



GRAVOGRAPH BRASS DOOR PLATES

ENGRAVING and COLOURING TIPS



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This plate is made of solid brass, and is easy to engrave. Its lacquered polished surface gives it a good outdoor and oxidation resistance.

When handling, always take care not to SCRATCH the plate.

ENGRAVING THE PLATE

Jigs
06 147 200

➤ **CLAMPING THE PLATES** : With special jigs that correspond to the shape of the plate. You can secure oval plates without jigs, taking care not to clamp them too tight so that you do not mark the sides. For batch production, use the mechanical stop located on the jigs.



Protective adhesive
08 013 000

➤ **ENGRAVING WITH A CUTTER**: with a steel regulating nose (or Nylon) and physical protection (protective adhesive) and the optional use of a swarf extractor (for optimised results).

Caution :

- Engraving with a pantograph : you must not press too much on the tool-holder so that you do not damage the physical protection.
- Engraving with an electronic machine : release the spindle spring as much as possible.

➤ **ENGRAVING WITH A DIAMOND**: (in this case, the engraving depth only enables colouring with Gravoxide). The pressure of the spindle spring defines the engraving width.

- Engraving with a pantograph: constant average pressure.
- Engraving with an electronic machine: we advise you to release the spindle spring half way.

Caution : do not use a regulating nose when using a diamond

TOOLS

▪ **Cutter** : carbide or steel



Grinding	
Cutting angle	40°
Half-taper angle	18°
Tip angle	7°
Clearance angle	15°

Type of tools	<u>Steel</u>	<u>Carbide</u>
Ø 3.17	05 576 xxx	05 410 xxx
Ø 4.36	58 106 xxx	58 101 xxx
TwinCut® Insert	-	B7 300 xxx

Warning : these parameters are only valid with Gravograph standard cutters

NB : The size of the tip depends on the engraving width you wish to obtain

▪ **Diamond** : tracing diamond

Type of tools	<u>Diamond</u>
Ø 3.17	05 410 xxx
Ø 4.36	58 101 xxx
TwinCut® Insert	B7 300 xxx

MACHINE PARAMETERS

	Speed (mm/s)			Dwelling time	Engraving depth
	Z	X-Y	Rotation (Revolution / mn)		
CUTTER	5	10	20 000	0	0.25 to 0.3mm spindle pressure*
DIAMOND	35	35	motorless	0	

* add +0.08 mm if using protective adhesive

We advise you to do **one pass at full depth**, whatever tool you use.

Recommended character height: one third of the plate height (on 1 line)

(For example : for a 28 mm high plate, take 8 mm high letters)

COLOURING THE PLATES

In order to achieve a lasting and aesthetic result, coloration with paint is recommended on plates engraved with a cutter.



- ❖ **Paint** : Apply it with a flat spatula that will not scratch (a piece of Gravoply or bristol) or fill the engraved characters with a syringe



Never apply 2 coats

Clear away the excess with a clean spatula

Leave to dry for 40 mn

Clean with application diluant *

Leave to dry for a few hours.

* Soak a piece of soft cloth, without wool, with application diluant. Lightly rub down your plate to clear away the excess paint

We recommend the use of Gravograph's paint to avoid an ink or paint incompatibility with the protection varnish.

Other techniques can also be used :

- ❖ **Gravoxide** : (on plates engraved with a cutter or a diamond)
Apply on the engraving with the pad supplied with the bottle.
Rinse with water in order to clear away the product.
Quickly clean with a soft cloth.
- ❖ **Cold wax** : (on plates engraved with a cutter)
First lightly heat the tip of the wax to soften it and apply on the characters.
Clean with absorbent paper.



Gravolaque
87 400 0xx

Application
diluant
87 413 000

Professional
tip

Gravoxide
58 476 000

Cold wax
pencils
#.06 710 00x