

NEW



Router cutter Diamaster PLUS³ EdgeExpert, Z3+3

Application:

Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides of boards with sensitive laminations, foils and veneers. Suitable for medium and large batch quantities. Z 3+3 for high feed speeds.

Machine:

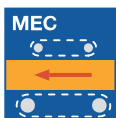
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

Workpiece material:

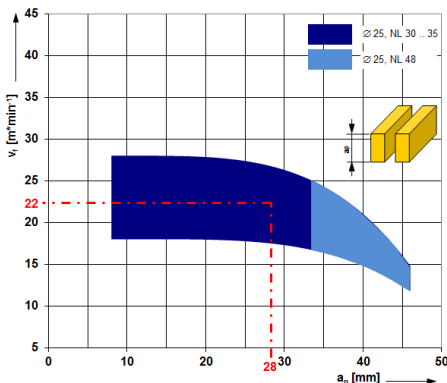
Chipboard and fibre materials (MDF, HF etc.), uncoated, plastic coated, veneered etc.

Technical information:

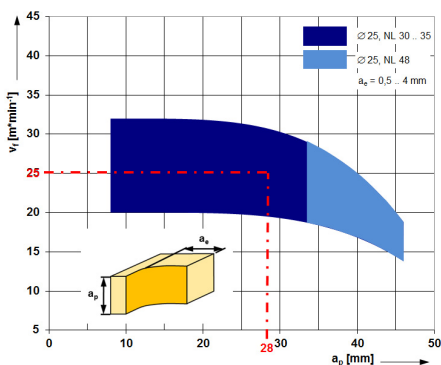
Spiral cutting edge arrangement with alternate shear angles and real-Z3 over the complete cutting length. DP plunging tip. Increased shear angle for tear free cut edges on both sides of boards with sensitive laminations, foils and veneers. Resharpenable 5 to 8 times with normal wear. Pre-cutting is recommended. Perfect for use on CNC machining centers with laser edgending unit. Cuts to be painted in MDF require finishing with tools with continuous edges.



Feed speed v_f on grooving depth a_p



Workpiece material: Plastic coated chipboard
Working step: Sizing
Spindle speed: $n = 24000$ rpm
Correction factor for v_f : MDF = 0,8
 Veneer across grain = 0,7
 Extremely sensitive laminations = 0,7 - 0,8



Workpiece material: Plastic coated chipboard
Working step: Sizing
Spindle speed: $n = 24000$ rpm
Correction factor for v_f : MDF = 0,8
 Veneer across grain = 0,7
 Extremely sensitive laminations = 0,7 - 0,8

DP, Z 3+3, symmetric edge arrangement
 WO 140-2

D mm	GL mm	NL mm	S mm	DRI	ID
25	105	30	25x60	RL	191073
25	105	35	25x55	RL	191074
25	125	48	25x60	RL	191075

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