

## SELECTION OF CUTTING HEIGHTS

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May we use this opportunity to advise you and your staff on how to select the correct cutting heights for the material to be welded.

### 1) Rule of thumb methode:

Cutting heights (in 10th omm) = total thickness of all layers of PVC foil (in 10th ofmm) divided by 2

Example: 1 layer of 400 ym (micron) = 4/10

1 layers of 200ym each = 4/10

Total thickness = 8/10

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Divided by 2 = 4/10 or 0.4mm

Therefore a Cutting heights of 4/10 should be selected.

### 2. If you prefer a more exact methode use the graph in Fig. 1

A typical view of a weld and cut rule is given in Fig. 2 and that of weld only in Fig.3.

The standard range of of cutting heights available are 1/10, 2/10, 3/10, 4/10, 5/10, 6/10. Others are available on special request.

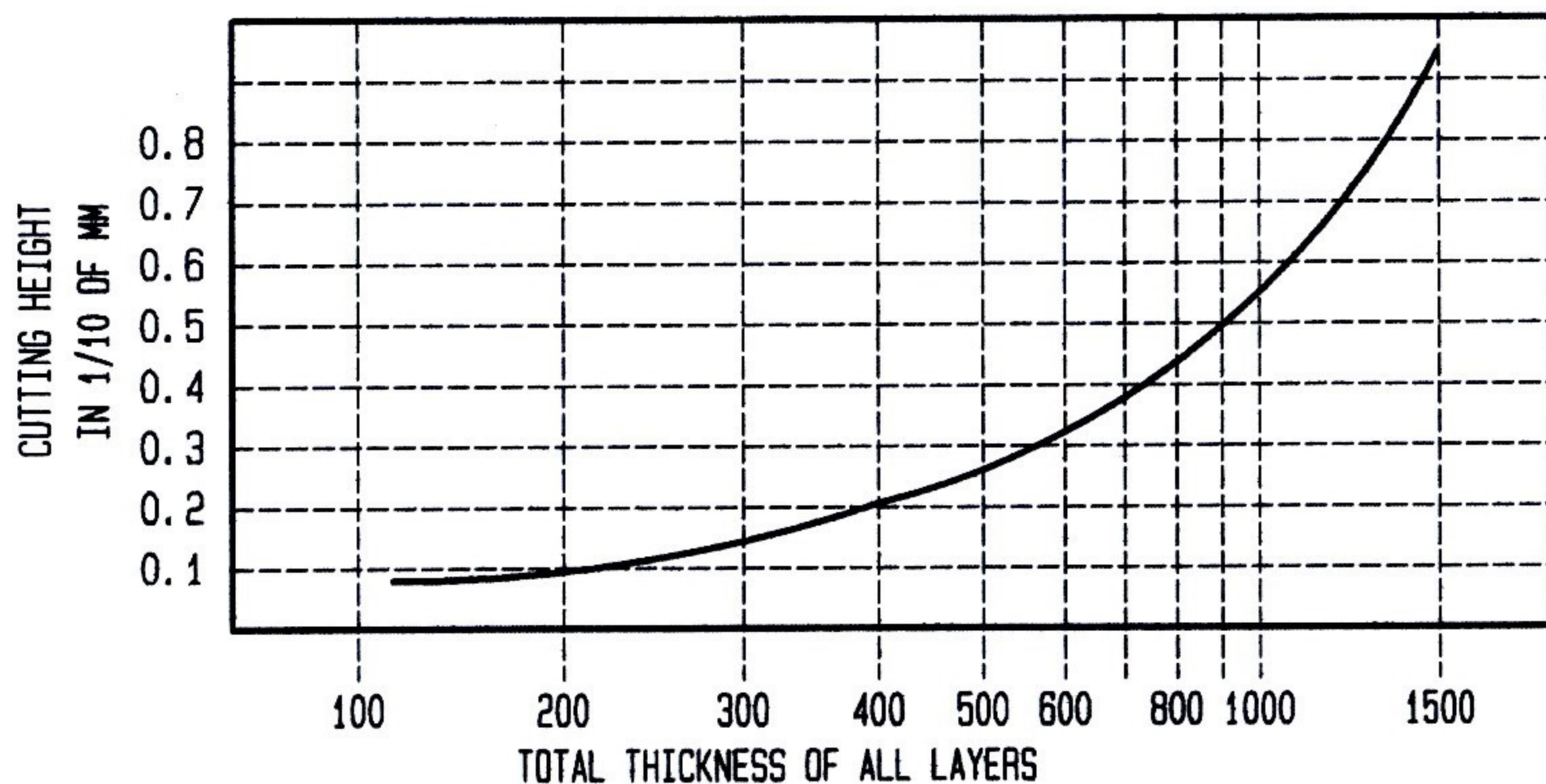


FIG 1

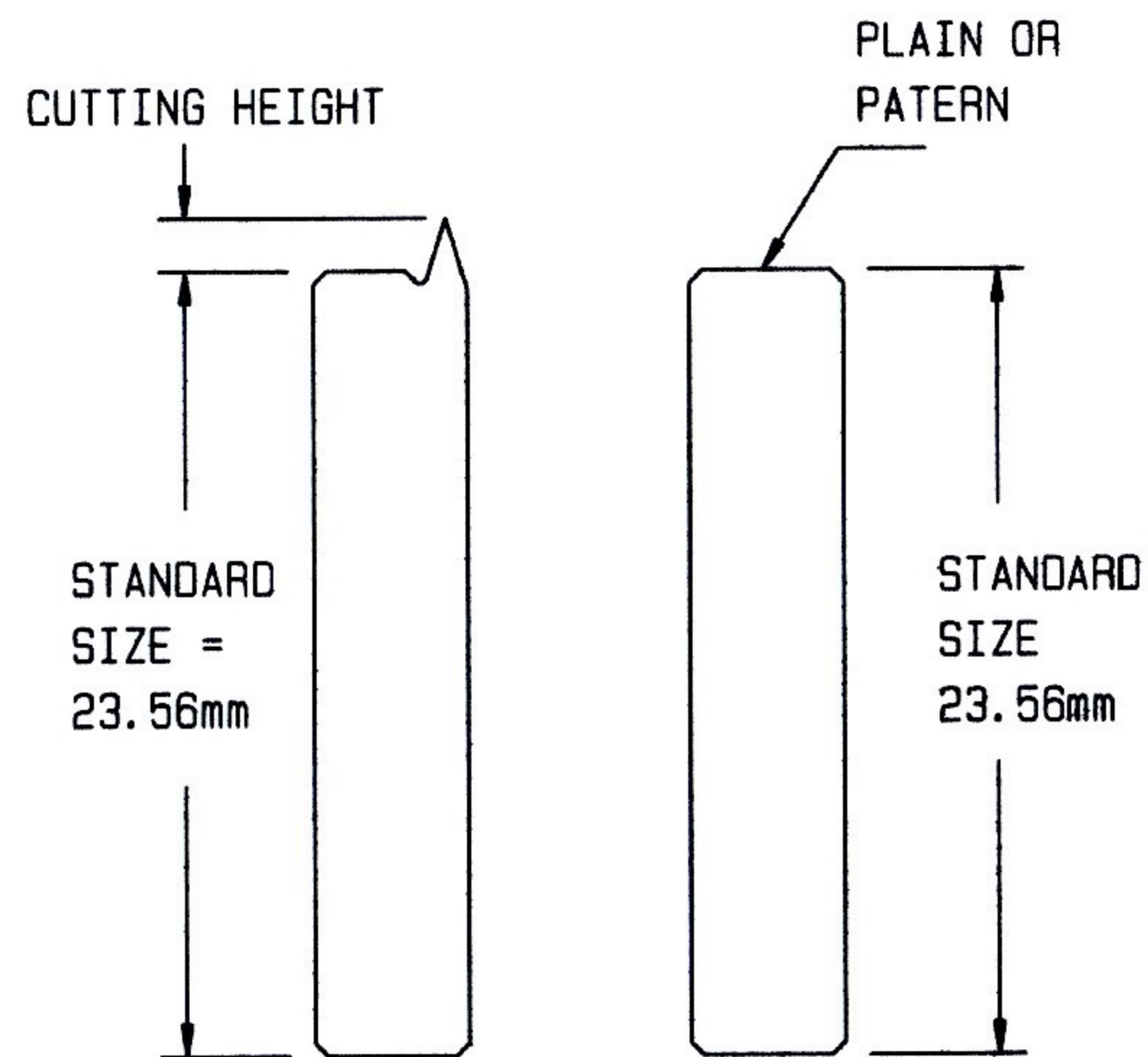


FIG 2

FIG 3



**Center & side Cut** M01

**Cut & weld 1.5mm** M02

**Cut & weld 2.25mm** M03

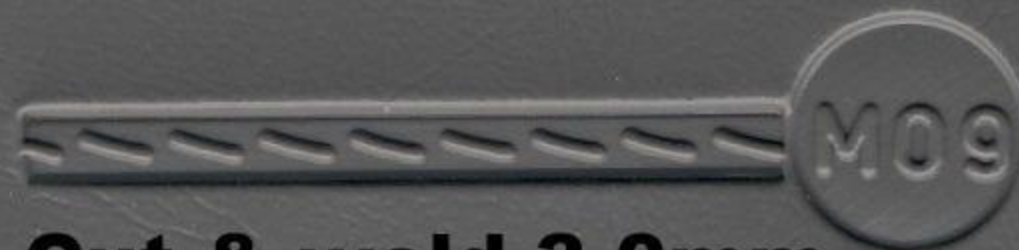
**Cut & weld 3.0mm** M04

**Cut & weld 1.5mm** M05

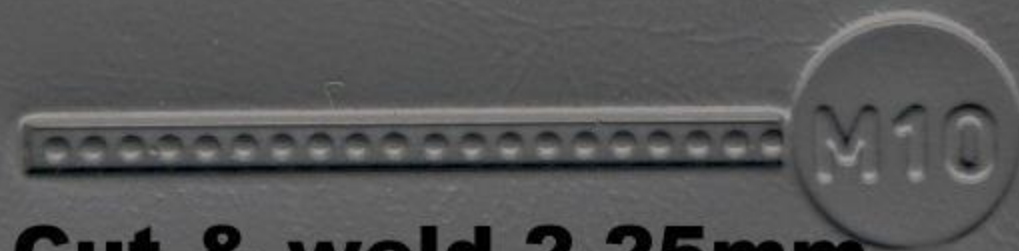
**Cut & weld 2.25mm** M06

**Cut & weld 2.25mm** M07

**Cut & weld 2.25mm** M08



**Cut & weld 3.0mm**



**Cut & weld 2.25mm**



**Cut & weld 2.25mm**



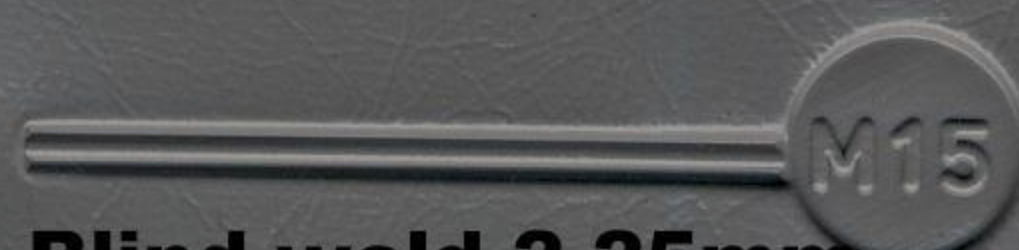
**Center cut & weld 2.25mm**



**Center cut & weld 3.0mm**



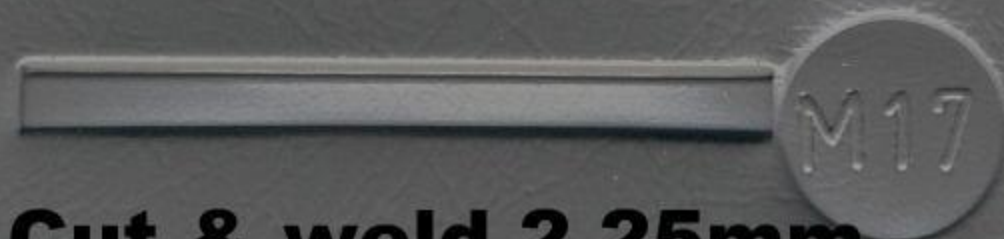
**Center cut & weld 4.5mm**



**Blind weld 2.25mm**



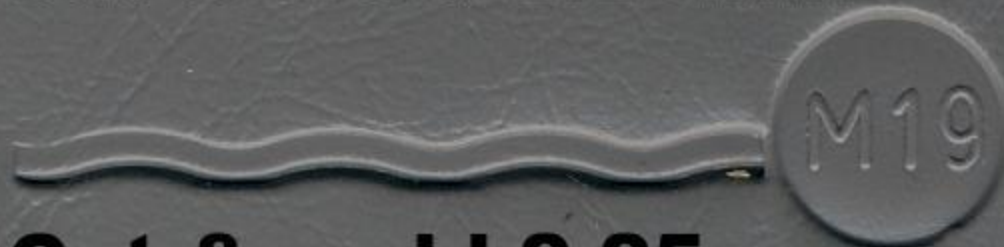
**Cut & weld 2.25mm**



**Cut & weld 2.25mm**



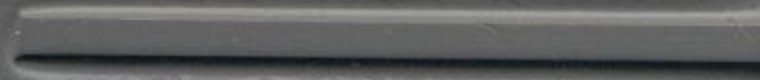
**Cut & weld 2.25mm**





**Cut & weld 2.25mm**





 M30  
**Weld only 1.5mm**


 M31  
**Weld only 2.25mm**


 M32  
**Weld only 3.0mm**

 M33  
**Weld only 4.5mm**

 M34  
**Weld only 6.0mm**


 M35  
**Weld only 1.5mm**

 M36  
**Weld only 2.25mm**


 M37  
**Weld only 2.25mm**


 M38  
**Weld only 2.25mm**

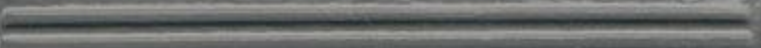
 M39  
**Weld only 3.0mm**

 M40  
**Weld only 2.25mm**


 M41  
**Weld only 3.0mm**

 M42  
**Weld only 1.5mm**

 M43  
**Weld only 1.5mm**

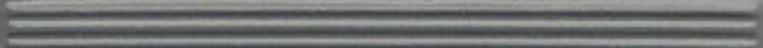
 M44  
**Weld only 2.25mm**

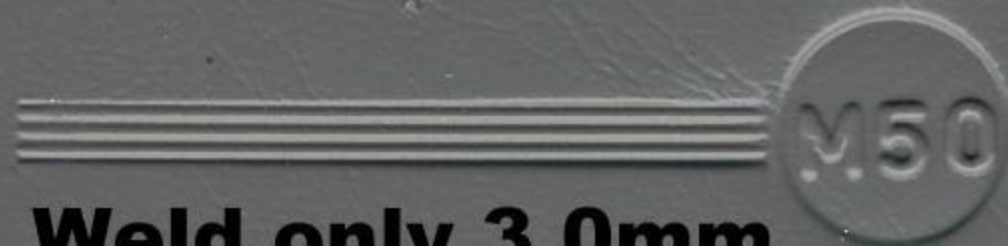
 M45  
**Weld only 3.0mm**

 M46  
**Weld only 4.5mm**

 M47  
**Weld only 3.0mm**

 M48  
**Weld only 4.5mm**

 M49  
**Weld only 2.25mm**



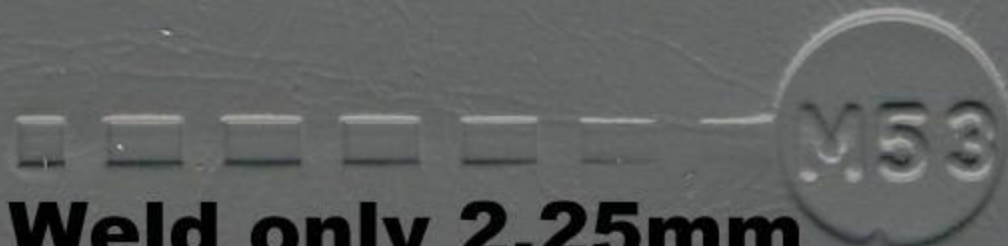
**Weld only 3.0mm**



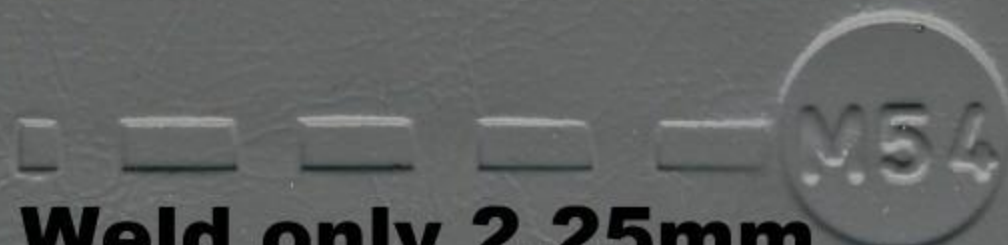
**Weld only 4.5mm**



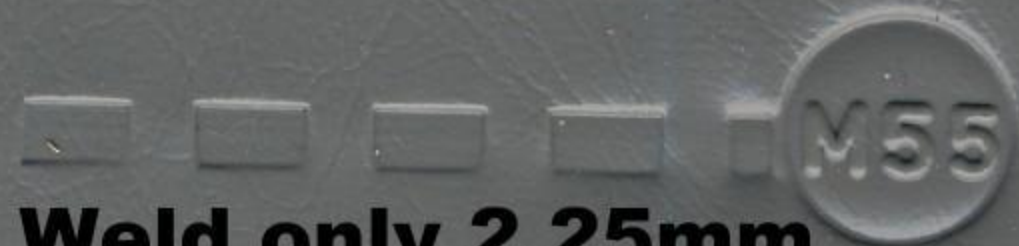
**Weld only 1.5mm**



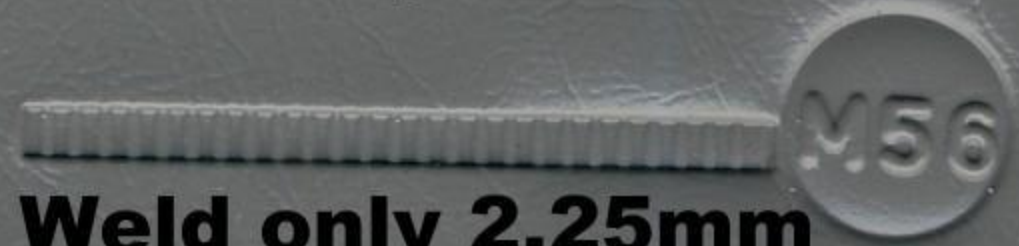
**Weld only 2.25mm**



**Weld only 2.25mm**



**Weld only 2.25mm**



**Weld only 2.25mm**



**Weld only 3.0mm**



**Weld only 4.5mm**



**Weld only 3.0mm**

OVAL



**Oval weld outs**

**Available as cut outs**

WO



**Round weld outs**



**Round cut outs**

**" T " cut outs**



TCO

CO