

Compatible with: IS400, IS900, IS6000/7000/8000 &amp; biseauteuse B6

1/4" SHANK SIZE



### 1/4" Radius cutters for rounded cut

Use reverse engraving on Gravoglas for neon tube look. Also used for gasket grooves & 3D milling

Material Type	Part no.
Gravoply	34259
Phenolic	33999
Ferrous metals	34010

Choose radius (1/32", 1/16", 3/32", 1/8", 5/32")



## How to choose parallel cutters

**Typical applications** – Typical applications for Parallel cutters include cutting holes and routing flexible engraving plastic.

**Type of cut** – The main difference between Parallel cutters and standard engraving cutters is that the cut is vertical rather than beveled.

### How to order

1. Choose the cutter family by the material you are engraving or cutting from the charts on these pages. For soft plastic, choose either Carbide or High Speed Steel (HSS). Carbide lasts longer but costs more than High Speed Steel (HSS). For metal, carbide is recommended.
2. Specify the tip diameter size.
  - Tip sizes can be specified from .015" to the shank diameter.
3. Specify the cutting depth.
  - For best strength, specify tip length up to 1.5 times the tip diameter.
  - Tip lengths > 1.5 x tip size can be specified, but they will tend to break easier.
4. Call Customer Service at 1-800-843-7637 to place an order.

**Parallel cutters vs. engraving cutters where tip size equals shank diameter** – Standard conical cutters with tip size equal to shank size will also provide a vertical cut. The difference is that the cutting depth is fixed with engraving cutters, but can be specified with Parallel cutters.

Typically, the cutting depth of engraving cutters with tip size equal to shank diameter is in the range of .125" - .150". These are primarily for engraving applications, but can also be used for routing.

**Application tips** – Cutting or routing 1/8" acrylic is best performed with a 90 x 150 Parallel cutter (.090" tip and .150 length). The Carbide tool is part number 34118, and the HSS tool is part number 34085. Cutting in one pass can be accomplished with the 200 watt spindle motor. Cut in multiple passes when using the 80 watt spindle motor.

Cutting or routing 1/4" acrylic is best performed with a 171 x 275 Parallel cutter (.171" tip and .275 length). The Carbide tool is part number 34118 and the HSS tool is part number 34085. This should be cut in multiple passes.

**Radius cutters** – Radius cutters are similar to Parallel cutters except for having a rounded shape. These are specified the same. Available in HSS or Carbide for tip sizes at least .030". Applications include reverse engraving, 3D contouring & gasket grooves.