

Surface²

Machining SURPAC

SALESTECH

AKE
Official Dealer

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CNC Routing

For high volumes diamond tools are necessary while for small batches solid carbide can be used. Feed speeds and edge life will be significantly lower. Running at "normal" parameters will break the tool.

	Cutting Material	Feed Speed / RPM	Part No.
12x25x83 z=3 Down Cut Roughing	Carbide	6-8m/min – 16,000RPM	SR0010
12x25x83 z=3 Down Cut Finishing	Carbide	6-8m/min – 16,000RPM	SR0011
10x14 z=3 45 Deg Chamfer/Finishing Cutter *	Carbide	2-3m/min – 18,000RPM	SR0012
12x22x16 z=2	PCD	4-6m/min - 18,000RPM	10202583
26.5x20x12.7 z=2 Chamfer Tool**	PCD	2-3 m/min – 15,000RPM	10221611

*risk of breakage is high if not careful

**not designed for nesting

Sawing

Cutting compact laminate on a panel saw or beam saw can be achieved with standard carbide tipped saw blades. Once again for large volumes diamond is a better solution as edge life will be greatly reduced. Saw dimensions will be determined by equipment used.

Below shows saw blades suitable on a panel saw

Tool	Cutting Material	Part Number
300x3.2/2.2x30x96 Triple Chip	Carbide	2130031
300x2.4/1.8x80 z=43	PCD	78213004330-B24

For more information on tooling please call AKE Sales Tech
on 03 9553 1883 or sales@akesalestech.com.au