

5. Routing

5.1 Sizing and grooving

5.1.1 Shank cutters

NEW



Router cutter Diamaster QUATTRO EdgeExpert

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 2+2 for increased feed speeds.

Machine:

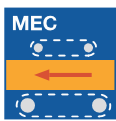
Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

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 DP plunging tip. Increased shear angle for tear free cut edges on both sides of boards with sensitive laminations, foils and veneers. Resharpenable 4 to 6 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges.



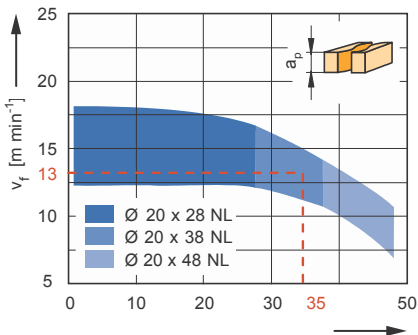
DP, Z 2+2

WO 140-2

D mm	GL mm	NL mm	S mm	DRI	ID
20	95	32	20x50	RL	191071
20	120	48	25x60	RL	191072

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

Feed speed v_f depending on grooving depth a_p



Workpiece material: Plastic coated chipboard

Working step: Sizing

Spindle Speed: $n = 18000 \text{ rpm}$

Correction factor for v_f : MDF = 0,8

Veneer across grain = 0,7

Extremely sensitive laminations = 0,7 - 0,8