



The Gilman Brothers Company

CUTTING GUIDELINES

KONGSBERG
 Precision Cutting Systems
 937 800 2140
support.na@kongsbergsystems.com

SERIES	MATERIAL	THICKNESS	TYPE OF CUT	TOOL	BLADE	DEGREE ANGLE	BIT	RPM	SPEED INCHES/MIN	SPEED FEET/MIN
X	Insite	3/16"	Thru Cut Less Detail	MPHF-	SR-6224				200	17
X	Insite	3/16"	Thru Cut More Detail	MPHF-	SR-6315				200	17
X	Insite	3/16"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Insite	3/16"	Thru Cut Straight	RM-KNIFE	SR-8124	0			1967	164
X	Insite	3/16"	'V' Cut	V145-16	BLD-DF570	45			1967	164
X	Insite	1/2"	Thru Cut Less Detail	MPHF-	SR-6310				200	17
X	Insite	1/2"	Thru Cut More Detail	MPHF-	SR-6315				200	17
X	Insite	1/2"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Insite	1/2"	'V' Cut	V145-16	BLD-DF570	45			1967	164
X	Insite	1/2"	pillow cut	CORRU Speed	BLO-8160				600	50
C	Insite	3/16"	Thru Cut Less Detail	HF VIBRACUT	SR-6310 OR 6303				600	50
C	Insite	3/16"	Thru Cut Straight	HD17	BLD-TZ511				3937	328
C	Insite	3/16"	'V' Notch		BLD-TZ511	45			3937	328
C	Insite	1/2"	Thru Cut Less Detail	HF VIBRACUT	SR-6310 OR 6303				600	50
C	Insite	1/2"	'V' Notch		BLD-TZ511	45			3937	328
C	Insite	1/2"	Thru Cut Less Detail	HF VIBRACUT	SR-6310 OR 6303				600	50
C	Insite	1/2"	Thru Cut Straight	HD17 or HD30***	BLD-TZ511				3937	328
X	Insite Canvas	3/16"	Thru Cut Less Detail	MPHF-	SR-6224				200	17
X	Insite Canvas	3/16"	Thru Cut More Detail	MPHF-	SR-6315				200	17
X	Insite Canvas	3/16"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Insite Canvas	3/16"	Thru Cut Straight	RM-KNIFE	SR-8124	0			1967	164
X	Insite Canvas	3/16"	'V' Cut	V145-16	BLD-DF570	45			1967	164
C	Insite Canvas	3/16"	Thru Cut Straight	HD17	BLD-TZ511				3937	328
C	Insite Canvas	3/16"	'V' Notch	HD17	BLD-TZ511	45			3937	328



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X	Infinity	3/16"	Thru Cut Less Detail	MPHF-	SR-6224				200	17
X	Infinity	3/16"	Thru Cut More Detail	MPHF-	SR-6315				200	17
X	Infinity	3/16"	Thru Cut Less Detail	Router	4MM or 6MM		BIT - MUD06-4016	55,000 - 60,000	300 - 600	25 - 50
X	Infinity	3/16"	Thru Cut More Detail	Router	4MM		BIT - MUD06-4016	55,000 - 60,000	400	33
X	Infinity	3/16"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Infinity	3/16"	Thru Cut Straight	RM-KNIFE	SR-8124	0			1967	164
X	Infinity	3/16"	Thru Cut More Detail	HF VIBRACUT	SR-6315					
X	Infinity	3/16"	'V' Cut	V145-16	BLD-DF570	45			1967	164
X	Infinity	1/2"	Thru Cut Less Detail	MPHF-	SR-6310				200	17
X	Infinity	1/2"	Thru Cut More Detail	MPHF-	SR-6310				200	17
X	Infinity	1/2"	Thru Cut Less Detail	Router	6MM		BIT - MUD06-6025	55,000 - 60,000	300 - 600	25 - 50
X	Infinity	1/2"	Thru Cut More Detail	Router	4MM		BIT - MUD06-4016	55,000 - 60,000	400	33
X	Infinity	1/2"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Infinity	1/2"	'V' Cut	V145-16	BLD-DF570	45			1967	164
C	Infinity	3/16"	Thru Cut Less Detail	HF VIBRACUT	SR-6224				600	50
C	Infinity	3/16"	Thru Cut Straight	HD17 or HD30***	BLD-TZ511				3937	328
C	Infinity	3/16"	'V' Notch		BLD-TZ511	45			3937	328
C	Infinity	1/2"	'V' Notch		BLD-TZ511	45			3937	328
C	Infinity	1/2"	Thru Cut Less Detail	HF VIBRACUT	SR-6310 OR 6303				600	50
C	Infinity	1/2"	Thru Cut Straight	HD17 or HD30***	BLD-TZ511				3937	328



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SERIES	MATERIAL	THICKNESS	TYPE OF CUT	TOOL	BLADE	DEGREE ANGLE	BIT	RPM	SPEED INCHES/MIN	SPEED FEET/MIN
X	Eagle Cell	1/4"	Thru Cut Less Detail	MPHF-	SR-6310				200	17
X	Eagle Cell	1/4"	Thru Cut More Detail	MPHF-	SR-6315				200	17
X	Eagle Cell	1/4"	Thru Cut Straight	RM-KNIFE	SR-8124	0			1967	164
X	Eagle Cell	1/4"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Eagle Cell	1/4"	'V' Cut	V145-16	BLD-DF570	45			1967	164
X	Eagle Cell	1/2"	Thru Cut Less Detail	MPHF-	SR-6310				200	17
X	Eagle Cell	1/2"	Thru Cut More Detail	MPHF-	SR-6315				200	17
X	Eagle Cell	1/2"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Eagle Cell	1/2"	'V' Cut	V145-16	BLD-DF570	45			1967	164
C	Eagle Cell	1/4"	Thru Cut Less Detail	HF VIBRACUT	SR-6310				300	25
C	Eagle Cell	1/4"	Thru Cut More Detail	HF VIBRACUT	SR-6315				300	25
C	Eagle Cell	1/4"	Thru Cut Straight	HD17	BLD-TZ511				3937	328
C	Eagle Cell	1/4"	'V' Notch		BLD-TZ511	45			3937	328
C	Eagle Cell	1/2"	Thru Cut Less Detail	HF VIBRACUT	SR-6310				300	25
C	Eagle Cell	1/2"	Thru Cut More Detail	HF VIBRACUT	SR-6315				300	25
C	Eagle Cell	1/2"	Thru Cut Straight	HD17 or HD30***	BLD-TZ511				3937	328
C	Eagle Cell	1/2"	'V' Notch		BLD-TZ511	45			3937	328
X	Ryno	3/16"	Thru Cut Less Detail	MPHF-	SR-6310				200	17
X	Ryno	3/16"	Thru Cut More Detail	MPHF-	SR-6310				200	17
X	Ryno	3/16"	Thru Cut Straight	RM-KNIFE	SR-8124	0			1967	164
X	Ryno	3/16"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Ryno	3/16"	'V' Cut	V145-16	BLD-DF570	45			1967	164
X	Ryno	1/2"	Thru Cut Less Detail	MPHF-	SR-6310				200	17
X	Ryno	1/2"	Thru Cut More Detail	MPHF-	SR-6310				200	17
X	Ryno	1/2"	Thru Cut Straight	RBI-90	SE-290				1967	164
X	Ryno	1/2"	'V' Cut	V145-16	BLD-DF570	45			1967	164



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SERIES	MATERIAL	THICKNESS	TYPE OF CUT	TOOL	BLADE	DEGREE ANGLE	BIT	RPM	SPEED INCHES/MIN	SPEED FEET/MIN
	Soft Touch Foam	LD 334w 2000x1000x 0.75	200 in/min 50% acceleration	MPHF Knife	BLD-SR6310					
	Soft Touch Foam	LD 334w 2000x1000x 0.5	200 in/min 50% acceleration	MPHF Knife	BLD-SR6310					
	Soft Touch Foam	EV 45 CN 1430X950X 0.5	50in/min 50% acceleration	MPHF Knife	BLD-SR6310					
	Soft Touch Foam	eV 45 CN 1430X950X 0.5	50in/min 50% acceleration	mPHF Knife	BLD-SR6310					
	Soft Touch Foam	Adhesive backed foam	100in/min 50% acceleration	mPHF Knife	BLD-SR6310					
	Soft Touch Foam	eV 50 BK 2000X1000X 0.75	500 in/min 50% acceleration	foam head or foam unit	BLD-SR6310					