

# Materials cut and processed by ARISTOMAT Cutter



Date: 2001-03-27

All materials and according specs were thoroughly tested and approved by our support team. Other materials and / or specs are possible, but require testing. Router device: The various materials can be routed normally up to 20 mm. Use the recommended maximum material thickness below for every working cycle.

| Material          | Use  | Thick-ness mm | Tool device  | Blade/Bit   | Recommended speed, pressure      | Remarks  |
|-------------------|--|---------------|--|---|----------------------------------|--|
| Aluminium laminat | Engraving signs                                | 0.5           | Precision Routing/Engraving Device No. 0000 07311 with cooling System No. 0000 07540 | engraving needle 3mm No. 0000 07140   | <= 20                            | double sided splicing tape, fastening critical for optimum speed   |
| Aluminium laminat | Signs, props                                   | 4             | Routing Device No. 0000 07530 with cooling System No. 0000 07540                     | milling cutter No. 0000 07531, milling cutter No. 0000 07532  | <= 20                            | Use double sided splicing tape, fastening critical for optimum speed. Materials brandname: Aludibond / Alusingen, WEKA |
| Aluminium         | Engraving signs                                | 0.5           | Precision Routing/Engraving Device No. 0000 07311 with cooling System No. 0000 07540 | engraving needle 3mm No. 0000 07140   | <= 20                            | Use double sided splicing tape, fastening critical for optimum speed. Materials brandname: Aludibond / Alusingen, WEKA |
| Aluminium         | Signs, templates                               | 3             | Routing Device No. 0000 07530 with cooling System No. 0000 07540                     | milling cutter No. 0000 07531   | <= 20                            | Use double sided splicing tape, fastening critical for optimum speed   |
| Brass             | Engraving signs                                | 0.5           | Precision Routing/Engraving Device No. 0000 07311 with cooling System No. 0000 07540 | engraving needle 3mm No. 0000 07140   | <= 20                            | Use double sided splicing tape, fastening critical for optimum speed   |
| Brass             | Signs  | 3             | Routing Device No. 0000 07530  | milling cutter No. 0000 07531   | <= 20                            | Use double sided splicing tape, fastening critical for optimum speed   |
| Cardboard, carton | Templates, forms for textile and shoe industry | up to 1.2     | Pneumatic cutting device No. 0000 07309  | blade for reflective vinyls No. 0000 07750, blade for cardboards No. 0000 07132   | up to 1200, <= 5 bar             | Vacuum hold  |
| Cardboard, carton | Templates, forms for textile and shoe industry | up to 1.2     | Standard cutting device No. 0000 07305   | blade for reflective vinyls No. 0000 07750, blade for cardboards No. 0000 07132   | up to 1200, <= 29 elec. pressure | Vacuum hold  |
| Cardboard, carton | Cartons, boxes, displays                       | up to 3       | MultiHead T.T.M.P No. 0000 07312   | blade for cutting depths up to 5mm No. 0000 07275, tool holder 6mm No. 0000 07564, tool holder for crease wheels for cardboard No. 0000 07711, crease wheels for cardboard                      | up to 1000                       | Vacuum hold  |
| Cardboard, carton | Cartons, boxes, displays                       | up to 3       | MultiHead OT.T.M.P II No. 0000 07313   | blade for cutting depths up to 5mm No. 0000 07275, tool holder 6mm for oscillating mode No. 0000 07553, tool holder for crease wheels for cardboard No. 0000 07711, crease wheels for cardboard | up to 1000                       | Vacuum hold  |
| Carpeting         | Marquetry, staircase covering                  | up to 10      | MultiHead OT.T.M.P II No. 0000 07313   | blade for cutting depths up to 5mm No. 0000 07275, blade for cutting depths up to 10mm No. 0000 07267   | <= 100                           | Vacuum hold, downholder use required, cut at the front side  |

| Material                            | Use   | Thick-ness mm | Tool device                                | Blade/Bit  | Recommended speed, pressure | Remarks   |
|-------------------------------------|---|---------------|--|--|-----------------------------|---|
| Cork                                | Floor material, mats, underlayer                          | up to 15      | MultiHead OT.T.M.P II<br>No. 0000 07313    | blade for cutting depths up to 5mm<br>No. 0000 07275, blade for cutting depths up to 10mm No. 0000 07267, tool holder 6mm for oscillating mode No. 0000 07553  | <= 50                       | Vacuum hold   |
| Corrugated cardboard                | Cartons, boxes, displays                                  | up to 8       | MultiHead T.T.M.P<br>No. 0000 07312        | blade for cutting depths up to 10mm No. 0000 07267, tool holder 6mm No. 0000 07564, tool holder for crease wheels for corrugated cardboard No. 0000 07560, crease wheels for corrugated cardboard                      | up to 1000                  | Vacuum hold, results deeping on corrugted cardboard quality   |
| Corrugated cardboard                | Cartons, boxes, displays                                  | up to 15      | MultiHead OT.T.M.P II<br>No. 0000 07313    | blade for cutting depths up to 15mm No. 0000 07265, tool holder 6mm for oscillating mode No. 0000 07553, tool holder for crease wheels for corrugated cardboard No. 0000 07560, crease wheels for corrugated cardboard | up to 1000                  | Vacuum hold   |
| Corrugated plastic (Polypropylene)  | Signage, free-standing displays, In-Store Promotions      | up to 5       | MultiHead OT.T.M.P II<br>No. 0000 07313    | blade for cutting depths up to 5mm<br>No. 0000 07275, blade for cutting depths up to 10mm No. 0000 07267, tool holder 6mm for oscillating mode No. 0000 07553  | <= 500                      | Vacuum hold, quality depending on speed. Material brandname: OS PLASTICS, Plasticor   |
| Fiber glass                         | electronic industry                                       | 0,6           | Routing Device No.<br>0000 07530           | milling cutter No. 0000 07531  | 10                          | Use double sided splicing tape, fastening critical for optimum speed  |
| Foam rubber (Zotefoams)             | Gaskets, briefcases, bags, handicraft industry, mousepads | up to 15      | MultiHead OT.T.M.P II<br>No. 0000 07313    | blade for cutting depths up to 15mm No. 0000 07265, blade for cutting depths up to 10mm No. 0000 07267, tool holder 6mm for oscillating mode No. 0000 07553  | <= 500                      | Vacuum hold. Matrial brandname: Zotefoams, Möllerring   |
| Foam Sheets made of rigid PU        | Signs, Displays   | up to 15      | MultiHead OT.T.M.P II<br>No. 0000 07313    | blade for cutting depths up to 15mm No. 0000 07265, blade for cutting depths up to 10mm No. 0000 07267, tool holder 6mm for oscillating mode No. 0000 07553  | <= 1000                     | Vacuum hold, speed for highest quality 100. Material brandname: KAPA, gotorfoam   |
| Foam Sheets made of rigid PVC       | Signs, Displays, puzzel, templates                        | up to 2       | MultiHead OT.T.M.P II<br>No. 0000 07313    | blade for cutting depths up to 5mm<br>No. 0000 07275, tool holder 6mm for oscillating mode No. 0000 07553  | <= 100                      | Vacuum hold. Material brandname: Kömatex, Foamex  |
| Foam Sheets made of rigid PVC       | Signs, Displays, puzzel, templates                        | up to 20      | Routing Device No.<br>0000 07530           | milling cutter No. 0000 07531  | <= 10                       | Use double sided splicing tape, fastening critical for optimum speed. Special router bit necessary for more than 10 mm          |
| Gaskets (Centellen)                 | Gaskets   | up to 2       | MultiHead OT.T.M.P II<br>No. 0000 07313    | blade for cutting depths up to 5mm<br>No. 0000 07275, tool holder 6mm for oscillating mode No. 0000 07553  | <= 20                       | Vacuum hold. Material brandname: Centellen  |
| Gaskets Kieselgur                   | Gaskets   | up to 5       | MultiHead OT.T.M.P II<br>No. 0000 07313    | blade for cutting depths up to 5mm<br>No. 0000 07275, tool holder 6mm for oscillating mode No. 0000 07553  | <= 20                       | Vacuum hold. Material brandname: Schenk Filtersysteme, AF-S800, AF-S2000  |
| HPL (High pressure laminate)        | Kitchen tabletops, dashboard inlays etc.                  | 2             | Routing Device No.<br>0000 07530           | special bit F54  | <= 40                       | Use double sided splicing tape, fastening critical for optimum speed. Material brandname: Resopal, Hornitex, Formica, Thermopal |
| Laminated Signmaking Standard Vinyl | Signs   | 1             | Pneumatic cutting device No.<br>0000 07309 | blade for standard vinyls No. 0000 07131, blade for cardboards No. 0000 07132  | 1200, 2 bar                 | Vacuum hold   |

| Material                            | Use   | Thick-ness mm | Tool device                             | Blade/Bit   | Recommended speed, pressure | Remarks   |
|-------------------------------------|---|---------------|---|---|-----------------------------|---|
| Laminated Signmaking Standard Vinyl | Signs   | 0,25          | Standard cutting device No. 0000 07305  | blade for standard vinyls No. 0000 07131, blade for cardboards No. 0000 07132   | 1200, 6-29 elec. pressure   | Vacuum hold, kisscutting, diecutting possible   |
| Leather                             | Shoes, bags, car seats                                | 4             | MultiHead OT.T.M.P II No. 0000 07313    | blade for cutting depths up to 5mm No. 0000 07275, tool holder 6mm for oscillating mode No. 0000 07553 or flat blade No. 0000 07264, tool holder for flat blade oscillating mode No. 0000 07085 | <= 400                      | Vacuum hold   |
| Magnetic Film                       | Signs   | 0,9           | Pneumatic cutting device No. 0000 07309 | blade for reflective vinyls No. 0000 07750, blade for cardboards No. 0000 07132   | 1200, 2 bar                 | Vacuum hold: Material producer: Haas  |
| Masking Film                        | Silk screen printing                                  | 0.025         | Standard cutting device No. 0000 07305  | blade for standard vinyls No. 0000 07131  | 1000, 1-4 elec. pressure    | Vacuum hold. Material brandname: Rubilith, Regulus  |
| MDF (Medium Density Fibreboard)     | Signs, furnitures                                     | 10            | Routing Device No. 0000 07530           | milling cutter No. 0000 07531   | <= 200                      | Use double sided splicing tape, fastening critical for optimum speed  |
| Nylon Grip                          | Signs for T-shirts, clothes                           | 0,5           | Standard cutting device No. 0000 07305  | blade for standard vinyls No. 0000 07131, blade for sandblast vinyls and flock No. 0000 07864   | 1000, 10-15 elec. pressure  | Vacuum hold   |
| Paper Film                          | Printing  | 0,025         | Standard cutting device No. 0000 07305  | blade for standard vinyls No. 0000 07131  | 1000, 10-12 elec. pressure  | Vacuum hold. Material producer: TENEKA  |
| Pavement Marking Materials          | Road sign on streets                                  | 1,2           | Pneumatic cutting device No. 0000 07309 | blade for reflective vinyls No. 0000 07750, blade for cardboards No. 0000 07132   | 1000, 2 bar                 | Vacuum hold, perhaps the material has to fix additional with adhesive tape . Material producer: 3M, SWARCO-TAPE 3000          |
| Pavement Marking Materials          | Road sign on streets                                  | 2             | MultiHead OT.T.M.P II No. 0000 07313    | flat blade No. 0000 07264, tool holder for flat blade oscillating mode No. 0000 07085   | 500, 2 bar                  | Vacuum hold, perhaps the material has to fix additional with adhesive tape . Material producer: 3M, SWARCO-TAPE 3000          |
| PCA (Poly-carbonat)                 | Spacer film sheets for keyboards, templates           | 1,2           | Pneumatic cutting device No. 0000 07309 | blade for reflective vinyls No. 0000 07750, blade for cardboards No. 0000 07132   | 1000, 2-5 bar               | Vacuum hold   |
| PCA (Poly-carbonat)                 | Spacer film sheets for keyboards, templates           | 2             | MultiHead OT.T.M.P II No. 0000 07313    | blade for cutting depths up to 5mm No. 0000 07275, blade for cutting depths up to 10mm No. 0000 07267   | 100                         | Vacuum hold   |
| PE (Polythene)                      |   | 8             | Routing Device No. 0000 07530           | milling cutter No. 0000 07531   | <= 20                       | Use double sided splicing tape, fastening critical for optimum speed  |
| Plywood                             | Signs   | 10            | Routing Device No. 0000 07530           | milling cutter No. 0000 07531   | <= 20                       | double sided splicing tape, fastening critical for optimum speed  |
| PMMA (Acrylic, Plexi)               | Signs, furniture, display cabinets, shelves           | 12            | Routing Device No. 0000 07530           | milling cutter No. 0000 07531   | <= 5                        | Use double-sided splicing tape, vacuum for engraving. Critical for optimum speed. Material brandname: Acrylic, Plexi, Perspex |
| PMMA mixed with stone dust          | Kitchen tabletops, looks like stone                   | 10            | Routing Device No. 0000 07530           | milling cutter No. 0000 07531   | <= 20                       | Use double sided splicing tape, fastening critical for optimum speed. Material brandname: Corian                              |
| Printed circuits boards, flexible   | Elektronic industry (car industry, electric balances) | 0,4           | Pneumatic cutting device No. 0000 07309 | blade for reflective vinyls No. 0000 07750  | up to 1000, 2 bar           | Vacuum hold, max. speed depends on material   |

| Material                                      | Use  | Thick-ness mm | Tool device  | Blade/Bit   | Recommended speed, pressure     | Remarks  |
|---|--|---------------|--|---|---------------------------------|--|
| <b>PS (Polystyrene)</b>                       |  | 8             | Routing Device No. 0000 07530                              | milling cutter No. 0000 07531   | <= 20                           | Use double sided splicing tape, fastening critical for optimum speed                                       |
| <b>PTFE (Teflon)</b>                          | Gaskets  | 2             | MultiHead OT.T.M.P II No. 0000 07313                       | blade for cutting depths up to 5mm No. 0000 07275, blade for cutting depths up to 10mm No. 0000 07267             | <= 50                           | Vacuum hold  |
| <b>PVB-PET laminate</b>                       | Film for safety glass                          | 1             | Dual mode Kisscutting / Diecutting toolhead No. 0000 07306 | blade for reflective vinyls No. 0000 07750  | 1200, up to 5-29 elec. pressure | Vacuum hold  |
| <b>PVB-PET laminate</b>                       | Film for safety glass                          | 1             | Pneumatic cutting device No. 0000 07309                    | blade for reflective vinyls No. 0000 07750  | 1200, 2 bar                     | Vacuum hold  |
| <b>PVC (rigid sheets of Polyvinylchlorid)</b> | Templates                                      | 1.2           | Routing Device No. 0000 07530                              | milling cutter No. 0000 07531   | 200                             | Use double sided splicing tape   |
| <b>PVC (rigid sheets of Polyvinylchlorid)</b> | Templates                                      | 1             | Pneumatic cutting device No. 0000 07309                    | blade for cardboard No. 0000 07132  | 1000, 2-5 bar                   | Vacuum hold  |
| <b>PVC (rigid sheets of Polyvinylchlorid)</b> | Templates                                      | 1             | MultiHead T.T.M.P No. 0000 07312                           | Tool holder 3mm No. 0000 07262, blade for cardboard No. 0000 07132  | 1000                            | Vacuum hold  |
| <b>Sandblast vinyl</b>                        | for sandblast stones, steel, glass, etc.       | 1             | Standard cutting device No. 0000 07305                     | blade for standard vinyls No. 0000 07131, blade for sandblast vinyls and flock No. 0000 07864                     | <= 200, 10-20 elec. pressure    | Vacuum hold  |
| <b>Signmaking Standard Vinyl</b>              | Signs  | 0,25          | Standard cutting device No. 0000 07305                     | blade for standard vinyls No. 0000 07131  | 1000, 6-12 elec. pressure       | Vacuum hold  |
| <b>Styropor</b>                               | Signs, displays                                | 10            | MultiHead OT.T.M.P II No. 0000 07313                       | blade for cutting depths up to 1 5mm No. 0000 07265, tool holder 6mm for oscillating mode No. 0000 07553,         | <= 200                          | Vacuum hold  |
| <b>Template Vinyl</b>                         | Paintings                                      | 0.025         | Standard cutting device No. 0000 07305                     | blade for standard vinyls No. 0000 07131  | 1000, 6-15 elec. pressure       | Vacuum hold  |
| <b>Traffic signs vinyl</b>                    | Diamond Grade (Typ III, 3M)                    | 0,6           | Pneumatic cutting device No. 0000 07309                    | blade for reflective vinyls No. 0000 07750 blade for cardboards No. 0000 07132                                    | 1000, 2 bar                     | Vacuum hold  |
| <b>Traffic signs vinyl</b>                    | Diamond Grade (Typ III, 3M)                    | 0,6           | MultiHead T.T.M.P No. 0000 07312                           | tool holder 3mm No. 0000 07262, blade for reflective vinyls No. 0000 07750 or blade for cardboards No. 0000 07132 | up to 1200, 2 bar               | Vacuum hold  |
| <b>Wax sheets</b>                             | Candle design                                  | 1             | Standard cutting device No. 0000 07305                     | blade for sandblast vinyls and flock No. 0000 07468   | 1000, 6-15 elec. pressure       | Vacuum hold, wax with carrier sheet  |
| <b>Wood, Balsa</b>                            | Scale models etc.                              | 1,2           | Pneumatic cutting device No. 0000 07309                    | blade for cardboards No. 0000 07132   | <= 50                           | Vacuum hold + top layer application tape   |
| <b>Wood, solid</b>                            | Signs, furniture                               | 10            | Routing Device No. 0000 07530                              | milling cutter No. 0000 07531   | <= 20                           | Use double sided splicing tape, fastening critical for optimum speed. Materials like Teak, Mahogany, Beech |
| <b>Wood, Veneer</b>                           | Marquetry (Intarsia) for doors, furnitures, .. | 0,55          | Pneumatic cutting device No. 0000 07309                    | blade for reflective vinyls No. 0000 07750  | 100, 2 bar                      | Vacuum hold + top layer application tape   |
| <b>Wood, Veneer</b>                           | Marquetry (Intarsia) for doors, furnitures, .. | 1,5           | Routing Device No. 0000 07530                              | 1mm bit (HAM Typ 421)   | 100                             | Vacuum hold + top layer application tape   |