

5. Routing

5.4 Profiling

5.4.5 Tools for special profiles



Profile cutterheads for serrated back blank knives

Application:

For cutting different profiles.

Machine:

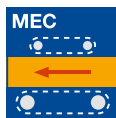
Routing machine with/without CNC control, special routers with spindles to hold shank tools.

Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood, etc.).

Technical information:

High precision knife clamping through back serrated knives. Wide range of different cutting materials to suit the workpiece material.



Z 2

WP 510 2 01

D	TD	SB	GL	S	Z	DRI	n _{max}	ID
mm	mm	mm	mm	mm			min ⁻¹	
100	63	40	108	25x60	2	RH	12000	042898 ●

Sales unit consisting of cutterhead and clamping system, but without knives.

Cutting material recommendation:

	HS	HW-30 F	HW-10 F
Softwood	◆	◆	
Hardwood		◆	◆
Glulam		◇	◆
Chipboard			◆
MDF		◆	◆
Solid surface materials			◆
HPL			◆

◆ suitable
◇ partly suitable

Blank knives HS

AT 103 0 28

SB	H	DIK	PT	SET	QAL	ID
mm	mm	mm	mm	PCS		
40	41.5	6	15	2	HS	697545 ●

Spare parts:

BEZ	ABM	ID
mm		
Clamping wedge	39x18.5x7.2	009970 ●
Allen screw	M8x14	006073 ●
Allen key	SW 4, L 71	005468 ●

Blank knives / support plates Powerknife System PKS

AT 103 0 35, AT 107 0 35

SB	H	DIK	PT	SET	QAL	ID	ID
mm	mm	mm	mm	PCS		Blank knife	Blank knife + support plate
40	42.5	2.5	15	2	HW-10F	698006	698106
40	42.5	2.5	15	2	HW-30F	698001	698101

Spare parts:

BEZ	ABM	ID
mm		
Clamping wedge MS	39x18x6	009771 ●
Allen screw	M8x14	006073 ●
Allen key	SW 4, L 71	005468 ●

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3. Planing and profiling

3.3 Profiling

3.3.3 Cutterheads for multi-purpose profiling



Profile cutterhead with HSK 85 WS for serrated back blank knives

Application:

For multi-purpose profiles in hard and/or materials likely to splinter.

Machine:

Four-sided moulders with HSK 85 WS interface.

Workpiece material:

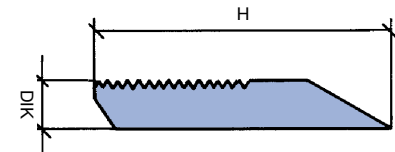
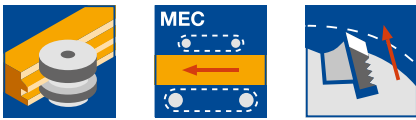
Cutting angle 20° for softwood and hardwood in general.

Cutting angle 12° for materials likely to splinter e.g. oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

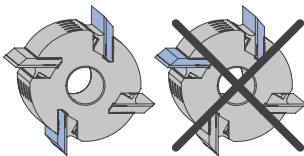
Technical information:

Profile cutterhead with back serration, 1.6 mm pitch, with integrated HSK.

Blanks with knife thickness 8 - 10 mm and knife heights of 40 - 70 mm can be used depending on the required profile depth. Cutting materials: Marathon (MC) and HW. Steel tool body. High balance quality by assembly with parts of the same weight.



Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



Attention:

For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

H mm	QAL	PT mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18
55		15
70		27

Table to determine maximum profile depth. The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.

Cutting angle 20°

WP 510 2 02

TD mm	SB mm	A mm	Z	n _{max} min ⁻¹	ID	ID
					LH / bottom	RH / top
90	40	26	2	12000	136200	136201
90	60	26	2	12000	136202 ●	136203 ●
90	80	26	2	12000	136204 ●	136205 ●
90	100	26	2	12000	136206 ●	136207 ●
90	130	26	2	12000	136208 ●	136209 ●
90	150	26	2	12000	136210	136211
* 90	170	26	2	12000	136212 ●	136213 ●
* 90	210	26	2	12000	136216	136217
* 90	240	26	2	12000	136218 ●	136219 ●
90	270	26	2	8000	136220	136221
90	40	26	4	12000	136224 ●	136225 ●
90	60	26	4	12000	136226 ●	136227 ●
90	80	26	4	12000	136228 ●	136229 ●
90	100	26	4	12000	136230 ●	136231 ●
90	130	26	4	12000	136232 ●	136233 ●
90	150	26	4	12000	136234	136235
* 90	170	26	4	12000	136236 ●	136237 ●
* 90	210	26	4	12000	136240	136241
* 90	240	26	4	12000	136242 ●	136243 ●
* 90	270	26	4	8000	136244	136245
115	80	26	6	10000	136198 ●	136199 ●
115	130	26	6	10000	136400 ●	136401 ●
115	170	26	6	10000	136402 ●	136403 ●
115	240	26	6	8000	136404 ●	136405 ●

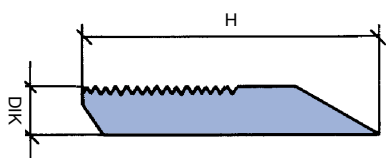
* = Not for PKS blank knives H = 70 mm with n = 12,000 min⁻¹

Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.

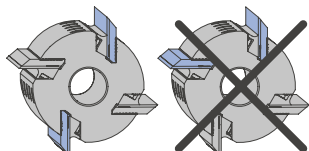
3. Planing and profiling

3.3 Profiling

3.3.3 Cutterheads for multi-purpose profiling



Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



Attention:

For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

H mm	QAL	PT mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18
55		15
70		27

Table to determine maximum profile depth. The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.

Cutting angle 12°

WP 510 2 02

TD mm	SB mm	A mm	Z	n _{max} min ⁻¹	ID LH / bottom	ID RH / top
90	40	26	2	12000	136248 ●	136249 ●
90	60	26	2	12000	136250 ●	136251 ●
90	80	26	2	12000	136252	136253
90	100	26	2	12000	136254 ●	136255 ●
90	130	26	2	12000	136256 ●	136257 ●
90	150	26	2	12000	136258	136259
*	90	170	2	12000	136260	136261
*	90	210	2	12000	136264	136265
*	90	240	2	12000	136266	136267
90	40	26	4	12000	136270 ●	136271 ●
90	60	26	4	12000	136272 ●	136273 ●
90	80	26	4	12000	136274 ●	136275 ●
90	100	26	4	12000	136276 ●	136277 ●
90	130	26	4	12000	136278	136279
90	150	26	4	12000	136280	136281
*	90	170	4	12000	136282	136283
115	80	26	6	10000	136192	136193
115	130	26	6	10000	136194	136195
115	170	26	6	10000	136196	136197

* = Not for PKS blank knives H = 70 mm with n = 12,000 min⁻¹

Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.

Spare parts:

BEZ	for knife thickness mm	for SB mm	ID
Clamping wedge	8/10	40	620816 ●
Clamping wedge	8/10	60	620817 ●
Clamping wedge	8/10	80	620818 ●
Clamping wedge	8/10	100	620819 ●
Clamping wedge	8/10	130	620820 ●
Clamping wedge	8/10	150	620821 ●
Clamping wedge	8/10	170	620822 ●
Clamping wedge	8/10	190	620823 ●
Clamping wedge	8/10	210	620824 ●
Clamping wedge	8/10	240	620825 ●
Clamping wedge	8/10	270	620826 ●
Clamping wedge	8/10	310	620827 ●
Allen screw			007396 ●
Filler piece		40	005305 ●
Filler piece		60	005306 ●
Filler piece		80	005307 ●
Filler piece		100	005308 ●
Filler piece		130	005310 ●
Filler piece		150	005311 ●
Filler piece		170	620770 ●
Filler piece		190	620772 ●
Filler piece		210	620773 ●
Filler piece		240	620771 ●
Filler piece		270	620774 ●
Filler piece		310	620775 ●
Dust protection cover			008244 ●
Allen key			117509 ●

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