

# WEINIG CentroLock Hydro-Moulding Cutter Head



## Original WEINIG Hydro-Moulding Cutter Head Type 534

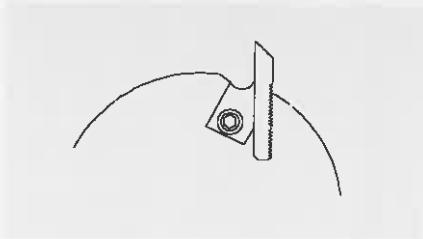
for processing smooth surfaces and mouldings at high feed speeds.

Technical data	Ø 137 x 60 – 240 x Ø 40 mm Z = 4
	Ø 150 x 60 – 240 x Ø 50 mm Z = 4 / 6
	Ø 163 x 60 – 240 x Ø 50 mm Z = 8

Operating speed:	up to 7500 rpm
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Number of cutting edges:	Z = 4 / 6 / 8
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Tool runout tolerance:	0.005 mm
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### Knife clamping technique and cutting edge geometry:

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

Quick action clamping gib with 2 lateral locking screws.  
Moulding cutters interlocked on the back.

### Knife materials:

	Cutting edge materials	Application	Tool life *
50 60 x 8 x L 70	HSS knives	Softwood	500 – 2000 lin.m 1x jointing each
55 70 x 10 x L	Stellite tipped	Hardwood / medium hardness, without knots	500 – 1500 lin.m 1x jointing each
50 x 10 x L	Carbide tipped	Hardwood / exotic woods / MDF	500 – 1500 lin.m 1x jointing each
38 50 60 x 7,5 + 2,5 x L 70	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 534 Z = 4 – 8

Item no.	Diameter	Working width	Bore diameter	Number of cutting edges
534.150.01	150 mm	60 mm	50 mm	4
534.150.04	150 mm	100 mm	50 mm	4
534.150.07	150 mm	130 mm	50 mm	4
534.150.10	150 mm	150 mm	50 mm	4
534.150.13	150 mm	230 mm	50 mm	4
534.150.21	150 mm	60 mm	50 mm	6
534.150.24	150 mm	100 mm	50 mm	6
534.150.27	150 mm	130 mm	50 mm	6
534.150.30	150 mm	150 mm	50 mm	6
534.150.33	150 mm	230 mm	50 mm	6
534.163.01	163 mm	60 mm	50 mm	8
534.163.04	163 mm	100 mm	50 mm	8
534.163.07	163 mm	130 mm	50 mm	8
534.163.10	163 mm	150 mm	50 mm	8
534.163.13	163 mm	230 mm	50 mm	8

Please state thickness of the knife blank when ordering

## Useful accessories

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

Prices and additional dimensions upon request.