

Foster KeenCut SteelTrak Substrate Cutter

V-Groove Tool Guide



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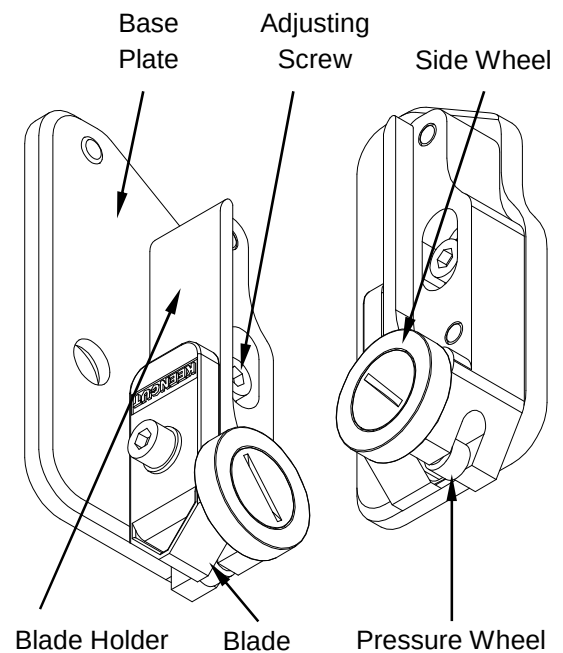
Using the Vee Grooving Tool on the SteelTraK



The Vee Grooving Tool is attached to the SteelTraK in place of the Twin Wheel Cutter and is used to cut Vee shaped grooves in the surface of a variety of materials such as composite boards (e.g. Dibond ®), PVC Foamboard and some fluted or honeycomb plastics such as Correx ®. Once the groove has been formed the board can be bent through various angles.

Each Vee Grooving tool is precisely machined to cut the correct size and depth of groove for a particular thickness of board. Check that the Vee size engraved on the tool matches the thickness of your board before attaching the Vee Grooving Tool to the machine.

There are various Vee Grooving Tools available to suit different thicknesses of board, please enquire further with your supplier.



Fitting, Adjusting & Using the Vee Grooving Tool

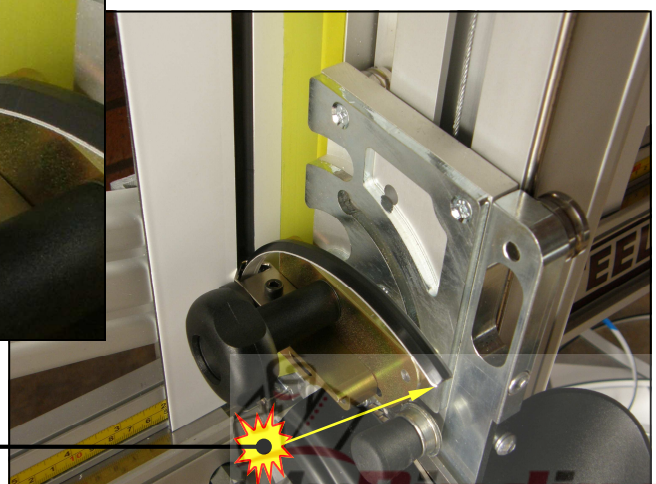
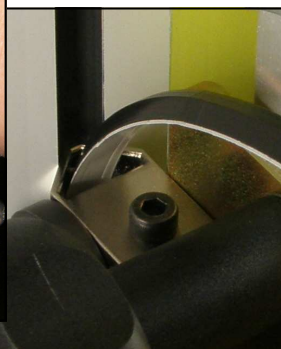
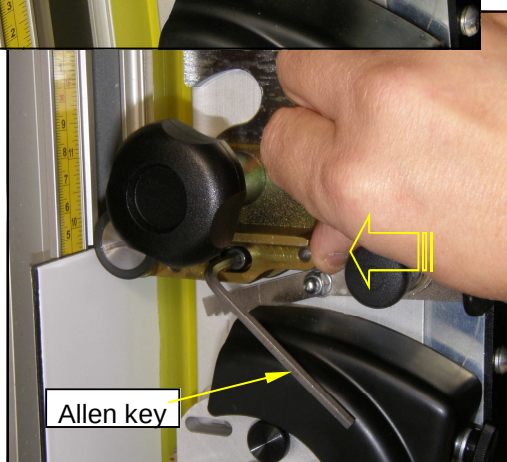
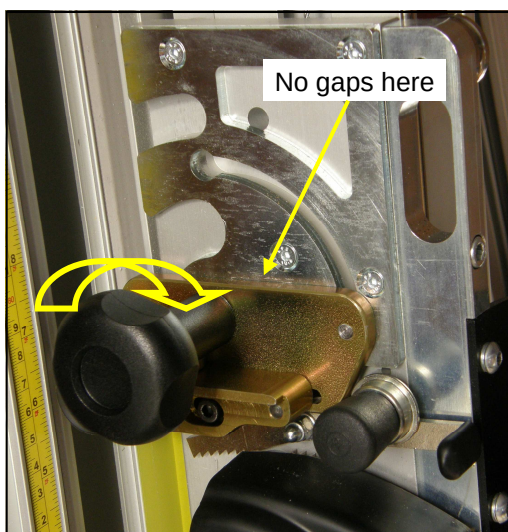
Remove the Twin Wheel Cutter, locate the Vee Groover in position as shown and clamp it in place with the knob. Ensure it is firmly clamped in place and there are no gaps between the Vee Groover base plate and the mounting plate.

Raise the cutting head on the SteelTraK and clamp a piece of the correct thickness of board in the machine.

Carefully bring the cutting head down until the Blade touches on the top edge of the board, loosen the Adjustment Screw with the Allen key supplied.

Push the Blade Holder until the Pressure Wheel is firmly pressed against the front surface of the board, tighten the Adjusting Screw whilst still pushing the Blade Holder.

The Vee Grooving Tool is now set for use.



To cut the vee just push down firmly on the cutting head being careful the off-cut does not cause injury. ●

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Position of the groove

The Vee Grooving Tool does not cut down the same line as the other blades, for accurate vee grooving either align a marked line on the sheet with the cutting tool by eye or use a production stop. For the second method place a piece of scrap material in the machine and score a line using the scoring blade on the turret head. Without moving the material fit the Vee Groove Tool and cut a vee groove. Measure the distance between the centre of the groove and the score line and that measurement will tell you how much to allow on the squaring arm scale when using the production stop.

Bending.

Most Materials can be easily bent by hand and a clean consistent radius is created along the bent edge. However, when bending materials such as PVC Foamboard ensure that the board is not cold, it can be very brittle when cold and could break.

Applying a small amount of heat to the PVC from a warm air blower or hair dryer will help if the board is cold. Experiment on some scraps of board to help you understand its folding properties. Bending slowly also helps.

Most boards that can be grooved can be bent to form anything from a 90° external corner ① to a 90° internal corner ②. It is also possible with some materials to form a 180° internal bend ③, this is particularly useful with aluminium faced composite boards as it provides a unique bevelled edge appearance and adds a lot of strength to the board once it is fixed in position with adhesive tape or glue.

Fixing the bend

Fixing the bends with adhesive both strengthens the whole board and sets the required angle accurately. There are two main methods to fix or glue the bends. The first method ④ uses pre-cut blocks or strips that are glued to the back of the board with a fast setting adhesive or hot-melt glue (seek advice from the board manufacturer regarding the best adhesive).

Alternatively, a bead of hot/melt glue or silicon adhesive/sealer ⑤ can be applied along the length of the groove and the board held in position whilst it sets.

If making a 180° internal bend a good quality double sided sponge tape can be used, apply it to the flap first peel off the release tape then fold the edge back onto the tape, silicon adhesive/sealer could also be used but do not use hot-melt glue for this application.

