

## Insert Tooling

### ■ Spoilboard Surfacing Cutters

#### For Use On:

**Soft Plastic:** ABS, Polycarbonate, Polyethylene, PVC, Polypropylene, HDPE, Polystyrene, UHMW, and Extruded Acrylic

**Hard Plastic:** Cast Acrylic, Melamine, Nylon, PVC and Vinyl

**Composite Wood:** MDF, Particle Board and Plywood

Designed for surfacing MDF, particle board and balsa core where "flow through" or "high flow" fixturing is employed using large capacity vacuum pumps. This method of surfacing spoilboards allows for much faster table planing.



Catalog Number	Cutting Edge Diameter	Cutting Edge Length	Shank Diameter	Overall Length
<b>Straight</b>				
H25XAM-RC2257	2-1/2	1/2	1/2	2-1/2
H25XAM-RC2258	4		3/4	4

#### ACCESSORIES

Description	
H25XAM-12	Replacement Blade
H25XAM-67115	Replacement Screw
H25XAM-5005	Replacement Wrench

#### NOTES:

- 1) These tools are dynamically balanced and approved for use on CNC routers. Max rpm 18,000, 1/8 in. depth of cut max.
- 2) Spoilboard surfaces: 2-1/2 in. diameter tools should be fed at 200-600 ipm at 12,000-16,000 rpm. 4 in. diameter tools should be fed at 200-600 ipm at 12,000-14,000 rpm. Do not exceed 1/8 in. depth per pass.

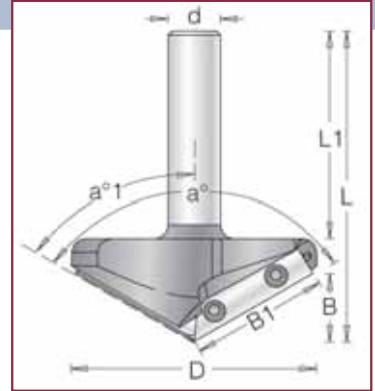
## Insert Tooling

- Single & Double Edge
- Carbide-Tipped, 1/2" Shank
- Miter Fold & Sign Making Insert Router Bit

### For Use On:

**Composite Wood:** MDF, Particle Board, Melamine

Designed to miter fold MDF, melamine and wood to a perfect joint.



Catalog Number	Overall Cutting Edge Dia.	Cutter Angle	Cutting Edge Angle	Angle Length	Max. Cutting Edge Lgth.	Overall Length	Shank Length	Replacement Blades
	(D)	(a°)	(a°1)	(B1)	(B)	(L)	(L1)	
<b>Single Edge</b>								
H25XAM-RC1045	13/16	45°	22.5°	1-1/16	1	2-3/8	1-3/8	H25XAM-RCK56
H25XAM-RC1046	7/8	50°	25°		31/32	2-9/16	1-1/2	
H25XAM-RC1108	1-1/32	60°	30°		29/32	2-7/16	1-3/8	
H25XAM-RC1048	1-7/32	70°	35°		7/8	2-9/16	1-1/2	
H25XAM-RC1102	1-1/2	90°	45°		3/4	3	1-25/32	H25XAM-RCK134
H25XAM-RC1100		91°	45.5°		11/16	3-3/16	2	H25XAM-RCK119
H25XAM-RC1103	1-5/8	100°	50°					
<b>Dual Edge</b>								
H25XAM-RC1105	1-3/4	110°	55°	1-1/16	5/8	3-1/16	2	H25XAM-RCK119
H25XAM-RC1104	2-1/32	120°	60°	1-5/32	9/16			H25XAM-RCK136
H25XAM-RC1107	2-1/8	130°	65°		1/2	3	H25XAM-RCK137	
H25XAM-RC1106	2-1/4	150°	75°		9/32	2-15/16		
H25XAM-RC1109	2-5/16	160°	80°		3/16	2-25/32		

### Notes:

- 1) Maximum RPM for H25XAM-RC1106 and H25XAM-RC1109 is 14,000.
- 2) Maximum RPM for H25XAM-RC1107 is 16,000.
- 3) Maximum RPM for H25XAM-RC1045, H25XAM-RC1046, H25XAM-RC1048, H25XAM-RC1104 and H25XAM-RC1108 is 18,000.
- 4) Maximum RPM for H25XAM-RC1100, H25XAM-RC1102, H25XAM-RC1103 and H25XAM-RC1105 is 22,000.

## Insert Tooling

- Double Edge
- Solid Carbide
- Insert Straight Router Bit

For Use On:

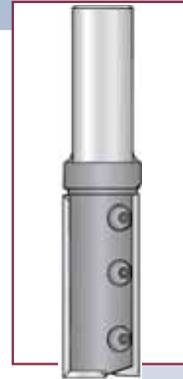
Wood

Wood Composites

Soft/Hard Plastics

PVC

Designed to yeild cuts which are cleaner than typical insert bits, offering high speed cuts with super clean finish. They also are channel set, double edge knives. Each blade has a double sided cutting edge for economy.



Catalog Number	Cutting Edge Diameter	Cutting Edge Length	Shank Diameter	Overall Length	Flutes	Replacement Blades	Retainer Clips
H25XAM-RC3100*	3/8	20 mm	1/2	2-7/8	1	H25XAM-RCK32	H25XAM-67104
H25XAM-RC3110*	1/2	30 mm		3-1/8	1	H25XAM-RCK34	H25XAM-67105

\*Maximum RPM 18,000

**Notes:**

- 1) Replacement 3 x .5mm set screwsfor RC3100 use 67015 (4mm long); RC-3110 use 67016 (5mm long); all others use 67017 (6mm long).
- 2) Replacement 1.5mm special hex key 5011.