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Betreff / Subject

LEUCO RELIEF-PICTURE SHANK-TYPE TOOL: GREYSCALE-EFFECT PICTURES ON THE CNC

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Inhalt / Content

The relief-image technology is a computerized method, to transfer image information onto board materials by means of CNC milling technology, e.g. with the light-reflective engraving software Pic2Plate by LettnerWorx.

For the V-groove milling on CNC machines the PCD-tipped LEUCO Relief-picture router bit is the ideal tool for a wide variety of materials.

Design and benefits

- ! Cutting edge material PCD: very long tool life, especially in hard panel materials
- ! LEUCO topline version: optimum cutting quality thanks to special cutting edge preparation
- ! Resharping zone 2 mm: several resharpenings, very long edgelife

Dimensions and order number

Ø D [mm]	L2 [mm]	L3 [mm]	Ø d [mm]	L1	Z	α [°]	Ident-No.
14	7	50	16	80	1	90	185156

The best performance is achieved by running the cutter in highly accurate clamping systems. LEUCO recommends:

- ! Hydro clamping chuck „LEUCO ps-System“, HSK 63F [Ident-No. 184307]
- ! Force-shrink chuck „Tribos“ HSK 63F [Ident-No. 180 899]
- ! Heat-shrink chuck HSK 63F [Ident-No. 183084]

→ RECOMMENDATIONS

The following application parameters are to be understood as a guideline. Optimum values depend on various conditions which may vary from case to case.

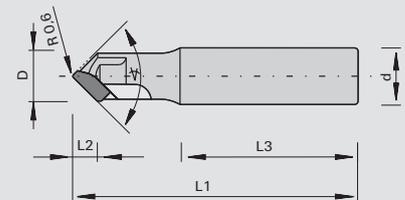
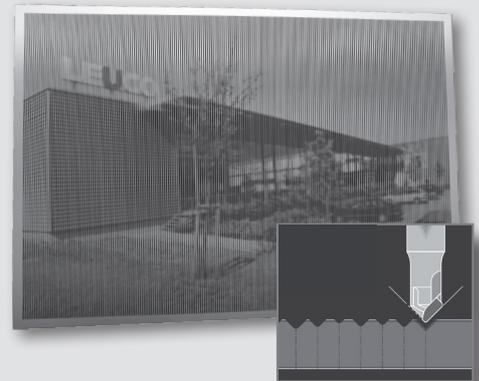
Board material Feedrate	RPM	
	18.000	24.000
HPL compact laminate	5 m/min	7 m/min
CDF (Compact Density Fibreboard)	6 m/min	8 m/min
MDF melamine-faced	7 m/min	10 m/min

OUR TIP

For the best possible cutting result when machining on console table machines:

Pay attention to the best possible fixing of the panels, including a sufficient number of vacuum suction cups, identical cup-heights, clean suction surfaces, possibly using aluminum suction cups.

Bildmaterial / Imagery



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