

## Suggested Settings for Various Force Accessories<sup>1</sup>

Settings: P – Passes; SD – Start Depth; CD/ED: Cut Depth/End Depth; CS – Cut Speed; PS – Plunge Speed

<u>Material</u>	<u>Application</u>	<u>Tool</u>	<u>Surface</u>	<u>P</u>	<u>SD</u>	<u>CD/ED</u>	<u>CS</u>	<u>PS</u>	<u>Other Comments</u>
Paper	Drawing	Test Pen	Mat	1		35	25	40	
Cardstock	Drawing	Sharpie: ultra fine tip	Mat	1		1 - 5	20	15	Use a low PS to protect delicate tip; do tests at low CD and work upwards
Cardstock - Neenah 65lb	Scoring	Embossing - small end	Mat	3		95	25	40	
Cardstock - Neenah 80lb	Scoring	Embossing - small end	Mat	2		100	25	40	
Cardstock - WorldWin CutMates	Scoring	Embossing - large end	Duck Shelf Liner	2		70	25	30	Don't use middle pinch wheel; keep wheels away.
Coated Cover: 18 pt Tango	Scoring	Uniball Signo Pen	Mat	2	40	80	20	20	Reversed directions on half of score lines for a box
Cardstock - C&C Mirror Board: 250 gm	Debossing	Embossing - small end	Mat	1		40-60	20	30	C&C: Create & Craft; sold in UK
Cardstock - C&C Pearlescent Bright Burst: 250 gsm	Debossing	Embossing - small end	Mat	1		80	20	30	C&C: Create & Craft; sold in UK
Cardstock - First Edition: 216 gm	Debossing	Embossing - small end	Mat	1		80	20	40	C&C: Create & Craft; sold in UK
Cardstock - Darice Coordinates	Embossing	Embossing - small end	Mat	2		95	25	40	
Cardstock - Neenah 65lb	Embossing	Embossing - large end	Duck Shelf Liner	3		110	35	40	Don't use middle pinch wheel; keep wheels away.
Cardstock - Neenah 80lb	Embossing	Embossing - large end	Duck Shelf Liner	3		115	35	40	Don't use middle pinch wheel; keep wheels away.
Acrylic - Plaskolite	Engraving	Engraver	Mat	2	20	35	25	40	0.05" Plaskolite from Home Depot
Aluminum	Engraving	Engraver	Mat	4		40	30	40	PS and LS = 20
Mirror	Engraving	Red Blade	Mat	1		5	15	7	Tape securely to the mat
Cardstock - Neenah 65lb	Punching	Piercer	Duck Shelf Liner	2		115	20	25	
Vellum - Heavy	Punching	Piercer	Duck Shelf Liner	2		100	20	25	
Cardstock	Stippling	Cuttlelola	Mat	1		1	10-25	30	Use different speeds to control fill pattern

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