

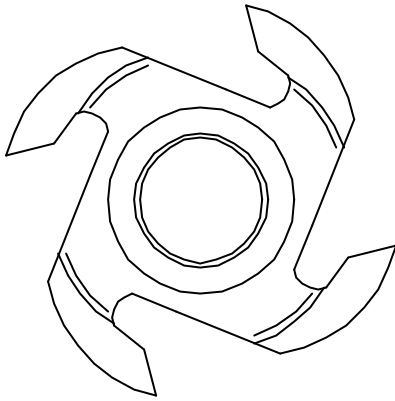
Cutter Blocks



SOLID & TIPPED CUTTERBLOCKS

TECHNISCHE INFORMATIONEN
 DATOS TECNICOS
 INFORMAZIONE TECNICHE
 INFORMATION TECHNIQUES

05-001



Cutterblocks

Cutterblocks are either solid or tipped tools. Tips are usually HSS, Stellite, TC or DIA (Polycrystalline Diamond). Cutterheads are plain or surface treated, using knives clamped into the body with wedge and power clamping methods.

Cutting edges are made from a variety of materials depending on tool, material and application.

SP	Special alloy steel
HLS	High alloy steel
HSS	High speed steel
Stellite	Cobalt based alloy
TC	Tungsten Carbide
DIA	Polycrystalline Diamond

Diamond tipped tooling is designed to cut materials which offer high abrasion. A thin layer of Diamond crystals are bonded to a Tungsten Carbide carrier under extreme pressure and temperature. Its resistance to wear makes it highly suitable and efficient for machining various materials. Diamond tools lower production costs and reduce downtime.

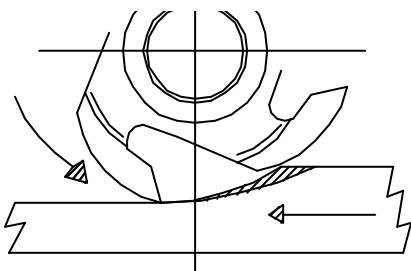
DIA Cutting range

Particle boards, M.D.F., hardboards and chipboards (with or without veneers or plastic laminates).

Solid timbers including hardwood and exotic hardwoods, especially when profiling or grooving on CNC machines.

Glass Reinforced Plastics (GRP) and similar composites.

Against feed (Power Cutting)



Cutting Methods

Against feed (Power cutting)

This is the most commonly used cutting method. Teeth cut against the direction of feed producing a long wedge chip. These methods give extended life and tool performance and are most effective when cutting a good quality grain.

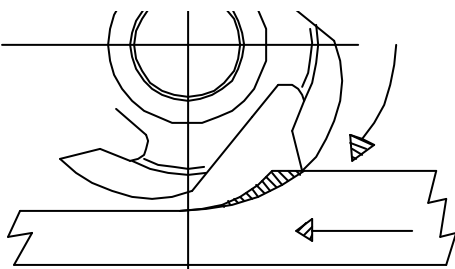
Only cut against feed when hand feeding.

With feed

Teeth cut with the direction of feed immediately producing short chips on contact. This method allows high feed speed for less power and fine finishes can be achieved even on twisted grains.

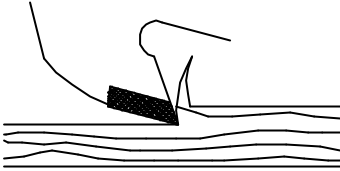
Tooth life is reduced as the tooth rubs the timber following the cut. Automatic feed only.

With feed – Automatic feed only



CUTTING ANGLES

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Along the grain**Cutting angles.****Along the grain**

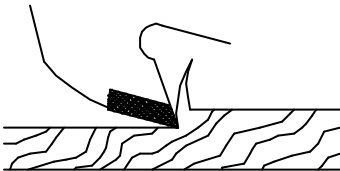
Teeth cutting along the grain cut easily producing a clean surface.

With the grain

Teeth cutting along the grain cut easily producing a clean surface.

Against the grain

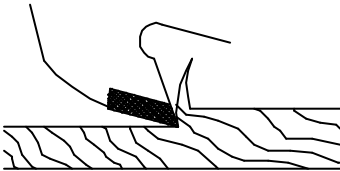
Teeth cutting against the grain experience difficulty as surface fibres lift.

With the grain**Cross cutting**

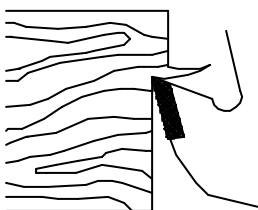
Cross cutting teeth cut easily producing a rough surface.

End cutting

Teeth at normals to the direction of the grain, difficult to cut producing a rough surface.

Against the grain**Cut quality**

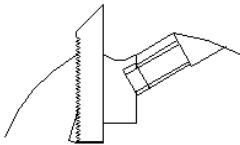
Cut quality can be improved by bevelling teeth to produce a shear cutting action. Grain distortion is reduced by increasing cutting speed. Cutting speed should not be increased without a relative increase in feed speed. An increase in cutting speed without a change in feed speed results in a shaving cut reducing cutter life and efficiency as well as increasing downtime.

Cross cutting**End cutting**

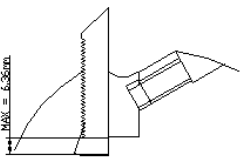
2 & 4 WING CUTTERHEAD



50mm Bore for use with Hydrolock sleeves. Coned ends for use with Wadkin machines available on request.



Knife position



Max. projection after re grinding.

Z – No. of Wings.

D	W	B	Z	Ref.
122	25	40	4	SH12225
122	40	40	4	SH12240
122	60	40	4	SH12260
122	80	40	4	SH12280
122	100	40	4	SH122100
122	130	40	4	SH122130
122	150	40	4	SH122150
122	180	40	4	SH122180
122	230	40	4	SH122230
122	25	40	2	SH12225/2
122	40	40	2	SH12240/2
122	60	40	2	SH12260/2
122	80	40	2	SH12280/2
122	100	40	2	SH122100/2
137	60	40	4	SH13760
137	80	40	4	SH13780
137	100	40	4	SH137100
137	130	40	4	SH137130
137	180	40	4	SH137180
137	230	40	4	SH137230

Technical

Safety cutter for 2 or 4 HSS, Stellite tipped or TCT serrated back knives.
TCT - 10mm thick.
Max. projection after regrind – 4 serrations.

Application

Profiling solid wood on mechanical feed machines at high rpm.
Best surface quality at fast feed rates.



2 & 4 WING CUTTERHEAD



50mm Bore for use with Hydrolock sleeves. Coned ends for use with Wadkin machines available on request.

Technical

Safety cutter for 2, 4, 6, 8, 10 or 12 HSS, Stellite tipped or TCT serrated back knives. Knives – 8 / 10mm thick. Max. projection after regrind – 4 serrations.

Application

Profiling solid wood on mechanical feed machines at high rpm. Best surface quality at fast feed rates.

Z – No. of Wings.

D	W	B	Z	Ref.
137	60	40	4	HH176342
137	100	40	4	HH176343
137	130	40	4	HH176344
137	150	40	4	HH1763465
137	180	40	4	HH176346
137	230	40	4	HH176347
150	60	50	4	HH176348
150	60	50	6	HH176349
150	100	50	4	HH176350
150	100	50	6	HH176351
150	130	50	4	HH176352
150	130	50	6	HH176353
150	150	50	4	HH176354
150	150	50	6	HH176355
150	180	50	4	HH176356
150	180	50	6	HH176357
150	230	50	4	HH176358
150	230	50	6	HH176359
163	60	50	8	HH176364
163	100	50	8	HH176365
163	130	50	8	HH176366
163	150	50	8	HH176367
163	180	50	8	HH176368
163	230	50	8	HH176369
195	60	50	10	HH176372
195	100	50	10	HH176373
195	130	50	10	HH176374
195	150	50	10	HH176375
195	180	50	10	HH176376
195	230	50	10	HH176377
215	60	50	12	HH176380
215	100	50	12	HH176381
215	130	50	12	HH176382
215	150	50	12	HH176383
215	180	50	12	HH176384
215	230	50	12	HH176385



2 & 4 WING CUTTERHEAD

Z – No. of Wings.

D	W	B	Z	Ref.
125	30	30	2/4	RH1253030
125	40	30	2/4	RH1254030
125	50	30	2/4	RH1255030
125	60	30	2/4	RH1256030
125	80	30	2/4	RH1258030
125	100	30	2/4	RH12510030
125	120	30	2/4	RH12512030
125	30	1 1/4	2/4	RH1253011/4
125	40	1 1/4	2/4	RH1254011/4
125	50	1 1/4	2/4	RH1255011/4
125	60	1 1/4	2/4	RH1256011/4
125	80	1 1/4	2/4	RH1258011/4
125	100	1 1/4	2/4	RH12510011/4
125	120	1 1/4	2/4	RH12512011/4

Technical

Rebating cutterhead with 2 or 4 knives and 2 top, 2 bottom spurs.

Reversible, disposable knives and spurs easily changed and give constant cutting circle.

Manual or mechanical feed.

Application

Rebating and jointing of hard or soft woods, panel materials with or without veneers or plastic laminates.

Special rebate heads with extra cutting teeth or spurs available on request.

Bore sizes can be machined to fit most machines.



2 & 4 WING CUTTERBLOCK



Other bore sizes available on request.

Z – No. of Wings.

D	W	B	Z	Ref.
125	60	40	4	PL12560
125	80	40	4	PL12580
125	100	40	4	PL125100
125	130	40	4	PL125130
125	150	40	4	PL125150
125	180	40	4	PL125180
125	230	40	4	PL125230
125	60	40	2	PL12560/2
125	80	40	2	PL12580/2
125	100	40	2	PL125100/2
140	60	40	4	PL14060
140	80	40	4	PL14080
140	100	40	4	PL140100
140	130	40	4	PL140130
140	180	40	4	PL140180
140	230	40	4	PL140230

Technical

Planer cutterhead for thin planer HSS, Stellite tipped or TCT. (30mm x 3mm)

Knives rest on springs for ease of setup.

Mechanical feed.

Application

Surface planing and jointing on four sided moulding machines.



4 WING CUTTERHEAD

*Z – No. of Wings.*

D	W	B	Z	Ref.
125	20	30	4	JH1252030
125	20	40	4	JH1252040
125	20	50	4	JH1252050
125	30	30	4	JH1253030
125	30	40	4	JH1253040
125	30	50	4	JH1253050
125	50	30	4	JH1255030
125	50	40	4	JH1255040
125	50	50	4	JH1255050

Technical

Cutterheads for side-by-side joining together to make continuous planing heads from 30mm to 250mm long.

Each segment has 4 knives.

Heads are staggered and pinned to prevent movement during use.

Mechanical feed.

Application

Planing and jointing timber on four sided moulding machines.

Available in Imperial bore sizes.



4 & 6 WING CUTTERSET

Z – No. of Wings.

D	W	B	Z	Ref.
160	4/7.5	30	4	AG16007
160	8/15.5	30	4	AG16015
160	12/23.5	30	4	AG16023
160	15/29.5	30	4	AG16029
160	20/39.5	30	4	AG16039
160	8/15.5	30	6	AG16015/3
160	12/23.5	30	6	AG16023/3
160	15/29.5	30	6	AG16029/3
160	20/39.5	30	6	AG16039/3
180	8/15.5	30	4	AG18015
180	12/23.5	30	4	AG18023
180	15/29.5	30	4	AG18029
180	20/39.5	30	4	AG18039
180	30/59.5	30	4	AG18059
180	50/99.5	30	4	AG18099

Technical

2 part cutterset adjusted with spacers. Easy change disposable tips give constant cutting circle.

4 grooving tips - 2 per element.

4 spur cutters - 2 per element.

Manual and mechanical feed.

Application

Cutting of grooves in natural and man made materials.



2 & 4 WING CUTTERHEAD

Z – No. of Wings.

D	W	B	Z	Ref.
50	12	16	2	EB501216/2
50	15	16	2	EB501516/2
50	20	16	2	EB502016/2
50	12	16	4	EB501216/4
70	12	16	4	EB701216/4
70	20	16	4	EB702016/4
70	20	20	4	EB702020/4
80	40	20	4	EB804020/4

Technical

Edge banding head with 2, 4 or 6 wing dependant on size.

Tungsten Carbide knives.

Can be used left and right hand .

Mechanical feed.

Application

Flush trimming of edge bands for solid wood, veneer and plastics.

2, 3 & 4 WING RADIUS CUTTERHEAD



57	12	16	2	EBR571216
62	16	16	2	EBR621616
73	16	20	3	EBR731620
82	16	16	4	EBR821616
82	16	20	4	EBR821620
73	16	16	3	EBR731616
81	24	16	3	EBR812416

Technical

Edge banding head with 2, 3 or 4 wings dependant on size.

Tungsten Carbide knives.

Can be used left or right hand.

One main body for radius' 2mm - 5mm.

Mechanical feed.

Application

Profiling of edge bands for solid wood and board materials.

81mm Diameter cutter only available with 6, 7, 8 or 9mm radius'. All others available in 2, 3, 4, or 5mm also.



3 WING CUTTERHEAD



Z – No. of Wings.

D	W	B	Z	Ref.
150	40	30	3	MP1504030
150	40	35	3	MP1504035
150	40	40	3	MP1504040
150	40	50	3	MP1504050
180	50	35	3	MP1805035

Technical

3 Wing multi profiler head .
Tungsten Carbide Knives with steel backing plates.
Backing plates sold separately.
Mechanical feed.

Application

Profiling timber and wood composites on through-feed machines.

2 & 3 WING CUTTER



125	40	30	2	MP1254030
125	40	31.75	2	MP125403175
125	60	30	2	MP1256030
125	60	31.75	2	MP125603175
150	40	30	3	MP1504030
150	40	35	3	MP1504035
150	60	30	3	MP1506030
180	40	40	3	MP1804040
180	60	40	3	MP1806040

Technical

2 or 3 Wing multi profiler head dependant on size.
Tugsten Carbide knives with steel backing plate.
Backing plates sold separately.
Mechanical feed.

Application

Profiling timber and wood composites on through-feed machines.



3 WING CUTTERHEAD



Keyways optional – available on request.

125mm Diameter cutterhead - 15°
All other cutterheads - 30°

Z – No. of Wings.

D	W	B	Z	Ref.
125	40	30	3	MP1254030
180	40	35	3	MP1804035
180	40	40	3	MP1804040
180	40	50	3	MP1804050
125	40	30	3	MP1254030/L
180	40	35	3	MP1804035/L
180	40	40	3	MP1804040/L
180	40	50	3	MP1804050/L

Technical

3 Wing multi profiler head.
Tungsten Carbide knives with steel backing plates.
Backing plates sold separately.
Mechanical feed.

Application

Profiling timber and wood composites on through-feed machines.



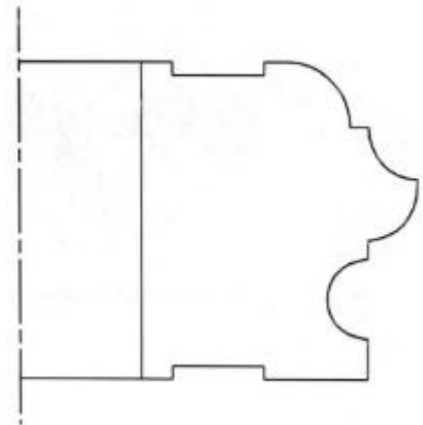
2 WING CUTTERHEAD



Keyways optional – available on request.

Z – No. of Wings.

D	W	B	Z	Ref.
140	50	30	2	SH4050302



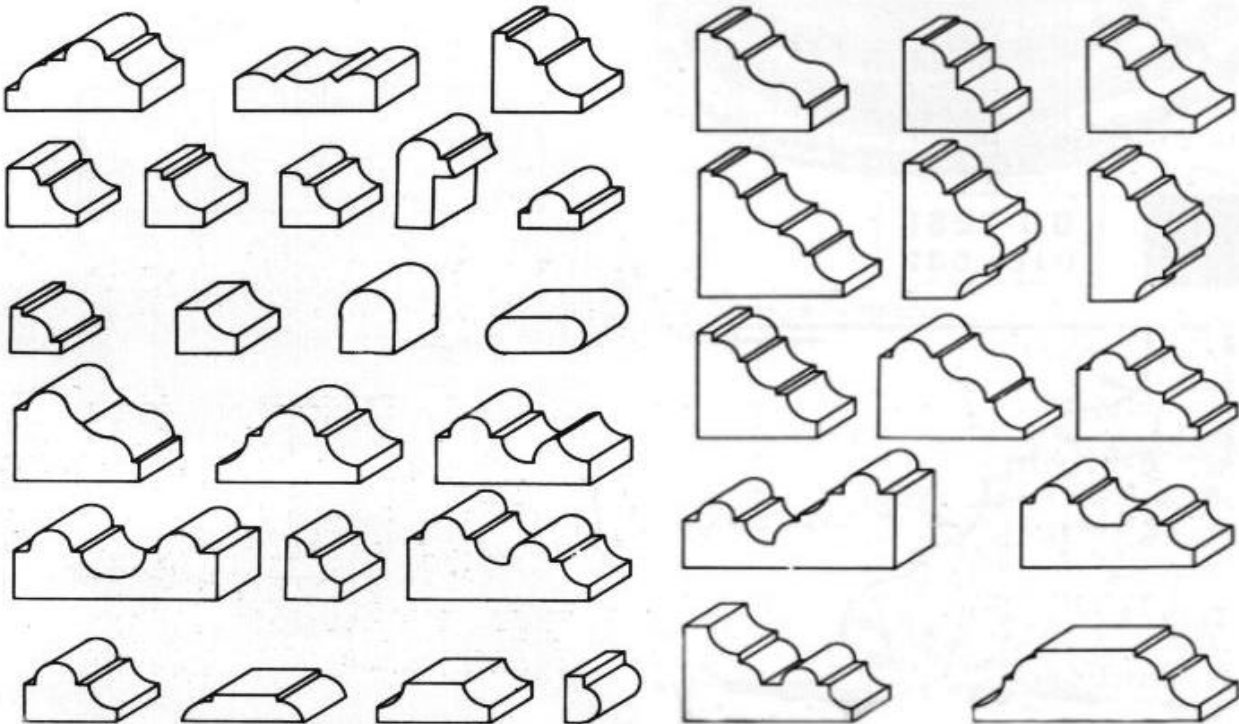
Technical

2 Wing multi profiler head.
Tungsten Carbide knives.

Mechanical feed.

Application

Profiling timber and wood composites on spindle moulders.



2 WING CUTTERHEAD

Z – No. of Wings.

D	W	B	Z	Ref.
120	40	30	2+2	HH1204030S

Technical

2 Wing universal cutter head.
 Uses standard profile knives and limiters sold separately
 Accepts 4mm or 5mm thick knives and limiters.
 Manual feed.

Application

Profiling timber and wood composites on spindle moulders.



EXAMPLE-PROFILES

Pro-01



Pro-02



Pro-03



Pro-04



Pro-05



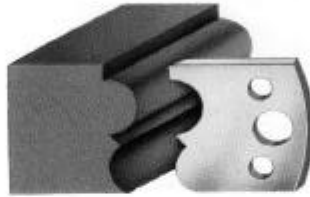
Pro-06



Pro-07



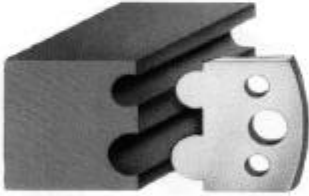
Pro-08



Pro-09



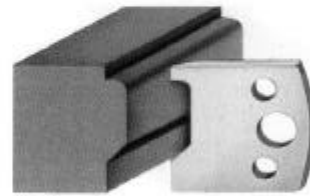
Pro-10



Pro-11



Pro-12



Pro-13



Pro-14



Pro-15



Pro-16



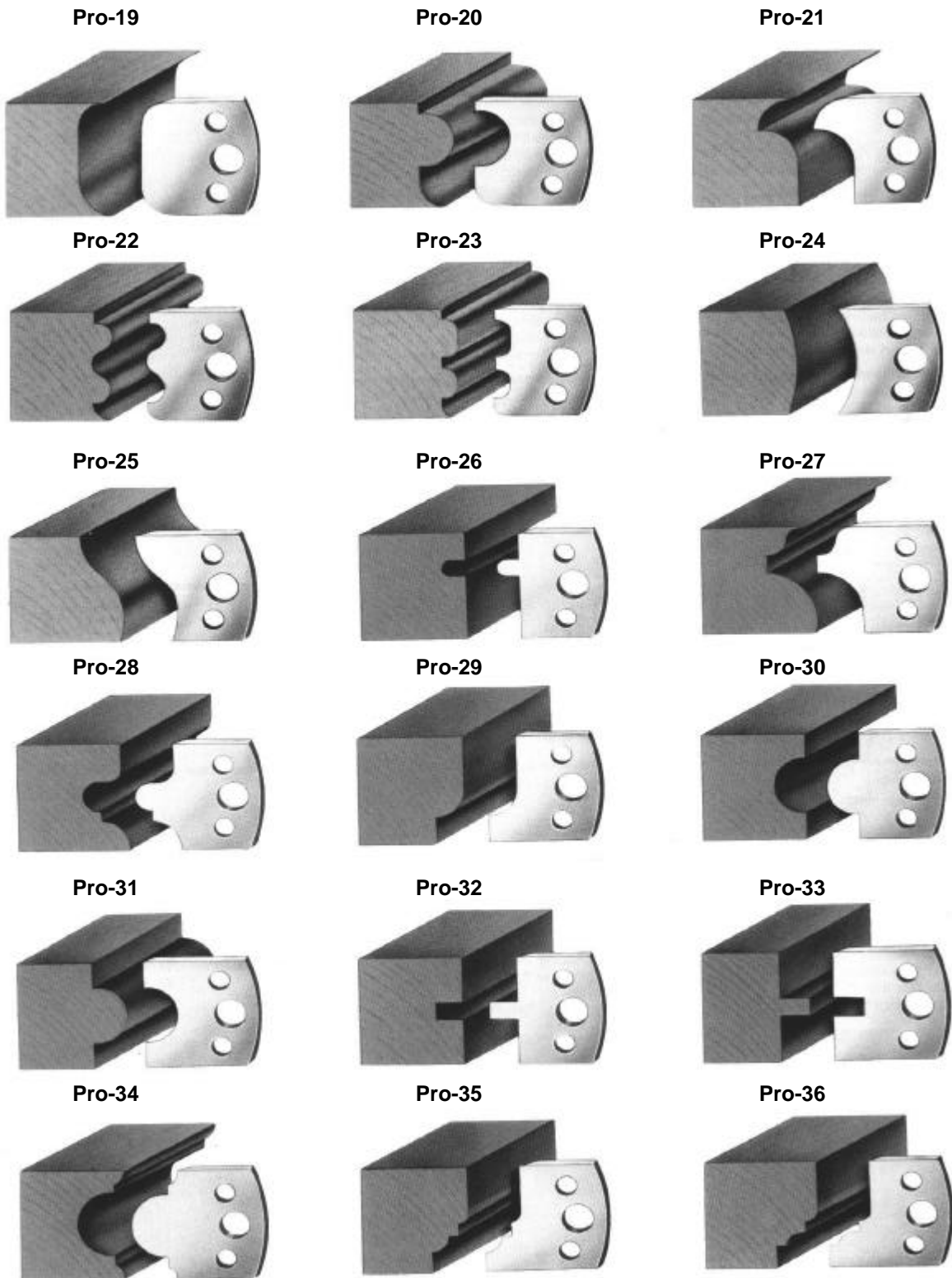
Pro-17



Pro-18



EXAMPLE-PROFILES



EXAMPLE-PROFILES

Pro-37



Pro-38



Pro-39



Pro-40



Pro-41



Pro-42



Pro-43



Pro-44



Pro-45



Pro-46



Pro-47



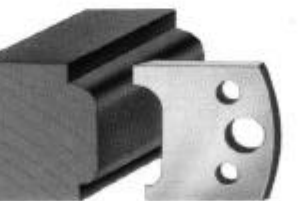
Pro-48



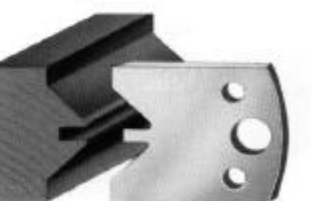
Pro-49



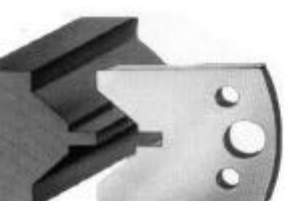
Pro-50



Pro-51



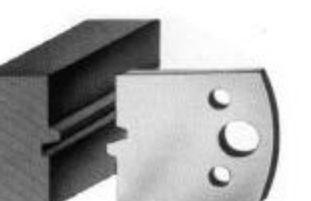
Pro-52



Pro-53



Pro-54



EXAMPLE-PROFILES

Pro-55



Pro-56



Pro-57



Pro-58



Pro-59



Pro-60



Pro-61



Pro-62



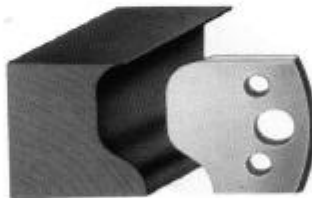
Pro-63



Pro-64



Pro-65



Pro-66



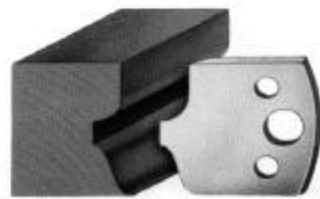
Pro-67



Pro-68



Pro-69



Pro-70



Pro-71



Pro-72



SPECIAL-TOOLS*Tooling for Doors, Windows and special mouldings*

05- 018

Where possible **CARBIDE (UK) LTD.** offers a solution for all types of Woodworking Production.

Our program covers special tooling to suit most production techniques.

Brazed type cutter blocks and routers.

Turnover type cutter blocks and routers.

Grindable type HSS / Carbide cutter blocks and routers.

Polycrystalline Diamond cutter blocks and routers.

Solid Carbide router cutters and drills.

CARBIDE (UK) LTD.**Special** tool Inquiry Form**Tool** Type

Company

Dimensions

Street

Diameter

City

Cutting Width

Phone/Fax

Bore

Contact Name

No. of teeth

Signature

Direction of Rotation

Sketch

Copy this page and fax for a prompt reply

