

# GRAFITYP

makes you stick



## Cutting films

A text that can be peeled and applied perfectly. This requires a good cutting plotter, a good knife and a good cutting film. We are happy to take care of the latter.

To cut a film perfectly, the following parameters should be taken in account:

- type of knife
- knife depth
- knife pressure
- state of the knife
- cutting speed
- condition cutting line/cutting strip
- age/condition of the machine
- ambient temperature



**Graftack**  
Graftyp signmaking films

For more information  
[sales@graftyp.com](mailto:sales@graftyp.com)  
+32 11 600 850

[graftyp.com](http://graftyp.com)

# Cutting PVC-free films

PVC-free GEF films require different plotter settings than standard PVC films. Always perform a cutting test to ensure that you are using the correct settings.

The current cutting plotters can cut at a speed of over 1000mm per second, but the knife must be given enough time to cut through the material. If the cutting speed is too high, the blade will bounce. The following guidelines apply for cutting PVC-free films:

- type of knife: standard 36° knife
- cutting speed: 300mm/s
- knife pressure: 90 g



## Advantages PVC-free products



100% recyclable\*



Phthalate-free



No plasticizers



Chlorine-free



Solvent-free adhesive



REACH conform



Fire certificate B1



No harmful substances during combustion

\* The production waste of the polyolefin films is fully recyclable



## GRAPHTEC

### drag knife

- type knife: CB09
- blade Length: 0.2mm
- cutting speed: 60cm/s
- knife pressure: 7
- acceleration: 3
- assign tool: 1
- tangential mode: 1

## Summa®

### tangential knife

- type knife: 390-534 std. 36°
- cutting speed: 1000mm/s
- knife pressure: 110gr.
- sorting & panneling function: 50 cm

## Roland

### drag knife

- type knife: ZEC\_U5025 std. 50°
- cutting speed: 200m/s
- knife pressure: 90 g

## Mimaki®

### drag knife

- type knife: SPB-00001 std. 30°
- cutting speed: 300m/s
- knife pressure: 75 g