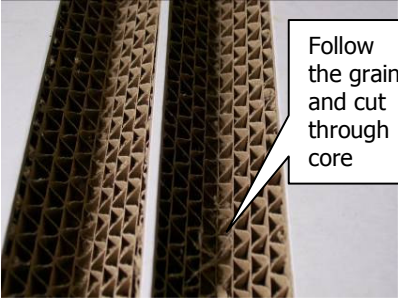
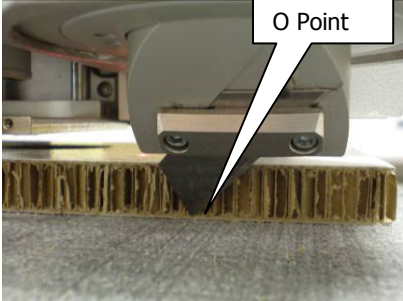
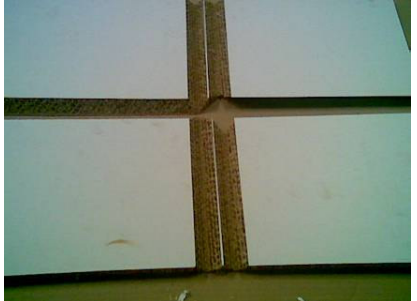
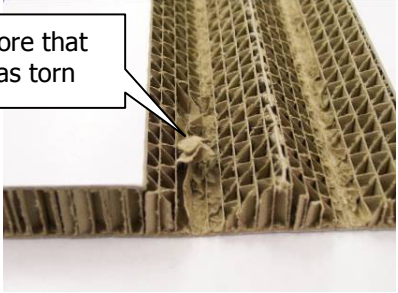
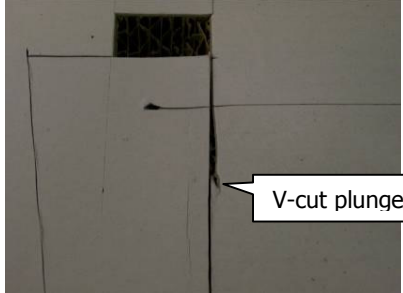
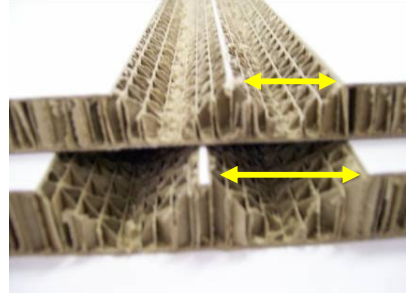
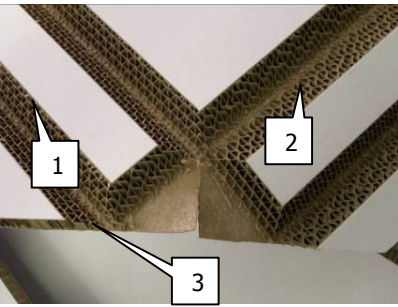
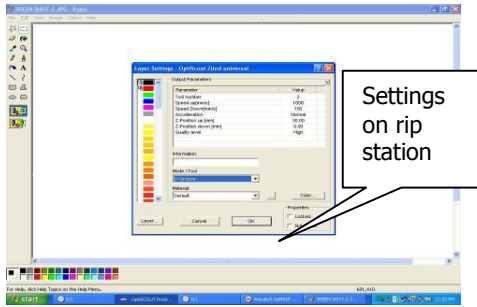


# Xanita Cutting – Critical Variables

<p><b>Q: Which direction do you cut when making a V-cut?</b></p>	<p><b>Q: What is the depth to set the blade when making a V-cut?</b></p>	<p><b>Q: What signs do I look for to see if the blade is becoming blunt?</b></p>
 <p>Follow the grain and cut through core</p> <p><b>A:</b> First cut is made following the grain of core, and then across the grain of the core.</p>	 <p><b>A:</b> The V-cut blade is stationed 1mm above the laminate or 0 point.</p>	 <p><b>A:</b> The vibration and sound of the blade on the material will increase. The tool head will also start losing direction.</p>
<p><b>Q: What happens if the cuts are too fast?</b></p>	<p><b>Q: What happens if the entry is too fast?</b></p>	<p><b>Q: What is the difference between making a 10mm,12mm and 16mm cut?</b></p>
 <p><b>A:</b> If the cuts are too fast, the cutting distance will be reduced and blunting of the blade will tear the core.</p>	 <p><b>A:</b> If the entry is too fast the blade may break or the plunge incision will be untidy.</p>	 <p><b>A:</b> The V-cut line spacing will vary according to the thickness of the X-board if folding onto itself. It is directly proportional 2:1</p>
<p><b>Q: Will the order of the different cuts made make a difference?</b></p>	<p><b>Q: What speed should I set the machine at?</b></p>	
 <p><b>A:</b> V-cuts come first, then straight cuts that don't penetrate material, and then all through cuts.</p> <ol style="list-style-type: none"> <li>1. V-cut with grain.</li> <li>2. V-cut against grain</li> <li>3. Straight cut all the way through.</li> </ol>	 <p><b>A:</b> It varies according to the tolerance of the tool head. V-cuts run best at 350mm/s. Straight cuts are best made at between 70mm/s to 100mm/s. The speed is set on software package designed for the machine.</p>	