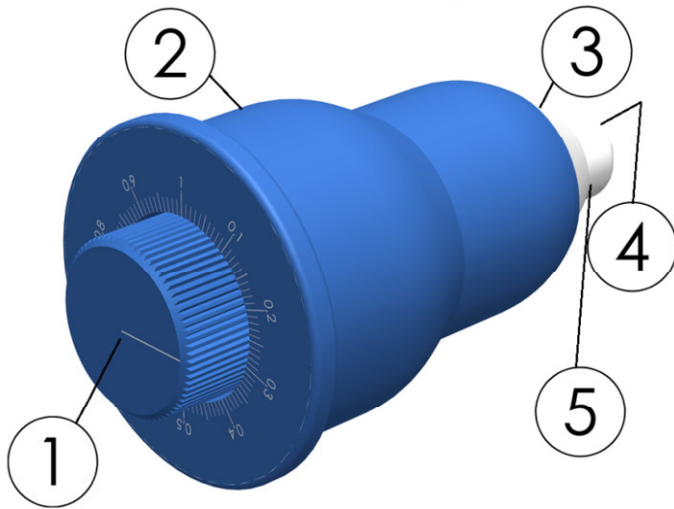


Manual

Drag Knife Holder

Parts and Functions



- 1.) Adjustment knob with pointer, for adjusting the cutting depth.
- 2.) Main body with measuring scale for precise adjustment of the cutting depth (1 graduation mark=0.01mm). The upper diameter is 43mm and fits into a standard spindle holder. Another clamping diameter with 33mm is available
- 3.) Spring-loaded knife holder to compensate for unevenness in the material to be cut. The spring travel is approximately 10mm. A spring preload of about 2-4 mm is recommended.
- 4.) The Roland plotter knife is inserted from below through the sliding cap (5) and bearing tube and held by a magnet. To take it out, it is unscrewed to maximum length by the adjustment screw (1) and then carefully pulled out with pliers or tweezers to avoid injury.
- 5.) Sliding cap made of POM to reduce friction on the material to be cut.

How to Use

- 1.) Insert a plotter knife through the sliding cap (5) into the knife holder (3). The neodymium magnet inside prevents the knife from falling out.
- 2.) Use the adjustment knob (1) to adjust the tip of the plotter knife (4) so that it is flush with the sliding cap (5)
- 3.) Open the grub screw on the adjustment knob (1) and turn it until the pointer points to "0". Now fix the adjustment knob again with the grub screw. Now the Pointer is zeroed.
- 4.) Mount the drag knife holder into the spindle holder of your CNC machine.
- 5.) Now adjust the cutting depth of the knife according to the thickness of the material you are using. If the material has a carrier material, this medium should only be slightly scratched, but not cut through. A test cut on remaining material is recommended.
- 6.) Open the program for processing your workpiece in the control software of the CNC machine.
- 7.) Now position the knife at the zero point of your workpiece (X, Y), after the reference run is completed. Now you move the Z-axis down until it touches the workpiece and set it to zero.
- 8.) Now configure the working depth (spring preload) on your control software (2-4 mm recommended).
- 9.) Now the Cutting process can be started.
- 10.) If it becomes apparent that the cut is too deep or too shallow, the cutting depth can be adjusted with the adjustment knob (1).

Safety Instructions



- To avoid personal injury with the sharp plotter knife do not touch it with your bare hands after the safety cap is removed. Use pliers or tweezers.
- Make sure that all persons using the drag knife have read and understood this manual. Misunderstandings can lead to injuries.
- Keep the drag knife holder and plotter knives safe and out of reach of children.
- Make sure that the material to be cut is securely fastened. Do not try to fix it with your hands.