



FC9000 SERIES

CUTTING HIGH REFLECTIVE 3M 4000 SERIES

3M
Diamond Grade™
DG³ Reflective Sheeting Series 4000

Instructions for Cutting 3M 4000 Series Reflective Sheeting: *To Achieve Optimal Cut Quality on FC9000 Cutters:*

- Prior to making any adjustments, download and Install the Latest Firmware from our website: <https://www.graphtecamerica.com/cp-downloads-fc9000>
- **4 Additional Push Rollers** are recommended for 3M 4000 Series Sheeting
- **Media Flanges with Stoppers** are also recommended when cutting this material.
- **Check Media Specs** for shelf life and ambient temperature settings which will affect cut quality.



TOOLS NEEDED:

- Blade: **CB15U-K30**
- Blade Holder: **PHP35-CB15N-HS**
- **LOUPE:** for setting blade length

CUT SETTINGS:

Adjust for CONDITIONS:

- FORCE: **39-44**
- SPEED: **15 or lower**
- ACCELERATION: **3 or lower**
- OVERCUT: **0.024"**
- CUT LINE PATTERN - TYPE: **USER** | CUT: **4"** | UP: **0.00** | UP MODE: **1**

Adjust for MENU: (menu button)

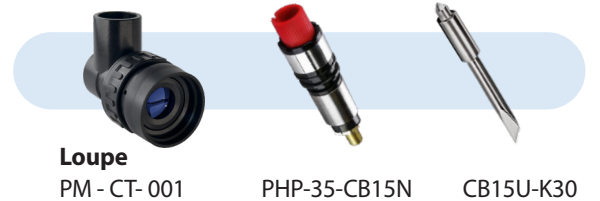
- 1 TOOL: Tool Up Move: **ENABLE**
- 1 TOOL: Moving Speed: **10cm/s**
- 2 ARMS: Scan Mode: **MODE 4**
- 2 ARMS: Sensing Speed: **5cm/s**
- SPEED: **15 or Lower**
- ACCELERATION: **3 or Lower**
- TANGENTIAL EMULATION: **Mode 1**
- OVERCUT: **0.024in**

BLADE LENGTH:

For **CB15U** Blades (45°) set length to **0.6mm**
For **CB15U-K30** Blades (60°) set length to **0.5mm**

TEST CUT:

Manufacturer instructions require a minimum **3.5" square test cut**.
(Above settings were acquired from a 5" square test cut)



Loupe
PM - CT - 001

PHP-35-CB15N

CB15U-K30

