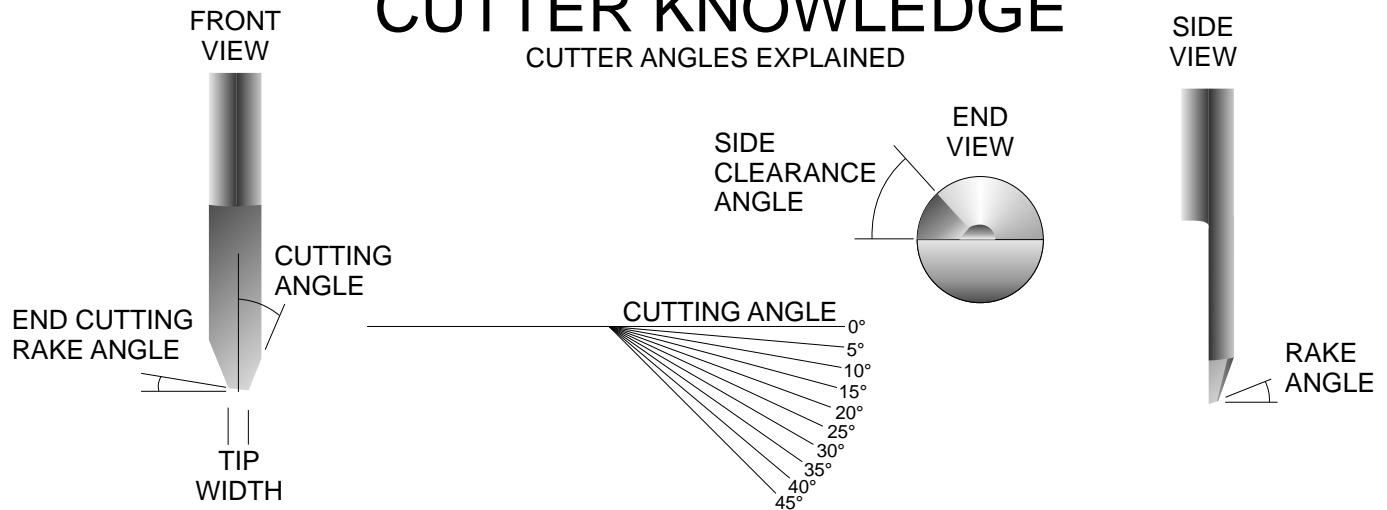


CUTTER KNOWLEDGE

CUTTER ANGLES EXPLAINED



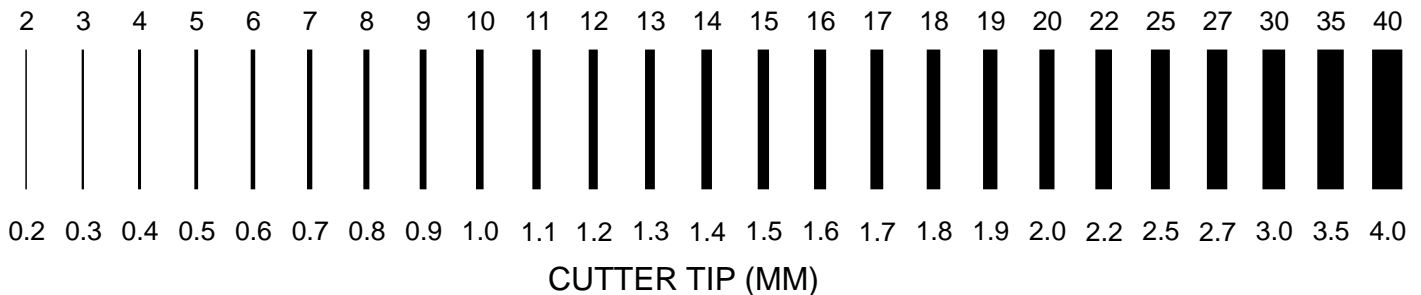
CUTTER TIP INFORMATION

THIS SCALE IS IDEAL FOR DECIDING ON CUTTER SELECTION FOR SINGLE LINE LETTERS

EXAMPLE LETTERS



LETTER HEIGHT (MM)



CHECK THE TIP OF
YOUR CUTTER AGAINST
THE SCALE BELOW

CONVERSION INFORMATION

1/32"	=	0.79mm	0.005"	=	0.13mm
1/16"	=	1.59mm	0.010"	=	0.25mm
3/32"	=	2.38mm	0.015"	=	0.38mm
1/8"	=	3.18mm	0.020"	=	0.51mm
3/16"	=	4.76mm	0.025"	=	0.64mm
1/4"	=	6.35mm	0.030"	=	0.76mm
5/16"	=	7.94mm	0.035"	=	0.89mm
3/8"	=	9.53mm	0.040"	=	1.02mm
7/16"	=	11.11mm	0.045"	=	1.14mm
1/2"	=	12.70mm	0.050"	=	1.27mm
9/16"	=	14.29mm	0.055"	=	1.40mm
5/8"	=	15.88mm	0.060"	=	1.52mm
11/16"	=	17.46mm	0.065"	=	1.65mm
3/4"	=	19.05mm	0.070"	=	1.78mm
13/16"	=	20.64mm	0.075"	=	1.91mm
7/8"	=	22.23mm	0.080"	=	2.03mm
15/16"	=	23.81mm	0.085"	=	2.16mm
1"	=	25.4mm	0.090"	=	2.29mm

CUP PLINTHS

To engrave directly onto trophy cup plinths, a carbide cutter is required. The tip should be very fine, ground to 0.005" with a cutting angle of 10°. A fine nose cone should be used to allow you to see the cutter tip. Depth of cut should be no more than 0.2mm. The engraving can then be filled with our soft filler wax.

CUTTER SHARPENING CHART

MATERIAL	RAKE ANGLE	SIDE CLEARANCE ANGLE	END CUTTING RAKE ANGLE	LUBRICANT REQUIRED
ENGRAVERS BRASS	20°	35°	5°	X
HALF-HARD ALUMINIUM	20°	40°	5°	X
SOFT ALUMINIUM	20°	40°	5°	✓
COPPER/BRONZE	20°	35°	5°	✓
FLEXIBLE PLASTIC	25°	45°	10°	X
RIGID PLASTIC	20°	40°	10°	X
HARDWOOD	25°	45°	15°	X
IRON/STEEL	15°	30°	5°	✓
STAINLESS STEEL	10°	20°	5°	✓

Cutter Shaft Diameter Guide	3mm	1/8"	4mm	11/64"	6mm	1/4"
	●	●	●	●	●	●

