

IDEAL SPINDLE SPEED PRESETS FOR EACH TYPE OF MATERIAL ON M20 X



Materials	Engraving mode	Tool	Tool		Spindle presets					To be used with
			Ref.	Truncation (mm / inch)	X/Y speed (mm/s)	Z speed (mm/s)	Depth (mm / inch)	Measurement on regulating nose	Rotation speed (rpm)	
Aluminum Brass Plastics Acrylics Phenolic PVC	Engraving Cutting by bevelling		48608	0.25	20	25	0.3 0.012"	12	16 000	Chip collector
			48610	0.50	30	25	0.3 0.012"	12	16 000	
			48612	1.00	35	25	0.3 0.012"	12	18 000	
			48615	1.75	35	20	0.3 0.012"	12	18 000	
Aluminum Brass Stainless Steel Copper	Engraving		48636	0.25	13	6	0.3 0.012"	12	18 000	Engraving Gel
			48638	0.50	13	6	0.3 0.012"	12	18 000	
			48640	1.00	15	7	0.3 0.012"	12	20 000	
Aluminum Brass Gold Silver Titanium Stainless Steel Copper Crystal	Engraving		23060	0.1	25	15	0.1 0.004"	4	10 000	Engraving Gel
Aluminum Brass Gold Silver Titanium Stainless Steel Copper Crystal	Engraving		23061	0.1	35	15	0.1 0.004"	4	No	Engraving Gel