ChromaLuxe®

ZUND G3-3XL 1600 - 1kW ROUTER MODULE

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Material

ChromaLuxe Aluminum Sheets 1.14mm

Used Router Bit :

ZUND R503 ø3 - 5218135

Advanced Machine Step Settings :

Accelaration, tool lowered	2	
Accelaration, tool lifted	4	
Speed, tool lowered	30	mm/s
Speed, tool lifted	1000	mm/s
Acceleration, lowering tool	2	
Acceleration, lifting tool	4	
Speed, lowering tool	10	mm/s
Speed, lifting tool	300	mm/s
Router speed	50000	rpm
Clearing distance	2	mm
Multi pass	ON	
> Multi pass max depth	0.5	mm
> Multi pass last depth	0.3	mm
Base depth	0.7	mm
Finishing path	ON	
> Finishing offset	10	%
> Speed finishing	30	mm/s
> Acceleration finishing	2	
Lead in / Lead out	OFF	
Reverse	OFF	
Offset side	OUTSIDE	
Router diameter	3	mm
Optimize start point to corner	YES	

Other Remarks :

ChromaLuxe Panel Placement	FACE DOWN

Other used tools: double side low tactile foil to hold the panel while cutting