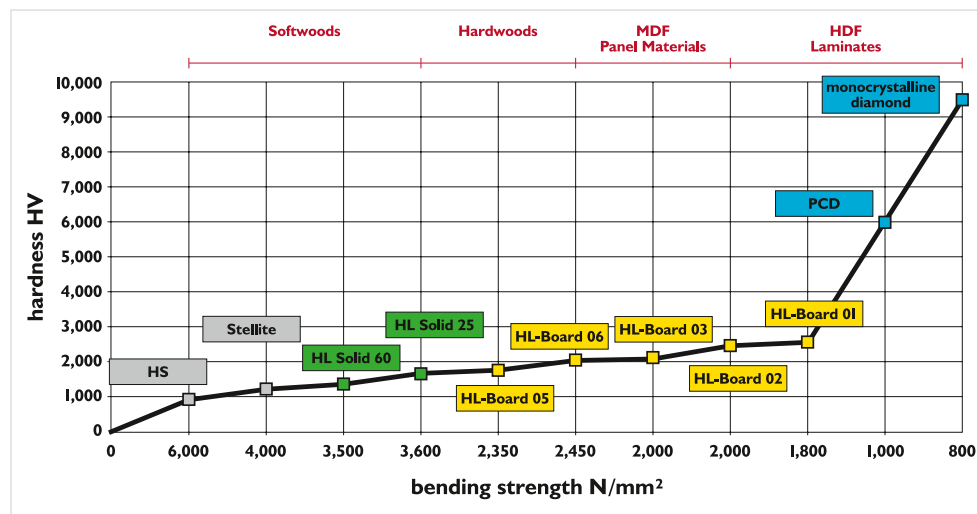


Technical Information

The multitude of **materials to be machined** and the various kinds of applications, make different demands on the **cutting edge material** and the **cutting edge geometry**.

Where as softwoods require a **small hook** angle, hardwoods and panel materials require a **larger hook** angle due to the increased hardness and strength of the more wear resistant carbide.

The chart shows the hardness and bending strength of the most popular cutting edge materials.



The increase in the the **hardness** of the carbide is inevitably linked with a decrease in **bending strength**.

Bevels	Material
60-70°	Diamond
45-55°	Tungsten Carbide
40-50°	Stellite
35-45°	H.S.S.



CUTTING MATERIAL – SOLID TUNGSTEN CARBIDE

- HL Board 01 for wood based panels and plastics.
- HL Board 02 for wood based panels and plastics.
- HL Board 03 for wood based panels and plastics.
- HL Board 05 for wood based panels, plastics, hardwoods.
- HL Board 06 for wood based panels, plastics, hard and softwoods.
- HL Board 15 for wood based panels, hard and softwoods.
- HL Board 40 for hard and softwoods.
- HW HL Board 05 for wood-based panels, plastics and hardwoods.
- HW HL Solid 25 for hard and softwoods.
- HW HL Solid 25 Topline for hard and softwoods.

Abrasive Panel Materials

eg: high density particle boards, high pressure laminated boards, cement-bound particle boards.

Panel Materials

eg: particle boards, MDF boards coated and covered hardwoods including oak, beech, teak.

Softwoods

eg: pine, spruce, fir.

Tungsten carbide grades are destined for the use in softwoods and laminated timbers as well as in wood-based panels.