



Helical planing cutterheads

Specification

Light alloy bodied disposable tip planing cutterhead. Helical design improves airflow around the tool, this in turn reduces noise, typically 7-10dB over conventional planing heads.

Power consumption is also reduced due to the staggered cut design.

Application

For use on softwoods and hardwoods when roughing and finishing.

MEC only.



Roughing heads with standard insert (G14) or (G14.5)

G14 (14x14x2.0 mm)

G14.5 (14.5x14.5x2.5 mm)

The G14 inserts are recommended for all normal roughing operations.

The G14.5 inserts should be used on particularly tough or knotty timber as they are more resistant to impact damage. Use of the G14.5 inserts will increase the tools cutting circle by 1mm on diameter.



(See table overleaf for grade selection)

Finishing heads with standard insert (G15)

G15 (15x15x2.5mm)

The G15 inserts are manufactured with a slight radius on the cutting edge which produces a small shear action giving an extremely good surface finish.

Sanding, if required, can be kept to a minimum.



(See table overleaf for grade selection)

Heads over 270 mm long.

Heads over 270 mm in length are supplied as segmented tools, this method of manufacture means that there is no maximum length of tool as several heads can be built up in this way.



Use the table below to select the available number of helices for a given tool diameter.

Length	Cutting Circle						Inserts on 1 helix
	100	120	125	140	160	180	
60	●■	●■	●■	●■★	●■★	■★♣	3
80	●■	●■	●■	●■★	●■★	■★♣	3
100	●■	●■	●■	●■★	●■★	■★♣	4
120	●■	●■	●■	●■★	●■★	■★♣	5
130	●■	●■	●■	●■★	●■★	■★♣	6
150	●■	●■	●■	●■★	●■★	■★♣	7
180	●■	●■	●■	●■★	●■★	■★♣	8
200	●■	●■	●■	●■★	●■★	■★♣	9
225	●■	●■	●■	●■★	●■★	■★♣	11
230	●■	●■	●■	●■★	●■★	■★♣	11
236	●■	●■	●■	●■★	●■★	■★♣	11
250	●■	●■	●■	●■★	●■★	■★♣	12

● 4 Helix ■ 6 Helix ★ 8 Helix ♣ 10 Helix

Use the table below to check maximum revs/min for a given tool diameter.

Diameter	n max
100	11500
120	10000
125	9500
140	8500
160	7000
180	6500
200	6000
250	4500

Helical planing head selection

Firstly, select the required feedrate for the revs/min of your machine from the tables below, to decide on number of helices required.

Secondly, check the table overleaf to see if the number of helices required is available in the diameter that you require.

Finally, select the appropriate style and grade of insert required.

Feedrates (m/min) for Roughing Heads with standard inserts G14/G14.5

	Z2	Z3	Z4
Revs	4 Helix	6 Helix	8 Helix
3600	11	17	23
4500	14	21	28
6000	19	28	38
7200	23	34	46
8000	25	38	51
9000	28	43	57
10000	32	48	64
11000	35	52	70
12000	38	57	76

For Roughing heads
Feed = 1.6*(no. of helix/2)*(revs/1000)

Feedrates (m/min) for Finishing Heads with standard inserts G15

	Z2	Z3	Z4
Revs	4 Helix	6 Helix	8 Helix
3600	8	12	17
4500	10	16	21
6000	14	21	28
7200	17	25	34
8000	19	28	38
9000	21	32	43
10000	24	36	48
11000	26	39	52
12000	28	43	57

For Finishing heads
Feed = 1.2*(no. of helix/2)*(revs/1000)

Insert Selection

	Roughing (G14)	Roughing (G14.5)	Finishing (G15)
Grade	14x14x2.0	14.5x14.5x2.5	15x15x2.5
	(general roughing)	(roughing knotty timbers)	(all finishing)
General Purpose	2211 2014 001	2211 2514 001	3015 2000 001
For Hardwoods	2211 2014 003	2211 2514 002	3015 0500 001
For Softwoods	2211 2014 004	3014 1000 001	3015 1000 001

If you require any further information or help in tool selection then please don't hesitate to call us.



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