

## Suggested Settings for Force Rotary Tool<sup>1</sup>

These suggested settings are for initial test cut purposes. Note that Z Origin for engraving is set on top of the material; Z Origin for cutting and drilling holes is set on top of the mat.

P – Passes; SD – Start Depth; CD/ED: Cut Depth/End Depth; CS – Cut Speed; US – Up Speed; PS – Plunge Speed; LS – Lift Speed

**IMPORTANT:** review and adhere to all safety instructions presented in Section 7.01 before using the rotary tool

<u>Material</u>	<u>Source of Material</u>	<u>Applic.</u>	<u>Surface Height</u>	<u>P</u>	<u>SD</u>	<u>CD/E D</u>	<u>CS</u>	<u>US</u>	<u>PS</u>	<u>LS</u>	<u>Other Comments</u>
Acrylic - 1/8"		Engraving	300	1		2	10	20	10	20	
Decorative Plastic Sheet		Engraving	300	1		2	10	20	10	20	Dual color, 'engrave' the top color off to reveal the pattern in the 'core' color. <a href="http://www.decorativeplasticsheets.com">www.decorativeplasticsheets.com</a>
Gold Mirrored Plastic	Midwest Products (see Comments)	Engraving	300	1		15	15	20	10	20	Midwest Products 707-01 Super Sheets Mirror Styrene, 0.040 Inch
Plexiglass (aka hard acrylic)	<a href="http://clearscraps.com">clearscraps.com</a>	Engraving	300	3	1	10	15	15	10	15	

<sup>[1]</sup> © 2015, 2016 Accugraphic Sales, Inc., All Rights Reserved