

# DP-Shank-Grooving-Cutter "Konstantin®-Mini-Finish"

C249

Cutting Material <b>DP</b>	Number of Teeth <b>Z2+2</b>	Feed <b>MEC</b>
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**Design:**

- Body in steel; with DP plunging cutters
- Two circumference cutters in 4 chip grooves; with axial angle
- Cutting elements fitted with DP (DIA)
- Shank grooving cutter with replaceable DP cutters
- Deep chip flutes for better chip capture
- Shank fit h6

**Application:**

- Grooving, jointing, rebating, sizing (cutting off)

**Workpiece Material:**

- Panel materials: especially melamine-coated and veneered particleboard, MDF, multiplex and plywoods

**Machine:**

- CNC machining centres

**Scope of Supply:**

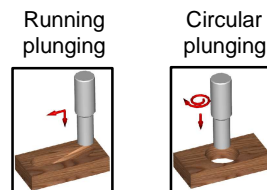
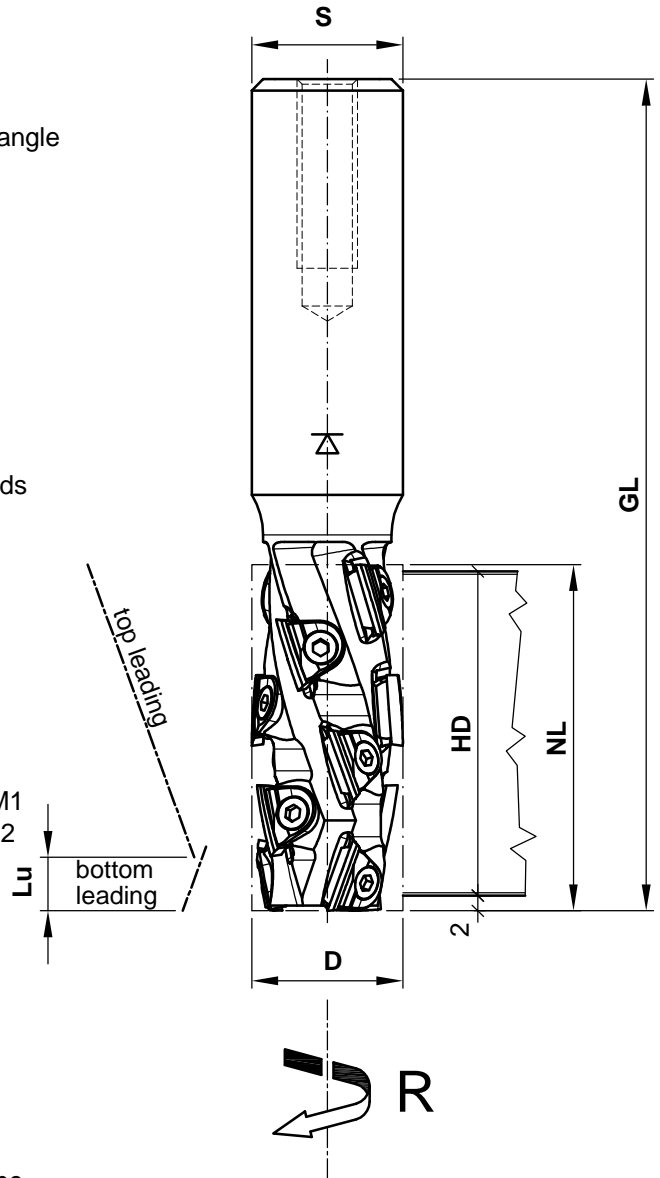
- Principally with a length adjustment screw  
With use in shrink chuck HSK-F 63 (C915) without a length adjusting screw
- Optionally also assembled (MS):  
Assembled in shrink chuck HSK-F 63 (C915): C249-...-M1  
Assembled in collet chuck HSK-F 63 (C910): C249-...-M2
- Tool body incl. DP knives
- Key with handle Torx T10

**Special Features:**

- Diameter-constant shank grooving cutter
- All knives replaceable on site
- Suitable for 5-axis machining centres that have no possibility for radius correction when "line milling"
- Suitable for different feed rates
- Very good chip removal
- for increased demands on the milling quality for melamine and HPL coated board materials
- for layer and ply materials with a tendency to tear out
- two different cutter types are mounted for best cutting quality

**Additional Information:**

- A torque wrench is recommended for the changing of the knives (see C986-FT1810)



**Aigner**  
WERKZEUGE

e-mail: office@aigner-werkzeuge.at  
www.aigner-werkzeuge.at

MS.....Machine Adaptor

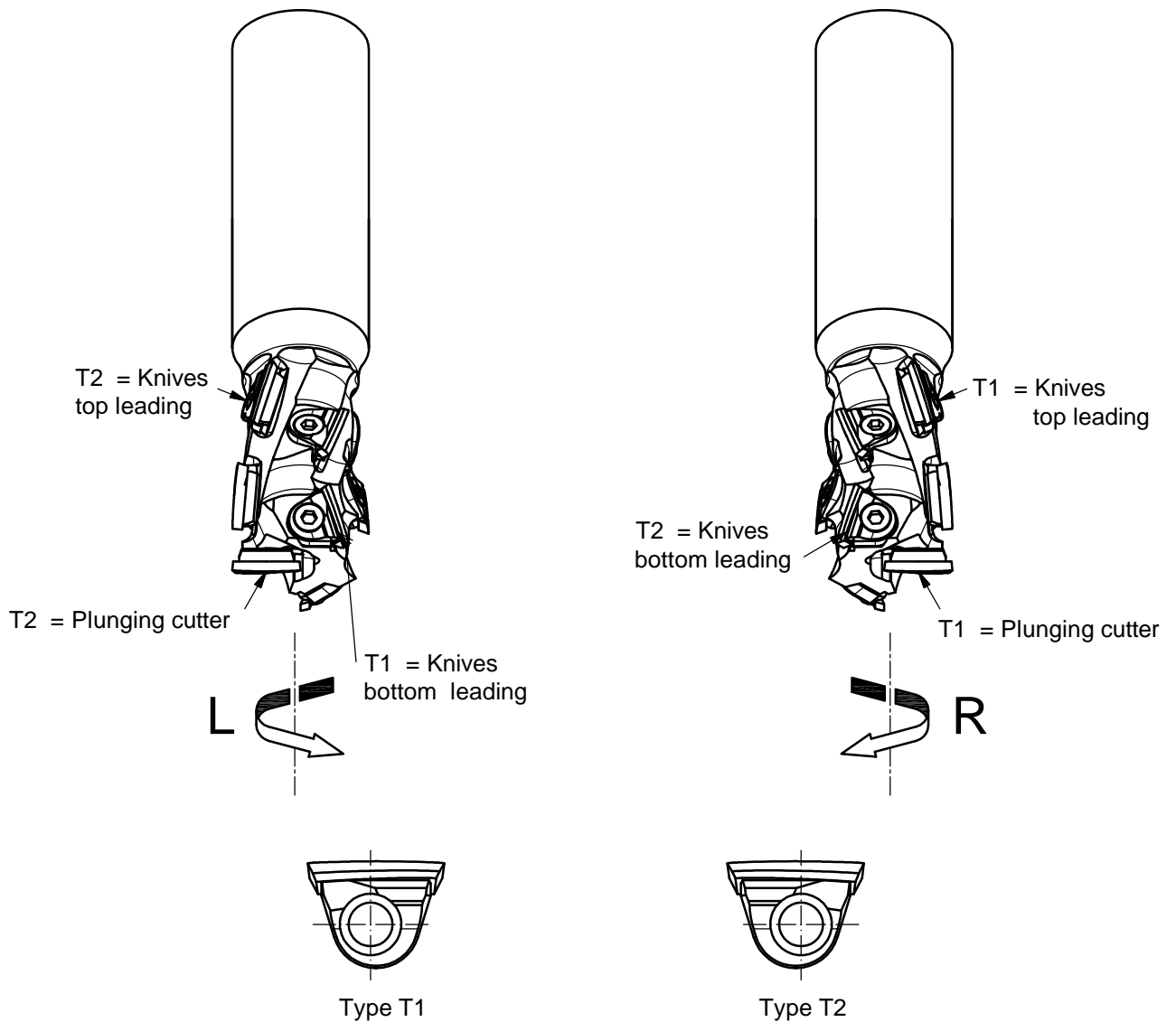
Z.....No. of Teeth

n max.....Maximum Rotational Speed (rpm)

Blattformat: **A4** All dimensions in mm


Zchnng.-Nr. KW.42490.4 | 00

**C249**



D	NL	GL	Lu	HD	S	Z	R/L	n max.	Ident-No.
20	31.2	95	7	28	20	2x4+1Q	R	24000	C249-2031220R
20	31.2	95	7	28	20	2x4+1Q	L	24000	C249-2031220L
20	31.2	95	7	28	25	2x4+1Q	R	24000	C249-2031225R
20	31.2	95	7	28	25	2x4+1Q	L	24000	C249-2031225L
20	45.8	110	7	43	20	2x6+1Q	R	24000	C249-2045820R
20	45.8	110	7	43	20	2x6+1Q	L	24000	C249-2045820L
20	45.8	110	7	43	25	2x6+1Q	R	24000	C249-2045825R
20	45.8	110	7	43	25	2x6+1Q	L	24000	C249-2045825L

Spare Parts				
Description	Qty.	Dimensions	MBM	Ident-No.
Replaceable knife-T1	1	10x8x2.5	2	KW.28188.7/B
Replaceable knife-T2	1	10x8x2.5	2	KW.28187.7/B
Clamping screw	1	Countersunk screw M3x6 T10	10	KW.15714.7

 <p>e-mail:office@aigner-werkzeuge.at www.aigner-werkzeuge.at</p>	MS.....Machine Adaptor	Blattformat: <b>A4</b> <small>All dimensions in mm</small>
		Zchnng.-Nr. KW.42490.4   00
		C249-1