



# The Gilman Brothers Company

## CUTTING GUIDELINES

MATERIAL	THICKNESS	TYPE OF CUT	TOOL	BLADE	DEGREE ANGLE	(ROUT) BIT	(ROUT) RPM	FEED RATE SPEED INCHES/SEC	ACCELERATION SPEED
InSite®	3/16"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
InSite®	3/16"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
InSite®	3/16"	Thru Cut Straight	UCT	Z46				39.67	4
InSite®	3/16"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
InSite®	1/2"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
InSite®	1/2"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
InSite®	1/2"	Thru Cut Straight	UCT	Z46				39.67	4
InSite®	1/2"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
Infinity®	3/16"	Thru Cut Less Detail	Router			R116	31,000	2	2
Infinity®	3/16"	Thru Cut More Detail	Router			R116	31,000	2	2
Infinity®	3/16"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
Infinity®	3/16"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
Infinity®	3/16"	Thru Cut Straight	UCT	Z46				39.67	4
Infinity®	3/16"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
Infinity®	1/2"	Thru Cut Less Detail	Router			R116	31,000	2	2
Infinity®	1/2"	Thru Cut More Detail	Router			R116	31,000	2	2
Infinity®	1/2"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
Infinity®	1/2"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
Infinity®	1/2"	Thru Cut Straight	UCT	Z46				39.67	4
Infinity®	1/2"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	3

\*These are guidelines, however, there can be many different blade and setting combinations.



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## CUTTING GUIDELINES

MATERIAL	THICKNESS	TYPE OF CUT	TOOL	BLADE	DEGREE ANGLE	(ROUT) BIT	(ROUT) RPM	FEED RATE SPEED INCHES/SEC	ACCELE- RATION SPEED
<b>Ecor® Tetrapak</b>		Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
<b>Ecor® Tetrapak</b>		Thru Cut Straight	UCT	Z46				39.67	4
<b>EAGLECELL™</b>	1/4"	Thru Cut Less Detail	EOT -250	Z60 or Z61				23.6	4
<b>EAGLECELL™</b>	1/4"	Thru Cut More Detail	EOT -250	Z21 or Z23				23.6	2
<b>EAGLECELL™</b>	1/4"	Thru Cut Straight	UCT	Z46				39.67	4
<b>EAGLECELL™</b>	1/4"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	2
<b>EAGLECELL™</b>	1/2"	Thru Cut Less Detail	EOT -250	Z60 or Z61				15.75	4
<b>EAGLECELL™</b>	1/2"	Thru Cut More Detail	EOT -250	Z21 or Z23				3.94	2
<b>EAGLECELL™</b>	1/2"	Thru Cut Straight	EOT -250	Z60 or Z61				39.67	4
<b>EAGLECELL™</b>	1/2"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
<b>Ryno Board®</b>									
<b>Ryno Board®</b>	3/16"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
<b>Ryno Board®</b>	3/16"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
<b>Ryno Board®</b>	3/16"	Thru Cut Straight	UCT	Z46				39.67	4
<b>Ryno Board®</b>	3/16"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4
<b>Ryno Board®</b>	1/2"	Thru Cut Less Detail	EOT -250	Z60 or Z61				5.5	4
<b>Ryno Board®</b>	1/2"	Thru Cut More Detail	EOT -250	Z21 or Z23				5.5	2
<b>Ryno Board®</b>	1/2"	Thru Cut Straight	EOT -250	Z60 or Z61				39.67	4
<b>Ryno Board®</b>	1/2"	'V' Cut	VCT	Z71	0,15,22.5,45			39.67	4

\*These are guidelines, however, there can be many different blade and setting combinations.

# Zünd America Support Escalation



To report technical issues/request assistance, please contact:

## ZÜND SERVICE CENTER

**(833) 721-1922 - 7am-7pm CT - Monday-Friday**

For **ESCALATION** during the first 24 hours, if no viable solution/recommendation is in place, please contact the **Supervisor Group**. Direct contact information for supervisors is also provided below.

### Supervisor Group

**\*\* Please have your ZÜND CASE NUMBER before contacting this group! \*\***

- Anthony Watts: Service/Call Center Supervisor, [anthony.watts@zund.com](mailto:anthony.watts@zund.com)
- RJ Dusak: West Service Supervisor, [rj.dusak@zund.com](mailto:rj.dusak@zund.com)
- Shawn Gethers: East Service Supervisor, [shawn.gethers@zund.com](mailto:shawn.gethers@zund.com)
- Jason Boring: Training Supervisor, [jason.boring@zund.com](mailto:jason.boring@zund.com)

(\*\*East and West Territories divided by Mississippi River\*\*)

**East includes Canada;  
Caribbean West includes Alaska and Hawaii**

### North American Service Manager

If the issue has not been resolved or there is not a viable plan in place **after 24 hours**, please contact our Service Manager directly.

- **Victor Quintana:** [victor.quintana@zund.com](mailto:victor.quintana@zund.com)

### Additional Contact Information

#### Shipping/Receiving/Spare Parts/Consumables:

- **Warehouse Manager:** Sean Davenport (414)-433-9082 [sean.davenport@zund.com](mailto:sean.davenport@zund.com)
- **Warehouse Lead:** Justin Jutrzonka (414)-433-0305 [justin.jutrzonka@zund.com](mailto:justin.jutrzonka@zund.com)
- **Consumables:** John Heineck (414)-433-9087 [john.heineck@zund.com](mailto:john.heineck@zund.com)