



GRAVOGRAPH



Indoor use



Surface engraving



Rotary engraving

table shear :
20199

Circular saw:
VA 1: #21762
VA 11: #21764

GRAVOTAC

ENGRAVING TIPS

Updated : April 2007

Gravotac range has been especially developed to create relief Signage for Braille applications .

CUTTING GRAVO-TAC

Use a 'plastic' type table shear or a saw.

Made of plastic ABS, gravo-tac can be cut with a Stanley® knife. (see step 1 on page 3)

ENGRAVING GRAVO-TAC

Always work on a clean surface.

➤ **STICKING GRAVO-TAC:**

Gravo-Tac already has an adhesive side, so all you need to do is stick it on the support. (see step 2 on page 3).

➤ **CLAMPING GRAVO-TAC:**

It can be clamped according to its shape and dimensions on a **clamping table** or a **vacuum table**, or else on an vice with **celoron or aluminium jigs**.

For batch production, use the mechanical stop located on the jigs.

⇒ **Carefully grip the piece : enough in order not to eject it, but not too much not to bend it** (see step 3 on page 3).

➤ **CUTTING LETTERS / LOGOS:**

➤ **To set the tool :** Screw the cutter knob (caution : left thread) and position the tool in the spindle in order to make contact with the Gravo-Tac (usually check through the little opening of the regulating nose that the cutter is really down) Save the position of the spindle (little pressure with Gravo-Tac). Validate the Z axis.

➤ **Select the engraving depth** by turning the micrometric vernier, knowing that :
4 scales = 0,1 mm thus **1 spin = 0,62 mm**

➤ **At the break :** Select the cutting depth as previously.
It is necessary to add pressure when cutting at the beginning.

If you wish to obtain a bevelled edge on a Matrix application, all you have to do is program a cutting depth according to the aspect you want to obtain and finish by « breaking » the plates off manually. For Gravo-Tac, we advise you to set the bevel depth equal or a little deeper than the plate thickness.

Cutting depth	Thickness	1.0
mm		1,2
Vernier divisions		48

Recommended cutters :

- Steel : 21055
- Carbide : 21038
- TwinCut® : 23055

GRAVOGRAPH

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MATRIX :

The Matrix function that is used for engraving and cutting plates produced in series is found in the GravoStyle 5 software (optional on Discovery level and integrated in higher levels).

➤ With Matrix, all you have to do is « break » the plates off manually.

➤ **UNSTICKING THE UNUSED PART:**

(see step 5 on page 3)

Take off the unused part quickly to avoid leaving excess glue on the material surface.

Caution:

Do not leave the surface layer stick too long to avoid leaving excess glue on the material surface.

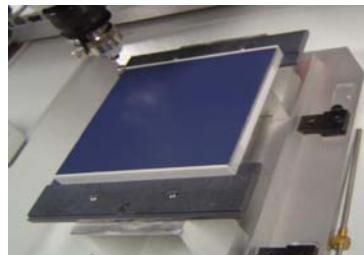
Engraving Steps



1. Cut Gravo-Tac



2. Stick Gravo-Tac on the support



3. Clamp Gravo-Tac and the support



4. Engrave



5. Take off the unused part of Gravo-Tac



5. Remove quickly



6. Final product