

KONGSBERG C SERIES

Tooling guide

Ball & Doggett

KONGSBERG
Precision Cutting Systems

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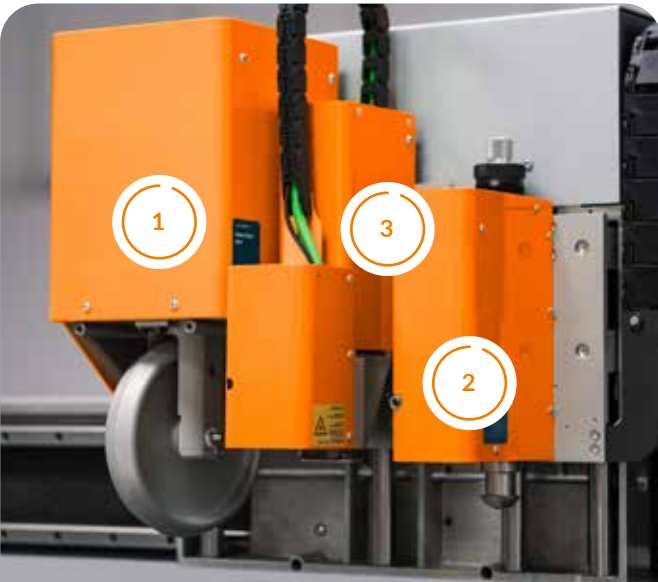
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The Kongsberg C tooling system

The Kongsberg C tooling system consists of a wide variety of optional tool units. These can be quickly mounted in the tool position. There are **three** tool positions available, so you can use up to three tools on the same job.

- 1. **Heavy-Duty Tool Position** for heavy-duty tools that are optimized for power
- 2. **Fast Tool Position** for knife tools optimized for speed
- 3. **Tool Insert Position**

		Tool Position 1	Tool Position 1 with the Fast Tool Adapter	Tool Position 2	Tool Position 3
Heavy-Duty Tools	Heavy-Duty Tool Unit	●			
	Dual Heavy-Duty Tool Unit	●			
	VariAngle Unit	●			
	High-Power Milling Unit	●			
	Foam Cutting Unit	●			
	Fast Tool Adapter (FTA)	●			
Fast Tools	High-Frequency VibraCut Knife Tool			●	
	CorruSpeed Tool		●	●	
	VibraCut Knife Tool		●	●	
	Hi-Force Knife Tool		●	●	
	Rigid Material (RM) Knife Tool		●	●	
	Psaligraphy Tool		●	●	
	RotaCut Tool		●	●	
	PressCut Tool			●	
	Braille Tool			●	
Tool Inserts	Drill Tool Insert				●
	Ballpoint Pen Insert				●
	FiberTip Tool Insert				●



Fast Tool Adapter

Sales code: 97AR5857



What is it used for?

The Fast Tool Adapter allows you to install a second fast tool in the Heavy-Duty tool position.

The Fast Tool Adapter comes in handy for jobs that need two different knife tools. Typical use cases will be trough-cutting and kiss-cutting of adhesive vinyl. The PressCut tool can be used for kiss-cutting and the RM Knife tool is perfect for trough-cutting.

Another use case could be the cutting of textile or canvas. The RM Knife can be used for the larger parts of the job on the inside the sheet; while the RotaCut tool can cut closer to the edges, preventing material buckling. This type of setup speeds up the production and delivers impeccable quality.

Notes

- The Fast Tool Adapter can be installed on all Kongsberg C and Kongsberg XP cutting tables (excl. Kongsberg XP Auto).
- The High-frequency VibraCut Knife Tool can't be used on the Fast tool Adapter (this tool can be used directly on the HD tool position)
 - The PressCut tool can't be used on the Fast Tool Adapter, it needs to be installed in the 3rd tool position

Software requirements

iPC version 2.2.1 or higher.



Heavy-Duty Tool Unit

Sales code: 97AR5456



What is it used for?

The Heavy-Duty Tool Unit (HDU) offers the possibility to crease, V-notch and cut straight lines at high speeds with a variety of adapters. This ensures superior performance with heavy duty material such as double wall, triple wall and recycled board, plus the newest environmental boards.

It features 150 mm (6 in.) diameter crease wheels with a scoring pressure equivalent to 50 kg (110 lbs); sufficient to crease triple and double wall corrugated with heavy liners. The large-size wheels also provide superior crease quality on recycled corrugated board, as a higher pressure can be applied without the risk of cracking the liner.

The HDU can offer V-notch cutting, with mitered corners and extremely precise folds for loading pallets, and container cushioning pieces, and paper core board displays.

Materials

All sorts of corrugated boards up to triple wall and including high recycled content, fluted core board, honeycomb, corrugated plastic, foam board.

Benefits

- 50 kg (110 lbs) down force
- Powerful head rotation
- Large variation of V-notch tools (multiple angles)
- HD knife tools

Included in package

- Heavy-Duty Tool Unit
- Crease wheel, Ø150, 4-point
- Crease wheel, Ø150, 6-point
- Crease wheel, U-shape, Ø150
- Adapter for 26 mm diameter wheels (w/o crease wheels)
- 2p / 26 mm crease wheel
- 3p / 26 mm crease wheel
- 6p / 26 mm crease wheel

Dual Heavy-Duty Tool Unit

Sales code: 97AR5876



What is it used for?

The Dual Heavy-Duty Tool Unit (Dual HDU) offers the possibility to crease, perforate, and cut V-notch and straight lines at high speeds with a variety of adapters. This ensures superior performance on heavy-duty material such as double wall, triple wall and recycled board, as well as the latest environmental boards.

It features 150 mm (6 in.) diameter crease wheels with a scoring pressure equivalent to 50 kg (110 lbs); sufficient to crease triple and double wall corrugated with heavy liners. The large-size wheels also provide superior crease quality on recycled corrugated board, as a higher pressure can be applied without the risk of cracking the liner.

The Dual HDU has a separate position for 60 mm wheels that facilitate creasing, perforation and tear lines through board up to 6 mm (¼ in.) without the need to change tools. Combining two independent wheels will significantly improve productivity.

The Dual HDU can offer V-notch cutting, with mitered corners and extremely precise folds for loading pallets, and container cushioning pieces, and paper core board displays.

Materials

All sorts of corrugated boards up to triple wall and including high recycled content, paper core board, honeycomb, corrugated plastic, foam board.

Benefits

- 50 kg -110 lbs down force
- Separate holder for 60 mm perforation wheels
- Powerful head rotation
- Large variation of V-notch tools (multiple angles)
- HD knife tools

Included in package

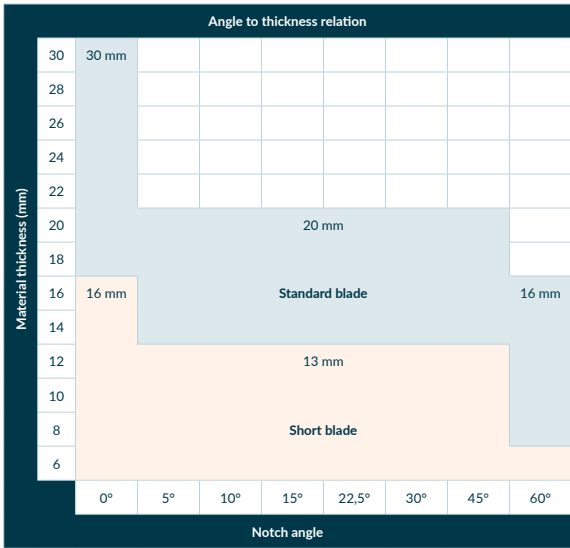
- Dual Heavy-Duty Tool Unit
- Crease wheel, Ø150, 4-point
- Crease wheel, Ø150, 6-point
- PERFormaX 955, 9 TPI x .060 in. (1.5 mm), Space 55% Hold Strength
- PERFormaX 568, 5 TPI x .135 in. (3.4 mm), Space 68% Hold Strength
- Perforation wheel, 5x5 mm
- Perforation wheel, 7x5 mm

Software requirements

iPC version 2.3 or higher.

VariAngle Unit

Sales code: 97AR5956



What is it used for?

The VariAngle Unit offers the possibility to make straight-cuts (0°) and V-notch cuts of all angles between 0° and 60°, with increments of 0.5°. The tool automatically changes the knife angle based on information from the input file. The knife angle can be set in Esko ArtiosCAD as well as in iPC.

Materials

All sorts of corrugated boards up to triple wall, paper core board, paper-based honeycomb, corrugated plastic, foam board and solid board.

Material thickness and angle overview

- Up to 60° in materials up to a thickness of 16 mm
- Up to 45° in materials up to a thickness of 20 mm
- Can cut straight (0°) in materials up to 30 mm in thickness

Benefits

- The VariAngle is a new and unique tool that will automatically adjust the cutting angle (from vertical up to 60° cutting angles) without the need to stop the production to change the tools. This results in increased productivity
- Explore and validate new creative designs with a faster time to market and more efficient production
 - Minimized operator involvement eliminates safety issues by decreasing handling of tools and blades

Included in package

- VariAngle Unit
- Knife adapter for standard knife blades
- 1x BLD-SF640 knife blade
- 2x BLD-SF641 knife blades

Optional

- Short knife blade adapter (97AR5957)
- BLD-SF620 knife blades

Software requirements

iPC version 2.4.1 or higher.

Foam Cutting Unit

Sales code: 97AR5458



What is it used for?

The Foam Cutting Unit (FCU) is a heavy-duty tool made for cutting a large range of foam materials up to 50 mm (2 in.) in thickness. These types of foam are typically used in the protective packaging industry.

The FCU has a reciprocating knife designed with characteristics optimal for low density porous material. It works with a stroke length of 4 mm and a frequency of 4,800 strokes per minute. The great Z-axis control gives an advantage when cutting foam as it ensures a consistent partial cut, which is very important for many foam designs.

Support wheels safeguard the user from the sharp blades and improve cutting abilities by applying pressure on top of the foam material. Foam materials can normally be converted at a speed up to about 15 m/min with this tool, depending on the quality of the material. A wide range of blades also makes it suitable for honeycomb and fluted core board.

Materials

Polyethylene foam; expanded polystyrene, fluted core board, paper honeycomb board.

Please note that some foam materials have a tendency to melt and stick to the knife. Materials with open cells might require additional support to hold down the material.

Benefits

- Perfect for cutting a wide range of foam materials at high speed
- Large range of specially designed blades for versatility
- Support wheels to hold the material down

Included in package

- There are two different adapters included, one for materials up to 32 mm (1¼ in.) in thickness and one for materials up to 50 mm (2 in.) in thickness
- The adapters accept the BLD-SR63xx and the BLD-SR65xx style blades. Two blades of each type are also included

Optional

- Adapter for flat 40 mm blades (34014845)
- See the Bits and Blades Catalog for more information

High-Power Milling Unit

Sales code: 97AR5457



What is it used for?

The High-Power Milling Unit (HPMU) allows for milling, contour cutting, routing, drilling and engraving. It's suitable for high speed routing in a wide range of materials such as foamed PVC, solid PVC/PS, acrylic, aluminum composite material (ACM), MDF, wood, ...

The 3 kW milling spindle offers fast feed rates, thus considerably widening the bottleneck that routing jobs often present. The spindle features 3 kW of milling power and speeds up to 60,000 RPM. It is liquid cooled in order to utilize its full power potential.

The HPMU includes a software function to supervise and monitor the spindle current, which is useful to adjust the feed rate and RPM settings for new materials.

Materials

Foamed PVC, solid PVC/PS, acrylic, aluminum composite material (ACM), MDF, wood...

The maximum material thickness that can be milled is 50 mm (2 in.). For milling thickness exceeding 25 mm (1 in.) it is beneficial to use milling bits with a shank size of 8 mm, used with an optional collet that can be interchanged with the standard 6 mm collet.

Benefits

- High quality routing at high speed
- High power, liquid cooled motor
- Large range of specialized and balanced milling bits
- Very fast milling bit exchange

Included in package

Milling starter kit for 6 mm shanks:

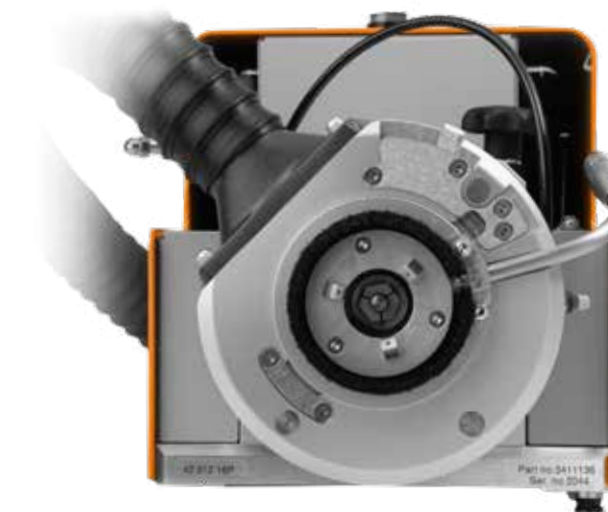
- 1x Acrylic, single flute, 3 mm tip, 11 mm flute length
- 1x Acrylic, single flute, 5 mm tip, 22 mm flute length
- 1x Multi-purpose, 3 mm tip, 11 mm flute length
- 1x Multi-purpose, 5 mm tip, 22 mm flute length
- Felt milling underlays: approx. 3 mm thick

Optional

- LubriCool misting option (see page 11)
- Collet shank sizes: 3 mm and 8 mm: see Bits and Blade Catalog
- Non-slip routing underlay: visit www.kongsbergstore.com

LubriCool misting option for HPMU

Sales code: 97AR5729



What is it used for?

LubriCool is an option for the High-Power Milling Unit. It cools and lubricates the milling bit, resulting in significantly higher productivity and an extended lifespan of the milling bits on materials such as aluminum composite material (ACM) and some aluminum alloys.

The system is set up with a reservoir with special oil that is converted into a mist with the help of compressed air and a mixing zone.

The mist is sprayed directly on the router bit via three nozzles during operation, so only a small drop of oil every 10 seconds is required (factory preset). This small amount ensures no trace on samples and low consumption.

The system can be turned off when routing materials where misting is not beneficial.

Materials

To be used for milling aluminum composite material (ACM) and aluminum.

Benefits

- Higher productivity (runs faster with fewer passes)
- Smoother routing surface, less after work
- Extended lifespan of router bits

Included in package

- Routing liquid
- Extra suction ring
 - › This ring has a larger opening and should normally be used when routing materials where the LubriCool function is not in use, especially when routing materials that generate a large amount of dust or chips such as MDF, wood and acrylics

VibraCut Knife Tool

Sales code: 97AR5464



What is it used for?

This tool is suitable for single and double wall corrugated board and other light-duty fibrous materials, such as corrugated board, soft foam board and corrugated plastic.

It runs at a frequency of 6,000 strokes per minute, with an amplitude of 0.3 mm. These properties, along with a powerful motor, enable cutting at full table speed on materials of good quality.

A floating foot is used to reduce material tear and to keep the material down. The cup is made of synthetic material to avoid scratching of printed surfaces.

Different knife adapters allow for different knife types. Maximum cutting thickness is 10-20 mm ($\frac{3}{8}$ in. - $\frac{3}{4}$ in.) depending on blade.

Materials

Corrugated single wall, corrugated double wall, micro flute, soft foam board, corrugated plastic.

Benefits

- High speed (full machine speed on materials of good quality)
- Cuts a wide range of porous materials
- Large range of high quality, durable knife blades

Included in package

- Adapter for BLD-SR6xxx blades includes
 - › 3x BLD-SR6223 knife blades
 - › 3x BLD-SR6224 knife blades
- Gliding foot for materials up to a thickness of 20 mm ($\frac{3}{4}$ in.)

Optional

- (97AR931) Separate knife blade adapter for BLD-SF216/217, including 4x BLD-SF216 and 4x BLD-SF217 blades
- Works with a wide range of blades, see the Bits and Blades Catalog

High-Frequency VibraCut Knife Tool

Sales code: 97AR5463



What is it used for?

The High-Frequency (HF) VibraCut Knife Tool is a high-frequency reciprocating knife tool for cutting a lot of different materials, such as corrugated board with high-recycled content, soft foam board, corrugated plastic and fluted core board.

It runs at a frequency of 12,000 strokes per minute, with an amplitude of 1.2 mm.

These properties, along with a powerful motor, enable cutting of heavily recycled board at efficient speed.

A floating foot is used to reduce material tear and to keep the material down.

Materials

- Corrugated material with high recycled content, fluted core board, honeycomb board, soft foam board, corrugated plastic, high density foam
- Maximum cutting thickness of 20 mm ($\frac{3}{4}$ in.) with the short foot, or 30 mm ($1\frac{1}{4}$ in.) with the optional long foot

Benefits

- Multi-purpose reciprocating knife tool for heavy-duty board
- Good performance on highly recycled content board
- Large range of knife blades

Included in package

- Adapter for BLD-SR6xxx blades, includes
 - › 3x BLD-SR6223
 - › 3x BLD-SR6224
 - › 3x BLD-SR6310
 - › 3x BLD-SR6303
- Gliding foot for materials up to a thickness of 20 mm ($\frac{3}{4}$ in.)

Optional

- (97AR931) Separate knife blade adapter for BLD-SF216/217, including 4x BLD-SF216 and 4x BLD-SF217 blades
- (97AR5148) Gliding foot for materials up to a thickness of 30 mm ($1\frac{1}{4}$ in.)
- Works with a wide range of knife blades, see the Bits and Blades Catalog

CorruSpeed Tool

Sales code: 97AR5731



What is it used for?

The CorruSpeed Tool is developed for cutting corrugated board at high speeds without oscillating. The CorruSpeed Tool achieves significant time savings on many corrugated boards, even with recycled content.

The CorruSpeed Tool operates with a crushing cup which, in combination with controlled down pressure, makes it possible to use a drag knife without tearing or cracking the liner.

Setting up the tool for different board qualities is easily done with help from the adjustment dials.

The tool also comes with two edge-crushing cups with radii of 16 and 14.5, with 14.5 offering more pre-crushing. Which cup to use depends on the thickness and quality of the corrugated board.

The feet are easy to change; they are guided by pins and magnets and snap in place easily.

Materials

The CorruSpeed Tool is designed to work with corrugated boards up to double wall BC flutes (7 mm).

Benefits

- High productivity (in many cases the full machine speed)
- Silent, the only noise you hear is that of the machine
- Smooth cut, the tool does not oscillate, so no tagged edges
- Pre-crushed lines: cutting lines are more similar to a die cut

Notes

For corrugated board with extremely short fibers and high recycled content, you might still need the properties of high frequency knife tools.

Included in package

- 2 crushing cups with radii of 16 and 14.5
- 8 standard knife blades: 2x BLD-SR8170, 2x BLD-SR8172, 2x BLD-DR8160, 2x BLD-DR8180

Optional

Works with the BLD-SR/DR8XXX blades, see the Bits and Blades Catalog.

Software requirements

iPC version 2.0 or higher.

Rigid Material Knife Tool

Sales code: 97AR5460



What is it used for?

The Rigid Material (RM) Knife Tool is a static knife tool suitable for a wide range of materials at high speed. There is a large selection of knife blades available that makes it possible to cut everything from light weight detailed work to heavy rigid board like plastic foamed PVC 3 mm.

The maximum cutting depth is defined by the blades; maximum thickness is 13 (½ in.).

Materials

Flexible plastic sheets, foamed PVC up to 3 mm, triple wall corrugated, soft foam board, corrugated plastic, cardboard, display board, vinyl, PVC banner.

Benefits

- A flexible all around knife tool, used for a wide range of applications
- Rigid board cutting at high speed
- High quality specially developed blades

Included in package

- 2x BLD-DR8160
- 2x BLD-DR8180
- 2x BLD-SR8170
- 2x BLD-SR8172

Optional

- Works with all Kongsberg PCS knife blades in the BLD-SR/DR8xxx series, including asymmetric blades for burr-free edges
- Crease blades

Psaligraphy Knife Tool

Sales code: 97AR5730



What is it used for?

The Psaligraphy Knife Tool is specifically developed for fine details in thin materials like paper and folding carton. This is achieved by a spring-loaded floating plastic foot in combination with specially designed knife blades.

This tool is typically used for applications like greeting cards, invitation cards, promotional items, folding carton samples and psaligraphy art.

Materials

Paper and folding carton.

Benefits

- Cuts intricate details without lifting, moving or tearing the material
- Durable, high quality, specially designed knife blades
- User-friendly plastic foot that snaps in place guided by pins and magnets

Included in package

2x BLD-SR6150 and 2x BLD-SR6151 round shaft cutting blades.

Optional

Works well with all Kongsberg PCS knife blades in the BLD-SR/DR61xx series, including asymmetrical blades for burr-free edges.

Software requirements

iPC version 2.0 or higher.

Hi-Force Knife Tool

Sales code: 97AR5461



What is it used for?

The Hi-Force Knife Tool is a general purpose knife tool, suitable for cutting a wide range of flexible, paper based and rigid materials.

The high downforce is achieved by directly using the machine Z-axis, which allows for cutting intricate details in tough materials. To reduce material tearing and keep the material down, a floating foot is available.

The maximum cutting depth is defined by the blades, with standard adapter maximum thickness is 3 mm (1/8 in.).

Different knife adapters allow for different knife types, see "Optional".

Materials

Flexible plastic sheets, folding carton, display board, vinyl, PVC banner, corrugated plastic.

Benefits

- A flexible, versatile knife tool
- High downforce
- Wide range of adapters and blades

Included in package

Adapter for SF blades, incl. 4x BLD-SF216 and 4x BLD-SF217 blades.

Optional

- (97AR452) Separate knife blade adapter for half-length BLD-DF112/113, including 2x BLD-DF112 and 2x BLD-DF113 blades
- (97AR5011) Separate blade adapter for the BLD-DR/SR61xx-series, including 2x BLD-DR6160 and 2x BLD-DR6161 blades
- Works with a wide range of Kongsberg PCS knife blades in the BLD-SR/DR6xxx, BLD-DF112/113, and BLD-SF216/217 series, including asymmetrical blades for burr-free edges

PressCut Knife Tool

Sales code: 97AR5462



What is it used for?

The PressCut Knife Tool is a specialty tool for kiss cutting adhesive vinyl (for decals) and foils. It's used for applications where it is important to keep the backing intact and only cut through the top film.

Due to the characteristics of the material, a spring loaded pressure is required in order to achieve perfect peel/weed quality.

The pressure is software controlled, allowing partial cut and through cut with same tool. It has an extremely fast-response on tool up/down movements.

The tool also features a software function that enables speed dependent tool pressure control, which is important to ensure reliable cutting when velocity ramps up and down.

Maximum downward knife pressure is 10 N.

Materials

Adhesive vinyl (for decals), foil, diamond grade foil.

Benefits

- Perfect weeding/peeling quality at high speed
- Tool pressure can be altered to allow both kiss cutting and through cutting
- Only the knife blade touches the material; i.e. no scratching of shiny or printed surfaces

Included in package

- 3x KC101 and 3x KC102 knife blades
- Plastic foot for accurate depth control when more pressure is required

Optional

Kongsberg PCS knife blades in the BLD-KCxx series.

Braille Tool

Sales code: 97AR5824



What is it used for?

The Braille Tool enables the application of raised dots for braille signage. The need for this tool in the market is due to regulations by governments throughout the world.

The Braille Tool inserts spheres into predrilled holes in rigid materials. The drilling requires a router tool head (HSMU or HPMU) and a special purpose milling bit. The tool is mounted as any other tool in the fast tool position.

The braille spheres are inserted into small holes by a spring load in the tool. The tool is supplied with a plunger that has two purposes; to force the spheres into the internal funnel, and to indicate the number of spheres remaining in the tool.

Materials

Rigid materials like Foamed PVC, PS, Acrylic, ACM, etc.

Benefits

Enables the creation of braille signage.

Included in package

The Braille Tool comes in the form of a kit, including:

- Two milling bits
- 10,000 clear acrylic spheres
- Various hand tools, samples and documentation on how to make braille signs

Optional

Range of different spheres.

Notes

The XP version of the Braille Tool comes with the same orange cover used for the C version.

Software requirements

iPC version 2.1 or higher.

RotaCut Tool

Sales code: 97AR5459



What is it used for?

The RotaCut Tool is specifically developed for cutting textiles, canvas, mesh and other air transparent materials. Since most textiles are more or less air transparent the vacuum hold-down system of the table will not be effective when cutting such materials. The RotaCut Tool has been designed with this in mind.

It operates by rotating a 10-facetted knife blade at 10,000 RPM. The blade protrudes from a slot in a hold-down foot that presses down on the material. The foot is made from a material that reduces friction to a minimum,. These properties, in combination with the fibrous surface of the conveyor belt or felt mats, provide a hold-down sufficient for cutting most textile materials.

Maximum cutting depth is 2 mm (0.07 in.).

Materials

Textile, banner, canvas, mesh, carpet.

Benefits

- Floating foot for holding down the material
- High-speed, 10-facetted knife blade
- Software controlled overcut function

Included in package

5x BLD-RC110 decagonal knife blades and tools for blade change.

Optional

Applicable BLD-RC110 decagonal knife blades.

Tool Insert Fixture

Sales code: 97AR5030



What is it used for?

The Tool Insert Fixture is an optional tool position and a prerequisite for the mounting tool inserts; the Ballpoint Pen Tool, Fiber Tip Pen Tool and the Drill Tool.

Ballpoint Pen Tool

Sales code: 97AR5031



What is it used for?

The Ballpoint Pen Tool is aimed for pen drawing, plotting and sample marking on materials such as folding carton, paper, cardboard and other paper based materials.

Notes

The Ballpoint Pen Insert mounts into the Tool Insert Fixture, which is an optional tool position. (97AR5030)

Included in package

2x pen refills: black, medium line weight.

Optional

Pen refills, see the Bits and Blades Catalog.

Fiber Tip Pen Tool

Sales code: 97AR5370



What is it used for?

The Fiber Tip Tool option provides drawing capabilities on materials such as clear vinyl, which normally cannot be marked with ballpoint or liquid ink pens.

Notes

The Fiber Tip Pen tool mounts into the Tool Insert Fixture, which is an optimal tool position (97AR5030).

Included in package

8 multi-colored pen refills, medium line weight.

Optional

Pen refills, thin and medium line weights; see the Bits and Blades Catalog.

Drill Tool

Sales code: 97AR5032



What is it used for?

The Drill Tool is aimed at light-duty drilling in materials such as fluted core board, honeycomb, soft foam board and triple wall corrugated. Mounting and creating fixations holes are the main applications. This tool has a 70W geared motor and spins with approximately 1,000 RPM.

The adjustable chuck accepts drill bits ranging from 0.5 to 6.5 mm (0.02 in. to 0.25 in.).

Notes

The Drill Tool mounts into the Tool Insert Fixture, which is an optional tool position (97AR5030).

Materials

Fluted core board, honeycomb, soft foam board and triple wall corrugated.

Included in package

- 2x 3 mm drill bits
- 2x 4 mm drill bits

HD Knife 17

Sales code: 97AR379



What is it used for?

Heavy-duty knife tool used for rigid board such as fluted core board, display board and triple wall material for fast straight cutting. Maximum cutting thickness is 17 mm (0.6 in.). Limited to straight lines longer than 50 mm (2 in.).

Materials

Fluted core board, triple wall, honeycomb board.

Benefits

Straight rigid panel cutting at high speeds.

Included in package

5x BLD-TZ129

HD Knife 30

Sales code: 97AR725



What is it used for?

Heavy-duty knife tool used for fast straight cutting of rigid board such as fluted core board and honeycomb board material. The maximum cutting thickness is 30 mm (1.2 in.). Limited to straight lines longer than 50 mm (2 in.).

Materials

Fluted core board, triple wall, honeycomb board.

Benefits

Straight rigid panel cutting at high speeds.

Included in package

2x BLD-TZ230, a specially designed, Tungsten Carbide knife blade.

HD Bevel Knife

Sales code: 97AR5821



What is it used for?

The HD Bevel Knife tool is suitable for a 45° slanted cut for V-notching or single through cutting.

The kit is developed for V-notching of folding lines in solid board (grey board) material using the special developed knife blade BLD-SF245.

The purpose is to create an exact, sharp 90° fold in materials that cannot be folded with conventional crease tooling.

Materials

- Solid board and display board
- Maximum cutting depth: 6-7 mm

Benefits

Perfect 45° slanted folding lines in thin materials missing.

Included in package

5x BLD-SF245.

Optional

BLD-SF212 knife blades.

Software requirements

iPC version 2.1 or higher.

45° V-notch Knife

Sales code: 97AR620



What is it used for?

For 45° V-notch cutting of triple wall corrugated, corrugated plastic and fluted core board. Its application is to make a 90° partially cut V-notch for folding functionality or a through-cut leaving a slanted cutting edge.

Max. cutting depth is 16 mm (5/8 in.). Limited to straight lines only.

Materials

Fluted core board, honeycomb board, soft foam board and triple wall corrugated.

Benefits

- Perfect 45° slanted folding lines in materials with a thickness of up to 16 mm
- Specially designed, high quality knife blades

Included in package

- 2x BLD-TZ511
- 5x BLD-TZ192

45° V-notch Knife, 10 mm

Sales code: 97AR274



What is it used for?

For 45° V-notch cutting for tougher materials like corrugated plastic. Its application is to make a 90° partially cut V-notch for folding functionality or a through-cut leaving a slanted cutting edge.

The maximum cutting depth is 10 mm (3/8 in.). Limited to straight lines only. This will provide a more accurate cut in thinner material due to the shorter free end of the blade which gives less flex.

Materials

Fluted core board, honeycomb board, soft foam board and triple wall corrugated.

Benefits

- Perfect 45° slanted folding lines in materials with a thickness of up to 10 mm
- Specially designed, high quality knife blades

Included in package

- 2x BLD-TZ511
- 5x BLD-TZ192

30° V-notch Knife

Sales code: 97AR983



What is it used for?

For 30° V-notch cutting in triple wall corrugated, corrugated plastic and fluted core board. Its application is to make a 60° partially cut V-notch for folding functionality, such as 6-edge polygonal pillars or a through-cut leaving a slanted cutting edge.

The maximum cutting depth is 16 mm (5/8 in.). Limited to straight lines only.

Materials

Fluted core board, honeycomb board, soft foam board and triple wall corrugated.

Benefits

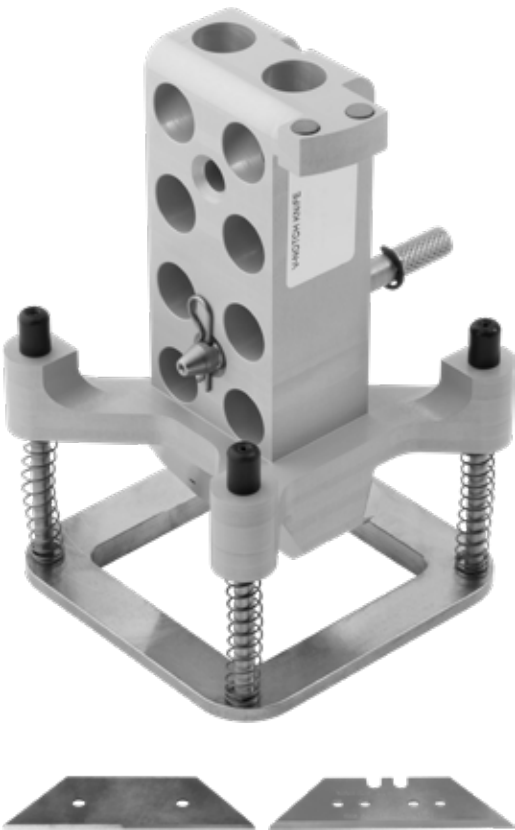
- Perfect 30° slanted folding lines in materials with a thickness of up to 16 mm
- Specially designed high quality knife blades

Included in package

- 2x BLD-TZ511
- 5x BLD-TZ192

22.5° V-notch Knife

Sales code: 97A5763



What is it used for?

For 22.5° V-notch cutting in triple wall corrugated, corrugated plastic and fluted core board. Its application is to make a 45° partially cut V-notch for folding functionality, for products such as octagonal pillars, or a through-cut leaving a slanted cutting edge.

The maximum cutting depth is 16 mm (5/8 in.). Limited to straight lines only.

Materials

Fluted core board, honeycomb board, soft foam board and triple wall corrugated.

Benefits

- Perfect 22.5° slanted folding lines in materials with a thickness of up to 16 mm
- Specially designed high quality knife blades

Included in package

- 2x BLD-TZ511
- 5x BLD-TZ192

Software requirements

iPC version 2.0 or higher.

15° V-notch Knife

Sales code: 97AR982



What is it used for?

For 15° V-notch cutting in triple wall corrugated, corrugated plastic and fluted core board. Its application is to make a 30° partially cut V-notch for folding functionality, such as 12-edge polygonal pillars or a through-cut leaving a slanted cutting edge.

Max. cutting depth is 16 mm (5/8 in.). Limited to straight lines only.

Materials

Fluted core board, honeycomb board, soft foam board and triple wall corrugated.

Benefits

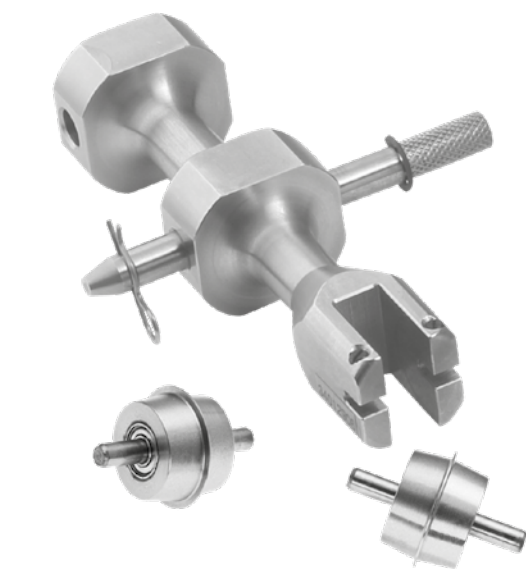
- Perfect 15° slanted folding lines in materials with a thickness of up to 16 mm
- Specially designed high quality knife blades

Included in package

- 2x BLD-TZ511
- 5x BLD-TZ192

15 mm Crease Wheel Adapter

Sales code: 97AR101



What is it used for?

An adapter for using crease wheels with diameter 15 mm is available as an optional crease tool to improve folding quality in thin materials. The application of this adapter is mainly folding carton and paper.

Materials

Paper and folding carton.

Benefits

- Use 15 mm crease wheels in combination with high down force
- Creasing in thin materials

Included in package

Adapter only. 15 mm crease wheels sold separately.

Optional

All 15 mm crease wheels.

26 mm Crease Wheel Adapter

Sales code: 97AR100



What is it used for?

An adapter for crease wheels with diameter of 26 mm is available as an optional crease tool. This adapter enables the use of a smaller sized wheel for micro flutes, folding carton and corrugated plastic. The smaller wheels and the heavy crease power have a beneficial effect on overcoming the 'memory' of the plastic material.

Materials

Corrugated single wall, micro well, corrugated plastic, folding carton.

Benefits

- Use 26 mm crease wheels in combination with high down force
- Creasing in tough plastic materials

Included in package

Adapter only. 26 mm crease wheels sold separately.

Optional

All 26 mm crease wheels.

60 mm Crease Wheel Adapter

Sales code: 97AR5588



What is it used for?

The 60 mm Crease Wheel adapter offers the possibility to crease most corrugated thicknesses.

The medium-size wheels also allow for creasing with a higher pressure without cracking the liner, and with a limited over-crease. It gives a sharper result compared to the 150 mm crease wheel, and at the same time allows harder pressure than the smaller wheel diameters.

The optional 60 mm Perforation Wheel pack offers the possibility to produce tear perforations at high speeds for corrugated board up to C flute (4 mm).

Materials

Corrugated single wall, corrugated double wall, micro flute.

Benefits

- Enables high speed perforation wheel cutting
- Enables High pressure, medium crease overcut

Included in package

Adapter only. 60 mm crease wheels and perforation wheels sold separately.

Optional

- All 60 mm Crease Wheels
 - › A 4-point wheel suitable for E- and Micro Flutes
 - › A 6-point wheel suitable for B- and C-flute
 - › U-shaped wheel for Double Wall Corrugated
- Perforation Wheel package: 4x 60 mm (97AR5517)
 - › For high speed perforation. Includes four standard perforation patterns: 3x3 mm, 5x5 mm, 7x5 mm, 10x10 mm
- Perforation Wheel package: 5x PERFormaX wheels (97AR5877)
 - › The PERFormaX wheels are used for shelf ready tear perforation. These wheels fit directly in the Kongsberg PCS 60 mm perforation wheel holder. Meaning it can be used with the 60 mm crease tool and the 60 mm crease wheel adapter for the HDU and PowerHead

Notes

There is no software control on the wheel rotation, it is not possible to control how the perforation line starts, i.e. with a cut or with a space.

8 mm Crease Blade Adapter

Sales code: 97AR5955



What is it used for?

Crease blades are typically used for creasing flexible plastic sheets such as polypropylene.

With this type of material a blunt blade will give better folding capabilities than what can be achieved with a crease wheel.

The adapter also accepts BLD-SR/DR8XXX blades.

Materials

Flexible plastic sheets, polypropylene.

Benefits

Creasing in tough flexible materials.

Included in package

- Crease Blades Adapter
- 0.5 mm crease blade
- 1.0 mm crease blade

Optional

All the 8 mm round shaft knife blades, BLD-SR/DRxxx. See the Bits & Blades catalog.

Knife Blade Adapter

Sales code: 97AR5973



What is it used for?

The adapter accepts BLD-DF212 and 213 knife blades, typically used together with the PressCut tool for trough cutting in combination with kiss cutting in adhesive vinyl and reflective foil.

Materials

Adhesive vinyl, reflective foil, diamond grade.

Benefits

Trough cutting in adhesive vinyl and reflective foil (diamond grade).

Included in package

- Knife Blade Adapter
- 1x BLD-DF212 knife blade
- 1x BLD-DF213 knife blade

Tool Trolley

Sales code: 97AR5844



What is it used for?

Keep your work area neat and safe while taking care of your valuable Kongsberg PCS tools with the Tool Trolley for Kongsberg C.

Depending on your needs, the trolley offers easy access for up to 2 HD Units and up to 4 fast tool units. The large internal storage space with two shelves allows you to store additional tools and there's a drawer for your bits and blades.

Additionally, there is a dedicated slot for used bits and blades for safe disposal and the trolley has five positions for screwdrivers for easy and fast access.

Then wheels allow the trolley to be moved easily, and can be locked for safe parking.

Dimensions

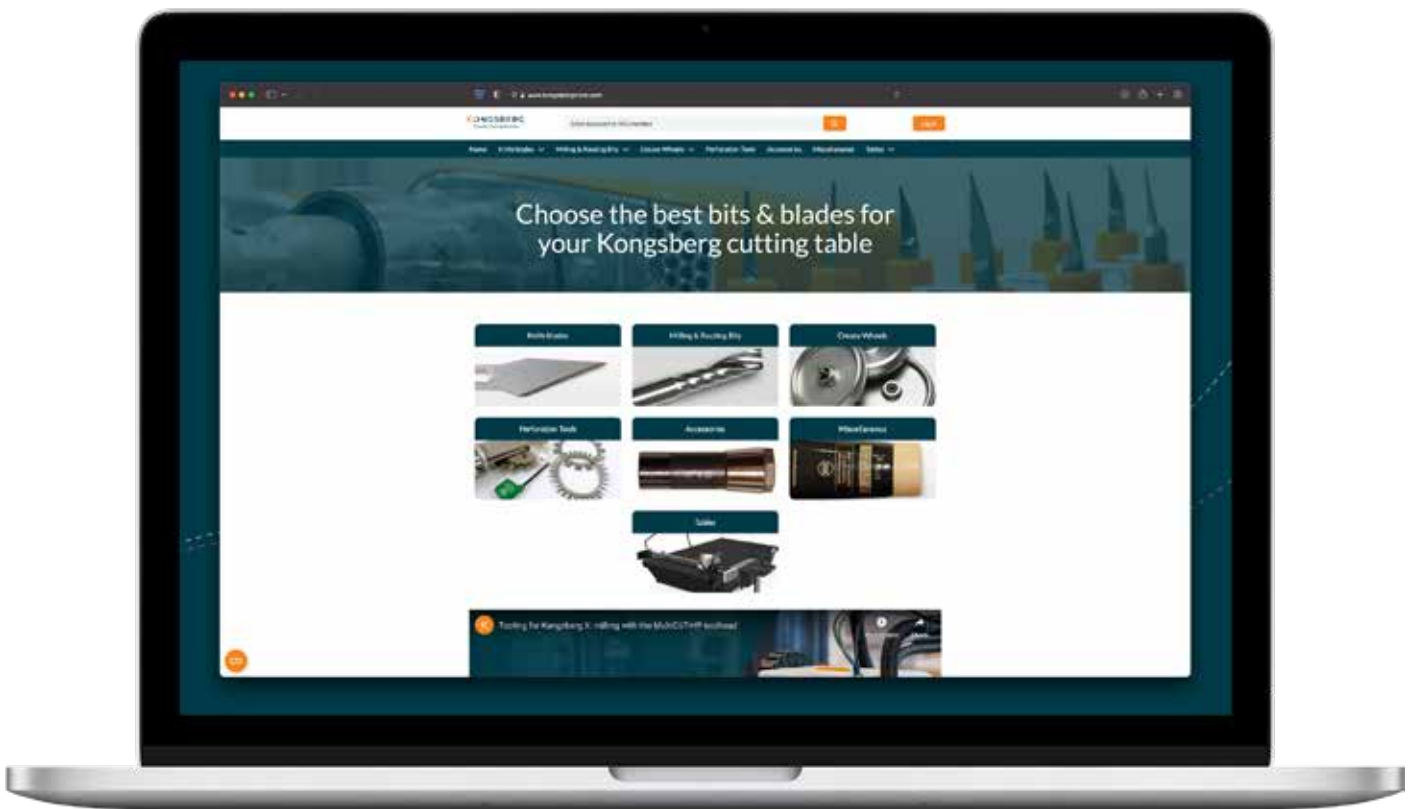
- Width: 100 cm (40 in.)
- Depth: 50 cm (20 in.)
- Height: 90 cm (35 in.)

Notes

Order your bits and blades online

Visit the Kongsberg Store to buy the best bits and blades for your Kongsberg cutting table.

www.kongsbergstore.com



Ball & Doggett

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