

45 Degree Blades



60 Degree Blades



Material	Blade Type	Blade Depth	Speed	Pressure
Sign Vinyl	45 Degree	Barely poking out of holder	Full speed up to 108 inches per second	90 grams (9 - Graphtec)
ThermoFlex	45 Degree	Barely poking out of holder	Full speed up to 108 inches per second	90 grams (9 - Graphtec)
Rhinestone Decal Material	45 Degree	Barely poking out of holder	6 to 8 inches per second	60 grams (6 - Graphtec)
Sequin Film	45 Degree	Barely poking out of holder	Up to 60 inches per second	110 grams (11 - Graphtec)
DecoSparkle	45 Degree	Barely poking out of holder	Up to 60 inches per second	90 grams (9 - Graphtec)
DecoFlock	60 Degree (Z Blade)	½ thickness of credit card	Up to 60 inches per second	120 grams (12 - Graphtec)
Wonder Flock	60 Degree (Z Blade)	½ thickness of credit card	Full speed up to 108 inches per second	155 grams (15 - Graphtec)
GlitterFlex Ultra/II	60 Degree (Z Blade)	¼ thickness of credit card	Up to 60 inches per second	120 grams (12 - Graphtec)
Polyester Twill	60 Degree (Z Blade)	½ thickness of credit card	Up to 30 inches per second	180 grams (18 - Graphtec)

Cutting and Weeding Tips

1. Use a 60 degree Z blade from DAS to cut Glitter vinyl or Wonder Flock on a Roland or GCC cutter. This is a special “narrow taper” blade that will cut more precise holes for rhinestone templates.
2. DO NOT use the same blade for cutting Glitter vinyl and Wonder Flock. The blade type is the same, but you should dedicate a separate blade for Glitter vinyl to avoid dulling the blade and causing weeding issues with the Wonder Flock. Mark your Glitter vinyl blade with nail polish.
3. When setting the blade depth for Thermoflex, Decal Film and Sign Vinyl, dial the blade all the way into the holder. Place a finger over the opening and dial blade out until you feel a prick. This would be the correct depth. It should barely be poking out of the holder.
4. If you know the correct pressure, simply adjust the blade depth until you get good weeding.
5. If your weeding is starting to deteriorate, it's time for a new blade, call DAS at **1-800-959-7627 ext 117** to re-order.
6. Make sure to periodically clear any debris or residue from your blade if you are cutting Wonder Flock.
7. If you cut too deep, you will carve a groove in the cutting strip of your cutter. You will need to replace the cutting strip if you start to experience inconsistent weeding.
8. The key to good cutting is maximum pressure and minimum blade depth. If you are dialing in a new material, it is better to adjust blade depth first, then experiment with increasing or decreasing pressure in 5 gram increments.
9. When you are cutting Wonder Flock, make sure that you have assigned the Overcut property in StoneCut Pro to the objects you are cutting. The overcut property will also help weeding with fine text. Select your object and choose **Convert to Rhinestone** from the StoneCut Pro **Macros** docker. Make sure Overcut is checked.
10. To insure the best cutting and weeding with a GCC cutter, make sure your knife offset is set to .400 and your Overcut is set to .400 on the cutter. Note: GCC Expert 24 cutters do not have an Overcut.