Instructions for Cutting 3M 4000 Series High Reflective Sheeting

To achieve Optimal Cut Quality on FC9000 Series cutters, please refer to the following instructions:

For **PROPER TRACKING**, we recommend **2 Additional Push Rollers, Media Flanges and Stopper**.

**Tools Needed:**
- CB15 Blade Holder: PHP33-CB15N-HS or PHP35-CB15N-HS
- Loupe for setting blade length
- Blades: CB15U / CB15UA / CB15U-K30

**Cut Settings:**
- Force: 39-44
- Speed: 15 or Lower
- Acceleration: 3 or Lower
- Tangential Emulation: **Mode 1**
- Overcut: 0.024in

**Blade Length:**
For CB15U Blades (45°) set length to .6mm
For CB15U-K30 Blades (60°) set to length to .5mm

**Test Cut:**
Manufacturer instructions require a minimum **3.5” square test cut**.
(Above settings were acquired from a 5” square test cut)