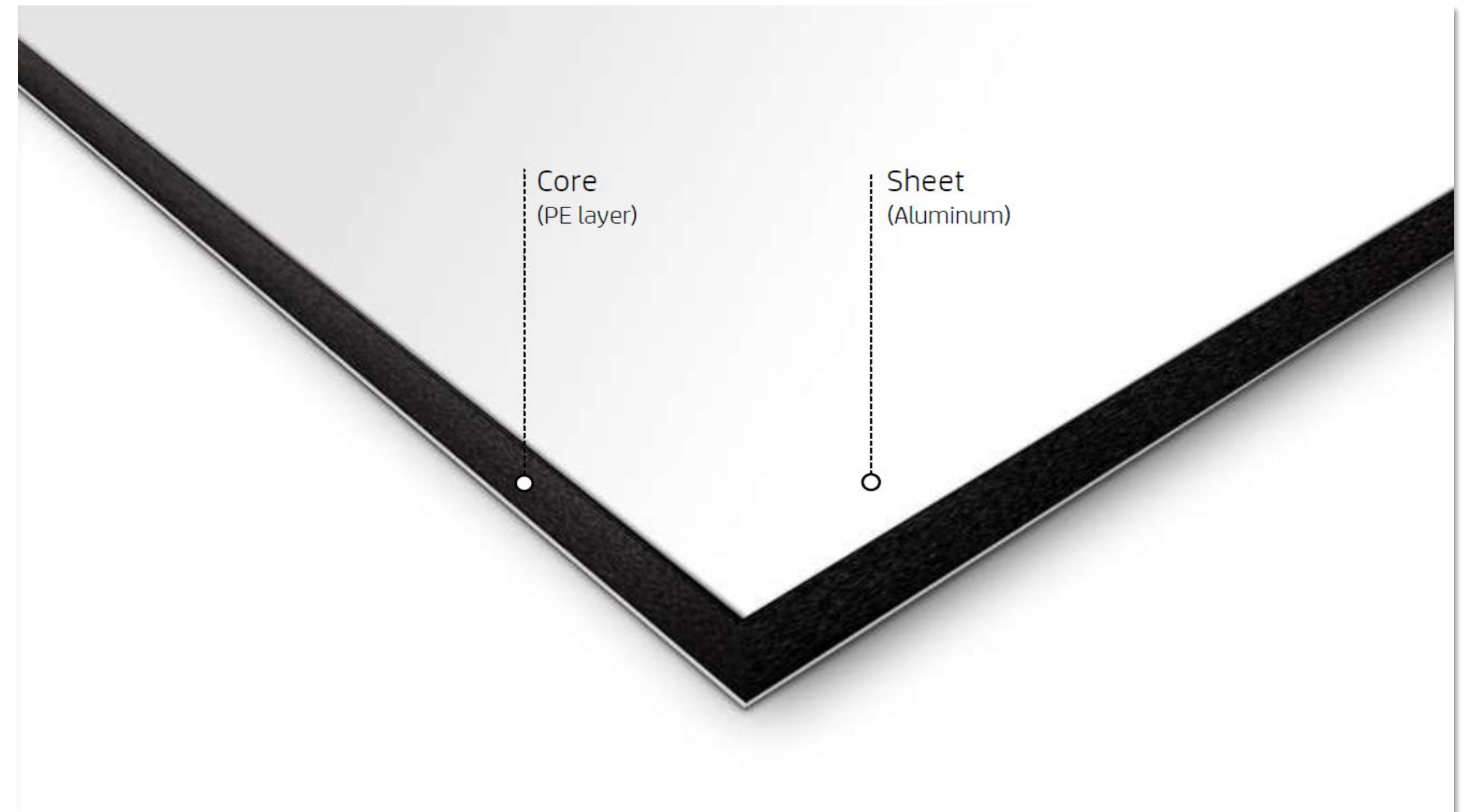


Recommended settings to cut **strong** corrugated PP boards

Head:	Pneumatic Oscillation Tool (POT)
Cut type:	Oscillating
Knife:	Z60
Cutting speed:	70 mm/s
Speed down tool:	200/500 mm/s
Acceleration down:	2.5 m/s



Cutting aluminum composite panels



Cutting aluminum composite panels

Recommended settings to cut all ACP sheets

Head:	Router Module RM-A QC
Cut type:	Drill
Drill:	R204 / R209 (4 mm diameter)
Cutting speed:	240 mm/s
Rotational speed:	46600 rpm
Compensation:	Out
Max. depth:	0.20 mm
Speed down tool:	30 mm/s
Distance to material:	3 mm
Max. cutting depth per pass:	4 mm





Cutting solid plastics



Recommended settings to cut rigid plastics

Softer plastics (Acrylic, PET-G, PVC)

Head:	Router Module RM-A QC
Cut type:	Drill
Drill:	R204 / R209 (4 mm diameter)
Cutting speed:	170 mm/s
Rotational speed:	46600 rpm
Max. depth:	0,20 mm
Speed down tool:	20 mm/s
Max. cutting depth per pass:	4 mm

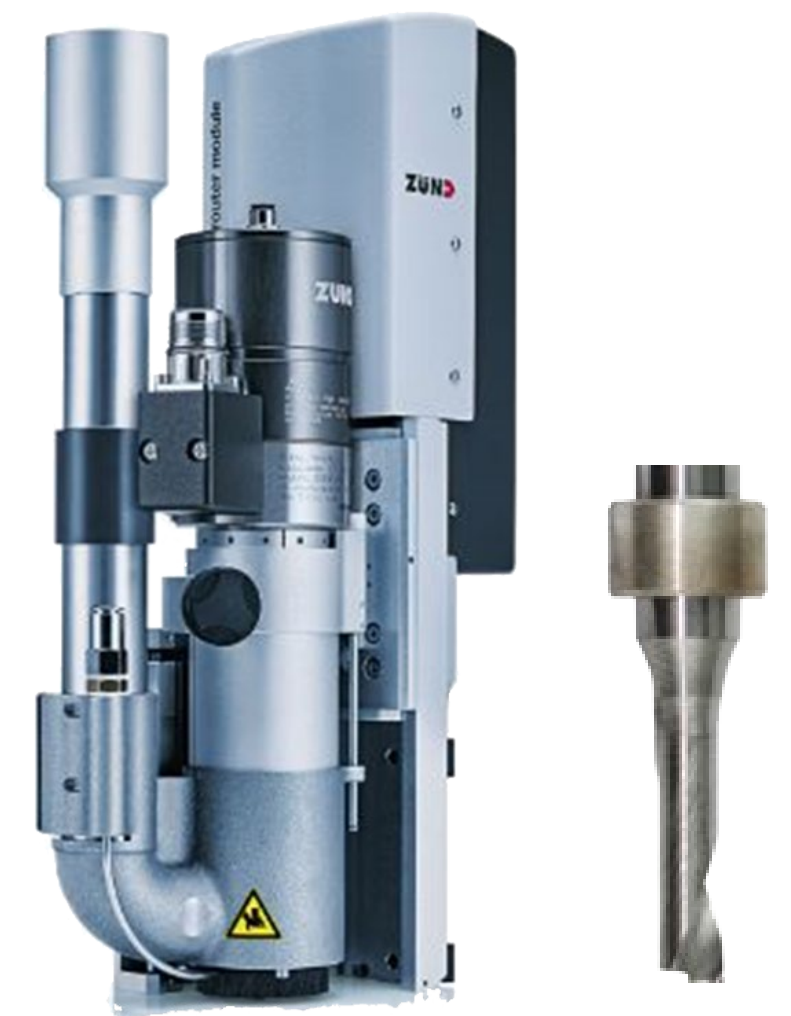
Harder plastics (Polycarbonate)

Head:	Router Module RM-A QC
Cut type:	Drill
Drill:	R204 / R209 (4 mm diameter)
Cutting speed:	170 mm/s
Rotational speed:	46600 rpm
Max. depth:	0.20 mm
Speed down tool:	20 mm/s
Max. cutting depth per pass:	2 mm

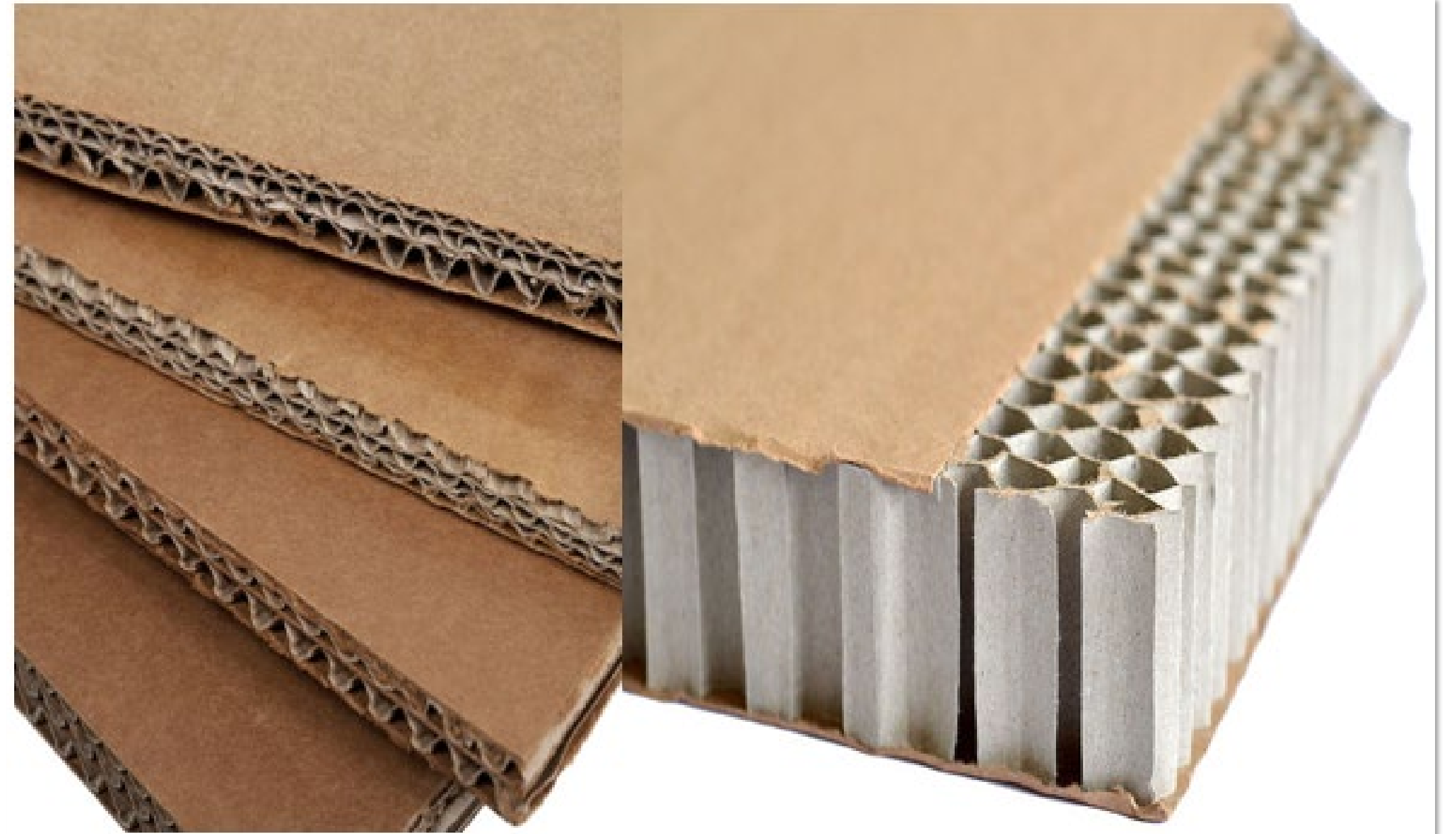


Important!

We recommend not using the same drill to cut different materials. Reserving drills for the same category of materials will ensure a more accurate cut.



Cutting corrugated cardboard



Cutting corrugated cardboard

Recommended settings to cut sheets up to **10 mm**

Head:	Electric Oscillation Tool (EOT)
Knife:	Z21
Cutting speed:	150 mm/s
Speed down tool:	200/500 mm/s
Speed up tool:	200/500 mm/s
Elevation angle:	40°
Acceleration down:	2.5 m/s
Acceleration up:	10 m/s

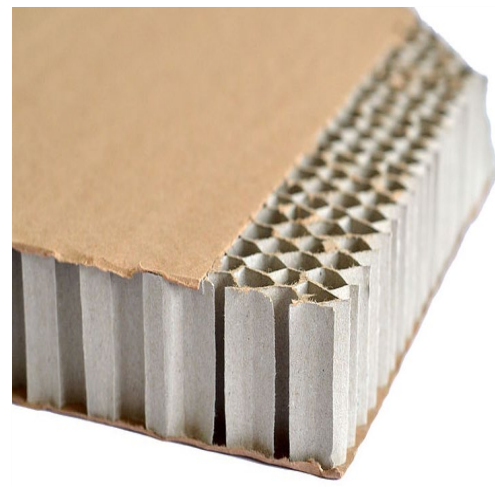


Cutting corrugated cardboard

Recommended settings to cut honeycomb cardboard

Straight cuts on sheets up to 16 mm

Head:	Pneumatic Oscillation Tool (POT)
Knife:	Z61
Cutting speed:	150 mm/s
Speed down tool:	500 mm/s
Acceleration down:	2.5 m/s

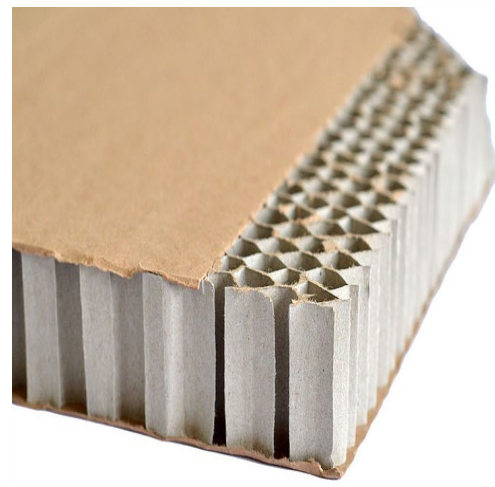


Cutting corrugated cardboard

Recommended settings to cut honeycomb cardboard

Straight cuts on sheets up to 29 mm

Head:	Pneumatic Oscillation Tool (POT)
Knife:	Z68
Cutting speed:	150 mm/s
Speed down tool:	500 mm/s
Acceleration down:	2.5 m/s

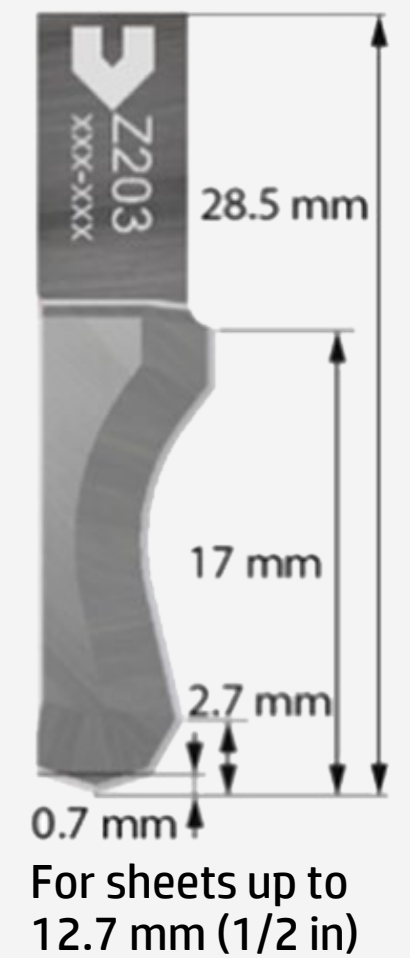
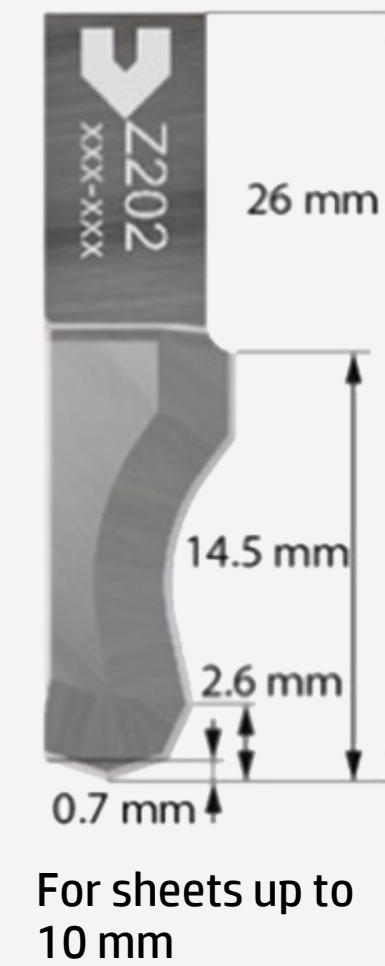
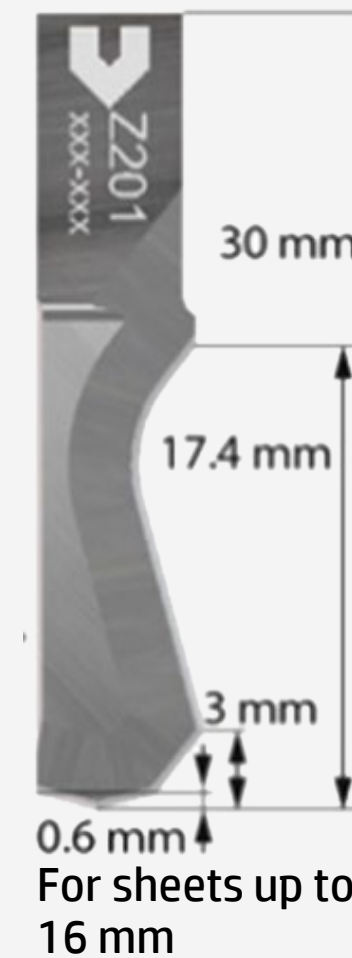
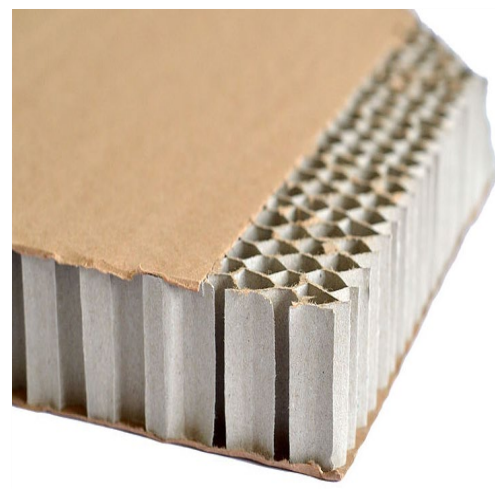


Cutting corrugated cardboard

Recommended settings to cut honeycomb cardboard

Straight cuts at high speed

Head:	Electric Oscillating Tool (EOT-250)
Knife:	Z201 / Z202 / Z203
Cutting speed:	600 mm/s
Speed down tool:	200 mm/s
Acceleration down:	10 m/s

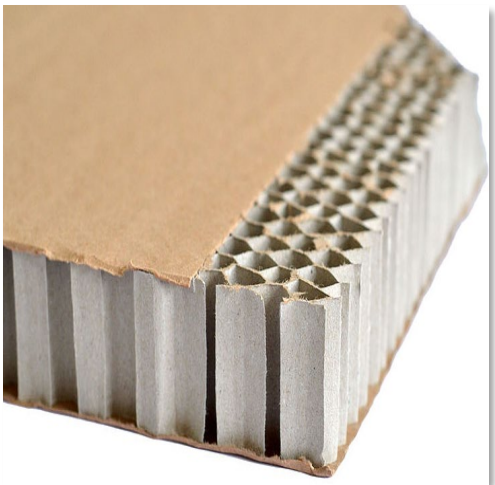


Cutting corrugated cardboard

Recommended settings to cut honeycomb cardboard

V-cuts

Head:	V-Cut Tool (VCT)
Knife:	Z71 / Z73
Cutting speed:	400 mm/s
Speed down tool:	150 mm/s
Acceleration down:	2.5 m/s



Cutting foam board



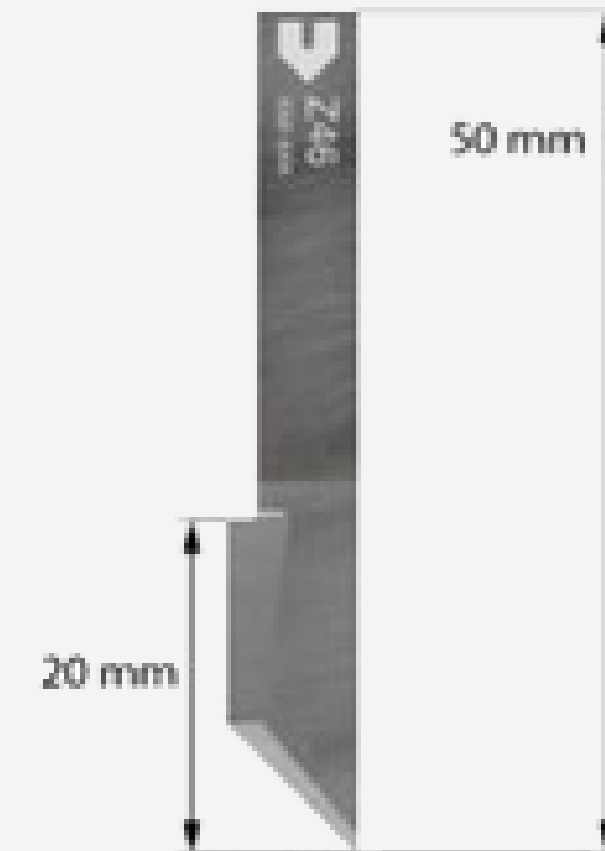
Cutting foam board

Recommended settings to cut sheets up to 5 mm

This method provides the cleanest cuts.

Note: 25 mm min. radius

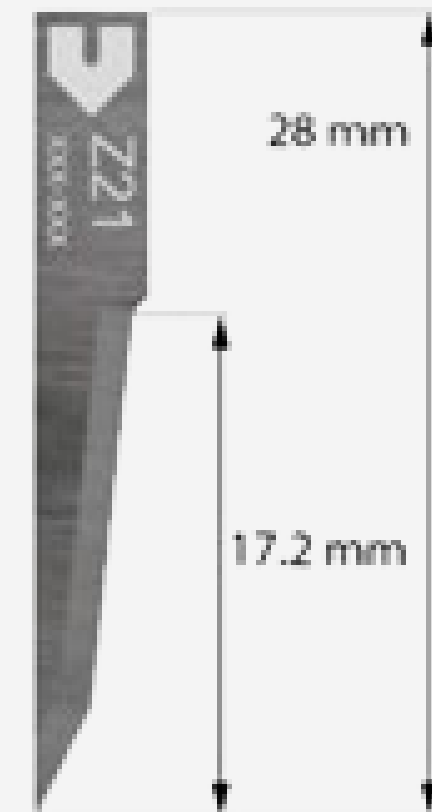
Head:	Universal Cutting Tool (UCT)
Cut type:	Continuous
Knife:	Z46
Cutting speed:	1000 mm/s
Acceleration down:	10 m/s



Cutting foam board

Recommended settings to cut sheets up to 10 mm

Head:	Electric Oscillation Tool (EOT)
Knife:	Z21
Cutting speed:	150 mm/s
Speed down tool:	200 mm/s
Speed up tool:	200/500 mm/s
Acceleration down:	2.5 m/s



Cutting foam board



Recommended settings for V-cuts on sheets up to 16 mm

Note: 100 mm min. radius

Head:	V-Cut Tool (VCT)
Knife:	Z71 / Z73
Cutting speed:	800 mm/s
Speed down tool:	150 mm/s
Acceleration down:	5 m/s



Cutting foam board



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