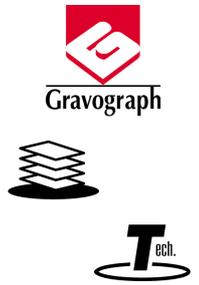




GRAVOGLAS 2 SURFACE

ENGRAVING and COLORATION TIPS



Updated : 17/11/00

Gravoglas 2 is a 2 layer acrylic material, it can be used outdoor and exists in matt, glossy and textured.

CUTTING GRAVOGLAS 2 SURFACE



We advise you to use a **Saw**.
(Be careful to check the blade quality and not move the saw carriage too quickly in order to avoid chips).

Circular saw
VA 1 : Réf. 68 000 000
VA 11 : Réf. 68 001 000

ENGRAVING GRAVOGLAS 2 SURFACE

Always work on a clean surface.

- **CLAMPING GRAVOGLAS 2** : The material can be clamped according to its shape and dimensions on a **clamping table** or a **vaccum table** or on a vice with **celoron or aluminium jigs** (for small piece of material).
For batch production, use the mechanical stop which is located on the jigs.
- **ENGRAVING WITH A CUTTER** : preferably use a **regulating nose**
You can choose your regulating nose according to the engraving width, the tools and the letters to be engraved.
The use of a **swarf extractor** is advised with Gravoglas 2 surface.



A standard spindle is used

- engraving with a pantograph : You should not apply too strong a pressure on the spindle in order not to scratch the plate but enough to ensure you will get the depth you wish to obtain.
- Engraving with an electronic machine : Ensure that the spindle spring is released so that the spindle remain supple (by using strong pressure , the regulating nose may scratch the plate).



TOOLS

Cutter :

- In steel
- In carbide (more resistant on the long run)

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

Type of tools	Steel	Carbide
Ø 3,17	05 576 xxx	05 410 xxx
Ø 4,36	58 106 xxx	58 101 xxx
TwinCut® insert	-	B7 301 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)			Dwelling time	Engraving depth
	Z	X-Y	Rotation (Revolution / mn)		
	20 to 35 (slower for textured)	13 to 20	18 to 20 000	0	0.25 to 0.3 mm

Professional tips

Number of passes : 2, one for the engraving and another to clean the bottom of the engraving

FINISH

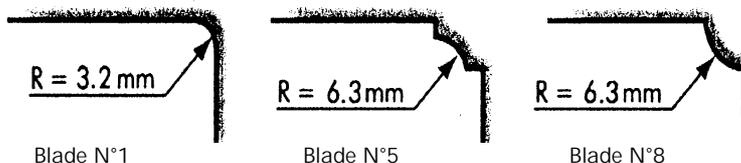
- ❖ **BEVELLING** : We can use the B4 or B6 (depending on the thickness) to enhance the finish of the plate, to obtain different types of beveling according to your requirement.

Examples :



- ❖ **CORNER CUTTING** : if you want to cut special corners on Gravoglas 2 surface (1.6mm thick), use the CSC table shear.

See examples below :



Different measures exist for various radius and width.

B4 : Réf.00 014 001
B6 : Réf.00 014 101

CSC Table shear
D4 000 000