



Summa nv
Rochesterlaan 6
8470 Gistel
Belgium

Summa Application Sheet

Material name		Fibre
Manufacturer		Swedboard
Material Thickness		16mm
Machine		F series

Method	Tool	Blade	Speed	Blade Compensation	Acceleration
Crease	/	/	/	/	/
Kiss-cut	/	/	/	/	/
Thru-cut	V-Cut 0° POT	500-9825/500-9826	400 150	/	/
V-cut 45	✓	V-cut blade HM or Standard knife	400	DPO 0.4mm VG 0.7mm	/
V-cut 30	✓	V-cut blade HM or Standard knife	400	DPO 0.4mm VG 0.7mm	/
V-cut 22.5	✓	V-cut blade HM or Standard knife	400	DPO 0.4mm VG 0.7mm	/
V-cut 15	✓	V-cut blade HM or Standard knife	400	DPO 0.4mm VG 0.7mm	/
Bevel-cut 45	/	/	/	/	/
Bevel-cut 30	/	/	/	/	/
Bevel-cut 22.5	/	/	/	/	/
Bevel cut 15	/	/	/	/	/
Engrave	/	/	/	/	/

Routing	Router Type	Bit	Speed (mm/s)	Rotational Speed (rpm)	Routing Mode	Max depth per pass
Thru-cut	/	/	/	/	/	/
V-cut 45	/	/	/	/	/	/
Engrave	/	/	/	/	/	/

General information

DPO = Down Position Offset, adjustable in GoProduce – tool settings
VG = V-cut Gap, adjustable in GoProduce – tool settings





Summa nv
 Rochesterlaan 6
 8470 Gistel
 Belgium

Summa Application Sheet

Material name		Fibre
Manufacturer		Swedboard
Material Thickness		10mm
Machine		F series

Method	Tool	Blade	Speed	Blade Compensation	Acceleration
Crease	/	/	/	/	/
Kiss-cut	/	/	/	/	/
Thru-cut	V-Cut 0° POT	500-9825/500-9826	400 150	/	/
V-cut 45	✓	V-cut blade HM or Standard knife	400	DPO 0.5mm VG 0.4mm	/
V-cut 30	✓	V-cut blade HM or Standard knife	400	DPO 0.5mm VG 0.4mm	/
V-cut 22.5	✓	V-cut blade HM or Standard knife	400	DPO 0.5mm VG 0.4mm	/
V-cut 15	✓	V-cut blade HM or Standard knife	400	DPO 0.5mm VG 0.4mm	/
Bevel-cut 45	/	/	/	/	/
Bevel-cut 30	/	/	/	/	/
Bevel-cut 22.5	/	/	/	/	/
Bevel cut 15	/	/	/	/	/
Engrave	/	/	/	/	/

Routing	Router Type	Bit	Speed (mm/s)	Rotational Speed (rpm)	Routing Mode	Max depth per pass
Thru-cut	/	/	/	/	/	/
V-cut 45	/	/	/	/	/	/
Engrave	/	/	/	/	/	/

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DPO = Down Position Offset, adjustable in GoProduce – tool settings
 VG = V-cut Gap, adjustable in GoProduce – tool settings

