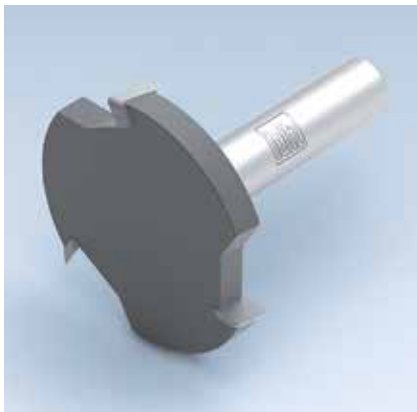


5. Routing

5.5 Portable routers

5.5.3 Tools for solid surface materials



Planing cutter

Application:

Router for cutting panel raising profiles.

Machine:

Portable routers.

Workpiece material:

Solid surface material (Corian, Varicor etc.).

Technical information:

Optimised cutting geometry for clean planed surface. Also suitable for edge trimming of installed sinks of solid surface material.



HW, Z 3

WO 110 1

D	GL	NL	S	n_{max}	DRI	ID
mm	mm	mm	mm	min^{-1}		
52	60	7.3	12x40	27000	RH	072693 □



HW



Grooving cutter with internal threaded shank

Application:

Router cutter for sizing and grooving.

Machine:

Portable routers. M10: Scheer, M12: DeWalt (former ELU).

Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

Technical information:

Straight cut, ground on end or tungsten carbide plunging tip.



HW, Z 2

WO 120 1 06, WO 120 1 11, WO 120 1 12

D	GL	NL	S	QAL	DRI	ID
mm	mm	mm	mm			
10	67	35	M10	HW	RH	042050 ●
12	70	40	M12	HW	RH	040082 ●
16	75	45	M12	HW	RH	040084 ●
20	60	25	M12	HW	RH	039942 ●



HW

RPM: $n = 16000 - 24000 \text{ min}^{-1}$

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 Челябинск (351)202-03-61
 Череповец (8202)49-02-64
 Ярославль (4852)69-52-93

5. Routing

5.1 Sizing and grooving

5.1.3 Shank cutters DP



Router cutter Diamaster PRO

Application:

Router for sizing and grooving with continuous cutting edge.

Machine:

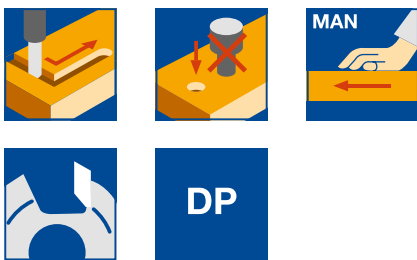
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Workpiece material:

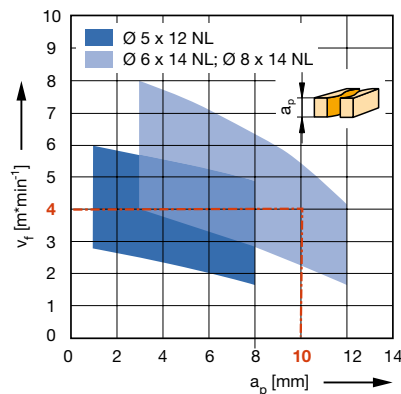
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, laminated materials (HPL-compact laminate, Trespa, multiplex plywood), NF-metals.

Technical information:

Solid tungsten carbide tool body for increased stability and smooth running. DP face edge suitable for plunging. Slightly positive shear angle for improved chip removal when ramp plunging. Axial infeed for grooving and sizing maximum 1.0 - 1.5 x D. Resharpenable up to 3 times with normal wear.



Feed speed v_f depending on cutting depth a_p

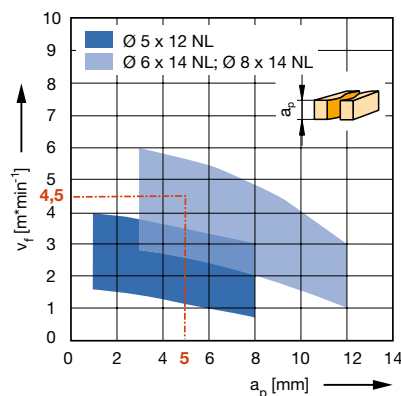


Workpiece material: Plastic coated chipboard

Operation: Sizing

RPM: $n = 18000 \text{ min}^{-1}$

Correction factor for v_f : MDF = 0.8; uncoated chipboard = 1.1



DP, Z 1

WO 120 2 50

D	GL	NL	S	Z	DRI	ID
mm	mm	mm	mm			
5	60	12	8x35	1	RH	191086 ●
6	60	14	8x35	1	RH	191087 ●
8	55	10	8x35	1 (0°)	RH	191107 ●
8	60	14	8x35	1	RH	191088 ●

RPM: $n = 18000 - 24000 \text{ min}^{-1}$

Workpiece material: Thermoplastics, compound materials

Operation: Sizing

RPM: $n = 18000 \text{ min}^{-1}$

5. Routing

5.1 Sizing and grooving

5.1.3 Shank cutters DP



Router cutter Diamaster PLUS

Application:

Router cutter for sizing and grooving with seamless cut. Particularly suitable for machining MDF with direct lacquering or foil coating of the machined edges

Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

Workpiece material:

Hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, laminated materials (HPL-compact laminate, Trespa, multiplex plywood).



Technical information:

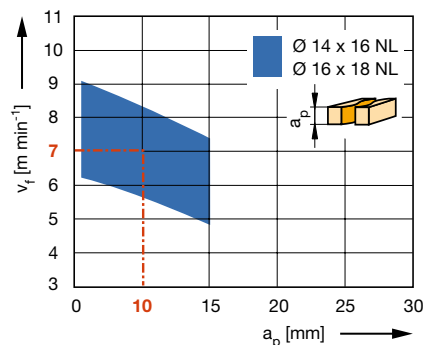
Negative cutting edge shear angles for tear-free edges during grooving and to support the workpiece clamping of smaller parts. Resharpenable 5 to 8 times with normal wear. Short and stable tool design ideal for grooving and sizing of abrasive and hard to machine materials (HPL, Trespa, GFRP, CFRP etc.).

DP, Z 2

WO 120 2 60

D	GL	NL	S	Z	DRI	ID
mm	mm	mm	mm			
14	80	16	20x50	2	RH	091157 ●
16	80	18	20x50	2	RH	091156 ●

Feed speed v_f depending on cutting depth a_p



RPM: Wood derived materials: $n = 16000 - 24000 \text{ min}^{-1}$

Plastics: $n = 12000 - 18000 \text{ min}^{-1}$

Workpiece material: Duromers, decorative laminates (HPL, CPL), fibre reinforced plastics

Operation: Sizing

Speed: $n = 12000 - 18000 \text{ min}^{-1}$

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