

Machining Metal / Magnetic Laminate

Cutting metal/magnetic laminate and MDF/ chipboard are things which obviate each other. The geometry and parameters for the laminate cutting are not able to cut the MDF / chipboard. The surface will be unusable.

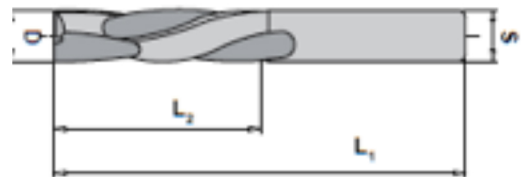
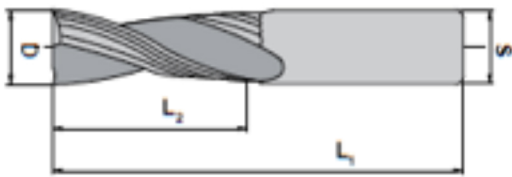
CNC Routing

The best and economical way is to use solid carbide tools, something from the normal woodworking range.

Example

If you're using material with magnetic laminate on one side you can use Z 2 a cutter like 10014585 Ø 16 x 35, S 16, R/R Z 2 (good side down)

If you're using material with magnetic laminate on both sides you can use an up/down cut cutter like 10022676 Ø 16 x 42, S 16, R/R Z 2+2



rpm	feed speed	rotation	use
about 14.000	5 – 8 m/min	against feed	oscillating continuously by using the Z-Axis, 5-6 mm to receive an exactable performance

Sawing

The best and most economical way to cut magnetic board with a circular saw blade is with a "tougher" carbide grade and a greatly reduced RPM. The most common mistake is to keep the RPM at the normal wood RPM – this will greatly reduce edge life. For example: 9156.305.80.30 305 x 2.2/1.80x30 z=80 with maximum RPM 1500.



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