



#### Spiral roughing/finishing router cutter Marathon

##### Application:

Router cutter for sizing, grooving and mortise slots in roughing/finishing quality.

##### Machine:

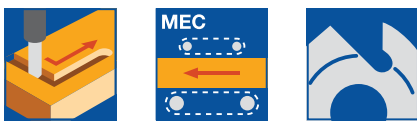
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

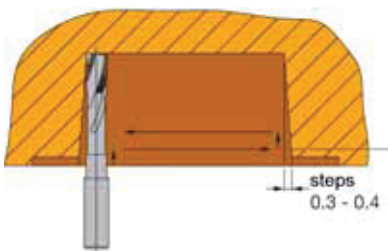
Softwood and hardwood, modified timber for window construction, chipboard and fibre working materials (MDF, HDF etc.) uncoated, laminated veneer lumber (plywood, multiplex plywood etc.), PVC window profiles.

##### Technical information:

Solid tungsten carbide. Marathon coating for increased performance time. Extra long design for increased cutting depth (in several steps). Higher feed speeds than conventional spiral roughing cutters, extremely smooth running.



Application example for mortise slot production



##### Application data:

###### Infeed at:

$a_p$  4 - 8 mm per stroke in solid wood;  
 $v_f$  10 - 16 m min<sup>-1</sup>;  
 $n$  = 12000 - 18000 min<sup>-1</sup>

$a_p$  8 - 15 mm per stroke in chipboard;  
 $v_f$  12 - 18 m min<sup>-1</sup>;  
 $n$  = 12000 - 18000 min<sup>-1</sup>

Z 2 / Z 3, extra long design, for mortise slots

WO 160 2 13

| D<br>mm | GL<br>mm | NL<br>mm | AL<br>mm | S<br>mm | Z | Twist | DRI | ID     | ID<br>Set<br>HSK-F 63 |   |
|---------|----------|----------|----------|---------|---|-------|-----|--------|-----------------------|---|
| 8       | 80       | 25       | 51       | 8x25    | 2 | LD    | RH  | 240010 | ● 240500              |   |
| 10      | 90       | 30       | 51       | 10x35   | 2 | LD    | RH  | 240011 | ● 240501              |   |
| 12      | 120      | 35       | 80       | 12x35   | 3 | LD    | RH  | 240012 | ● 240502              |   |
| 12      | 120      | 35       | 80       | 12x35   | 3 | RD    | RH  | 240000 | ●                     |   |
| 14      | 170      | 30       | 95       | 16x50   | 3 | RD    | RH  | 240001 | ●                     |   |
| 14      | 190      | 30       | 120      | 16x50   | 3 | RD    | RH  | 240002 | ●                     |   |
| 16      | 170      | 50       | 105      | 16x50   | 3 | RD    | RH  | 240003 | ●                     |   |
| 16      | 179      | 30       | 120      | 16x58   | * | 3     | RD  | RH     | 240004                | ● |
| 16      | 179      | 30       | 120      | 16x58   | 3 | RD    | RH  | 240013 | ●                     |   |
| 16      | 179      | 30       | 120      | 20x58   | * | 3     | RD  | RH     | 240005                | ● |
| 16      | 179      | 30       | 120      | 20x58   | 3 | RD    | RH  | 240014 | ●                     |   |
| 16      | 205      | 30       | 135      | 20x50   | 3 | RD    | RH  | 240006 | ●                     |   |
| 17      | 190      | 30       | 120      | 20x50   | 3 | RD    | RH  | 240008 | ●                     |   |
| 18      | 170      | 50       | 115      | 20x50   | 3 | RD    | RH  | 240009 | ●                     |   |

RPM: Wood/wood derived material: D 10-12 mm:  $n$  = 18000 - 24000 min<sup>-1</sup>  
Wood/wood derived materials: D 14-18 mm:  $n$  = 12000 - 20000 min<sup>-1</sup>  
Plastics:  $n$  = 12000 - 18000 min<sup>-1</sup>

\* with clamping fl at for HOMAG/WEEKE lock case trimming unit

##### Note:

Set HSK-F 63 = tools marked with the note „Set HSK-F 63“ will be supplied mounted in shrink-fit chuck HSK-F 63.