



The Gilman Brothers Company

CUTTING GUIDELINES

MATERIAL	THICKNESS	TYPE OF CUT	TOOL	BLADE	DEGREE ANGLE	(ROUT) BIT	(ROUT) RPM	FEED RATE SPEED INCHES/SEC	ACCE- LERA- TION SPEED
InSite®	3/16"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
InSite®	3/16"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
InSite®	3/16"	Thru Cut Straight	UCT	Z46				39.67	4
InSite®	3/16"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
InSite®	1/2"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
InSite®	1/2"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
InSite®	1/2"	Thru Cut Straight	UCT	Z46				39.67	4
InSite®	1/2"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
Infinity®	3/16"	Thru Cut Less Detail	Router			R116	31,000	2	2
Infinity®	3/16"	Thru Cut More Detail	Router			R116	31,000	2	2
Infinity®	3/16"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
Infinity®	3/16"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
Infinity®	3/16"	Thru Cut Straight	UCT	Z46				39.67	4
Infinity®	3/16"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
Infinity®	1/2"	Thru Cut Less Detail	Router			R116	31,000	2	2
Infinity®	1/2"	Thru Cut More Detail	Router			R116	31,000	2	2
Infinity®	1/2"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
Infinity®	1/2"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
Infinity®	1/2"	Thru Cut Straight	UCT	Z46				39.67	4
Infinity®	1/2"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	3

*These are guidelines, however, there can be many different blade and setting combinations.



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MATERIAL	THICKNESS	TYPE OF CUT	TOOL	BLADE	DEGREE ANGLE	(ROUT) BIT	(ROUT) RPM	FEED RATE SPEED INCHES/SEC	ACCELE- RATION SPEED
Ecor® Tetrapak		Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
Ecor® Tetrapak		Thru Cut Straight	UCT	Z46				39.67	4
EAGLECELL™	1/4"	Thru Cut Less Detail	EOT -250	Z60 or Z61				23.6	4
EAGLECELL™	1/4"	Thru Cut More Detail	EOT -250	Z21 or Z23				23.6	2
EAGLECELL™	1/4"	Thru Cut Straight	UCT	Z46				39.67	4
EAGLECELL™	1/4"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	2
EAGLECELL™	1/2"	Thru Cut Less Detail	EOT -250	Z60 or Z61				15.75	4
EAGLECELL™	1/2"	Thru Cut More Detail	EOT -250	Z21 or Z23				3.94	2
EAGLECELL™	1/2"	Thru Cut Straight	EOT -250	Z60 or Z61				39.67	4
EAGLECELL™	1/2"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
Ryno Board®									
Ryno Board®	3/16"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
Ryno Board®	3/16"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
Ryno Board®	3/16"	Thru Cut Straight	UCT	Z46				39.67	4
Ryno Board®	3/16"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
Ryno Board®	1/2"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
Ryno Board®	1/2"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
Ryno Board®	1/2"	Thru Cut Straight	EOT -250	Z60 or Z61				39.67	4
Ryno Board®	1/2"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4

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Zund America Contact Information

For technical assistance, please contact:

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