

Router cutter Diamaster PRO Z=1



Number of teeth: Z 1+1
 RPM: n 18000 - 36000 min⁻¹

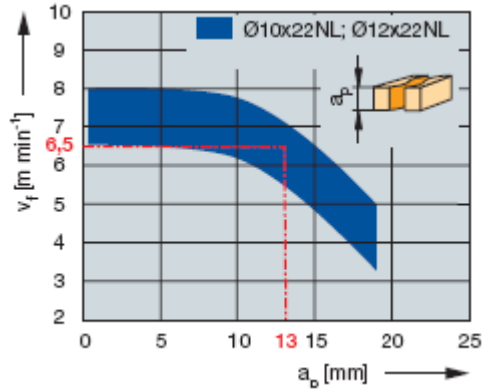


Diagram to determine feed speed v_f depending on grooving depth a_p , D 8 - 12 mm

Router cutter Diamaster PRO

Workpiece material:
 Chipboard plastic coated
 Operation: Sizing
 RPM: n 18000 min⁻¹
 Correction factor v_f : MDF = 0,8;
 Chipboard = 1,1;
 Veneer across grain = 0,7

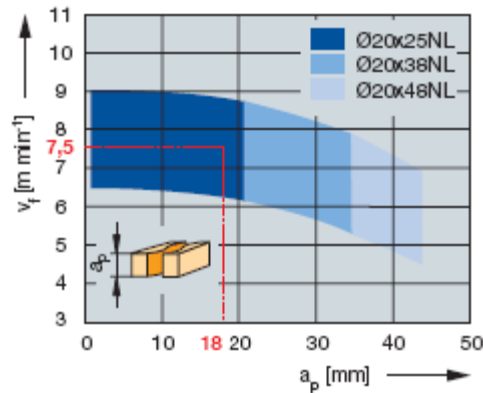


Diagram to determine feed speed v_f depending on grooving depth a_p , D 20 mm

Router cutter Diamaster PRO

Workpiece material:
 Chipboard plastic coated
 Operation: Sizing
 RPM: n 18000 min⁻¹
 Correction factor v_f : MDF = 0,8;
 Chipboard = 1,1;
 Veneer across grain = 0,7

Z 1+1

WO 140-2-50 *

| Class | D mm | GL mm | NL mm | S mm | ID Nr. LL | ID Nr. RL |
|-------|---------|----------|----------|---------|--------------|--------------|
| * | 10 | 70 | 22 | 12x40 | | 091264 |
| * | 12 | 70 | 22 | 12x45 | | 091265 |
| * | 12 | 100 | 28 | 25x60 | | 091266 |
| * | 14 | 90 | 28 | 16x50 | | 091267 |

| | | | | | | | |
|---|----|-----|----|-------|--------|---------|---|
| * | 16 | 80 | 22 | 16x50 | | 091268 | • |
| * | 16 | 95 | 22 | 25x60 | | 091269 | • |
| * | 16 | 90 | 28 | 16x50 | 091271 | •091270 | • |
| * | 16 | 100 | 28 | 16x50 | | 091272 | • |
| * | 16 | 95 | 35 | 20x50 | | 091273 | • |
| * | 16 | 105 | 35 | 25x60 | | 091274 | • |
| * | 16 | 115 | 43 | 25x60 | 091276 | •091275 | • |
| * | 18 | 90 | 28 | 20x50 | | 091277 | • |
| * | 18 | 95 | 35 | 20x50 | | 091278 | • |
| * | 18 | 105 | 35 | 25x60 | | 091279 | • |
| * | 18 | 105 | 43 | 20x50 | 091281 | •091280 | • |
| * | 18 | 115 | 43 | 25x60 | | 091282 | • |
| * | 20 | 90 | 28 | 16x50 | | 091283 | • |
| * | 20 | 100 | 28 | 25x60 | 091285 | •091284 | • |
| * | 20 | 95 | 35 | 20x50 | | 091286 | • |
| * | 20 | 105 | 35 | 25x60 | | 091287 | • |
| * | 20 | 105 | 43 | 20x50 | 091289 | •091288 | • |
| * | 20 | 115 | 43 | 25x60 | | 091290 | • |
| * | 20 | 110 | 48 | 20x50 | 091292 | •091291 | • |
| * | 20 | 120 | 48 | 25x60 | 091294 | •091293 | • |
| * | 20 | 125 | 53 | 25x60 | | 091295 | • |

Z 1+1

WO 140-2-50 *

| Class. | D mm | D Inch | GL mm | GL Inch | NL mm | NL Inch | S mm | S Inch | ID Nr. RL |
|--------|---------|-----------|----------|------------|----------|------------|----------|--------------|--------------|
| * | 12,7 | 1/2" | 70 | 2 3/4" | 22,23 | 7/8" | 12,7x38 | 1/2" x1 1/2" | 091296 |
| * | 19,05 | 3/4" | 110 | 4 3/8" | 48 | 1 7/8" | 19,05x50 | 3/4" x2" | 091297 |



Number of teeth: Z 2+2, Z 2+2/3+3

RPM:

D 22 mm: n 16000 - 30000 min⁻¹

D 25 mm - RL + LL-Router cutter:

n max. 24.000 min⁻¹

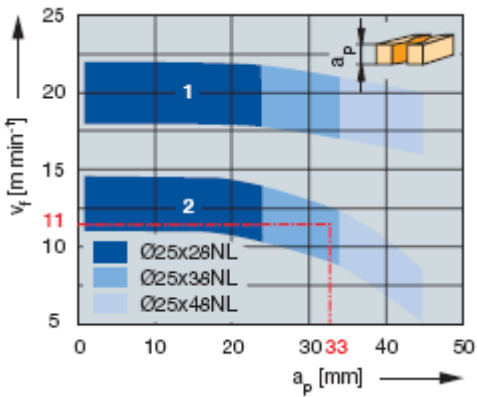


Diagram to determine feed speed v_f depending on grooving depth a_p

1 = Jointing

2 = Sizing

Router cutter PRO, Z 2+2

Workpiece material:

Chipboard plastic coated

Operation: Jointing, Sizing

RPM: n 18000 min⁻¹

Correction factor v_f ; MDF = 0,6;

Veneer, across grain = 0,7

Router cutter for sizing and pre-cutting, DP PRO-tipped, Z2+2, finishing, with HW-plunging tip, suitable for small and medium sized batches.

Z 2+2**WO 140-2-50 ***

| Class. | D mm | NL mm | S mm | ID Nr. RL |
|--------|---------|----------|---------|--------------|
| * | 22 | 28 | 20x50 | 091222 |
| * | 22 | 28 | 25x60 | 091224 |
| * | 22 | 38 | 20x50 | 091226 |
| * | 22 | 38 | 25x60 | 091228 |
| * | 22 | 48 | 20x50 | 091230 |
| * | 22 | 48 | 25x60 | 091232 |

Router cutter for sizing + pre-cutting, DP PRO-tipped, Z2+2, finishing, design with right hand and left hand rotation. Combination tool suitable for tear-free machining of coated wood, with right and left hand rotation, without the need for a tool change. To be mounted in Hydro- or ThermoGrip shrink fit chucks.

RL + LL - Combination tool**WO 140-2-50 ***

| Class. | D mm | GL mm | NL mm | S mm | DRI | ID Nr. RL |
|--------|---------|----------|----------|---------|---------|--------------|
| * | 25 | 145 | 35+35 | 25x55 | RL / LL | 191020 |

Router cutter Diamaster QUATTRO Z 2+2

Number of teeth: Z 2+2

RPM: n 16000 - 36000 min⁻¹

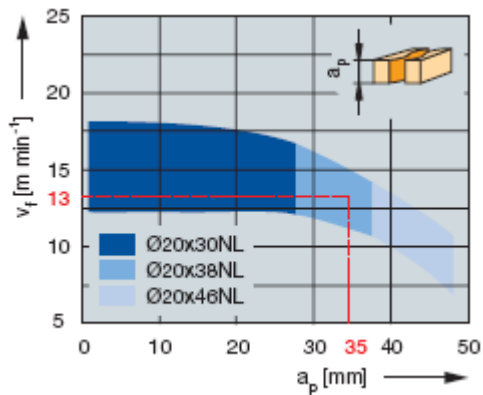


Diagram to determine feed speed v_f depending on grooving depth a_p , D 20 mm

Router cutter Diamaster QUATTRO,

Z 2+2

Workpiece material:

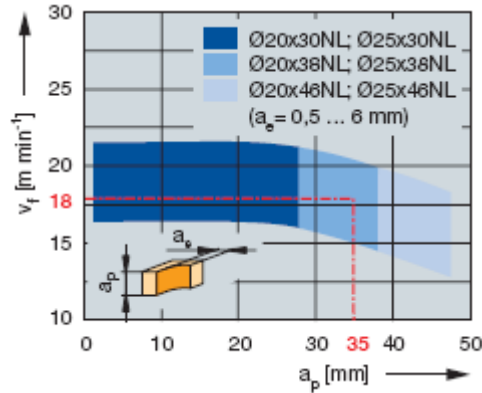
Chipboard plastic coated

Operation: Sizing

RPM: n 18000 min⁻¹

Correction factor v_f : MDF = 0,6;

Paper coated = 0,8



**Diagram to determine feed speed v_f depending on grooving depth a_p , D 20 mm
Router cutter Diamaster QUATTRO,
Z 2+2**

Workpiece material:
Chipboard plastic coated
Operation: Jointing
RPM: n 18000 min^{-1}
Correction factor v_f : MDF = 0,9;
Paper coated = 0,8;
Veneer across grain = 0,8

High performance router cutter for sizing + pre-cutting, DP PLUS-tipped, Z2+2, finishing, with HW plunging tip. Suitable for machining coated timber and composite material with
Higher performance than Z1+1 DP routing tools.

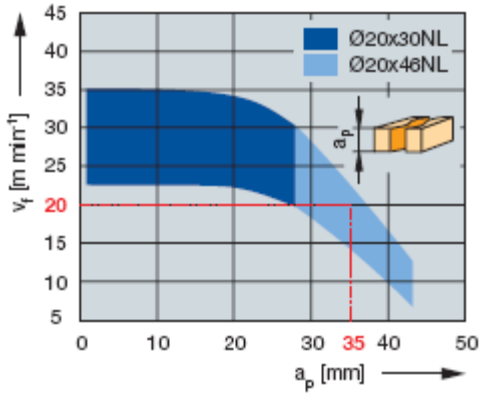
WO 140-2 *

| Class | D mm | GL mm | NL mm | S mm | ID Nr. LL | ID Nr. RL |
|-------|---------|----------|----------|---------|--------------|--------------|
| * | 20 | 90 | 28 | 20x50 | 091234 | 091235 |
| * | 20 | 100 | 28 | 25x60 | | 091237 |
| * | 20 | 100 | 38 | 20x50 | | 091239 |
| * | 20 | 110 | 38 | 25x60 | | 091241 |
| * | 20 | 110 | 48 | 20x50 | | 091238 |
| * | 20 | 120 | 48 | 25x60 | 091246 | 091247 |
| * | 25 | 100 | 28 | 25x60 | | 091249 |
| * | 25 | 110 | 38 | 25x50 | 091250 | 091251 |
| * | 25 | 110 | 48 | 20x50 | | 091245 |
| * | 25 | 120 | 48 | 25x60 | 091252 | 091253 |

Router cutter Diamaster PLUS Z 3+3

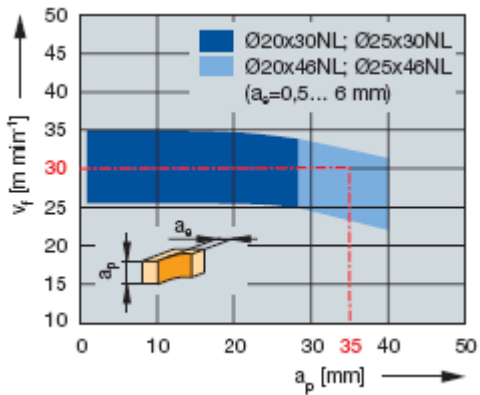


Number of teeth: Z 3+3
RPM: n 16000 - 37000 min^{-1}



Router cutter Diamaster PLUS, Z 3+3

Workpiece material:
 Chipboard plastic coated
 Operation: Sizing
 RPM: n 24000 min⁻¹
 Correction factor v_f:
 MDF = 0,8; Paper coated = 0,8



Router cutter Diamaster PLUS, Z 3+3

Workpiece material:
 Chipboard plastic coated
 Operation: Jointing
 RPM: n 24000 min⁻¹
 Correction factor v_f:
 MDF = 0,9;
 Paper coated = 0,8;
 Veneer across grain = 0,8

High performance router cutter for sizing + pre-cutting, DP PLUS-tipped, Z3+3, finishing, with DP-plunging tip. Suitable for machining coated timber and composite workpieces with a performance than Z1+1 and Z2+2 DP routing tools. Negative twist to support the clamping of small workpieces.

WO 140-2 *

With negative twist

| Class | D mm | GL mm | NL mm | S mm | ID Nr. LL | ID Nr. RL |
|-------|---------|----------|----------|---------|--------------|--------------|
| * | 18 | 100 | 24 | 25x60 | | 091204 |
| * | 20 | 90 | 24 | 20x50 | | 091207 |
| * | 20 | 100 | 24 | 25x60 | | 091209 |
| * | 20 | 105 | 30 | 25x60 | 091170 | 091171 |
| * | 20 | 110 | 38 | 25x60 | | 091211 |
| * | 20 | 110 | 46 | 20x50 | | 091172 |
| * | 20 | 120 | 46 | 25x60 | | 091174 |
| * | 25 | 100 | 24 | 25x60 | | 091213 |
| * | 25 | 95 | 30 | 20x50 | | 091175 |
| * | 25 | 105 | 30 | 25x60 | 091176 | 091177 |
| * | 25 | 110 | 38 | 25x60 | 091214 | 091215 |

| | | | | | | |
|---|----|-----|----|-------|--------|----------|
| * | 25 | 120 | 46 | 25x60 | 091179 | •091180• |
|---|----|-----|----|-------|--------|----------|

High performance router cutter for sizing + pre-cutting, DP PLUS-tipped, Z3+3, finishing, with DP-plunging tip. Suitable for machining coated timber and composite workpieces and offers a performance than Z1+1 and Z2+2 DP routing tools. Positive twist for optimum chip removal into the extraction. Firm clamping necessary for small workpieces.

WO 140-2 *

With positive twist

| Class. | D mm | GL mm | NL mm | S mm | ID Nr. LL | ID Nr. RL |
|--------|---------|----------|----------|---------|--------------|--------------|
| * | 16 | 100 | 24 | 20x60 | | 091254• |
| * | 25 | 110 | 38 | 25x60 | 091216 | •091217• |