

# Tool recommendation 09/2020

## EGGER Compact Laminates

### Product description EGGER compact laminate



EGGER compact laminates have a multilayer structure and consist of a top layer made of decor paper impregnated with melamine resin and a fibrous core layer bounded with thermosetting resin.

### General tool recommendation

The following machining information is based on a wide range of test series with the best machining results in each case being produced in cooperation with Fritz EGGER GmbH & Co. OG.

### Technical information

When machining compact laminates, the ratio of the number of teeth (Z), cutting speed ( $v_c$ ) and feed speed ( $v_f$ ) should be observed.

Machining method	Cutting speed $v_c$ m/s	Tooth feed rate $f_z$ mm
Sawing	50 - 80 (Soll 60)	0,02 - 0,05
Cutting	30 - 50	0,3 - 0,5
Drilling	0,5 - 2,0	0,1 - 0,6

The following formulas apply to the calculation of cutting speed, tooth feed rate and feed speed:

$v_c$  – Cutting speed [m/s]

$$v_c = D \cdot \pi \cdot n / 60 \cdot 1000$$

D = Tool diameter [mm]  
n = RPM of tool [ $\text{min}^{-1}$ ]

$f_z$  – Tooth feed rate [mm]

$$f_z = v_f \cdot 1000 / n \cdot z$$

$v_f$  = Feed speed [m/min]  
n = RPM of tool [ $\text{min}^{-1}$ ]  
z = Number of teeth

$v_f$  – Feed speed [ $\text{m} \cdot \text{min}^{-1}$ ]

$$v_f = f_z \cdot n \cdot z / 1000$$

$f_z$  = Tooth feed rate [mm]  
n = RPM of tool [ $\text{min}^{-1}$ ]  
z = Number of teeth

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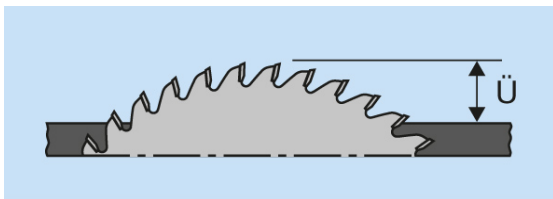
### Sawing

#### General note:

- Visible side (decorative side) upwards
- Make sure that the sawblade protrudes correctly (see table)
- Adjust RPM and number of teeth to feed speed
- The use of a scoring sawblade is recommended for precise cuts on the bottom side of the panel

Depending on the sawblade protrusion, the entry and exit angle and thus the quality of the cutting edge change. If the top cutting edge becomes rough, set the sawblade higher. If the cut on the bottom side is rough, the sawblade must be set lower. In this way the most favorable height setting must be determined.

The following sawblade protrusions ( $\ddot{U}$ ) must be set for sizing and panel sizing saws, depending on the diameter (D):



Circular sawblade diameter D:	Protrusion $\ddot{U}$ :
D 250 mm	ca. 5 - 10 mm
D 300 mm	ca. 5 - 10 mm
D 350 mm	ca. 5 - 10 mm
D 400 mm	ca. 5 - 10 mm
D 450 mm	ca. 5 - 10 mm

Sawblades with a high number of teeth are generally recommended for good machining quality. For circular sawing, the recommended cutting speed  $v_c$  is 60 – 90 m/s.

#### Recommended saw tooth shapes



TR/TR (trapezoidal tooth/trapezoidal tooth) FZ/TR (flat tooth/trapezoidal tooth)

To process compact laminates glued on both sides, a scoring saw is also required in order to avoid breakouts on the bottom side.

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### Sizing of single boards in finish cut quality *Excellent* - RazorCut

**Application:**

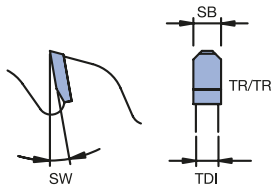
For panel sizing of single boards and stacks of boards with low cutting heights (up to 60 mm) with scoring.

**Machine:**

Panel sizing saws with scoring unit and pressure beam.

**Technical information:**

Special cutting geometry for excellent cutting results in finish cut quality. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level. Irregular tooth pitch.



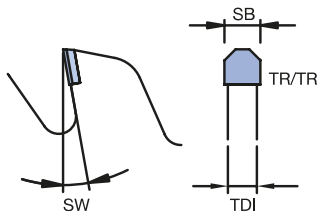
**Circular sawblade RazorCut**

WK 878 2 87

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	ID
	mm	mm	mm	mm	mm			°	
Felder, Holz-Her, Striebig	250	3.2	2.2	30	KNL	60	TR/TR	15	161100 ●
	280	3.2	2.2	30	KNL	60	TR/TR	15	161101 ●
	300	4.4	3.2	30	KNL	60	TR/TR	15	161102 ●
Striebig	300	3.2	2.2	30	KNL	72	TR/TR	15	161103 ●
Homag	300	4.4	3.2	60	2/14/100	72	TR/TR	15	161104 ●
Selco	300	4.4	3.2	65	2/9/110	60	TR/TR	15	161134 □
Homag	308	3.2	2.4	60	2/14/100	96	TR/TR	15	161105 ●
Homag	310	4.4	3.2	60		72	TR/TR	15	161106 ●
Giben	320	4.4	3.2	50	3/15/80	60	TR/TR	15	161107 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15	161108 ●
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15	161109 ●
Homag	350	4.4	3.2	75		72	TR/TR	15	161110 ●
Giben, Homag	355	4.4	3.2	75		72	TR/TR	15	161111 ●
Selco	355	4.4	3.2	80	2/9/130	72	TR/TR	15	161112 ●
					4/19/120				
Schelling	360	4.4	3.2	30	2/13/94	72	TR/TR	15	161113 ●
	370	4.4	3.2	30	KNL	72	TR/TR	15	161114 ●
Holz-Her	380	4.4	3.2	30	KNL	72	TR/TR	15	161132 ●
Giben	380	4.4	3.2	50	4/13/80	72	TR/TR	15	161115 ●
Homag	380	4.4	3.2	60	2/14/100	72	TR/TR	15	161116 ●
					2/14/125				
Homag	380	4.8	3.5	60	2/14/100	72	TR/TR	15	161117 ●
					2/14/125				
Mayer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	15	161118 ●
					2/13/94				
Giben, Homag	400	4.4	3.2	75	4/15/105	72	TR/TR	15	161119 ●
					2/7/110				
Selco	400	4.4	3.2	80	2/9/130	72	TR/TR	15	161120 ●
					4/19/120				
Gabbiani, SCM	400	4.4	3.2	80	4/9/100	72	TR/TR	15	161121 ●
					2/14/110				
					2/7/110				
Homag	420	4.8	3.5	60	2/14/125	72	TR/TR	15	161122 ●
					2/19/120				
Schelling	430	4.4	3.2	30	KNL	72	TR/TR	15	161123 ●
Giben	430	4.4	3.2	75	4/15/105	72	TR/TR	15	161124 ●
					2/7/110				
Selco	430	4.4	3.2	80	2/9/130	72	TR/TR	15	161125 ●
					4/19/120				
Mayer, Schelling	450	4.4	3.2	30	2/13/94	72	TR/TR	15	161126 ●
					KNL				
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	15	161127 ●
					2/19/120				
Selco	450	4.8	3.5	80	2/9/130	72	TR/TR	15	161128 ●
					4/19/120				
Schelling	460	4.4	3.2	30	2/13/94	72	TR/TR	15	161129 ●
Homag	480	4.8	3.5	60	2/19/120	72	TR/TR	15	161130 ●
Selco	480	4.8	3.5	80	2/9/130	72	TR/TR	15	161133 □
					4/19/120				
Schelling	520	4.8	3.5	30	2/13/94	72	TR/TR	15	161131 ●

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### Sizing of single boards and stacks of boards *Excellent*

**Application:**

For panel sizing of single boards and stacks of boards with scoring.

**Machine:**

Panel sizing saws with scoring unit and pressure beam.

**Technical information:**

DP tipped for long tool life. Irregular tooth pitch for better running. **Excellent** design with plastic filled laser ornaments for damping vibration and noise reduction.

**Panel sizing sawblade TR/TR, Diamaster PLUS**

WK 278 2, WK 858 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	ID
	mm	mm	mm	mm	mm			°	
	300	4.4	3.2	30	KNL	60	TR/TR	15	<b>190706 ●</b>
Homag	308	3.2	2.4	60	2/14/100	96	TR/TR	10	<b>190746 ●</b>
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15	<b>190707 ●</b>
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15	<b>190708 ●</b>
					2/14/125				
Homag	380	4.4	3.2	60	2/14/100	72	TR/TR	15	<b>190709 ●</b>
					2/14/125				
Homag	380	4.8	3.5	60	2/14/100	72	TR/TR	15	<b>190710 ●</b>
					2/14/125				
Mayer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	15	<b>190711 ●</b>
					2/13/94				
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	15	<b>190712 ●</b>
					2/19/120				

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## EGGER Compact Laminates

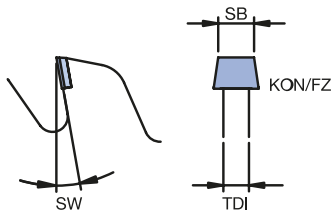


### Scoring sawblades KON/FZ *Excellent*

**Application:**  
For scoring with feed.

**Machine:**  
Panel sizing saws with scoring unit and pressure beam.

**Technical information:**  
Scoring depth 2.00 - 2.50 mm. DP tipped for long tool life. Scoring sawblade has to be selected according to the cutting width of the main sawblade. Usable in combination with HW and DP tipped main sawblade. For use in combination with resharpened HW tipped main sawblades the cutting width (SB) of scoring sawblade is 0.1 mm less.



### Scoring sawblades KON/FZ, Diamaster PLUS

WK 804 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	ID
	125	3.1	2.5	20		20	KON/FZ	10	<b>190564 ●</b>
Felder, Mayer	150	4.3	3.2	30		24	KON/FZ	10	<b>190565 ●</b>
Gabbiani	160	4.3	3.5	55	3/ 7/ 66	30	KON/FZ	10	<b>190566 ●</b>
Holz-Her	180	4.3	3.5	30	2/10/ 60	30	KON/FZ	10	<b>190567 ●</b>
Homag	180	4.3	3.5	45		30	KON/FZ	10	<b>190568 ●</b>
Homag	180	4.7	3.5	45		30	KON/FZ	10	<b>190569 ●</b>
Schelling	200	4.3	3.5	20	2/11/66	30	KON/FZ	10	<b>190570 ●</b>
	200	4.3	3.5	30	2/10/ 60	30	KON/FZ	10	<b>190571 ●</b>
Homag	200	4.3	3.5	45		30	KON/FZ	10	<b>190572 ●</b>
Selco	200	4.3	3.5	65	2/ 9/100	30	KON/FZ	10	<b>190615 ●</b>
					2/ 9/110				
Homag	200	4.7	3.5	45		30	KON/FZ	10	<b>190573 ●</b>
Selco	200	4.7	3.5	65	2/9/110	30	KON/FZ	10	<b>190574 ●</b>
					2/9/100				
Homag	220	3.1	2.4	45		48	KON/FZ	10	<b>190744 ●</b>
Schelling	300	4.3	3.5	30	2/11/73	48	KON/FZ	10	<b>190743 ●</b>
					2/13/94				

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EGGER Compact Laminates



## Sizing *Excellent*

### Application:

For sizing of single boards.

### Machine:

Table, sizing and vertical panel sizing saws.

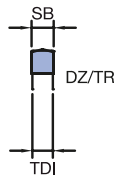
### Technical information:

DP tipped for long tool life. **Excellent** design with plastic filled laser ornaments for damping vibrations and reduction of noise level.

### Circular sawblade DZ/TR, Diamaster PRO

WK 872 2

D	SB	BO	NLA	Z	ZF	ID
mm	mm	mm	mm			
303	3.2	30	KNL	60	DZ/TR	<b>190673 ●</b>
303	3.2	30	KNL	96	DZ/TR	<b>190674 ●</b>



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## EGGER Compact Laminates



### Trimming cut

**Application:**

For sizing, trimming and cross cutting.

**Machine:**

Portable and table saws.

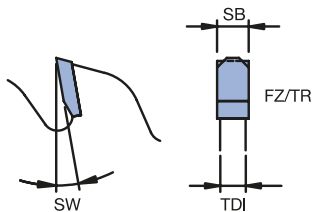
**Technical information:**

Solid tooth shape for universal use.

**Circular sawblade FZ/TR cutting angle 5°**

WK 452 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	ID
	mm	mm	mm	mm	mm			°	
AEG, Atlas Copco, Festool, Haffner, Hilti, Holz-Her, Mafell, Narex, Protool	160	2.6	1.8	20		48	FZ/TR	5	<b>166300</b> ●
Bosch, Festool, Holz-Her, Mafell, Makita, Skil	180	3.2	2.6	16		42	FZ/TR	5	<b>166301</b> ●
Emmegi	190	2.8	1.8	30		54	FZ/TR	5	<b>166302</b> ●
Eisele, Elu, DeWalt, Haffner	200	2.8	2.2	20		84	FZ/TR	5	<b>166303</b> ●
Makita	200	3.2	2.6	30	KNL	48	FZ/TR	5	<b>166304</b> ●
Elektra Beckum, Elu, DeWalt, Haffner, Mafell, Makita, Metabo, PHM, Rapid, Scheppach	250	3.2	2.6	30	KNL	60	FZ/TR	5	<b>166305</b> ●
Elu, Pressta Eisele	250	3.2	2.6	30	KNL	80	FZ/TR	5	<b>166306</b> ●
Eisele, Graule	250	3.2	2.6	40	2/11/63	60	FZ/TR	5	<b>166307</b> □
					2/11/63	80	FZ/TR	5	<b>166308</b> □
					2/8/55	80	FZ/TR	5	<b>166309</b> □
					4/12/64				
Eisele, Graule	275	3.4	2.8	40	2/9/55	72	FZ/TR	5	<b>166310</b> ●
					4/12/64				



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## EGGER Compact Laminates

### Panel processing



#### WhisperCut jointing / milling cutter - cutterhead design

**Application:**

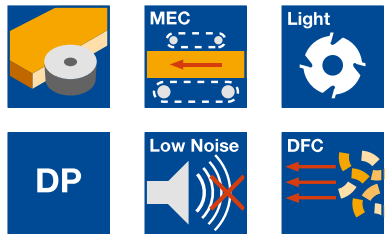
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

**Machine:**

Edgebanding machines, copy shaping machines, double-end tenoners etc.

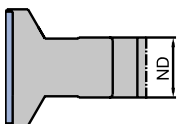
**Technical information:**

DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for tightly fitting edgebanding. Noise reduced design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) through DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.

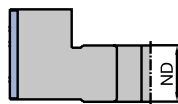


**Diamaster WhisperCut EdgeExpert - DFC, LowNoise, aluminium alloy tool body WM 230 2 01**

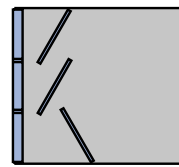
Machine	D mm	SB mm	ND mm	BO mm	NAL	n <sub>max</sub> min <sup>-1</sup>	Z	Type	ID	
									LH	RH
Biesse	125	43	40	30	DKN	2	13700	3x6	S	192249 ● 192249 ●
Biesse	125	63	40	30	DKN	2	13700	3x8	S	192250 ● 192250 ●
Homag	125	43	40	30	DKN	2	13700	3x6	S	192249 ● 192249 ●
IMA	125	43	40	30	DKN	2	13700	3x6	AS	192251 ● 192252 ●
IMA	125	63	40	30	DKN	3	13700	3x8	AS	192301 ● 192302 ●



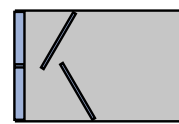
Position of boss (NAL) 2



Position of boss (NAL) 3



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



# Tool recommendation 09/2020

## EGGER Compact Laminates



### Jointing and rebating cutterhead

**Application:**

For rebating and jointing, rounding and profiling at the same time.

**Machine:**

Spindle moulders and moulders, double-end tenoners. Stationary routers with/without CNC control.

**Technical information:**

Cutterhead with turnblade knives. With alternate shear angle, triangle spurs and seating to adapt edging knives.

**Cutterhead with seatings for edging knives**

WW 420 1 01

D	SB	BO	Z	KM	n	QAL	ID
mm	mm	mm		PCS	min <sup>-1</sup>		
125	51	30	2	4	6200 - 10600	HW	<b>029073</b> ●
125	101	30	2	4	6200 - 10600	HW	<b>029074</b> ●
170	51	30	2	4	4500 - 7800	HW	<b>029075</b> ●



### Profile cutterhead ProfilCut Q for glue joints along the grain and mitre joints

**Application:**

For 45° glue joint profiles along grain with precise positioning. Exact positioning of the wood to be glued together and for producing corner joints.

**Machine:**

Spindle moulders and moulders.

**Technical information:**

Not suitable for melamine or paper coated panel materials.

**Profile cutterhead ProfilCut Q 45°**

WE 610 1 53

D	SB	HD	BO	Z	BO <sub>max</sub>	n	ID
mm	mm	mm	mm		mm	min <sup>-1</sup>	
175	40	28	30	2	50	4400 - 7600	<b>125130</b> ●
175	40	28	50	2	50	4400 - 7600	<b>125131</b> □



# Tool recommendation 09/2020

EGGER Compact Laminates

## Milling



### Bevel cutter

**Application:**

Router cutter for bevelling workpiece edges. Tool guided along workpiece by ball bearing guide.

**Machine:**

Portable routers.

**Technical information:**

Ball bearing guide ring on bottom for use with templates or guided by the workpiece edge.

**Bevel cutter, HW, Z 2, shank 8 mm**

WO 314 1, WO 315 1

D	D <sub>0</sub>	GL	SB	FAW	S	DRI	ID
mm	mm	mm	mm	°	mm		
25.7	12.7	70	25.1	15°	8x30	RH	072522 □
25	12.7	50.3	12	30°	8x30	RH	072774 □
38.5	12.7	64.5	23	30°	8x30	RH	072523 □
26	12.7	47.8	7	45°	8x30	RH	072775 ●

**Bevel cutter, HW, Z 2, shank 12 mm**

WO 315 1

D	D <sub>0</sub>	GL	SB	FAW	S	DRI	ID
mm	mm	mm	mm	°	mm		
55	12.7	74	26	45°	12x40	RH	072517 ●

RPM: n = 18000 - 27000 min<sup>-1</sup>



### Spiral roughing/finishing router cutter Marathon

**Application:**

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

**Machine:**

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

**Technical information:**

Solid tungsten carbide. Tungsten carbide grade and Marathon coating for increased performance time, particularly in abrasive materials. Recommended for abrasive materials such as HPL/CPL.

**HW, Z 2, short design, for abrasive materials**

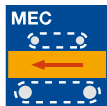
WO 160 2 15

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
10	70	25	10x40	2	RD	RH	240200 ●
12	70	25	12x40	2	RD	RH	240201 ●
16	100	40	16x50	2	RD	RH	240202 ●

RPM: n<sub>max</sub> = 24000 min<sup>-1</sup>

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## EGGER Compact Laminates



### Router cutter Diamaster PLUS

**Application:**

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides.

**Machine:**

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

**Technical information:**

Cutting edges with alternate shear angle and tungsten carbide plunging tip (ID **090174** with DP plunging edge). Resharpenable 5 to 8 times with normal wear. Cuts for painting in MDF require finishing with tools with continuous edges. Stable and rigid tips suitable for machining abrasive and hard to machine materials (HPL, GFRP, CFRP etc.).

**DP, Z 1+1**

WO 140 2

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
12	90	24	16x50	RH	<b>090174 ●</b>
16	90	28	20x60	RH	<b>090188 ●</b>
18	110	48	20x60	RH	<b>091101 ●</b>
20	130	58	25x60	RH	<b>090167 ●</b>

**RPM:** n = 16000 - 24000 min<sup>-1</sup>



### Router cutter Diamaster PLUS

**Application:**

Router cutter for sizing and grooving with seamless cut. Particularly suitable for machining MDF with direct lacquering or foil coating of the machined edges

**Machine:**

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

**Technical information:**

Negative cutting edge shear angles for tear-free edges during grooving and to support the workpiece clamping of smaller parts. Resharpenable 5 to 8 times with normal wear. Short and stable tool design ideal for grooving and sizing of abrasive and hard to machine materials (HPL, GFRP, CFRP etc.).

**DP, Z 2**

WO 120 2 60

D	GL	NL	S	Z	DRI	ID
mm	mm	mm	mm			
14	80	16	20x50	2	RH	<b>091157 ●</b>
16	80	18	20x50	2	RH	<b>091156 ●</b>

**RPM:** n = 12000 - 18000 min<sup>-1</sup>

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## Router cutter Diamaster PRO

### Application:

Router cutter for sizing and grooving (Nesting) at high feed speeds. For tear-free cut edges on both sides of the workpiece.

### Machine:

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

### Technical information:

Spiral cutting edge arrangement with alternate shear angles and real - Z 2 over the complete cutting length, with DP plunging tip. Resharpenable up to 3 times with normal wear. Tool body made from high-tensile material. Important to follow the application data parameters.



### DP, Z 2+2, Nesting

WO 140 2 50

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
12	70	24	12x42	RH	<b>191060 ●</b>
12	75	28	12x42	RH	<b>191061 ●</b>

# Tool recommendation 09/2020

## EGGER Compact Laminates



### Diamond tipped profile shank cutter with ThermoGrip shrink fit chuck HSK-F 63

**Application:**

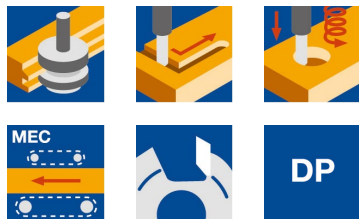
Router cutter for profiling and bevelling of compact laminate panels.

**Machine:**

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

**Technical information:**

Resharpenable 5 to 8 times with normal wear. Stable tipping, therefore particularly suitable for the processing of abrasive and difficult to machine materials (HPL, GFK, CFK, etc.).



### Profile router cutter with shrink fit chuck HSK-F 63

SO 599-2

P1 mm	D mm	Z	ID
12	18	2/2	<b>184090476</b>
13	58	5UT	<b>184026405</b>

**Application:**

Router cutter for drilling, profiling and bevelling of compact laminate panels.

**Technical information:**

Plunging and axial plunging possible. Resharpenable 5 to 8 times with normal wear. Stable tipping, therefore particularly suitable for the processing of abrasive and difficult to machine materials (HPL, GFK, CFK, etc.)

### Profile router cutter with shrink fit chuck HSK-F 63, with plunging tip

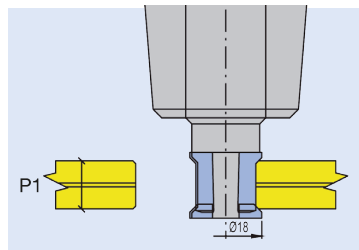
SO 599-2

P1 mm	D mm	Z	ID
6	19	2/2/2	<b>184080161</b>
8	19	1/2/1	<b>184034099</b>
10	19	2/2/2	<b>184061877</b>

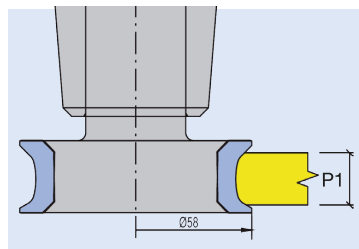
**Feed speed:**  $v_f = 4 - 8 \text{ m/min}$

**RPM:**  $n = 18000 - 24000 \text{ min}^{-1}$

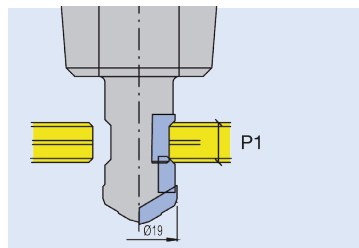
**RPM max.:**  $n_{\text{max}} = 30000 \text{ min}^{-1}$



Profile router cutter ID 184090476



Profile router cutter ID 184026405



Profile router cutter with plunging tip

# Tool recommendation 09/2020

## EGGER Compact Laminates

### Drilling



#### Shank 10 mm, HW solid

##### Application:

For drilling blind holes, particularly dowel holes in furniture construction. Suitable for drilling tear-free blind holes in visible areas and for machining panel materials which are covered with laminations difficult to machine (e.g. thin decorative paper).

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Technical information:

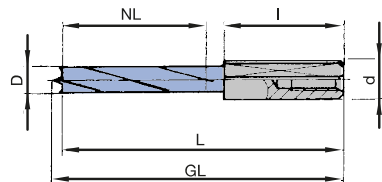
Spur geometry with high shear cut. Solid tungsten carbide design with high wear resistant tungsten carbide grade. High stability and long performance time. Polished gullet for minimum friction and feed forces. Very large resharping area.



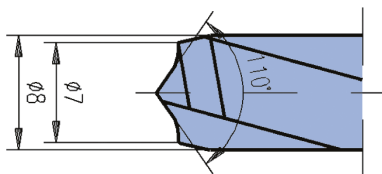
#### GL 57.5 mm, Z 2 / V 2

WB 120 0 32

D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
3	57.5	56	25	10x25	033788 ●	033789 ●
4	57.5	56	25	10x25	033784 ●	033785 ●
5	57.5	56	25	10x25	033728 ●	033729 ●
6	57.5	56	25	10x25	033730 ●	033731 ●
8	57.5	56	25	10x25	033732 ●	033733 ●
10	57.5	55.5	25	10x25	033786 ●	033787 ●



Design without heel



Drill GL 70 mm with modified drill bit for excellent processing results

#### Exemplary application parameters compact laminate panels:

Diameter  $\varnothing = 5$  mm  
 Feed speed  $v_f = 1 - 1,5$  m/min  
 RPM  $n = 3000 - 4500$  min<sup>-1</sup>

#### GL 70 mm, Z 2 / V 2 - with modified drill bit

WB 120-0-10, WB 120-0-11, WB 120-0-32

D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LL	RL
3	70	68,5	16	10x45	130075555 □	130075554 □
4	70	68,5	35	10x27	130075557 □	130075556 □
5	70	68,5	35	10x27	130075559 □	130075558 □
5,1	70	68,5	33	10x27	130072567	130072172
6	70	68,5	33	10x27	130075560 □	130072173
8	70	68,5	33	10x27	130075561 □	130072175
8,5	70	68,5	33	10x27	130072568	130072138
9,3	70	68,5	33	10x27	130072570	130072141
10	70	68,5	33	10x27	130075562 □	130072176

#### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Allen screw for S10x27	M5x8	Length adjustment	006378 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●

# Tool recommendation 09/2020

## EGGER Compact Laminates



### HW solid, Z 2

**Application:**

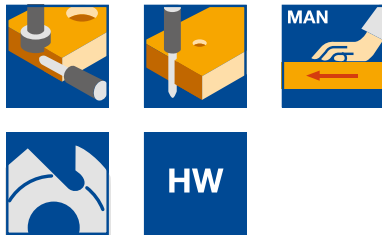
For multi-purpose drilling of blind and through holes.

**Machine:**

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units, column drilling machines, portable drills.

**Technical information:**

Flat V-point. Shank diameter identical to drill diameter. Convert for shank D 10 mm with reducing sleeve TB 110 0 or PM 320 0 25. Drilling in NF-metal requires suitable lubrication (spray mist or minimal lubrication).

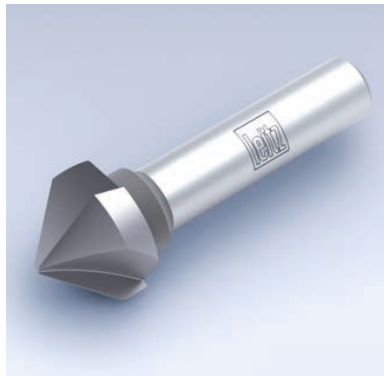


**V-point 120°**

WB 101 0 04

D	GL	NL	QAL	ID	ID
mm	mm	mm		LH	RH
2	40	17.5	HW solid	<b>034410</b> ●	<b>034411</b> ●
2.5	40	18	HW solid	<b>034412</b> ●	<b>034413</b> ●
3	46	16	HW solid	<b>034414</b> ●	<b>034415</b> ●
3.2	49	18	HW solid	<b>034420</b> ●	<b>034421</b> ●
3.5	52	20	HW solid	<b>034416</b> ●	<b>034417</b> ●
4	55	22	HW solid	<b>034418</b> ●	<b>034419</b> ●
5	62	26	HW solid	<b>034424</b> ●	<b>034425</b> ●

**RPM:** n = 3000 - 9000 min<sup>-1</sup>



### Shank 10 mm

**Application:**

For the additional countersinking of holes.

**Machine:**

Multi spindle units, column drilling machines, portable drills.

**Technical information:**

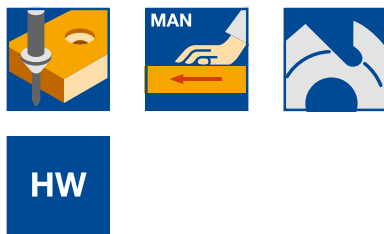
Countersink 90° Z 3 solid tungsten carbide. Special grinded section for clean and chatter-free cut.

**Countersink 90°**

WB 700 0, WB 702 0

D	GL	S	QAL	DRI	ID
mm	mm	mm			
20.5	58	10x40	HW solid	RH	<b>036255</b> ●

**RPM:** n = 2500 - 6000 min<sup>-1</sup>



# Tool recommendation 09/2020

## EGGER Compact Laminates

						<b>SP</b>	Alloyed tool steel
						<b>HL</b>	High-alloyed tool steel
						<b>HS</b>	High-speed steel
						<b>ST</b>	Stellite
						<b>HW</b>	Tungsten carbide
						<b>DP</b>	Poly-crystalline diamond (PKD)
						<b>DM</b>	Mono-crystalline diamond (MKD)
						<b>Marathon</b>	Carbide metal coating
						<b>Diamond</b>	Diamond coating