

# ESKO Kongsberg Application Sheet



STADUR: Viscom Sign Easyprint

Material Name	STADUR VISCOM SIGN EASYPRINT 100% PVC-free Lightweight foam board
Material Thickness	10 - 19 mm
Special info	The settings in this list are ESKO's general recommendations for this material. Settings could vary depending on the geometry and details of the cut file.
Alternative materials	Lightweight rigid foam board
Machine model	C / X / Edge/ Starter
Toolhead	Kongsberg C / EDGE: HF VibraCut tool / Milling Unit (3kW router)
	Kongsberg X / EDGE: MultiCut (3kW router) / FlexiHead / PowerHead / MP High Frequency Knife Tool
	Kongsberg X Starter: MultiCut (Milling Unit 1kW) / FlexiHead

PROCESSING TYPE	MACHINE	TOOL	BLADE / BIT	SPEED	ACCEL	RPM	PASS*
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Milling	Kongsberg C Same for C-Edge, XP (Milling Unit 3kW)	Milling Unit (HPMU 3kW)	BIT-AUS06-4012-50	20 m/min	25%	52000	1-2
			BIT-AUS06-4022-50	20 m/min	25%	52000	1-2
			BIT-AUS06-6012-50	20 m/min	25%	52000	1-2
			BIT-AUS06-6022-58	20 m/min	25%	52000	1-2
			BIT-AUS06-6032-64	20 m/min	25%	52000	1-2
	Kongsberg X Same for X-Edge, XL, XN (MultiCut head 3kW router)	Milling Unit (HPMU 3kW)	BIT-AUS06-4012-50	30 m/min	50%	52000	1-2
			BIT-AUS06-4022-50	30 m/min	50%	52000	1-2
			BIT-AUS06-6012-50	30 m/min	50%	52000	1-2
			BIT-AUS06-6022-58	30 m/min	50%	52000	1-2
	X Starter Same for Kongsberg VL and V table (MultiCut head 1kW router)	Milling Unit (HPMU 1kW)	BIT-AUS06-4012-50	30 m/min	50%	45000	1-2
			BIT-AUS06-4022-50	30 m/min	50%	45000	1-2
			BIT-AUS06-6012-50	30 m/min	50%	45000	1-2
BIT-AUS06-6022-58			30 m/min	50%	45000	1-2	

Cutting standard	Kongsberg C Same for C-Edge, XP, XP Auto	HF VibraCut tool	BLD-SR6307	15 m/min	25%		1-2
			BLD-SR6310	15 m/min	25%		1-2
	Kongsberg X Same for X-Edge/ XL, XN (Insert tools for FlexiHead, MultiCut and PowerHead)	MP High Frequency Knife Tool	BLD-SR6307	20 m/min	30%		1-2
BLD-SR6310			20 m/min	30%		1-2	
Kongsberg X Starter Same for Kongsberg VL and V table (Insert tools for FlexiHead & MultiCut)	MP High Frequency Knife Too	BLD-SR6307	30 m/min	40%		1-2	
		BLD-SR6310	30 m/min	40%		1-2	

V-notching, fold & beveled edges	Kongsberg C Same for C-Edge, XP, XP Auto	V-notch Knife 45° **	BLD-TZ511	50 m/min	50%		1
		V-notch Knife 45° 10mm	BLD-TZ511	50 m/min	50%		1
	Kongsberg X Same for X-Edge, XL, XN (With PowerHead)	V-notch Knife 45° ** V-notch Knife 45° 10mm	BLD-TZ511	50 m/min	50%		1
			BLD-TZ511	50 m/min	50%		1
			V-notch Insert VI45 - 16 **	BLD-DF571 / BLD-DF572	50 m/min	50%	
	Kongsberg X Same for X-Edge, XL, XN (V-notch Insert tools for FlexiHead/MultiCut)	V-notch Insert VI45 - 10 V-notch Insert VI30 - 16 **	BLD-DF561 / BLD-DF562	50 m/min	50%		1
			BLD-DF571 / BLD-DF572	50 m/min	50%		1
			BLD-DF571 / BLD-DF572	50 m/min	50%		1
	X Starter Same for Kongsberg VL and V table (V-notch Insert tools for FlexiHead and MultiCut toolhead)	V-notch Insert VI45 - 16 ** V-notch Insert VI45 - 10 V-notch Insert VI30 - 16 **	BLD-DF571 / BLD-DF572	30 m/min	100%		1
			BLD-DF561 / BLD-DF562	30 m/min	100%		1
			BLD-DF571 / BLD-DF572	30 m/min	100%		1

\*For milling: the number of passes depends on material type, thickness and bit diameter/blade thickness. Use a pass depth that makes the groove free of chips, normally that is a depth equal to the cutting diameter of the bit you use.

\*\*The V-notch Knife 45° and V-notch Insert VI45-16 have a max cutting thickness of 16/17 mm, but V-notching in the 19mm thick material is possible, with good results.

The settings in this list are ESKO's recommendation settings for this material with a standard cutfile. Settings could vary depending on the geometry and details of the cut file.