

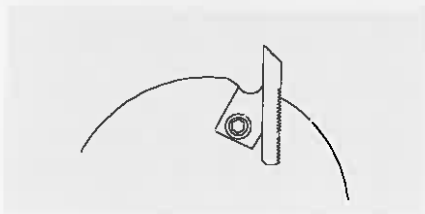
# WEINIG PowerLock Tool System



## Original WEINIG PowerLock Moulding Cutter Head Type 539

for processing smooth surfaces and mouldings.

Technical data:	Ø 90 x 60 – 240 mm	Steel
Operating speed:	up to 12000 rpm	
Number of cutting edges:	Z = 2	
Tool runout tolerance:	0.01mm (ground in the head on WEINIG Rondamats)	



### Knife clamping technique and cutting edge geometry:

Cutting angle 20°	Standard	Softwood / mixed species
Cutting angle 12°		Hardwood

Knife clamping with CentroLock quick action clamping gib (gibs are clamped with 2 lateral locking screws). Knives can be profiled and reground within the tool.

### Knife materials:

	Cutting edge materials	Application	Tool life *
 38 45 x 5 x L	HSS knives	Softwood / mixed species	500 – 3000 lin.m.
 38 45 x 6 x L	Carbide tipped	Hardwood / exotic woods / MDF	500 – 1500 lin.m.
 50 60 x 8 x L 70	HSS knives	Softwood / mixed species	500 – 3000 lin.m.
 55 50 x 10 x L	Stellite / Carbide tipped	Hardwood / mixed species, without knots	500 – 1500 lin.m.
 38 50 60 x 7,5+2,5 x L 70	Carbide – knife blank with supporting plate	Two-piece knife system with micro corrugations cutting between supporting plate and carbide knife blank	

### Special features:

Original WEINIG knives can be ground within the tool set. This provides a better knife tolerance and a better surface quality on the work piece.

Very economic tool system by means of re-grinding on all WEINIG Rondamats.

For each knife thickness, the corresponding quick action clamping gibs are used.

\* 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 539 Z = 2

Item no.		Working width	Bore diameter	Number of cutting edges	Spindle
<b>Cutting angle 20° for smooth planing including knives</b>					
<b>HSS 5 mm</b>	<b>Carbide 6 mm</b>				
539.092.21	539.092.41	60 mm	HSK	2	left / below
539.092.22	539.092.42	80 mm	HSK	2	left / below
539.092.23	539.092.43	100 mm	HSK	2	left / below
539.092.24	539.092.44	130 mm	HSK	2	left / below
539.092.25	539.092.45	150 mm	HSK	2	left / below
539.092.26	539.092.46	170 mm	HSK	2	left / below
539.092.29	539.092.48	190 mm	HSK	2	below
539.092.30	539.092.49	210 mm	HSK	2	below
539.092.27	539.092.47	240 mm	HSK	2	below
539.092.31	539.092.51	60 mm	HSK	2	right / above
539.092.32	539.092.52	80 mm	HSK	2	right / above
539.092.33	539.092.53	100 mm	HSK	2	right / above
539.092.34	539.092.54	130 mm	HSK	2	right / above
539.092.35	539.092.55	150 mm	HSK	2	right / above
539.092.36	539.092.56	170 mm	HSK	2	right / above
539.092.39	539.092.58	190 mm	HSK	2	above
539.092.40	539.092.59	210 mm	HSK	2	above
539.092.37	539.092.57	240 mm	HSK	2	above
<b>Cutting angle 20° for moulding</b>					
<b>HSS 8 mm</b>	<b>Carbide 10 mm</b>				
539.090.21	539.091.21	60 mm	HSK	2	left / below
539.090.22	539.091.22	80 mm	HSK	2	left / below
539.090.23	539.091.23	100 mm	HSK	2	left / below
539.090.24	539.091.24	130 mm	HSK	2	left / below
539.090.25	539.091.25	150 mm	HSK	2	left / below
539.090.26	539.091.26	170 mm	HSK	2	left / below
539.090.29	539.091.28	190 mm	HSK	2	below
539.090.30	539.091.29	210 mm	HSK	2	below
539.090.27	539.091.27	240 mm	HSK	2	below
539.090.31	539.091.31	60 mm	HSK	2	right / above
539.090.32	539.091.32	80 mm	HSK	2	right / above
539.090.33	539.091.33	100 mm	HSK	2	right / above
539.090.34	539.091.34	130 mm	HSK	2	right / above
539.090.35	539.091.35	150 mm	HSK	2	right / above
539.090.36	539.091.36	170 mm	HSK	2	right / above
539.090.39	539.091.38	190 mm	HSK	2	above
539.090.40	539.091.39	210 mm	HSK	2	above
539.090.37	539.091.37	240 mm	HSK	2	above

## Useful accessories

Item no.	Item description	Dimension
Upon request	Quick action clamping gib	-
507.312.002	Hammer for releasing the knives	-
00.600.199	Spanner	Spanner width 5 mm

Prices and additional dimensions upon request.