

CUTTERS AND CUTTER COMBINATIONS

According to Application Made in:

H.S.S.T (High Speed Steel Tipped)
For softwood & hardwood without glue lines.

STELLITE (Stellite Tipped)
For softwood & hardwood without glue lines.

T.C.T (Tungsten Carbide-Tipped)
For hardwood, plywood, chipboard, MDF and other panel materials.

Our cutters are designed to conform with safety regulations, and are dynamically balanced.

To determine min. diameter on profiled cutters the calculation is: bore ("B") + 60mm (2-3/8") + (2 x profile depth) ("P"). As per table below.

"B"	"P"							
	5	10	15	20	25	30	35	40
30	100	110	120	130	140	150	160	170
35	105	115	125	135	145	155	165	175
40	110	120	130	140	150	160	170	180
50	120	130	140	150	160	170	180	190
60	130	140	150	160	170	180	190	200

"B"= Bore Diameter "P"= Profile Depth

"B"	"P"				
	3/8"	3/4"	1"	1-1/4"	1-1/2"
3/4"	3-7/8"	4-5/8"	5-1/8"	5-5/8"	6-1/8"
1-1/4"	4-3/8"	5-1/8"	5-5/8"	6-1/8"	6-5/8"
1-13/16"	4-14/16"	5-7/16"	5-11/16"	5-15/16"	6-3/16"
2"	5-1/8"	6-1/8"	6-5/8"	7-1/8"	7-5/8"

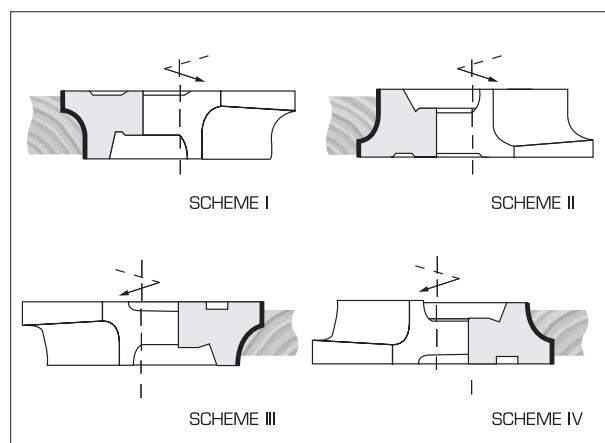
"B"= Bore Diameter "P"= Profile Depth

Order Details

- (1) Type of cutter as numbered.
For softwood & hardwood without glue lines.
- (2) Main dimensions in the following order:
(diameter) x (cutting width) x (bore) x (number of teeth)
- (3) Cutting materials H.S.S.T, STELLITE or T.C.T.
- (4) R.P.M. of machine and rate of feed.
Material to be cut, if possible supply sample.
- (5) Type of cut: against feed direction or with feed direction.

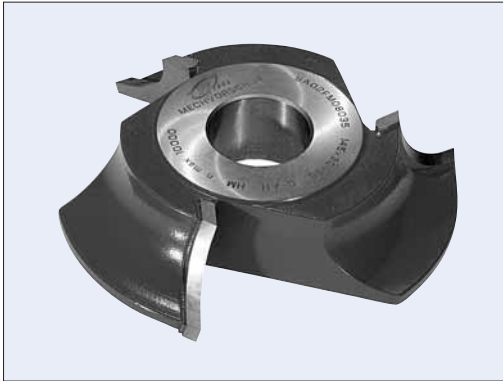
When Ordering Cutters with Profiles

Sketches fully dimensioned, DXF files or samples of profiles should be supplied. Details of side to table, fence side, and direction of feed should be given.



Direction of Rotation:
Scheme I - II = Counter Clock Wise (CCW)
Scheme III - IV = Clock Wise (CW)

PA PROFILE CUTTERS - SIMPLE PROFILES

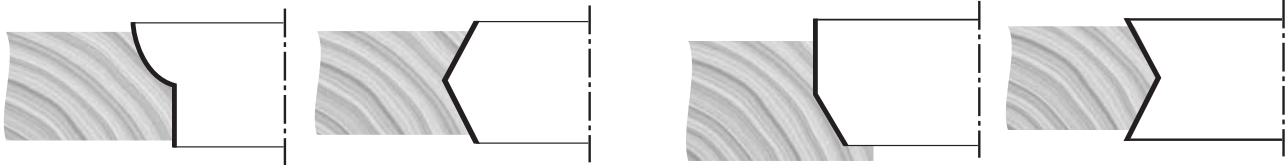


DESIGN:

- With 2-3-4-6 cutting teeth, straight or with shear angle according to profile

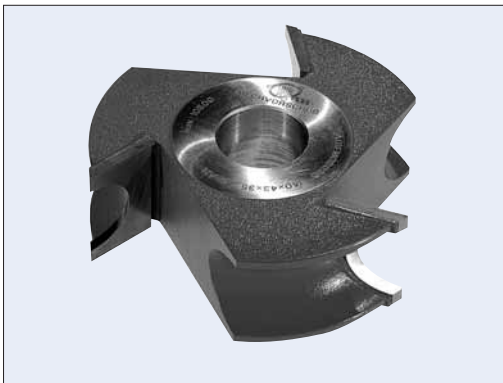
WHEN ORDERING SPECIFY:

- Type of wood or material to be cut
- Rotation
- Details of profile to table, fence side
- R.P.M. of machine
- Rate of feed
- Exact sketch of profile
- Possibly a wood sample or a DXF file
- Bore diameter
- Diameter of cutter



Example of Simple Profile - PA

PB PROFILE CUTTERS - COMPLEX PROFILES

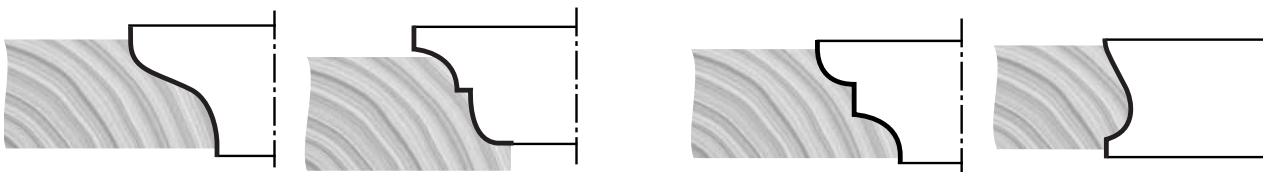


DESIGN:

- With 2-3-4-6 cutting teeth, straight or with shear angle according to profile

WHEN ORDERING SPECIFY:

- Type of wood or material to be cut
- Rotation
- Details of profile to table, fence side
- R.P.M. of machine
- Rate of feed
- Exact sketch of profile
- Possibly a wood sample or a DXF file
- Bore diameter
- Diameter of cutter



Example of Complex Profile - PB

PC PROFILE CUTTERS - VERY COMPLEX PROFILES



DESIGN:

- With 2-3-4-6 cutting teeth, straight or with shear angle according to profile

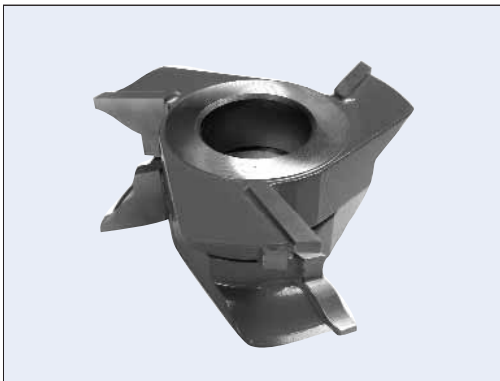
WHEN ORDERING SPECIFY:

- Type of wood or material to be cut
- Rotation
- Details of profile to table, fence side
- R.P.M. of machine
- Rate of feed
- Exact sketch of profile
- Possibly a wood sample or a DXF file
- Bore diameter
- Diameter of cutter



Example of Very Complex Profiles - PC

PI PROFILE CUTTERS - COMBINED PROFILES

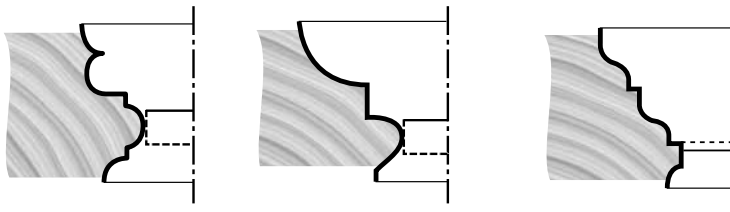


DESIGN:

- With 2-3-4 teeth interlocked. For staggered cut and spur action with shearing cut

WHEN ORDERING SPECIFY:

- Type of wood or material to be cut
- Rotation
- Details of profile to table, fence side
- R.P.M. of machine
- Rate of feed
- Exact sketch of profile
- Possibly a wood sample or a DXF file
- Bore diameter
- Diameter of cutter



Example of Combined Profiles - PI

**DESIGN:**

- Straight teeth, bevelled teeth, 4 or 6 teeth cutters
- Tungsten carbide cutting edges

APPLICATION:

- On edgeworking machines
- For flush trimming, chamfering and profiling of wood-veneer and plastic edge bands

FOR MACHINES:

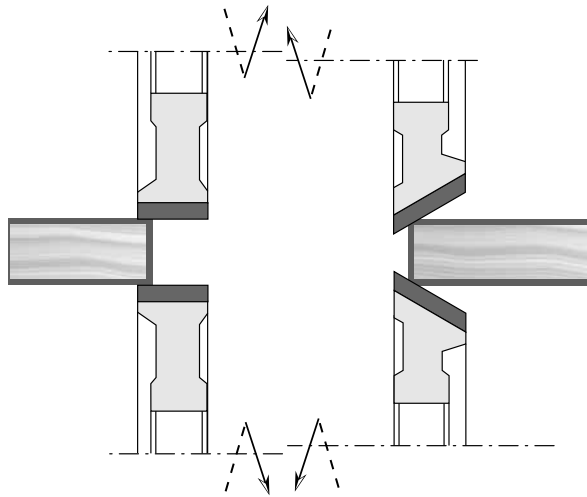
- Brandt, Egurco, Franke, Homag, Homburg, IDM, IMA, IMEF, Manea, Ocmac, Olympic, Raiman, Salgo, Stefani.

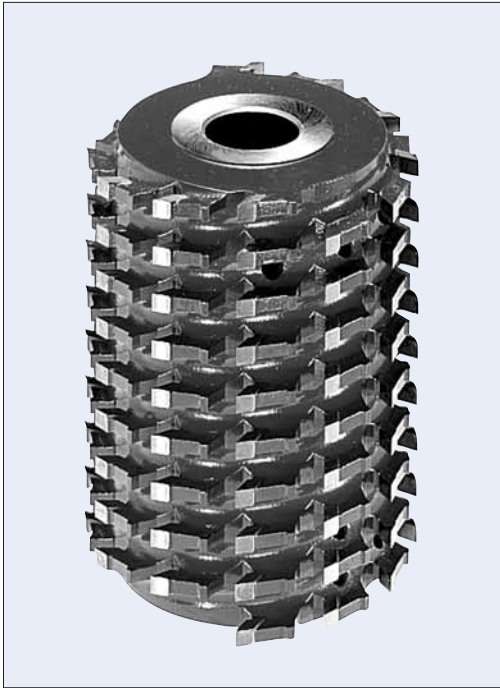
WHEN ORDERING SPECIFY:

- For which machine, and if bevelled, cutting edge degrees required.

SPECIAL PRODUCTION

UNIT OF MEASURE	DIAMETER	KERF	NO. TEETH
INCH	2-3/4" to 4"	5/8" to 1-3/8"	4 or 6
MM	70 to 100	15 to 35	4 or 6



**DESIGN:**

- High tensile steel body with 8 or 12 rows of carbide teeth. Straight - staggered on a spiral progression
- Tungsten carbide cutting edges

APPLICATION:

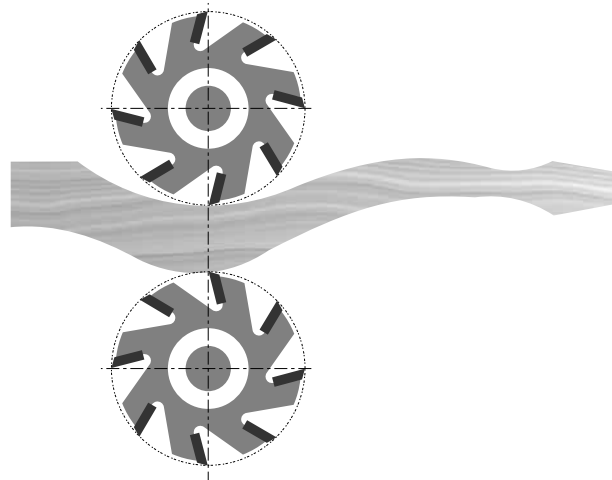
- Ideal for "easy chip flow" with fast feeding on solid wood and composite materials. Mainly used for roughing-out furniture components
- On shapers and copying machines

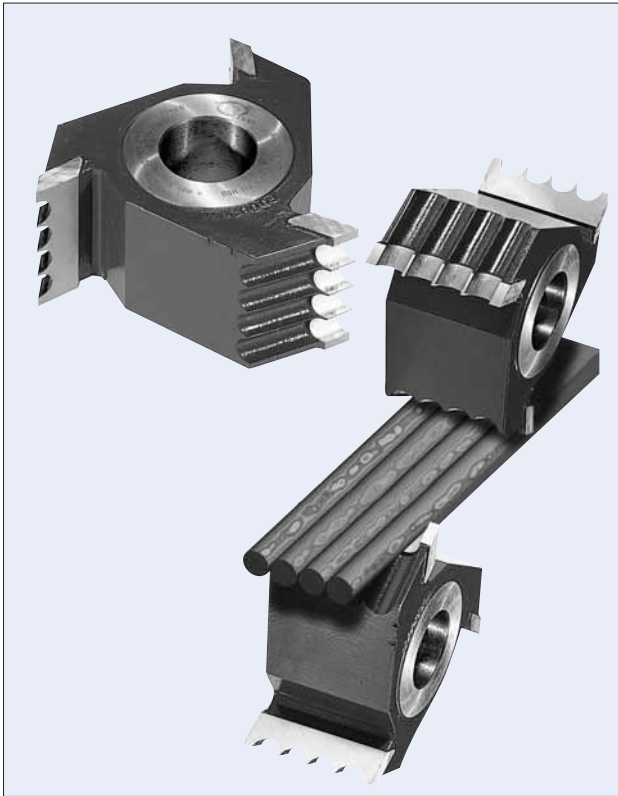
WHEN ORDERING SPECIFY:

- Cutter diameter
- Bore diameter
- Number of teeth
- Type of wood to cut
- Usable length of spindle

SPECIAL PRODUCTION

UNIT OF MEASURE	DIAMETER				KERF	NO. TEETH
	3-1/8"	4"	4-3/4"	5-1/2"		
INCH	3-1/8"	4"	4-3/4"	5-1/2"	2-3/8" to 9"	8 or 12
MM	80	100	120	140	60 to 230	8 or 12

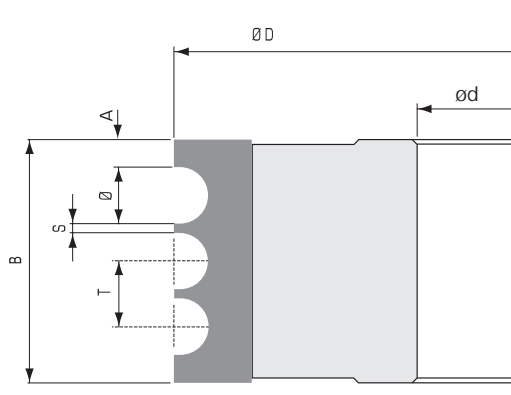


**DESIGN:**

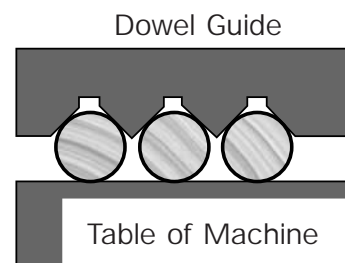
- 2 or 3 teeth, straight cut. Cutters work in pairs to produce single or multiple dowels
- H.S.S. Tipped cutting edges

APPLICATION:

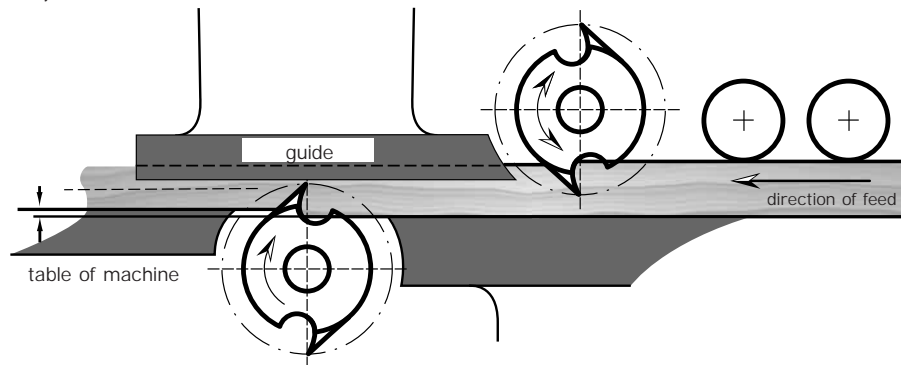
- To produce single or multiple dowels
- On moulders
- All dowels produced must be guided at three points all the way (ILL.2). Guide must take hold of dowels immediately after leaving cutting edge area. (ILL.3)



(ILL.2)



(ILL. 3)



DIMENSIONS															
Diam. of dowel Ø mm	3	4	5	6	7	8	9	10	11	12	13	14	15	16	
Splitting point S mm	1	1	1	1	1	1	1	1	1.5	1.5	1.5	1.5	1.5	1.5	
Pitch T mm	4	5	6	7	8	9	10	11	12.5	13.5	14.5	15.5	16.5	17.5	
Square end A mm	4	4	4	4	4	4	4	5	5	5	5	5	5	5	
Diam. ØD mm	120	120	120	120	120	120	120	120	120	120	120	120	120	140	
Kerf B mm	1	11	12	13	14	15	16	17	20	21	22	23	25	26	
No. of dowels	2	15	17	19	21	23	25	27	31	33.5	35.5	37.5	39.5	41.5	43.5
	3	19	22	25	28	31	34	37	42	46	49	52	55	58	61
	4	23	27	31	35	39	43	47	53	58.5	62.5	66.5	70.5	74.5	78.5
	5	27	32	37	42	47	52	57	64	71	76	81	86	91	96
	6	31	37	43	49	55	61	67	75	83.5	89.5	95.5	101.5	107.5	113.5
	7	35	42	49	56	63	70	77	86	96	103	110	117	124	131
	8	39	47	55	63	71	79	87	97	108.5	116.5	124.5	132.5	140.5	148.5
	9	43	52	61	70	79	88	97	108	121	130	139	148		
	10	47	57	67	77	87	97	107	119	133.5	143.5				
	11	51	62	73	84	95	106	117	130	146					
Diam. of dowel Ø mm	17	18	19	20	21	22	23	24	25	26	27	28	29	30	
Splitting point S mm	1.5	1.5	1.5	2	2	2	2	2	2	2	2	2	2	2	
Pitch T mm	18.5	19.5	20.5	22	23	24	25	26	27	28	29	30	31	32	
Square end A mm	5	5	5	5	7	7	7	7	7	7	7	7	7	7	
Diam. ØD mm	140	140	140	140	140	140	140	140	160	160	160	160	160	160	
Kerf B mm	1	27	28	29	30	35	36	37	38	39	40	41	42	43	44
No. of dowels	2	45.5	47.5	49.5	52	58	60	62	64	66	68	70	72	74	76
	3	64	67	70	74	81	84	87	90	93	96	99	102	105	108
	4	82.5	86.5	90.5	96	104	108	112	116	120	124	128	132	136	140
	5	101	106	111	118	127	132	137	142	147					
	6	119.5	125.5	131.5	140										

The minimum diameter indicated allows for centre bore of 40mm max.
Other sizes available upon request.