

ESKO Kongsberg Application Sheet

ANTALIS - COALA AIR BOARD



Material Name	COALA AIR BOARD 2D & 3D
Material Thickness	10 and 16 mm
Special info	The settings in this list are ESKO's recommendation settings for this material. Settings could vary depending on the geometry of the cut file.
Alternative materials	Any other honeycomb type materials of the same thickness
Machine model	C / X / X Starter
Toolhead	Kongsberg C: MP HF VibraCut / HD Unit / V-notch Knife
	Kongsberg X: MultiCut / FlexiHead / PowerHead
	Kongsberg X Starter: MultiCut / FlexiHead

PROCESSING TYPE	MACHINE	TOOL	BLADE / BIT	SPEED	ACCEL	PASSES
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Cutting standard	Kongsberg C Same for XP, XP Auto	HF VibraCut Knife	BLD-SR8172	30 m/min	40%	1
			BLD-SR8160	30 m/min	40%	1
		HD Knife 17 ***	BLD-TZ129	100 m/min	100%	1
		HD Knife 30 ***	BLD-TZ230	100 m/min	100%	1
	Kongsberg X Same for XL, XN (Insert tools for FlexiHead, MultiCut and PowerHead)	MP HF VibraCut Knife	BLD-SR8172	35 m/min	40%	1
			BLD-SR8160	40 m/min	40%	1
		RBI90 - 16 **	BLD-SF290	50 m/min	100%	1
	Kongsberg X Same for XL, XN (Tools for PowerHead HD unit)	HD Knife 17 *	BLD-TZ129	50 m/min	100%	1
		HD Knife 30 *	BLD-TZ230	50 m/min	100%	1
	Kongsberg X Starter Same for Kongsberg VL and V table (V-notch Insert tools for FlexiHead and MultiCut toolhead)	MP HF VibraCut Knife	BLD-SR8172	30 m/min	50%	1
			BLD-SR8160	30 m/min	50%	1
		RBI90 - 16 **	BLD-SF290	30 m/min	100%	1

V-notching	Kongsberg C Same for XP, XP Auto	V-notch Knife 45°	BLD-TZ511 / BLD-TZ192	100 m/min	100%	1
		V-notch Knife 45° 10mm	BLD-TZ511 / BLD-TZ192	100 m/min	100%	1
		V-notch Knife 30°	BLD-TZ511 / BLD-TZ192	100 m/min	100%	1
		V-notch Knife 22.5°	BLD-TZ511 / BLD-TZ192	100 m/min	100%	1
		V-notch Knife 15°	BLD-TZ511 / BLD-TZ192	100 m/min	100%	1
	Kongsberg X Same for XL, XN (For PowerHead HD unit)	V-notch Knife 45°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
		V-notch Knife 45° 10mm	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
		V-notch Knife 30°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
		V-notch Knife 22.5°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
		V-notch Knife 15°	BLD-TZ511 / BLD-TZ192	50 m/min	100%	1
	Kongsberg X (V-notch Insert tools for FlexiHead, MultiCut and PowerHead)	VI45-16	BLD-DF571 / BLD-DF572	50 m/min	100%	1
		VI45-10	BLD-DF561 / BLD-DF562	50 m/min	100%	1
		VI30-16	BLD-DF571 / BLD-DF572	50 m/min	100%	1
	Kongsberg X Starter Same for Kongsberg VL and V table (V-notch Insert tools for FlexiHead and MultiCut toolhead)	VI45-16	BLD-DF571 / BLD-DF572	30 m/min	100%	1
		VI45-10	BLD-DF561 / BLD-DF562	30 m/min	100%	1
VI30-16		BLD-DF571 / BLD-DF572	30 m/min	100%	1	

* only for PowerHead on Kongsberg X tables. This knife is limited to straight line only, longer than 50mm (2")

** Tooling insert for Kongsberg X tables. This knife is limited to straight line only)

*** HD Knife for Heavy Duty Unit on C is limited to straight line only, longer than 50mm (2")