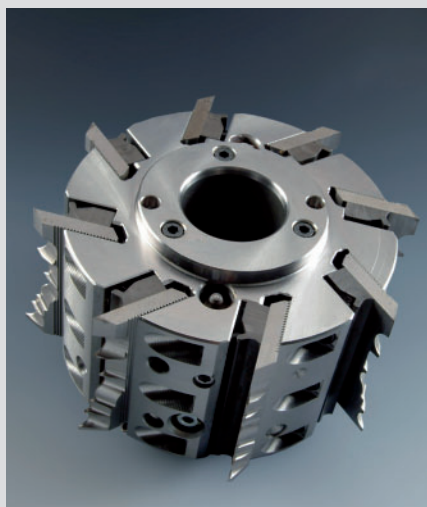


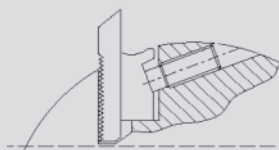
WEINIG Hydro Moulding Cutter Head



Original WEINIG Hydro Moulding Cutter Head Type 504

for processing smooth surfaces and mouldings at high feed speeds.

Technical data:	Ø 137 x 60 – 150 x Ø 40 mm steel Z = 4 Ø 150 x 60 – 310 x Ø 50 mm steel Z = 4 – 6 Ø 163 x 60 – 310 x Ø 50 mm steel Z = 8 Ø 195 x 60 – 330 x Ø 50 mm steel Z = 10 Ø 215 x 60 – 260 x Ø 50 mm steel Z = 12
Operating speed:	up to 6000 rpm Ø 150 = up to 8000 rpm
Number of cutting edges:	Z = 4 – 12
Tool runout tolerance:	0.005 mm



Knife clamping technique and cutting edge geometry:

Cutting angle 20°	Standard	Softwood / hardwood
Cutting angle 12°		Hardwood

Taper gib clamped with tightening screws.
Moulding cutters interlocked on the back.

50 60 x 8 x L 70	
55 70 x 10 x L	
50 x 10 x L	
38 50 60 x 7,5 + 2,5 x L 70	

Knife materials:

Cutting edge materials	Application	Tool life *
HSS knives	Softwood	500 – 2000 lin.m. 1 x jointing each
Stellite tipped	Hardwoods / medium hardness, without knots	500 – 1500 lin.m. 1 x jointing each
Carbide tipped	Hardwoods / exotic woods / MDF	500 – 1500 lin.m. 1 x jointing each
Carbide – knife blank with supporting plate	Two-piece knife system with micro corrugations between supporting plate and carbide knife blank	

Special features:

The moulding cutter knives must be ground within the tool set in order to achieve a knife tolerance of 0.005 mm which is the prerequisite for jointing. Moulding cutter knives can be reground on WEINIG Rondamats 960 and 970.

Jointing the tools within the machine guarantees an absolutely true cutting circle and at the same time prolongs the tool life.

Up to 30 jointing actions feasible, jointing phase max. 0.7 mm.

Depending on cutting edge materials, various types of jointing stone are available (see page 43).

* Tool life may vary depending on feed speed, chip removal, wood quality, humidity, material content, inclusions and quality requirements. The data are approximate values.

Tools type 504 Z = 4 – 8

Item no.	Diameter	Working width	Bore diameter	Number of cutting edges
Cutting angle 20°				
504.150.82	150 mm	60 mm	50 mm	4
504.150.01	150 mm	100 mm	50 mm	4
504.150.04	150 mm	130 mm	50 mm	4
504.150.07	150 mm	150 mm	50 mm	4
504.150.85	150 mm	60 mm	50 mm	6
504.150.19	150 mm	100 mm	50 mm	6
504.150.22	150 mm	130 mm	50 mm	6
504.150.25	150 mm	150 mm	50 mm	6
504.163.37	163 mm	60 mm	50 mm	8
504.163.01	163 mm	100 mm	50 mm	8
504.163.04	163 mm	130 mm	50 mm	8
504.163.07	163 mm	150 mm	50 mm	8

Useful accessories

Item no.	Item description	Dimension
00.206.944	Planer head screw	Allen screw M12 x 20 mm
Upon request	Taper gibs	–
00.309.102	Hydro-grease gun	see page 46
00.317.520	Grease cartridge	see page 46
00.311.560	High-pressure nipple	–
00.303.856	Pressure relief valve	–
00.600.197	Spanner	Spanner width 3 mm
00.600.200	Spanner	Spanner width 6 mm

Prices and additional dimensions upon request.