

The new reference class for
DP-shank grooving cutters

Aigner

PRECISION IN BEST TIME



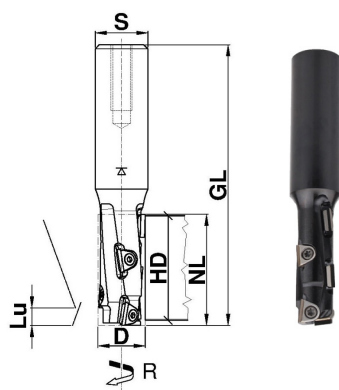
DP-SHANK GROOVING CUTTER FAMILY KONSTANTIN® MINI

Due to the consistent development of the Konstantin® Mini DIA grooving cutter family, suitable cutter types are available for modern CNC applications. The Konstantin® Mini exchange system enables our customers to change the DIA cutters on site by themselves, an exchange among each other can of course be done for larger effective lengths. Due to the disposable blades, the diameter always remains constant and no correction of the tool data in the software is required. Single-measurement errors can thus be successfully avoided! Increased demands on edge quality are covered by the new FinishCut series. Also, different feed rates of the CNC spindles are optimally served by the possibility of selecting different tooth variants. Even for extremely crack-intensive materials, the Speedy series with an axis angle of 54° is a problem solver for joining operations.

For the right selection of tools, our trained technical consultants are available for you and will be happy to advise you personally on site!

DP-Shank grooving cutter Konstantin®-Mini

Standard C243 Z1



The „workhorse“ among the DIA grooving cutters could be the correct designation for this type of milling cutter. Equipped with the proven Konstantin® Mini System, this tool is suitable for all standardized milling operations on the machining center with rather slow feed rates.

Design:

Steel body; with DP cutting edge Z1 + 1 in three flutes; with axis angle 10°. Cutting elements equipped with DP (DIA); grooving cutter with exchangeable DP cutting edges; deep chip spaces for better chip collection; shank fit h6

Application:

Grooving, jointing, rebating and formatting (cut-off milling) of MDF, raw chipboard, OSB, Melamine coated board materials and MDF primer foil coated.

Range of use: speed range 18000-24000 rpm; feed range: 4-8m/min.

Article no.	Z	D	NL	GL	S	LR
C243-1622916R	1x3 + 1Q	16	22,9	90	16	R
C243-1622920R	1x3 + 1Q	16	22,9	90	20	R
C243-1622925R	1x3 + 1Q	16	22,9	90	25	R
C243-1643916L	1x6 + 1Q	16	43,9	102	16	L
C243-1643916R	1x6 + 1Q	16	43,9	102	16	R
C243-1643920L	1x6 + 1Q	16	43,9	105	20	L
C243-1643920R	1x6 + 1Q	16	43,9	105	20	R
C243-1643925L	1x6 + 1Q	16	43,9	110	25	L
C243-1643925R	1x6 + 1Q	16	43,9	110	25	R
C243-1843920L	1x6 + 1Q	18	43,9	105	20	L
C243-1843920R	1x6 + 1Q	18	43,9	105	20	R
C243-1843925L	1x6 + 1Q	18	43,9	110	25	L
C243-1843925R	1x6 + 1Q	18	43,9	110	25	R



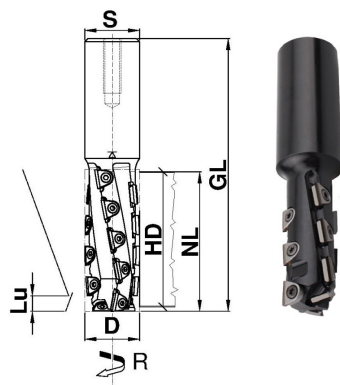
SPARE PARTS

Article no.		
KW.15766.7/B25	Replaceable DP cutters "Konstantin-Mini"	Circumference cutter all diameters Drill cutter for D=20+25mm
KW.15768.7/B25	Replaceable DP cutters "Konstantin-Mini"	For D=16mm
KW.19099.7/B25	Replaceable DP cutters "Konstantin-Mini"	For D=18mm
C986-FT1810	Torque wrench for "Konstantin-Mini"	1,8 Nm, incl. Torx-Bit / T10
KW.15714.7	Spare clamping screw "Konstantin-Mini"	60° / M3x6 / T10



DP-Shank grooving cutter Konstantin®-Mini

Standard C244 Z2



The „workhorse“ among the DIA grooving cutters could be the correct designation for this type of milling cutter. Equipped with the proven Konstantin® Mini System, this tool is suitable for all standardized milling operations on the machining center with medium to high feed rates.

Design:

Body made of steel; with DP cutting edge Z2+2; Two peripheral cutting edges in 4 flutes with axis angle 10° cutting elements equipped with DP (DIA); grooved shank cutter with interchangeable DP cutting edges; Deep chip spaces for better chip collection; Shank fit h6

Application:

Grooving, jointing, rebating and formatting (cut-off milling) of MDF, raw chipboard, OSB, Melamine coated board materials and MDF primer foil coated.

Range of use: Speed range 18000-24000 rpm; Feed range: 6-18 m/min.

Article no.	Z	D	NL	GL	S	LR
C244-2029920L	2x4 + 1Q	20	29,9	95	20	L
C244-2029920R	2x4 + 1Q	20	29,9	95	20	R
C244-2029925L	2x4 + 1Q	20	29,9	95	25	L
C244-2029925R	2x4 + 1Q	20	29,9	95	25	R
C244-2043920L	2x6 + 1Q	20	43,9	105	20	L
C244-2043920R	2x6 + 1Q	20	43,9	105	20	R
C244-2043925L	2x6 + 1Q	20	43,9	105	25	L
C244-2043925R	2x6 + 1Q	20	43,9	105	25	R
C244-2064925L	2x9 + 1Q	20	64,9	125	25	L
C244-2064925R	2x9 + 1Q	20	64,9	125	25	R
C244-2564925L	2x9 + 2Q	25	64,9	125	25	L
C244-2564925R	2x9 + 2Q	25	64,9	125	25	R

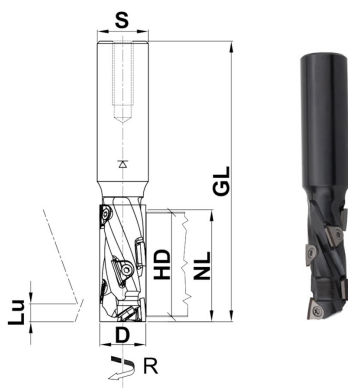


SPARE PARTS

Article no.		
KW.15766.7/B25	Replaceable DP cutters "Konstantin-Mini"	Circumference cutters all diameters Drill cutters for D=20+25mm
C986-FT1810	Torque wrench for "Konstantin-Mini"	1,8 Nm, incl. Torx-Bit / T10
KW.15714.7	Spare clamping screw "Konstantin-Mini"	60° / M3x6 / T10



DP-Shank grooving cutter Konstantin®-Mini FinishCut C248 Z1



„One for all“ describes the new reference class, the Konstantin®Mini FinishCut grooving cutter. This type of cutter is ideally suited for machining plywood and veneered materials. But this cutter type also achieves a record-breaking edge finish in standard panel materials. For slow feed ranges up to max. 8m/min. This cutter works with almost tear-out free results!

Design:

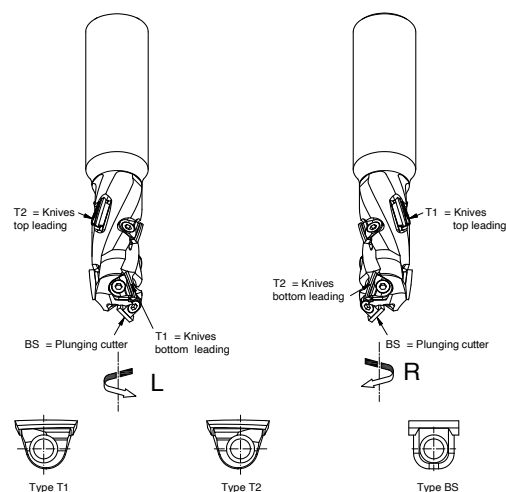
Steel body; with DP cutting edge; Z1 + 1 in three flutes; with axis angle 20°; cutting elements tipped with DP (DIA); grooving cutter with interchangeable DP cutting edges; deep chip spaces for better chip collection; shank fit h6.

Application:

Grooving, jointing, rebating and formatting (cut-off milling) of melamine-coated and veneered chipboard, MDF, multiplex and plywood, three-ply, hardwood furniture panels as well as blockboards.

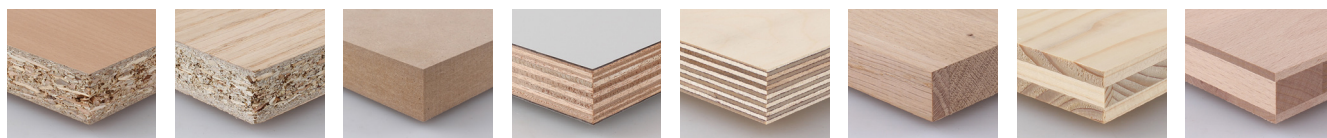
Range of use: Speed range 18000-24000 rpm; Feed range: 4-8 m/min.

Article no.	Z	D	NL	GL	S	LR
C248-1831220L	1x4 + 1Q	18	31,2	95	20	L
C248-1831220R	1x4 + 1Q	18	31,2	95	20	R
C248-1831225L	1x4 + 1Q	18	31,2	95	25	L
C248-1831225R	1x4 + 1Q	18	31,2	95	25	R
C248-1845820L	1x6 + 1Q	18	45,8	110	20	L
C248-1845820R	1x6 + 1Q	18	45,8	110	20	R
C248-1845825L	1x6 + 1Q	18	45,8	110	25	L
C248-1845825R	1x6 + 1Q	18	45,8	110	25	R

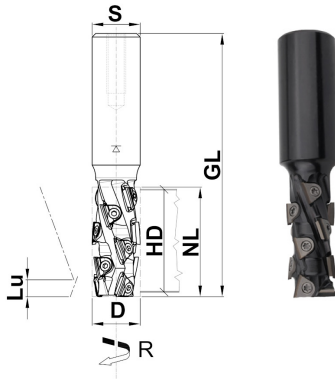


SPARE PARTS

Article no.		
KW.19099.7/B25	Replaceable DP cutters "Konstantin-Mini-Finish"	For D=18mm
KW.28188.7/B	Replaceable DP cutters "Konstantin-Mini-Finish"	Type "T1" / 10x8x2,5 mm
KW.28187.7/B	Replaceable DP cutters "Konstantin-Mini-Finish"	Type "T2" / 10x8x2,5 mm
C986-FT1810	Torque wrench for "Konstantin-Mini"	1,8 Nm, incl. Torx-Bit / T10
KW.15714.7	Spare clamping screw "Konstantin-Mini"	60° / M3x6 / T10



DP-Shank grooving cutter Konstantin®-Mini FinishCut C249 Z2



„One for all“ describes the new reference class, the Konstantin®Mini FinishCut grooving cutter. This type of cutter is ideally suited for machining plywood and veneered materials. But this cutter type also achieves a record-breaking edge finish in standard panel materials. For slow feed ranges up to max. 18m/min. This cutter works with almost tear-out free results!

Design:

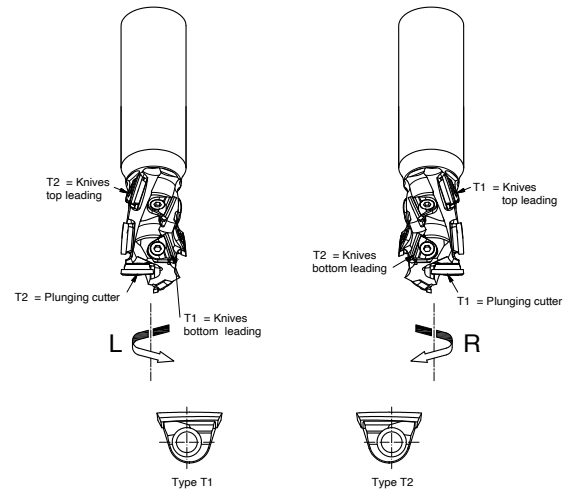
Body made of steel; with DP drilling cutting edge; Two peripheral cutting edges in 4 flutes; with axis angle 20°; cutting elements equipped with DP (DIA); grooved shank cutter with interchangeable DP cutting edges; Deep chip spaces for better chip collection; Shank fit h6

Application:

Grooving, jointing, rebating and formatting (cut-off milling) of melamine-coated and veneered particle boards, MDF, multiplex and plywood, three-ply, hardwood furniture boards as well as blockboards.

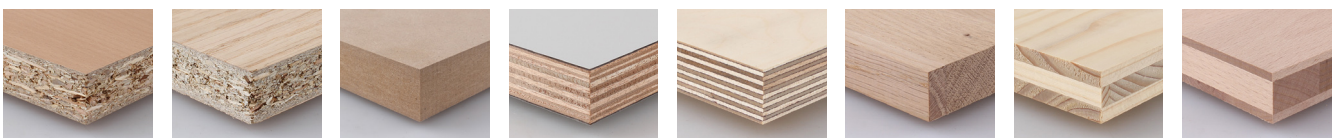
Range of use: speed range 18000-24000 rpm; feed range: 6-18 m/min.

Article no.	Z	D	NL	GL	S	LR
C249-2031220L	2x4 + 1Q	20	31,2	95	20	L
C249-2031220R	2x4 + 1Q	20	31,2	95	20	R
C249-2031225L	2x4 + 1Q	20	31,2	95	25	L
C249-2031225R	2x4 + 1Q	20	31,2	95	25	R
C249-2045820L	2x6 + 1Q	20	45,8	110	20	L
C249-2045820R	2x6 + 1Q	20	45,8	110	20	R
C249-2045825L	2x6 + 1Q	20	45,8	110	25	L
C249-2045825R	2x6 + 1Q	20	45,8	110	25	R

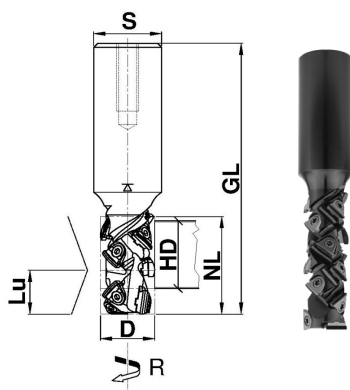


SPARE PARTS

Article no.		
KW.28188.7/B	Replaceable DP cutters "Konstantin-Mini-Finish"	Type "T1" / 10x8x2,5 mm
KW.28187.7/B	Replaceable DP cutters "Konstantin-Mini-Finish"	Type "T2" / 10x8x2,5 mm
C986-FT1810	Torque wrench for "Konstantin-Mini"	1,8 Nm, incl. Torx-Bit / T10
KW.15714.7	Spare clamping screw "Konstantin-Mini"	60° / M3x6 / T10



DP-Shank grooving cutter Konstantin®-Mini Speedy C246 Z1



The absolute top class when it comes to fine jointing operations on tear-out-intensive panel materials. The Speedy geometry with 54° AWS enables reliable prevention of tear-out on the top and bottom of panel materials. The Z1 variant is suitable for slow feed ranges.

Design:

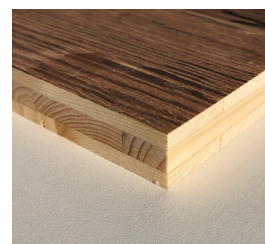
Body made of steel; with DP drilling cutting edge Z1 + 1; cutting elements equipped with DP (DIA). Joining end mill with interchangeable DP cutting edges; joining area with 54° axis angle; Drilling area (drilling cutting edge and lowest peripheral cutting edge); with standard axis angle; Different cutting edges in drilling and joining area; shank fit h6.

Application:

Fine jointing operations from 0.5 to 2.0 mm in melamine faced and veneered particle-board, MDF, multiplex and plywood, three-layer board, hardwood furniture boards as well as blockboards.

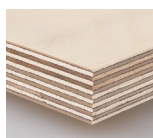
Range of use: speed range 18000-24000 rpm; feed range: 2-4 m/min.

Article no.	Z	D	NL	GL	S	LR
C246-203625R	1x9+ 1Q	20	36	100	25	R
C246-206025R	1x16 + 1Q	20	60	123,5	25	R

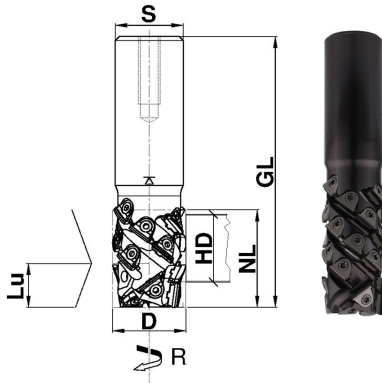


SPARE PARTS

Article no.		
KW.22331.7/B25	Replaceable DP cutters "Konstantin-Mini"	Circumference cutter (bottom) and Drill cutter (Speedy Z1+1 + Z2+2)
KW.16728.7/B02	Replaceable DP cutters "Konstantin-Mini-Speedy"	Circumference cutter (Speedy Z1+1)
C986-FT1810	Torque wrench for "Konstantin-Mini"	1,8 Nm, incl. Torx-Bit / T10
KW.15714.7	Spare clamping screw "Konstantin-Mini"	60° / M3x6 / T10



DP-Shank grooving cutter Konstantin®-Mini Speedy C247 Z2



The absolute top class when it comes to fine jointing operations on tear-out intensive panel materials. The Speedy geometry with 54° AWS enables a reliable prevention of tear-out on the top and bottom of panel materials. The Z2 variant is suitable for medium to fast feed ranges.

Design:

Body made of steel; with DP drilling cutting edge Z2 + 2; cutting elements equipped with DP (DIA); Joining end mill with interchangeable DP cutting edges; joining area with 54° axis angle; Drilling area (drilling cutting edge and lowest peripheral cutting edge); with standard axis angle; Different cutting edges in drilling and joining area; shank fit h6.

Application:

Fine jointing operations from 0.5 to 2.0 mm in melamine faced and veneered particleboard, MDF, multiplex and plywood, three-layer board, hardwood furniture boards as well as blockboards.

Range of use: speed range 18000-24000 rpm; feed range: 6-12 m/min.

Article no.	Z	D	NL	GL	S	LR
C247-273625R	2x9 + 2Q	27	36	100	25	R
C247-275325R	2x14 + 2Q	27	53	117	25	R



SPARE PARTS

Article no.		
KW.22331.7/B25	Replaceable DP cutters "Konstantin-Mini"	Circumference cutter (bottom) and Drill cutter (Speedy Z1+1 + Z2+2)
KW.23098.7/B02	Replaceable DP cutters "Konstantin-Mini"	Circumference cutter (Speedy Z2+2)
C986-FT1810	Torque wrench for "Konstantin-Mini"	1,8 Nm, incl. Torx-Bit / T10
KW.15714.7	Spare clamping screw "Konstantin-Mini"	60° / M3x6 / T10



The DP-Shank grooving cutter with many advantages:

- + DP cutting edges can be exchanged by the users themselves on site
- + Constant diameter cutter, no radius correction required after cutting edge changing
- + The risk of an error when calibrating the tool is eliminated
- + Only damaged or worn blades must be replaced
- + No additional spare tools need to be kept on hand
- + In the event of a light crash, the cutter is very quickly ready for use again
- + Due to the exchangeable cutting edges, it is generally possible to mill with a long useful length, because only blunted areas have to be exchanged
- + Easy handling due to torque wrench with fixed torque
- + The optimum cutting geometry can be offered for every milling situation (axis angle: Standard 10°, FinishCut 20°, Speedy 54°)

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