KATZ DISPLAY BOARD
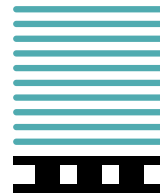## — best for digital printing —

PROCESSING RECOMMENDATIONS

KATZ DISPLAY BOARD is a natural product. To reduce climatically caused paper problems or deviations to the properties of KATZ DISPLAY BOARD, we recommend the following:
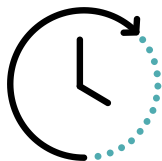
STORAGE & PROCESSING RECOMMENDATIONS

Ideal storage & converting conditions:
- temperature: 18 - 22 °C (64 - 72 °F)
- relative humidity: 45 - 55 %

Storage:
- in dry, air conditioned warehouse
- flat in horizontal position
- no high temperature & humidity changes
- no direct sunlight

Before processing:
Leave originally packed product for at least 48 hours in the production hall.

Recommendation to process the board within 1 year from the time of production.
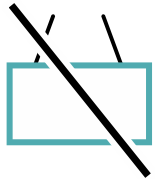
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HANDLING RECOMMENDATIONS

Wearing white cotton gloves avoids fingerprints and protects the surface.

Hanging hangers must be slanted outwards.

Never hang signs with hangers slanted inwards.
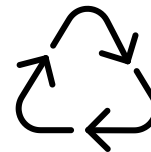
Production residues or printed end products are 100 % recyclable in paper waste.

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HALF THROUGH CUT

We achieved the best results with a static knife and an oscillating knife.

Cut

Setting: -0.5 mm

Folding:
fold the cut side,
but not more
than 90°

90°
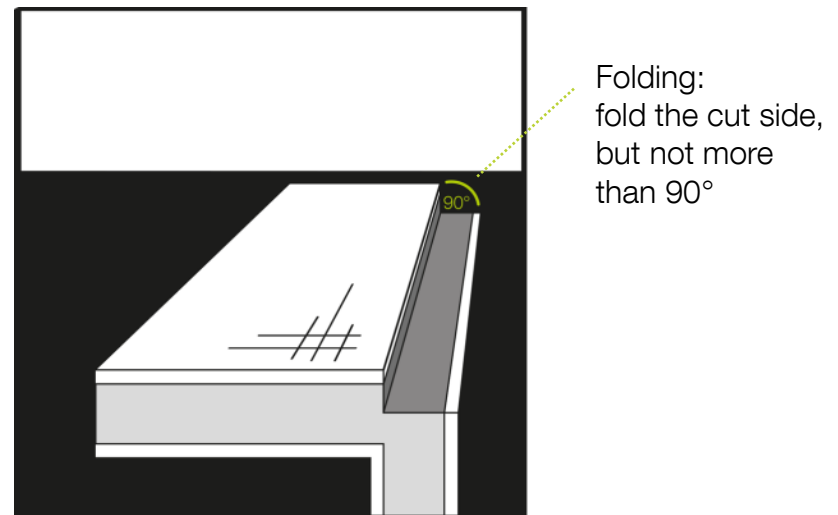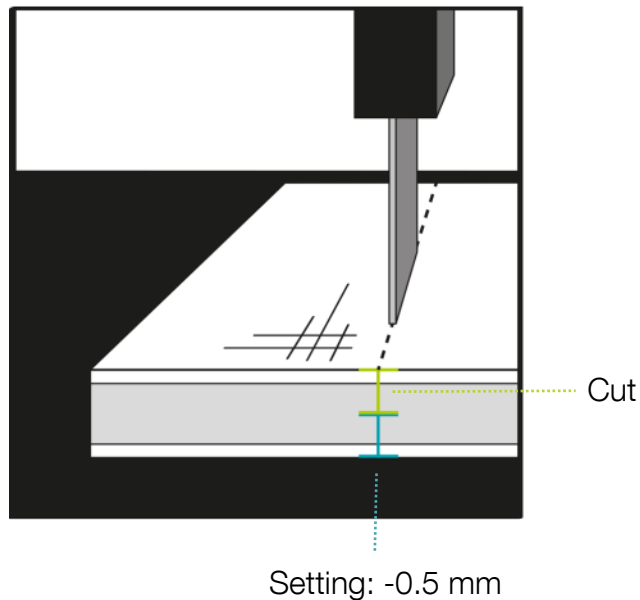
* All values are based on our experience and may differ from machine to machine.

V-CUT WITH GAP

Instead of a V-Cut tool, a router can be used too

45°

Folding of 90° and more possible without liner tension

90°

V-Cut 45°

Setting: -0.5 mm

It is important to have a small horizontal cut here
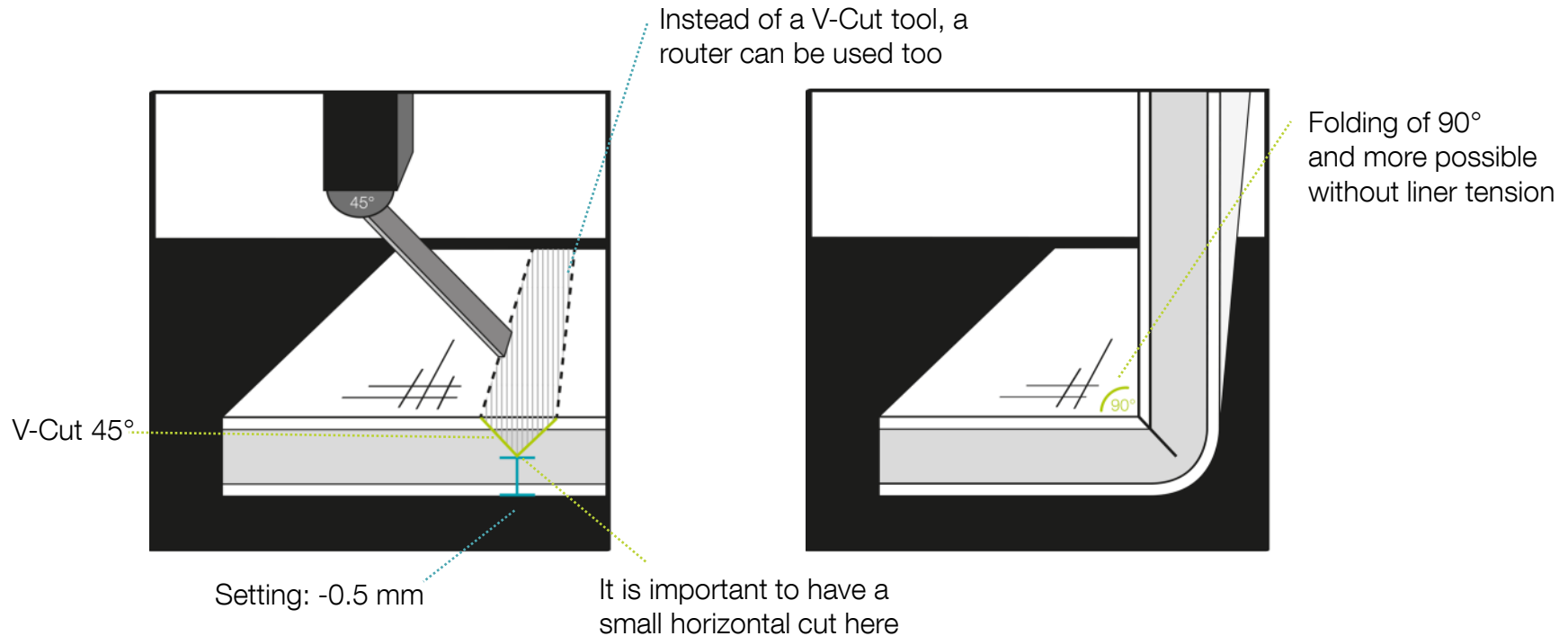
* All values are based on our experience and may differ from machine to machine.

CREASING
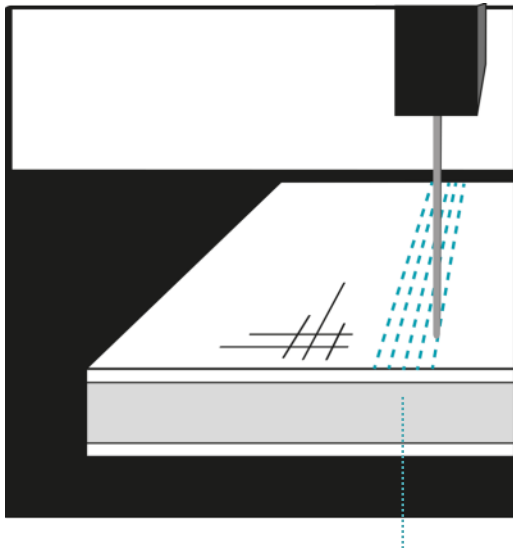
Instead of 5 creasing lines, a creasing matrix can be used

<90°

Folding of 90° and more possible

* All values are based on our experience and may differ from machine to machine.

ZÜND
swiss cutting systems

EOT: ELECTRIC OSCILLATING TOOL

TOOL

The EOT is ideally suited for cutting materials like KATZ DISPLAY BOARD. The high oscillating frequency makes it possible to cut at high processing speeds especially for fine, precise contours.

· Knife stroke: 1 mm
· Electric drive
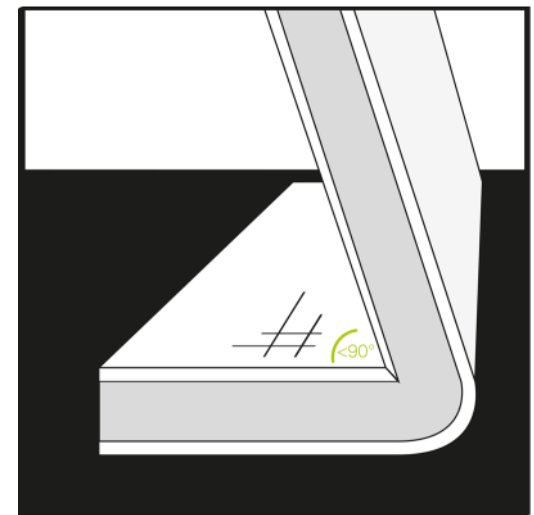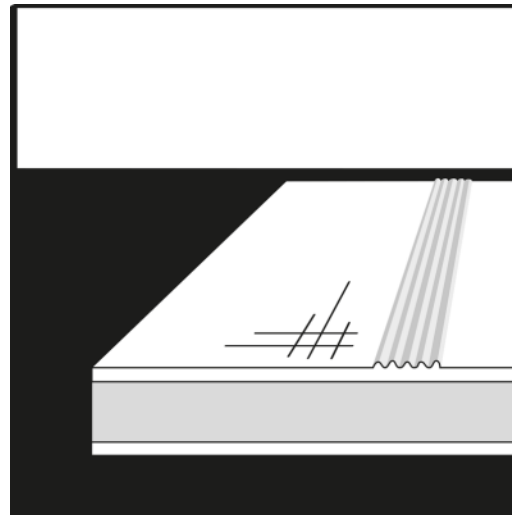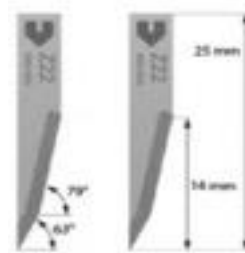· No cooling
· Compatible with G3, S3, L3

BLADE

Fine, robust blade with low overcut; designed to cut small radii and intricate detail.

· Z22

UNDERLAY

Uncoated MDF (Medium-Density Fibreboard): it's a fibreboard, which has a hard surface but doesn't affect the vacuum of the cutting machine.

· Thickness: 3.0 mm
· Strong underlay that doesn't support vibration of the cutting substrate
· Cheap and solid underlay as an alternative to the basic grey cutting felt (PLP)

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed mm/sec										Underlay	Acceleration	Cutting quality
			80	100	120	140	160	180	200	220	240	260			
1.2 mm	Z 22	14 mm	X	X	X	X	X	X	X	X	X	X	MDF - board	3	High
1.6 mm	Z 22	14 mm	X	X	X	X	X	X	X	X			MDF - board	3	High
2.0 mm	Z 22	14 mm	X	X	X	X	X	X	X	X			MDF - board	3	High
3.0 mm	Z 22	14 mm	X	X	X	X	X	X	X				MDF - board	3	High
5.0 mm	Z 22	14 mm	X	X	X	X	X	X	X				MDF - board	3	High

Half through cut/scoring: minus 0.5 mm board are left measured from the bottom.
All values are based on our experience and may differ from machine to machine.

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POT: PNEUMATIC OSCILLATING TOOL

TOOL

The POT is an air-driven powerful and durable tool particularly well suited for cutting thicker KATZ DISPLAY BOARD (> 3 mm). Suitable especially for fine, precise contours.

· Knife stroke: 8 mm
· Robust, maintenance-free pneumatic drive
· No cooling
· Compatible with G3, S3, L3.
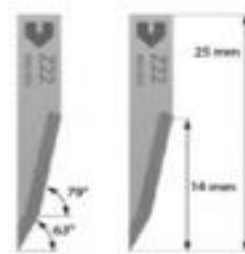
BLADE

Fine, robust blade with low overcut; designed to cut small radii and intricate detail.

· Z22
· alternatively Z 28 (blade is longer, therefore risk of breaking is higher)

UNDERLAY

ZÜND standard grey cutting felt (PLP).

· PLP for G3 series
· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed mm/sec				Underlay	Acceleration	Cutting quality
			80	150	250	350			
1.2 mm	Z 22	14 mm	X	X			Felt	2	High
1.6 mm	Z 22	14 mm	X	X			Felt	2	High
2.0 mm	Z 22	14 mm	X	X			Felt	2	High
3.0 mm	Z 22	14 mm	X	X			Felt	2	High
5.0 mm	Z 22	14 mm	X	X			Felt	2	High

All values are based on our experience and may differ from machine to machine.

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UCT: UNIVERSAL CUTTING TOOL

TOOL

The UCT it's perfect for thinner through cutting and half through cutting materials like KATZ DISPLAY BOARD 1.2 mm & 1.6 mm. The use of drag knives allows for maximum processing speeds.

· Very high cutting speeds
· Compatible with G3, S3, L3.
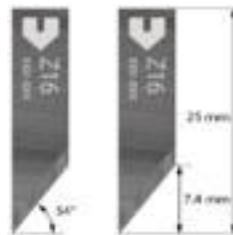
BLADE

Flat-stock drag blade, designed for rather thin KATZ DISPLAY BOARDS. It allows fast speed.

· Z16
· Flat-stock drag blade

UNDERLAY

ZÜND standard grey cutting felt (PLP).

· PLP for G3 series
· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed mm/sec								Underlay	Acceleration	Cutting quality
			80	150	250	350	450	550	650	750			
1.2 mm	Typ Z 16	7.4 mm	X	X	X	X	X	X	X	X	Felt	3	High
1.6 mm	Typ Z 16	7.4 mm	X	X	X	X	X	X	X	X	Felt	3	High
2.0 mm	Typ Z 16	7.4 mm	X	X	X	X					Felt	3	High
3.0 mm	Typ Z 16	7.4 mm	X	X	X	X					Felt	3	High
5.0 mm	Typ Z 16	7.4 mm	X	X	X	X					Felt	3	High

Half through cut/scoring: minus 0.5 mm board are left measured from the bottom.
All values are based on our experience and may differ from machine to machine.

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CTT2: CREASING TOOL TYPE 2 - USING C212 | 1.5 CREASE WHEEL

TOOL

The CTT2 is a universally applicable crease tool. The CTT2 is very good for processing KATZ DISPLAY BOARD 1.2 mm or 1.6 mm. It produces high-quality creases for folding KATZ DISPLAY BOARD.

· High quality clean creases
· Makes KATZ DISPLAY BOARDS foldable without cracking
· Directional pressure adjustments (with/against corrugation)
· Compatible with G3, S3

CREASE WHEEL

Crease wheel C212 | 1.5

· Creasing width: 4-point
· Creasing wheel diameter: 24 mm
· Radius: 1.5 mm

UNDERLAY

ZÜND basic grey cutting felt (PLP).

· PLP for G3 series
· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Creasing Tool	Pressure	Amount of Creasing lines							Speed	Underlay	Acceleration	Cutting quality
			1	2	3	4	5	6	7				
1.2 mm	C212 1.5	6.5* / 9.5* Kg	X							1000	Felt	3	Normal
1.6 mm	C212 1.5	6.5* / 9.5* Kg	X							1000	Felt	3	Normal
2.0 mm	not recommended												
3.0 mm	not recommended												
5.0 mm	not recommended												

* With grain / across grain
Best results: 0.5 mm space between each creasing line.
All values are based on our experience and may differ from machine to machine.

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CTT2: CREASING TOOL TYPE 2 - USING C202 Crease Wheel

TOOL

The CTT2 is a universally applicable crease tool.
The CTT2 is very good for processing KATZ DISPLAY BOARD 1.2 mm or 1.6 mm. It produces high-quality creases for folding KATZ DISPLAY BOARD.

· High quality clean creases
· Makes KATZ DISPLAY BOARDS foldable without cracking
· Directional pressure adjustments (with/against corrugation)
· Compatible with G3, S3

CREASE WHEEL

Crease wheel C202 with support 3910604.

· Creasing width: 4-point
· Creasing wheel diameter: 24 mm
· Width: 1.5 mm
· Depth: 1.5 mm

UNDERLAY

ZÜND basic grey cutting felt (PLP).

· PLP for G3 series
· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Creasing Tool	Pressure	Amount of Creasing lines							Speed	Underlay	Acceleration	Cutting quality
			1	2	3	4	5	6	7				
1.2 mm	1.5 / 1.5	5 - 8 Kg	X	X	X	X	X	X	X	1000	Felt	4	Normal
1.6 mm	1.5 / 1.5	5 - 8 Kg	X	X	X	X	X	X	X	1000	Felt	4	Normal
2.0 mm	not recommended												
3.0 mm	not recommended												
5.0 mm	not recommended												

Best results: 0.5 mm space between each creasing line.
All values are based on our experience and may differ from machine to machine.

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VCT: V-CUT TOOL

TOOL

The perfect tool for producing complex structural designs from KATZ DISPLAY BOARD.
This tool is designed for quick tool changes and easy, precise setting of the various cutting angles. The tool can be set for cutting at 5 different angles (0°, 15°, 22.5°, 30°, 45°).

· Simple, precise
  angle settings
· Cuts at 5 different angles
  (0°, 15°, 22.5°, 30°, 45°)
· Quick blade changes
· Compatible with G3, S3

BLADE
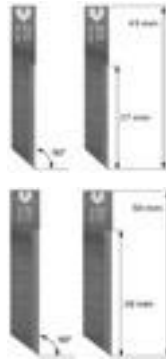
Z 70 and Z 71: Stable, long-life carbide blade for V-Cut KATZ DISPLAY BOARDS with very fast processing speeds.

· Z 70
· Blade for 45° V-Cut
· Z 71
· Knife material:
  HM/Carbide

UNDERLAY

ZÜND standard grey cutting felt (PLP).

· PLP for G3 series
· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed mm/sec			Underlay	Acceleration	Cutting quality
			400	600	800			
1.2 mm	Z 70 / 71	27 / 38 mm	X	X		Felt	3 - 4	Normal
1.6 mm	Z 70 / 71	27 / 38 mm	X	X		Felt	3 - 4	Normal
2.0 mm	Z 70 / 71	27 / 38 mm	X	X		Felt	3 - 4	Normal
3.0 mm	Z 70 / 71	27 / 38 mm	X	X		Felt	3 - 4	Normal
5.0 mm	Z 70 / 71	27 / 38 mm	X	X		Felt	3 - 4	Normal

All values are based on our experience and may differ from machine to machine.

ZÜND
swiss cutting systems

PPT: PASSE PARTOUT CUTTING TOOL

TOOL

The perfect tool for producing complex structural designs from KATZ DISPLAY BOARD. This tool is designed for quick tool and knife changes. The Knife angle is 45 degree.

· Compatible with G3, S3
· Quick blade change
· Best 45° cut quality

BLADE
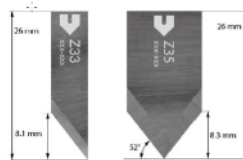
Z33, Z35 for cutting KATZ DISPLAY BOARDS with high quality and fast processing speeds

· Z 33, Z35
· Blade for 45° V-Cut
· Knife material: HM/Carbide

UNDERLAY

ZÜND standard grey cutting felt (PLP).

· PLP for G3 series
· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed mm/sec			Z-Speed down	Pressure (Kg) X / Y	Underlay	Acceleration	Cutting quality
			500	800	1000					
1.2 mm	Z33 / Z35	8.3 mm	X	X	X	150	6 / 6	PLP	3	High
1.6 mm	Z33 / Z35	8.3 mm	X	X	X	150	6 / 6	PLP	3	High
2.0 mm	Z33 / Z35	8.3 mm	X	X		150	6 / 6	PLP	3	High
3.0 mm	Z33 / Z35	8.3 mm	X			150	6 / 6	PLP	3	High
5.0 mm	Z33 / Z35	8.3 mm	X			150	6 / 6	PLP	2	High

All values are based on our experience and may differ from machine to machine.

KATZ DISPLAY BOARD
— best for digital printing —

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cutting room technology

EOK: ELECTRIC OSCILLATING TOOL

TOOL

Bullmer EOK is especially suitable for 3.0 mm and 5.0 mm KATZ DISPLAY BOARDS.

· Compatible Bullmer premiumcut elc

BLADE

Oscillating knife for cutting fine structures.

· RS 10

UNDERLAY

Grey bullmer standard cutting felt in 4 mm thickness for optimum cutting quality with bullmer digital cutting machines.

· Thickness: 4.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed m/min				Underlay	Acceleration (g)
			20	30	50	60		
1.2 mm	RS 10	15 mm				X	Felt: 4 mm	1.8
1.6 mm	RS 10	15 mm				X	Felt: 4 mm	1.7
2.0 mm	RS 10	15 mm			X		Felt: 4 mm	1.5
3.0 mm	RS 10	15 mm		X			Felt: 4 mm	1.5
5.0 mm	RS 10	15 mm	X				Felt: 4 mm	1.5

All values are based on our experience and may differ from machine to machine.

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DK: STATIC KNIFE TOOL

TOOL

Bullmer DK is especially suitable for KATZ DISPLAY BOARDS in the thicknesses 1.2 mm; 1.6 mm; 2.0 mm and 3.0 mm. It allows very fast cutting speeds with the static knife.

· Compatible Bullmer premiumcut elc

BLADE

Static knife, for rather thin KATZ DISPLAY BOARDS. It allows fast speed.

· B 16
· Knife length in total 25 mm

UNDERLAY

Grey bullmer standard cutting felt in 4 mm thickness for optimum cutting quality with bullmer digital cutting machines.

· Thickness: 4.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed m/min				Underlay	Acceleration (g)
			50	80	90	100		
1.2 mm	B 16	7.4 mm*				X	Felt: 4 mm	1.6
1.6 mm	B 16	7.4 mm*			X		Felt: 4 mm	1.6
2.0 mm	B 16	7.4 mm*		X			Felt: 4 mm	1.6
3.0 mm	B 16	7.4 mm*	X				Felt: 4 mm	1.6
5.0 mm	B 16	not recommended						

* Value corresponds to cutting depth
All values are based on our experience and may differ from machine to machine.

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RRA: CREASING TOOL

TOOL

The RRA is very good for processing KATZ DISPLAY BOARD 1.2 mm, 1.6 mm and even 2.0 mm.
It produces high-quality creases for folding KATZ DISPLAY BOARD.

· Compatible Bullmer premiumcut elc
· Makes KATZ DISPLAY BOARDS foldable without cracking

CREASING WHEEL

Recommended use: For solid board and paper based board.

· Creasing wheel 2415

UNDERLAY

Grey bullmer standard cutting felt in 4 mm thickness for optimum cutting quality with bullmer digital cutting machines.

· Thickness: 4.0 mm

KATZ DISPLAY BOARD thickness	Creasing Tool	Pressure	Speed m/min	Underlay	Acceleration (g)
			60		
1.2 mm	2415	n.a.	X	Felt: 4 mm	1.6
1.6 mm	2415	n.a.	X	Felt: 4 mm	1.6
2.0 mm	2415	n.a.	X	Felt: 4 mm	1.6
3.0 mm	2415	not recommended			
5.0 mm	2415	not recommended			

All values are based on our experience and may differ from machine to machine.

KATZ DISPLAY BOARD
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DKV: V-CUT TOOL

TOOL

This tool is used for producing KATZ DISPLAY BOARD with V-Cut. V-Cut allows folding of different board thicknesses.

· Compatible Bullmer premiumcut elc
· Cuts at 6 different angles (0°, 15°, 22.5°, 30°, 45°, 60°)

BLADE

Stable V-Cut knife, suitable to cut all 6 angles from 0° up to 60°

· B 71
· Knife length in total 50 mm

UNDERLAY

Grey bullmer standard cutting felt in 4 mm thickness for optimum cutting quality with bullmer digital cutting machines.

· Thickness: 4.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed m/min			Underlay	Acceleration (g)
			40	50	60		
1.2 mm	B 71	11.8 mm*			X	Felt: 4 mm	1.5
1.6 mm	B 71	11.8 mm*			X	Felt: 4 mm	1.5
2.0 mm	B 71	11.8 mm*		X		Felt: 4 mm	1.5
3.0 mm	B 71	11.8 mm*	X			Felt: 4 mm	1.5
5.0 mm	B 71	11.8 mm*	X			Felt: 4 mm	1.5

* Value corresponds to cutting depth
All values are based on our experience and may differ from machine to machine.

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ELECTRIC OSCILLATING TOOL:

TOOL

We recommend oscillating cutting, especially for 3.0 mm and 5.0 mm KATZ DISPLAY BOARDS with the HF VibraCut Knife.

· Compatible with Kongsberg XP/C

BLADE

Oscillating knife for cutting fine structures.

· BLD-SR6224

UNDERLAY

Grey standard cutting felt in 3.0 mm thickness for optimum cutting quality with Kongsberg cutting machines.

· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed m/min				Underlay	Acceleration (%)
			20	30	50	60		
1.2 mm	BLD-SR6224	12 mm		X	X		Felt: 3 mm	50
1.6 mm	BLD-SR6224	12 mm		X	X		Felt: 3 mm	50
2.0 mm	BLD-SR6224	12 mm		X	X		Felt: 3 mm	50
3.0 mm							Felt: 3 mm	50
5.0 mm							Felt: 3 mm	50

All values are based on our experience and may differ from machine to machine.

KATZ DISPLAY BOARD — best for digital printing

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STATIC KNIFE TOOL:

TOOLS

For the normal trough cut in the KATZ material you get best result with the coated rigid material knives. They are compatible with the rigid material cutting tool and the corruspeed tool.

Rigid Material Cutting Tool

Corruspeed Tool

BLADES

BLD-SR8184

BLD-SR8170

BLD-SR8171A

BLD-SR8160

These coated static knives perform best in recycled, natural materials.

· BLD-SR8171A (asymetric): for high detailed cutting. It ploughs all burr's and waste to one side. It is very important to control the cutting direction!
· BLD-SR8160: for general use
· BLD-SR8170: for general use
· BLD-SR8184: for general use and long straight edges. Rounded corners should have a radius larger than 20 mm

UNDERLAY

Grey standard cutting felt in 3.0 mm thickness for optimum cutting quality with Kongsberg cutting machines.

· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Speed m/min			Underlay	Acceleration (%)
		Kongsberg C 60	Kongsberg X 50	X Starter 30		
1.2 mm	BLD-SR8171A BLD-SR8160 BLD-SR8170 BLD-SR8184	X	X	X	Felt: 3 mm	80
1.6 mm	BLD-SR8171A BLD-SR8160 BLD-SR8170 BLD-SR8184	X	X	X	Felt: 3 mm	80
2.0 mm	BLD-SR8171A BLD-SR8170 BLD-SR8184	X	X	X	Felt: 3 mm	80
3.0 mm	BLD-SR8171A BLD-SR8170 BLD-SR8184	X	X	X	Felt: 3 mm	80
5.0 mm	BLD-SR8184 BLD-SR8170	X	X	X	Felt: 3 mm	80

All values are based on our experience and may differ from machine to machine.

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CREASING TOOL:

TOOLS

Crease adapter / tools: HPU, Power Head Crease tool XE, Crease Tool 26 mm

CREASING WHEELS

Crease Wheel | Diameter 26 mm | Triple wall (i-662)

Crease Wheel | Diameter 26 mm | 12-point

Crease Wheel | Diameter 26 mm | 14-point

Crease Wheel | Diameter 150 mm | 6-point

Recommended for solid board like KATZ DISPLAY BOARD and corrugated board.

Best creasing results, without breaking the liner, are experienced with a matrix.

Use a crease wheel diameter depending on the thickness of the material and length of the crease line in the cut file.

UNDERLAY

Grey standard cutting felt in 3.0 mm thickness for optimum cutting quality with Kongsberg cutting machines.

· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Creasing Tool	Speed m/min			Underlay	Acceleration (%)
		Kongsberg C 100	Kongsberg X 50	X Starter 30		
1.2 mm	Crease tool / adapter	X	X	X	Felt: 3 mm	100
1.6 mm	Crease tool / adapter	X	X	X	Felt: 3 mm	100
2.0 mm	Crease tool / adapter	to be tested				
3.0 mm		not recommended				
5.0 mm		not recommended				

All values are based on our experience and may differ from machine to machine.

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V-NOTCH / BEVEL CUTTING TOOL:

TOOL

This tool is used for producing KATZ DISPLAY BOARD with V-Cut. V-Cut allows folding of different board thicknesses.

HD Bevel knife tool 17 for solid board

BLADE

A special tungsten carbide knife blade for cutting V-notch folding lines in solid board.

V-Cut double and single cut with 45° angle.

Double cut dW-setting: Along and Across -0.5 mm

BLD-SF245

UNDERLAY

Grey standard cutting felt in 3.0 mm thickness for optimum cutting quality with Kongsberg cutting machines.

· Thickness: 3.0 mm

KATZ DISPLAY BOARD thickness	Blade type	Speed m/min				Underlay	Acceleration* (%)
		20	40	60	80		
1.2 mm	BLD-SF245	X				Felt: 3 mm	20
1.6 mm	BLD-SF245	X				Felt: 3 mm	20
2.0 mm	BLD-SF245	X				Felt: 3 mm	20
3.0 mm	BLD-SF245	X				Felt: 3 mm	20
5.0 mm	BLD-SF245	X				Felt: 3 mm	20

* Acceleration for Kongsberg X Starter is 40%
All values are based on our experience and may differ from machine to machine.

KATZ DISPLAY BOARD
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trotec®
laser. marking cutting engraving

SPEEDY 400 120W: THROUGH CUT

KATZ DISPLAY BOARD thickness	P (%)	V (%)	PPI/Hz	Passes	Air Assist	Z-offset (mm)	Extension	Lens	Comment
1.2 mm									Nozzle with very small hole diameter, honeycomb cutting support
1.6 mm	14	1.2	1000 Hz	1	ON	-0.2	Corr.: 5	1.5"	Nozzle with very small hole diameter, honeycomb cutting support
2.0 mm									Nozzle with very small hole diameter, honeycomb cutting support
3.0 mm									Nozzle with very small hole diameter, honeycomb cutting support
5.0 mm									Nozzle with very small hole diameter, honeycomb cutting support

SPEEDY 400 120W: HALF THROUGH CUT

KATZ DISPLAY BOARD thickness	P (%)	V (%)	PPI/Hz	Passes	Air Assist	Z-offset (mm)	Extension	Lens	Comment
1.2 mm									Nozzle with very small hole diameter, honeycomb cutting support
1.6 mm	6.2	1	1000 Hz	1	ON	1	Corr.: 8	1.5"	Nozzle with very small hole diameter, honeycomb cutting support
2.0 mm									Nozzle with very small hole diameter, honeycomb cutting support
3.0 mm									Nozzle with very small hole diameter, honeycomb cutting support
5.0 mm									Nozzle with very small hole diameter, honeycomb cutting support

All values are based on our experience and may differ from machine to machine.

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SPEEDY 400 120W: ENGRAVING

KATZ DISPLAY BOARD thickness	P (%)	V (%)	PPI/Hz	Passes	Air Assist	Z-offset (mm)	Extension	Lens	Comment
1.2 mm									Nozzle with very small hole diameter, honeycomb cutting support
1.6 mm	30	100	500 Hz	1	ON	0.5	High Quality	1.5"	Nozzle with very small hole diameter, honeycomb cutting support
2.0 mm									Nozzle with very small hole diameter, honeycomb cutting support
3.0 mm									Nozzle with very small hole diameter, honeycomb cutting support
5.0 mm									Nozzle with very small hole diameter, honeycomb cutting support

All values are based on our experience and may differ from machine to machine.

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EOT: ELECTRONIC OSCILLATING TOOL

TOOL

The EOT is ideally suited for cutting materials like KATZ DISPLAY BOARD. The high oscillating frequency makes it possible to cut at high processing speeds especially for fine, precise contours.

· Knife stroke: 1 mm
· Electric drive

BLADE

Fine, robust blade with low overcut; designed to cut small radii and intricate detail.

500-9810 - EOT
L25 knife 65° - 80°

UNDERLAY

SUMMA standard grey cutting felt

Thickness: 2.5 mm

KATZ DISPLAY BOARD thickness	Blade type	Cutting length with gliding disk	Cutting length without gliding disk	Speed mm/sec				Blade Compensation	Underlay
				50	100	150	200		
1.2 mm	500-9810	5 mm	11 mm	X	X	X	X	0 mm	Felt
1.6 mm	500-9810	5 mm	11 mm	X	X	X	X	0 mm	Felt
2.0 mm	500-9810	5 mm	11 mm	X	X	X	X	0 mm	Felt
3.0 mm	500-9810	5 mm	11 mm	X	X	X	X	1 mm	Felt
5.0 mm	500-9810	5 mm	11 mm	X	X	X	X	1 mm	Felt

All values are based on our experience and may differ from machine to machine.

KATZ DISPLAY BOARD
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POT: PNEUMATIC OSCILLATING TOOL

TOOL

The POT is an air-driven powerful and durable tool particularly well suited for cutting thicker KATZ DISPLAY BOARD (> 3 mm). Suitable especially for fine, precise contours.

· Knife stroke: 8 mm
· Robust, maintenance-free pneumatic drive

BLADE

Fine, robust blade with low overcut; designed to cut small radii and intricate detail.

500-9830 - POT knife flat point L20 T 0.63

UNDERLAY

SUMMA standard grey cutting felt

Thickness: 2.5 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed mm/sec		Blade Compensation	Underlay
			50	150		
1.2 mm	500-9830	18 mm			-	Felt
1.6 mm	500-9830	18 mm			-	Felt
2.0 mm	500-9830	18 mm			-	Felt
3.0 mm	500-9830	18 mm	X	X	1 mm	Felt
5.0 mm	500-9830	18 mm	X	X	1 mm	Felt

All values are based on our experience and may differ from machine to machine.

## DOUBLE EDGE CUT-OUT TOOL: THROUGH CUT AND HALF THROUGH CUTTING

TOOL

The Double edge cut-out tool it's perfect for thinner through cutting and half through cutting materials like KATZ DISPLAY BOARD 1.2 mm & 1.6 mm. The use of this knives allows maximum processing speeds.

Very high cutting speeds.

BLADE

Burr free knifes are designed for thin KATZ DISPLAY BOARDS. It gives a perfect finishing on one side of the cut part.
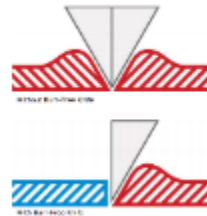
500-9804: double edge cut-out knife 50° burr-free

UNDERLAY

SUMMA standard grey cutting felt

Thickness: 2.5 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed mm/sec					Underlay
			100	200	400	600	800	
1.2 mm	500-9804	3 mm	X	X	X	X	X	Felt
1.6 mm	500-9804	3 mm	X	X	X	X	X	Felt
2.0 mm	500-9804	3 mm	X	X	X	X	X	Felt
3.0 mm	500-9804	3 mm	Only for half cutting/scoring					Felt
5.0 mm	500-9804	3 mm						Felt

Half through cut/scoring: minus 0.5 mm board are left, measured from the bottom.
All values are based on our experience and may differ from machine to machine.

KATZ DISPLAY BOARD
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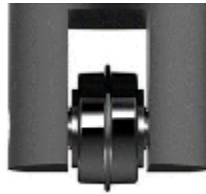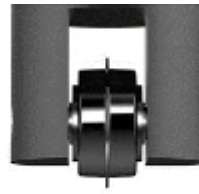## CREASING TOOLS: D15 R0.17 W0.35 - 1PT OR D15 R0.17 W0.35 - 2PT

TOOL

The Creasing Tool processing KATZ DISPLAY BOARD 1.2 mm or 1.6 mm.
It produces high-quality creases for folding KATZ DISPLAY BOARD.

High quality clean creases makes KATZ DISPLAY BOARDS foldable without cracking

CREASE WHEEL

500-9828 Creasing tool D15 R0.35 W0.7 - 2pt

500-9829 Creasing tool D15 R0.17 W0.35 - 1pt

UNDERLAY

SUMMA standard grey cutting felt

Thickness: 2.5 mm

KATZ DISPLAY BOARD thickness	Creasing Tool	Amount of Creasing lines			Speed	Down Position Offset	Underlay
		1	2	3			
1.2 mm	500-9828 / 500-9829	X	X		800 mm/s	0.5 mm	Felt
1.6 mm	500-9828 / 500-9829		X		800 mm/s	1.2 mm	Felt
2.0 mm	500-9828 / 500-9829		X	X	800 mm/s	1.5 mm	Felt
3.0 mm	not recommended						
5.0 mm	not recommended						

Best results: 0.5 mm space between each creasing line.
All values are based on our experience and may differ from machine to machine.

V-CUT TOOL 45°

TOOL

The perfect tool for producing complex structural designs from KATZ DISPLAY BOARD.

BLADE

500-9826: Stable, long-life carbide blade for V-Cut KATZ DISPLAY BOARDS with very fast processing speeds.

500-9826 - V-Cut hard metal

UNDERLAY

SUMMA standard grey cutting felt

Thickness: 2.5 mm

KATZ DISPLAY BOARD thickness	Blade type	Blade length	Speed mm/sec			V-cut gap	V-cut gap
			50	100	200		
1.2 mm	500-9826	18 / 27 mm				Felt	0.3 mm
1.6 mm	500-9826	18 / 27 mm				Felt	0.3 mm
2.0 mm	500-9826	18 / 27 mm	X	X	X	Felt	0.3 mm
3.0 mm	500-9826	18 / 27 mm	X	X	X	Felt	0.3 mm
5.0 mm	500-9826	18 / 27 mm	X	X	X	Felt	0.3 mm

All values are based on our experience and may differ from machine to machine.

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EUROLASER XL-1600 I 400 W: KISS CUT

KATZ DISPLAY BOARD thickness	Output Max / Min%	V (mm/Sec.)	Passes	Compressed air (bar)	Lens	Nozzle (mm)	Frequency (Hz)	Comment
1.2 mm	19 / 1.5	1000	1	5.0	5"	2	20000	Position of the nozzle at the bottom
2.0 mm	34 / 2	1000	1	5.0	5"	2	20000	Position of the nozzle at the bottom
3.0 mm	34 / 2	650	1	5.0	5"	2	20000	Position of the nozzle at the bottom
5.0 mm	34 / 2	220	1	5.0	5"	2	20000	Position of the nozzle at the bottom

EUROLASER XL-1600 I 400 W: LASER CUT

KATZ DISPLAY BOARD thickness	Output Max / Min%	V (mm/Sec.)	Passes	Compressed air (bar)	Lens	Nozzle (mm)	Frequency (Hz)	Comment
1.2 mm	67 / 2	950	1	5.0	5"	2	20000	Position of the nozzle at the bottom
2.0 mm	67 / 3	500	1	5.0	5"	2	20000	Position of the nozzle at the bottom
3.0 mm	67 / 2	305	1	5.0	5"	2	20000	Position of the nozzle at the bottom
5.0 mm	67 / 5	165	1	5.0	5"	2	20000	Position of the nozzle at the bottom

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EUROLASER XL-1600 I 400 W: ENGRAVING

KATZ DISPLAY BOARD thickness	Output Max / Min%	V (mm/Sec.)	Passes	Compressed air	Lens	Nozzle (mm)	Frequency (Hz)	Comment
1.2 mm	2.3 / 0.6	60	1	Scavening air	5"	2	2250	Position of the nozzle at the bottom
2.0 mm	2.3 / 0.6	60	1	Scavening air	5"	2	2250	Position of the nozzle at the bottom
3.0 mm	2.3 / 0.6	60	1	Scavening air	5"	2	2250	Position of the nozzle at the bottom
5.0 mm	2.3 / 0.6	60	1	Scavening air	5"	2	2250	Position of the nozzle at the bottom

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EUROLASER XL-1600 I 400 W: PASSEPARTOUT

KATZ DISPLAY BOARD thickness	Blade type	V (mm/Sec.)	Passes	Underlay
1.2 mm	X	X	X	Cutting and milling felt
2.0 mm	Z33	100	1	Cutting and milling felt
3.0 mm	Z33	100	1	Cutting and milling felt
5.0 mm	Z33	100	1	Cutting and milling felt

EUROLASER XL-1600 I 400 W: KNIFE CUT EOT

KATZ DISPLAY BOARD thickness	Blade type	V (mm/Sec.)	Passes	Underlay
1.2 mm	Z21	150	X	
2.0 mm	Z21	150	1	Cutting and milling felt
3.0 mm	Z21	150	1	Cutting and milling felt
5.0 mm	Z21	150	1	Cutting and milling felt

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Any questions, comments or suggestions?
Please do not hesitate to contact us.
Or have a look at :

THE **KATZ** GROUP
Member of the Koehler Paper Group

KATZ GmbH & Co. KG

Hauptstr. 2

76599 Weisenbach

Phone +49 7224 647 0

Fax +49 7224 647 10 165

office@thekatzgroup.com

www.thekatzgroup.com

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