

leitz

# Carbide Compression Router Program



# Increase in productivity and flexibility

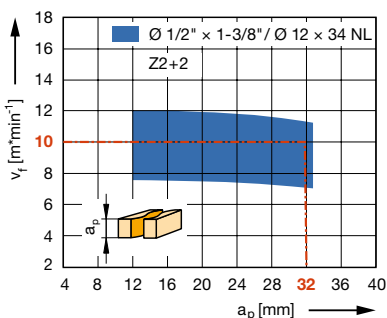
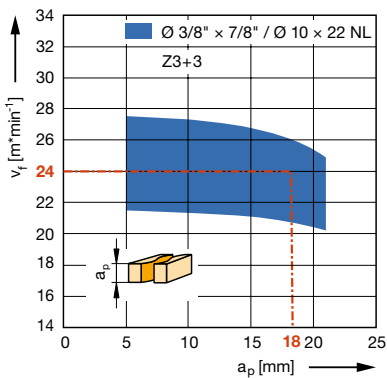
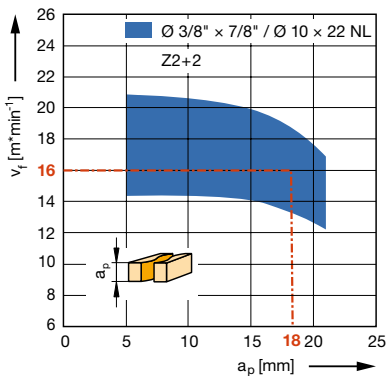
Leitz Australia compression router cutter range is produced to exact high precision standards required by our German parent company, this high quality is due to our German factory trained staff. Leitz Australia also uses only the best quality carbide rod, using the correct grade for each tool design to achieve maximum performance.

These cutters are produced on Australian made ANCA FX7 Linear 5-axis grinding machines, ANCA being one of the world's leading CNC grinding machine manufacturers.

**YOUR BENEFITS**

- Up to 40 % increase in edge life
- For all common material sizes
- Special sizes upon request
- Comprehensive range

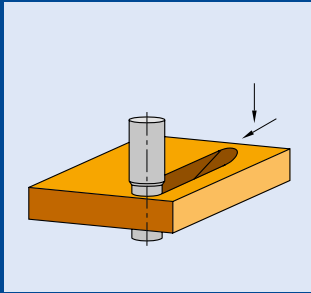
Feed speed  $v_f$  depending on cutting depth  $a_p$



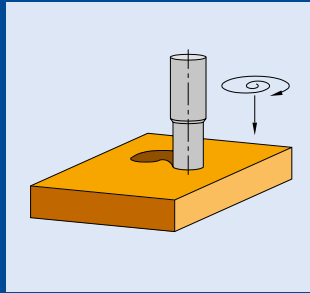
## Product Information (imperial)

D in	GL in	NL in	S in	$a_{p \text{ min}}$ mm	DRI	ID
<b>Z2+2 Standard</b>						
1/4"	2-1/2"	7/8"	1/4"	5	RH	60113AU •
3/8"	3"	7/8"	3/8"	5	RH	60123AU •
3/8"	3"	1-1/8"	3/8"	10	RH	60124AU •
<b>Z2+2 Coated for extra edge life</b>						
3/8"	3"	7/8"	3/8"	5	RH	60123HC •
3/8"	3"	1-1/8"	3/8"	10	RH	60124HC •
<b>Z3+3 Standard</b>						
3/8"	3"	7/8"	3/8"	7	RH	60126AU •
3/8"	3"	1-1/8"	3/8"	12	RH	60125AU •
<b>Z3+3 Coated for extra edge life</b>						
3/8"	3"	7/8"	3/8"	7	RH	60126HC •
3/8"	3"	1-1/8"	3/8"	12	RH	60125HC •
<b>Z2+2 Standard</b>						
1/2"	3-1/2"	7/8"	1/2"	5	RH	60163AU •
1/2"	3-1/2"	1-3/8"	1/2"	7	RH	60173AU •
1/2"	4"	1-5/8"	1/2"	10	RH	60178AU •
<b>Z2+2 Coated for extra edge life</b>						
1/2"	3-1/2"	1-3/8"	1/2"	7	RH	60173HC •
1/2"	4"	1-5/8"	1/2"	19	RH	60172HC •
<b>Z3+3 Standard</b>						
1/2"	3-1/2"	1-3/8"	1/2"	5	RH	60177AU •
<b>Z2+2 Chipbreaker for plywood</b>						
3/8"	3"	7/8"	3/8"	5	RH	60123C •
3/8"	3"	1-1/8"	3/8"	10	RH	60124C •

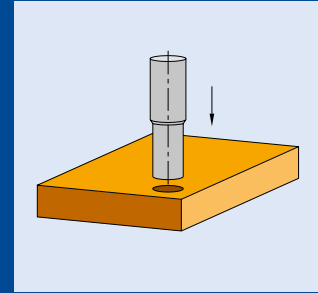
# Operation notes – Recommended cut entry method



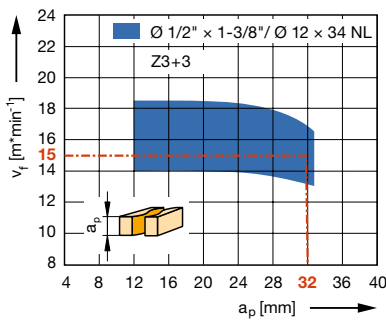
Ramp plunging  
(recommended at 15 deg)



Spiral plunging



Axial plunging  
(not recommended)



Workpiece material: Chipboard

Speed:  $n = 18000 \text{ min}^{-1}$

Correction factor for  $v_f$ : MDF and Plywood = 0.7

Note: Z2 design recommended when cutting MDF and in chipbreaker design for Plywood

## Product Information (metric)

D mm	GL mm	NL mm	S mm	$a_{p \text{ min}}$ mm	DRI	ID
<b>Z2+2 Standard</b>						
6	64	22	6	5	RH	60116AU •
10	75	24	10	7	RH	42799AU •
10	80	35	10	10	RH	60137AU •
<b>Z2+2 Coated for extra edge life</b>						
10	75	22	10	7	RH	42799HC •
<b>Z3+3 Standard</b>						
10	75	22	10	7	RH	42797AU •
<b>Z3+3 Coated for extra edge life</b>						
10	75	22	10	7	RH	42797HC •
<b>Z2+2 Standard</b>						
12	90	35	12	9	RH	42174AU •
12	100	42	12	19	RH	42537AU •
<b>Z3+3 Standard</b>						
12	90	37	12	10	RH	42175AU •
<b>Z2+2 Coated for extra edge life</b>						
12	100	42	12	19	RH	42537HC •
12	90	35	12	9	RH	42174HC •
<b>Z2+2 Chipbreaker for plywood</b>						
10	75	22	10	7	RH	42799C •



## Vacuum

- Ensure vacuum suction is sufficient
- Check filters are clean

## Spoil board technique

- Machine/re-surface both sides of spoil board and seal edges with glue to prevent loss of vacuum

## Chucks and collets

- All interfaces, collet, chuck, machine spindle and tool shank must be clean and free of wear or damage
- Collets should be replaced every 6-12 months (depending on number of tool changes)
- Collets must be matched to shank diameter
- Never squeeze a 10 mm collet down to 9.53 mm shank tool

Note: 15 deg ramp entry angle reduces chipping on entry.



● = available ex stock

□ = available at short notice

$a_p$  = cutting depth (axial)  
D = cutting circle diameter  
DRI = rotation

GL = total length  
ID = ident number  
n = RPM

NL = cutting length  
S = shank dimension  
 $v_f$  = feed speed



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