

## **HOW TO CUT A V-GROOVE IN AN 8 PLY MAT**

8 ply mats are very thick, and the best cut results are achieved when cutting is done from the back of the mat, to help eliminate blade flex and “hooking”. Thus cutting an 8 ply mat with a v-groove on the front needs to be done in a two stage process. Here are the steps below –

### **STAGE ONE – CUTTING & SIZING THE MAT**

1. Remove the protective plate from the table of the machine, to allow extra space under the clamps.
2. Insert the un-sized piece of 8 ply mat into the clamps, ready to cut.
3. Make sure the software in “cut from the back” mode (F4)
4. Select the “Eight Ply” blade profile (usually C8 – approx 3.0mm?) in the software.
5. Design the mat and the opening required on the screen, as per normal.
6. Apply the OC (Outside Cut)
7. Insert the pre-configured 8 ply blade holder (approx 3.0mm - 3.5mm) into the cutting head with a fresh blade – always use a new blade when cutting 8 ply – as it is quite dense and abrasive against the blade.
8. Cut the mat (CTRL F9).

### **STAGE TWO – CUTTING THE V-GROOVE**

1. Remove the off-cuts and fallout – and turn the mat over, face up.
2. Position the mat in the correct orientation\*\*, and make sure it is tight underneath the clamps.
3. Change the software into “cut from the front” mode (F4).
4. Select the “Regular” blade profile (usually C3 – 1.3mm) in the software.
5. Start with a new design (CTRL N)
6. Create the desired mat layout with a V-groove only (no opening).
7. **DO NOT APPLY AN OUTSIDE CUT**
8. Insert the regular blade holder (1.3mm) into the cutting head with a fresh blade – always use a new blade for v-grooves.
9. Cut the mat.

*\*\*Beware there is a trap here if you are cutting a weighted bottom mat – make sure you have the matboard rotated and positioned in the correct orientation under the clamps when you come to cut the v-groove from the front, as the design on the screen (or the mat itself) may have to be inverted.*

- Keep in mind that different brands of 8 ply come in different thicknesses (*Crescent = 3.0mm thick, Bainbridge = 3.5mm thick*) thus you may wish to create separate blade holders for different brands, or do test cuts and make

any required blade depth adjustments prior to cutting your brand new full sheet.

- Until you are confident with following these steps, it is always best to perform a practice run on a spare 8 ply off-cut first, to be sure you understand everything correctly.