

## Cutter Blade Manual

The following describes items on cutter blade.

When the cutter blade is replaced, perform test cutting (cutting test) to adjust the cutter blade.

For operations of the plotter, refer to the user's manual of the plotter.

Contents of this manual and product specifications are subject to change without notice.

## カッター刃に関する説明書

カッター刃に関する項目を説明します。

カッター刃を交換した場合は、テストカット（カットテスト）を行い、調整してください。







プロッター本体の操作に関しては、プロッター本体の取扱説明書を参照してください。

本書の内容および製品の仕様は、予告なしに変更することがあります。

## Types of Cutter Blades

### ⚠ CAUTION

Handle cutter blades with care!

Blade type	Remarks
<p>Supersteel blades</p> <p>CB15U (Φ1.5mm)</p>  <p>CB15U-K20 (Φ1.5mm)</p>  <p>CB15U-K30 (Φ1.5mm)</p>  <p>CB09UB (Φ0.9mm)</p> 	<ul style="list-style-type: none"> <li>The maximum cutting distance is about 4000 m (depending on the media and cutting pressure used).</li> </ul>
<p>Supersteel blades</p> <p>CB30UC (Φ3.0mm)</p>  <p>PM-CB-001 (Φ3.0mm)</p> 	<ul style="list-style-type: none"> <li>Cutting accuracy is not guaranteed.</li> <li>Be sure to try it before using it.</li> </ul>

## Cutter pen and cutter blade combinations

Color of the adjustment knob	Cutter pen part no.	Compatible blade types		
		Diameter	Part no.	Material
Blue	PHP35-CB09-HS	Φ0.9 mm	CB09UB	Cemeted carbide
Red	PHP35-CB15-HS	Φ1.5 mm	CB15U	
			CB15U-K20	
			CB15U-K30	
Silver	PM-CH-001	Φ3.0 mm	CB30UC	
			PM-CB-001	

## Setting the Cutting Conditions (Setting Conditions)

The values that can be set for each parameter are shown in the following table.

Parameter	Value that can be set	Remarks				
Cutting force (FORCE)	Tool holder 1: 1 to 40	40 steps				
	Tool holder 2: 2 to 80	40 steps; even numbers only				
Cutter blade type/ offset (OFFSET)	<table border="1"> <thead> <tr> <th>Cutter blade type</th> <th>Offset</th> </tr> </thead> <tbody> <tr> <td>CB09U, CB15U, CB15U-K20, CB15U-K30, CB30U*</td> <td>-5 to +5</td> </tr> </tbody> </table>	Cutter blade type	Offset	CB09U, CB15U, CB15U-K20, CB15U-K30, CB30U*	-5 to +5	
	Cutter blade type	Offset				
CB09U, CB15U, CB15U-K20, CB15U-K30, CB30U*	-5 to +5					
Speed (SPEED)	1 to 10, 15, 20, 25, 30, 35, 40	Unit: cm/s				
Acceleration (ACCELERATION)	1 to 6	The lower the number, the higher the cutting quality				
Tool No.	1, 2	Refer to the User's Manual.				

\* When the PM-CB-001 blade is used, please set the cutter blade type to the CB30U.

## Media and Cutting Conditions

### Cutting conditions for each media type

Cutting media		Thickness (mm)	Blade type	FORCE	SPEED	ACCELERATION
Marking film	Indoor	0.1	Cemeted carbide blade • CB09UB • CB15U	14 to 17	Up to 30	3
	Outdoor	0.05 to 0.1		10 to 14	Up to 30	3
Fluorescent film		0.2 to 0.25		16 to 20	Up to 30	3
Masking film for block copy production		0.01 to 0.1	CB15U-K20	5 to 7	5 to 20	2
Masking rubber for sandblasting		Up to 1	CB15U-K30	21 to 34	Up to 10	1
Thick paper		Up to 0.5		28 to 38	3 to 13	1
F, G flute		Up to 1.2	CB30UC	34 to 80	Up to 20	2
Thick media		1.0 to 2.0	PM-CB-001	34 to 80	Up to 20	2

### Blade Model Names and the Cutter Blade Type and Offset Displayed

Cutter blade type	Cutter blade number	LCD panel		
		Screen display	OFFSET	
			Default	Setting range
Supersteel	CB09UB	CB09U	0	±5
	CB15U	CB15U	0	±5
	CB15U-K20	CB15U-K20	0	±5
	CB15U-K30	CB15U-K30	0	±5
	CB30UC	CB30U	0	±5
	PM-CB-001	CB30U	0	±5
Other	-	OTHER	29	1 to 99

Select "OTHER" when using a blade type that is not listed in the table above or when a cutting operation using a thick or otherwise difficult-to-cut media produces unsatisfactory results, and then alternately adjust the OFFSET value and run a cutting test until the desired results are achieved.

The table below lists the guideline OFFSET settings when the blade type is set to OTHER.

Model name of the cutter blade used	OFFSET
CB09UB	19
CB15U	29
CB15U-K20	29
CB15U-K30	29
CB30UC	60
PM-CB-001	60

## Supplies

Item	Model	Contents
Cutter blade	CB09UB-5	0.9 mm diameter, cemented carbide blade (set of 5)
	CB15U-5	1.5 mm diameter, cemented carbide blade (set of 5)
	CB15U-K20-2SP	1.5 mm diameter, cemented carbide blade (set of 2)
	CB15U-K30-5	1.5 mm diameter, cemented carbide blade (set of 5)
	CB30UC-1	3.0 mm diameter, cemented carbide blade (set of 1)
	PM-CB-001	3.0 mm diameter, cemented carbide blade (set of 2)

Please check our company's home page for the latest information on supplies.