



C.T.A

WOODWORKING TOOLS



CROWN TOOLING
SPECIALIST IN
WOODWORKING TOOLS



C.T.A SPECIALISTS IN WOODWORKING TOOLS

CROWN TOOLING has been designing and manufacturing disposable tipped tooling for the woodworking industry for over 20 years. During this time the company has built up a wealth of experience and knowledge to compete on world markets. Because of its close relationship with the woodworking industry, the company is able to supply exactly the right tool for the job. This provides the end user with a competitive edge, which is important in today's demanding environment.

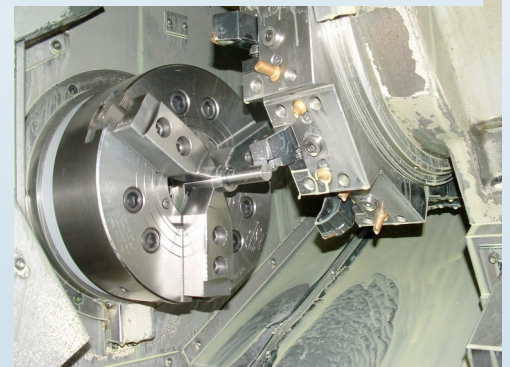
Based in Sydney, Australia, CROWN TOOLING supplies world class tooling to the local and overseas markets. The success of CROWN TOOLING is based on the philosophy of supplying a safe, high performance tool, at a competitive price, which meets the increasing demands of today's woodworking industry.

To achieve this objective, modern C.N.C. machine tools are used in all stages of production. Profile inserts are ground on a specially designed C.N.C. grinder, which ensures highly accurate and repeatable profiles.

IMPORTANT NOTICE

CROWN TOOLING has a policy of continual improvement. Consequently there may be minor differences between the parts shown in this catalogue and those supplied. Information supplied in this catalogue is given in good faith. Due to the fact that conditions of use are outside our control the purchaser and/or end user accepts that Crown Tooling shall not be held responsible for any subsequent damage or loss.

CONDITIONS OF SALE are shown at page 59 this catalogue.



TECHNICAL INFORMATION AND SAFETY INSTRUCTIONS. SEE PAGES 53-58.

Helpful information on these matters is available from CROWN TOOLING. Please contact your nearest distributor, Crown Tooling, or it can be downloaded from our website.
www.crowntooling.com.au

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C.T.A SPECIALISTS IN WOODWORKING TOOLS

SECTION I SPINDLE CUTTERS



SECTION II CUTTERS FOR MULTI HEAD MOULDING MACHINES



SECTION III C.N.C. ROUTER TOOLING



SECTION IV HAND. ROUTER TOOLING



SECTION V TECHNICAL INFORMATION



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SPINDLE CUTTERS

**Spindle Moulders
and
Multi-Head Moulding
Machines**



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SECTION I

Door Profile Sets

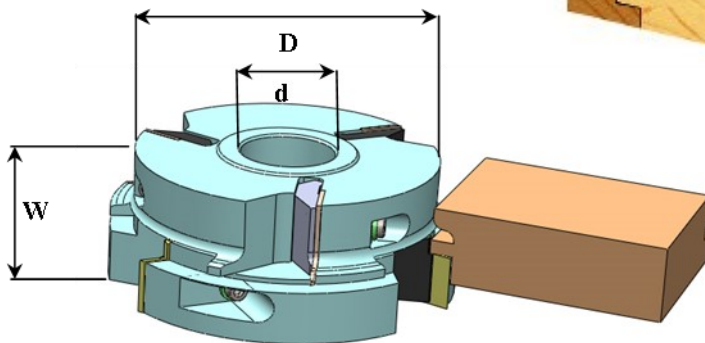
3 + 3



Application:

For production of kitchen and similar size doors in solid timber.
Material can vary in thickness from 16-30 mm depending on design of profile.
Cutters designed for use on spindle moulders and multi-head machines.

Recommended for mechanical feed



Technical Details:

2 Pieces construction allows very accurate setting of tongue and groove dimensions. Inserts are able to be re-sharpened thus reducing costs.
Wide range of standard profiles. Hi Strength Aluminum construction. Balanced design for smooth running.
Bores to H7 tolerance. Positive insert location.

CODE	D	d	W	Insert
SFDP-150 6030-1¼	150	1¼	60	30x30x2 OS
SFDP-150 6030-40	150	40	60	30X30X2 OS

Spare Parts

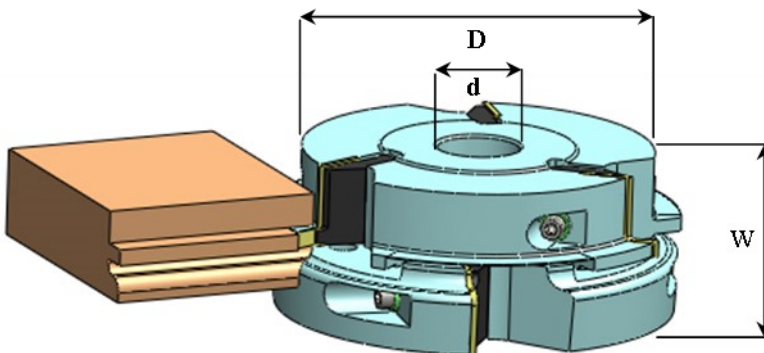
Clamp W-3030-0S-BS
Screw M6 x 26 SHCS
Key 5A/F-TEE
End Stop M4x9HD

Door Counter Profile Sets

3 + 3

Application:

Matching cutters for Door Profile Sets.
Suitable for doors in 16-30 material.
Suitable for Spindle Moulders and D.E.T. machines.
Recommended for mechanical feed



Technical Details:

2 Piece construction allows very accurate setting of tongue and groove dimensions. Inserts are able to be re-sharpened thus reducing costs.
Wide range of standard profiles. Hi Strength Aluminum construction. Balanced design for smooth running.
Bores to H7 tolerance. Positive insert location.

Sizes Available

CODE	D	d	W	Insert
SFDCP-150 6030-1¼	150	1¼	60	30x30x2 OS
SFDCP-150 6030-40	150	40	60	30x30x2 OS

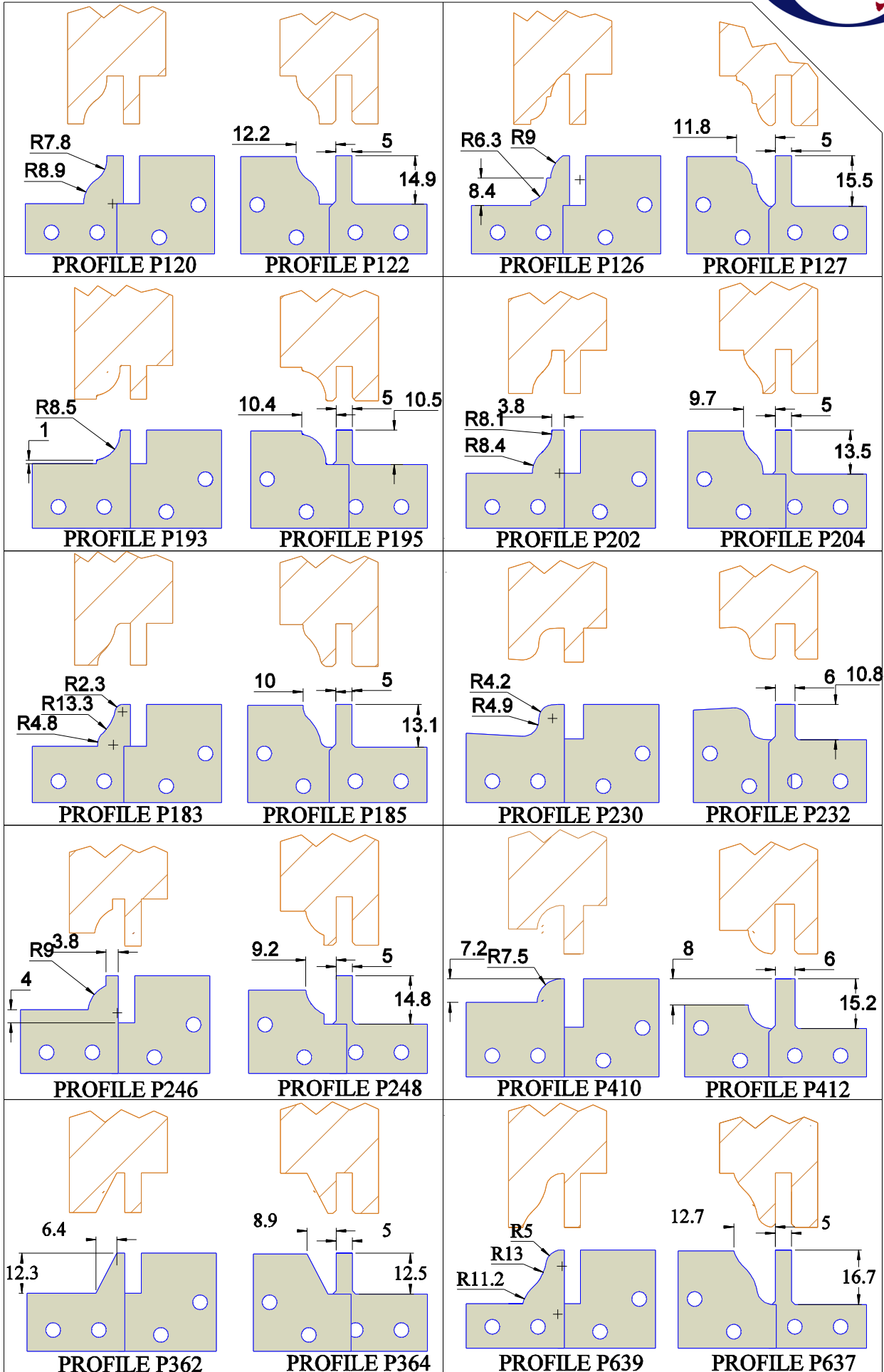
Spare Parts:

Clamp W-3030-0S BS
Clamp Screw M6 x 26 SHCS
Key 5A/F-TEE
Inserts 30x30x2 OS Profiled
End Stop M4x9HD

Standard Profiles Available



NB: SPECIAL PROFILES AVAILABLE UPON REQUEST



Raised Panel Cutters

3 Wing

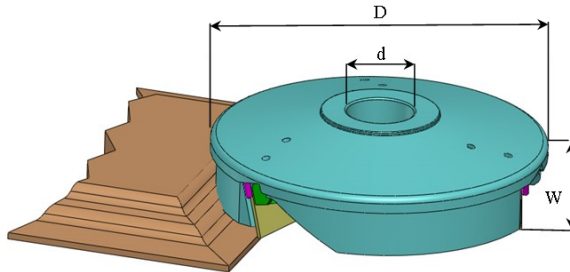


Application:

For production of raised profile panels on solid timber doors
 Used on spindle moulders or D.E.T machines.
 Can be mounted in pairs to give a raised profile on both sides of a panel. **Recommended for mechanical feed.**

Special Features

Large range of standard profiles.
 Available in left and right hand rotation.
 This allows production of double sided profile panels.
 Inserts are able to be re-sharpened thus reducing costs.
 Body supplied in high strength, heat treated aluminum .



Technical Details:

Aluminum construction.
 Balanced design for smooth running.
 Bores to H7 tolerance.
 Positive insert location.

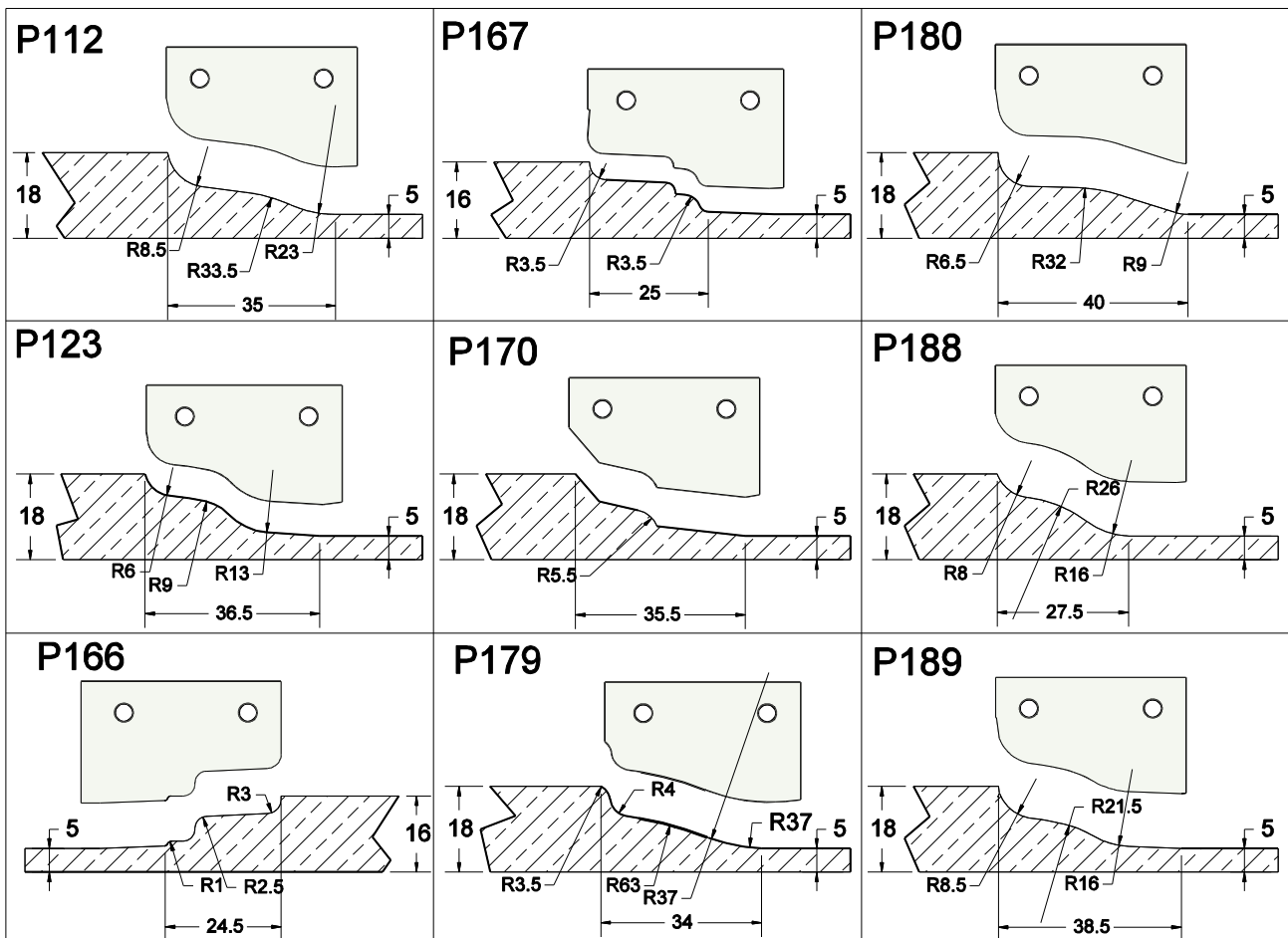
Add profile to end of insert size
 EG 40x25x2 P112
 Profile No P112

Sizes Available

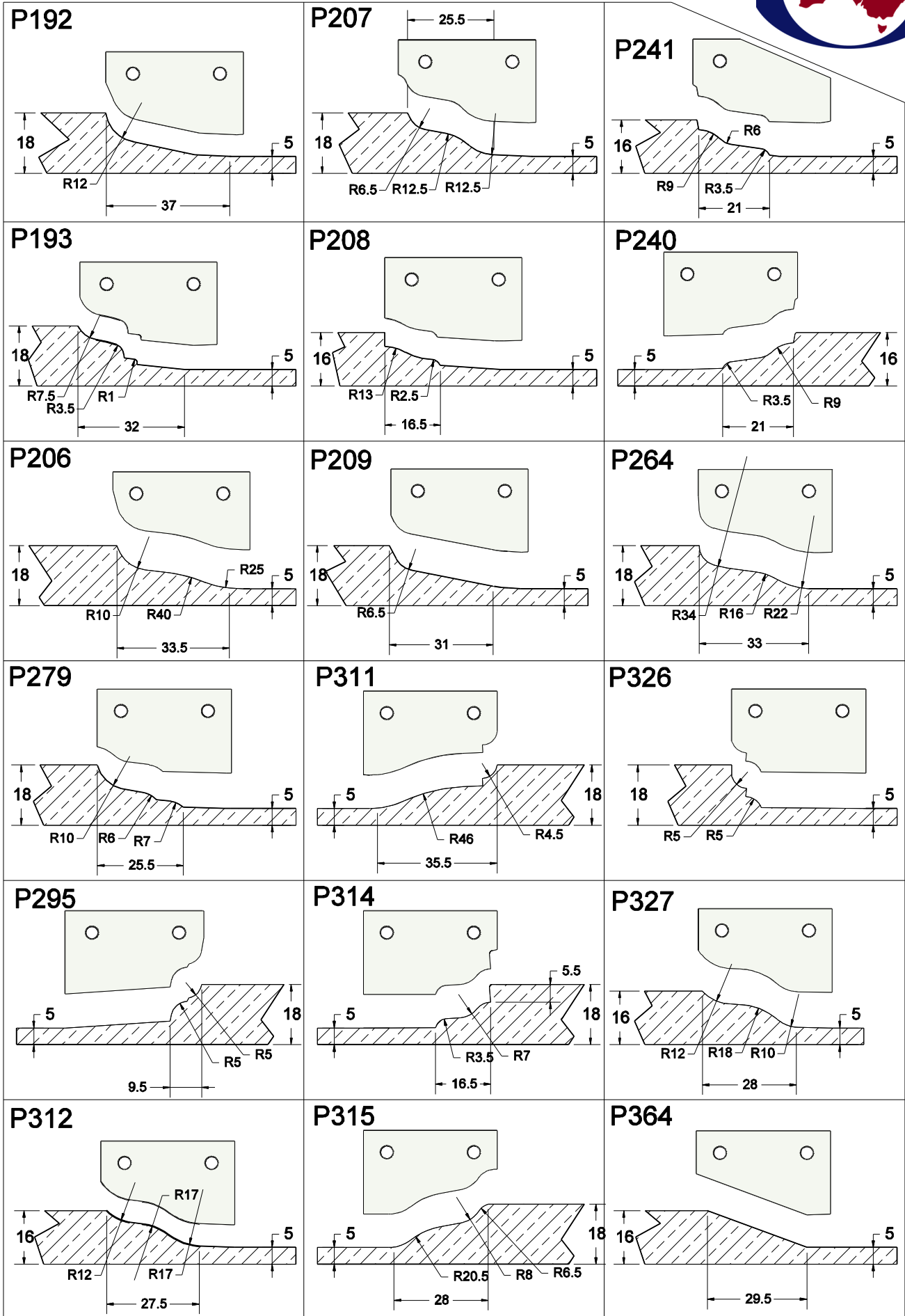
CODE	D	d	W	Insert
SRP-1504025-1¼	150	1¼	55	40x25x2 P...
SRP-1504025-40	150	40	55	40x25x2 P...
SRP-1804025-1¼	180	1¼	55	40x25x2 P...
SRP-1804025-40	180	40	55	40x25x2 P...

Spare Parts:

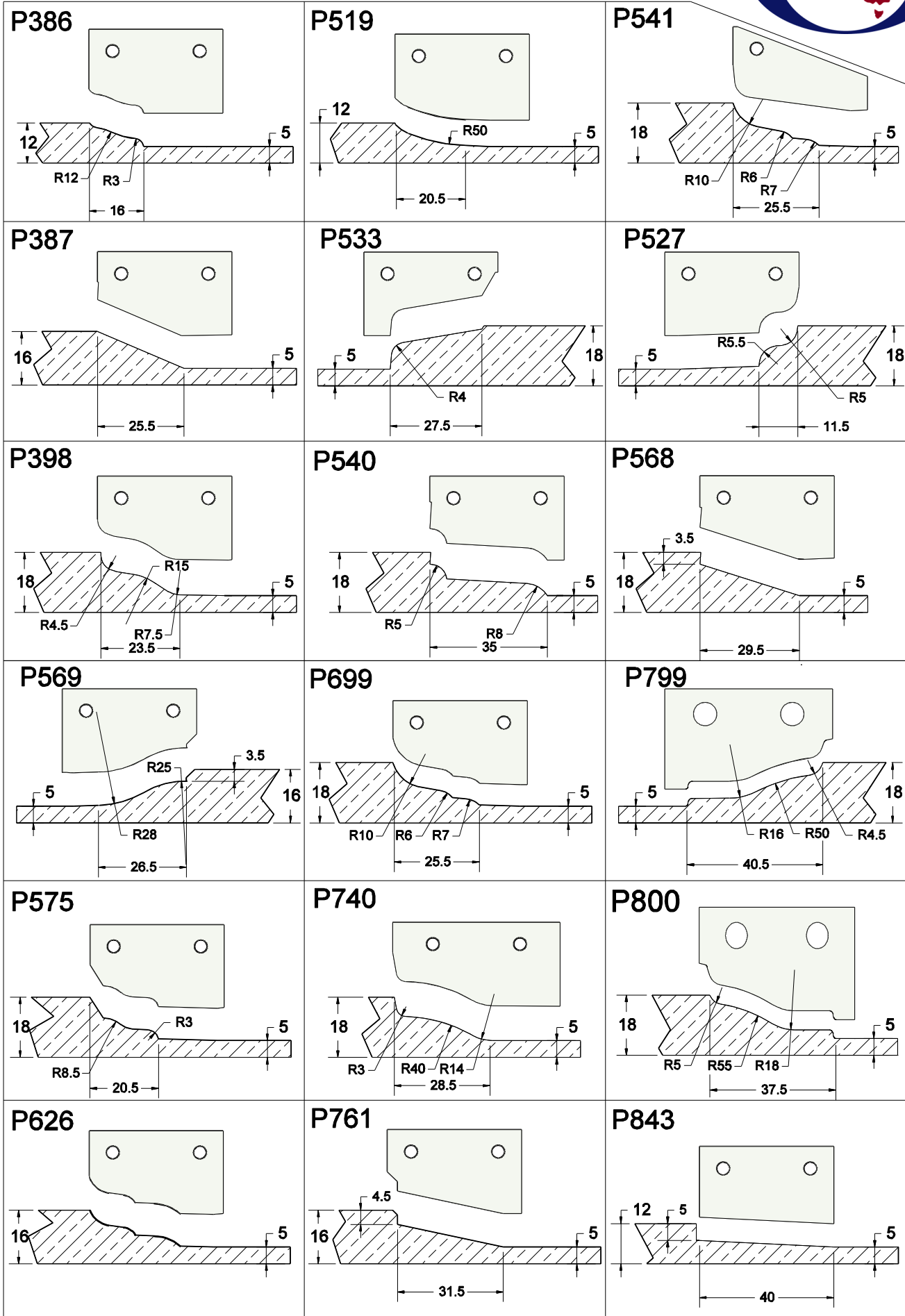
Inserts 40 x 25 x 2-Profiled
 Wedge WSPR-4020-T3
 Clamp Screw M6 x 16 x 9HD
 Key 4A/F
 Inserts 40x25x2 ...P. No



Raised Panel Profiles



Raised Panel Profiles



Entry Door Cutters

3 + 3 Wing



Application:

For production of solid timber doors both internal and external.
Used on spindle moulders or D.E.T machines.

Special Features

Large range of standard profiles.

Available in left and right hand rotation.

Body supplied in high strength steel to give long lasting tool body with many years of service.

Technical Details:

Steel construction.

Balanced design for smooth running.

Bores to H7 tolerance.

Positive accurate insert location.



Bullnose Profile



Ovolo Profile



Splay Profile



Lambs Tongue



Rail Cutter Set:

Tooling set consisting of Rebate and Profile cutters.

Profile cutters have backing plates and the ability

to interchange profiles in the one cutter set. **Recommended for mechanical feed.**

Wedge 20x30x2 WSEDP2030-BS

Wedge Screw M5 x 25SHCS

Wedge 20x12x1.5 WSEDP2012-BS

Key T15 FLAG

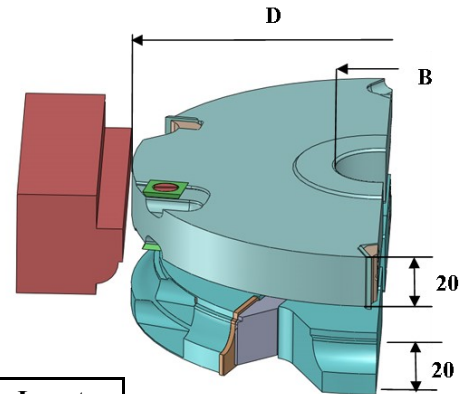
End Stop M4x9HD

Backing Plate BPSEDP2030-BS

Backing Plate Screw M4 x 7 HD

Scribe Screw SS-M5x12

Key 4A/F-TEE



Sizes Available

CODE	D	B	Width	Insert	Insert
SEDP-1802030-1/4 or 40	180	1/4 or 40	20	20x30x2 FT	14x14x2
SEDR-1802012-1/4 or 40	180	1/4 or 40	20	20x12x1.5	14x14x2

LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 1/4 OR 40.

Tenon Cutter Set:

Tooling set consisting of Rebate and Profile Cutters.

Profile cutters have backing plates and the ability to interchange profiles in the one cutter set.

Recommended for mechanical feed.

Spare Parts:

Wedge

WSEDP2030-BS

Backing Plate

BPSEDP2030-BS

Wedge Screw

M5 x 25SHCS

Backing Plate Screw

M4 x 7 HD

Wedge 20x12x1.5

WSEDP2012-BS

Scribe Screw

SS-M5x12

End Stop

M4x9HD

Key

T15 FLAG

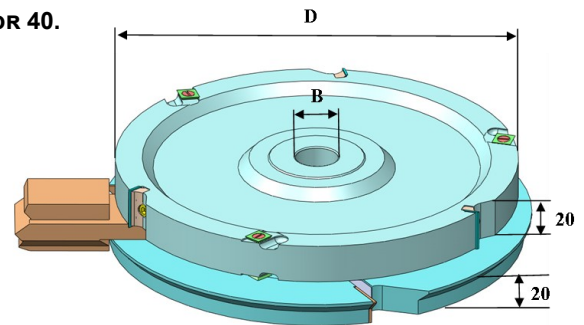
Key

4A/F-TEE

Sizes Available

CODE	D	B	Width	Insert	Insert
SEDP-3002030-1/4 or 40	300	1/4 or 40	20	20x30x2 FT	
SEDR-3002012-1/4 or 40	300	1/4 or 40	20	20x12x1.5	14x14x2

LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 1/4 OR 40.



Post Forming Cutters

3 Wing

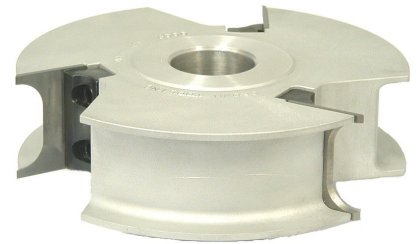


Application:

For producing a full bull nose on 32 mm to 33 mm boards prior to sanding and post forming operations. By adding additional rebate cutter a rebate for flush finish laminate can be achieved.

Special Features

One piece cutters allow simple operation with no adjustment necessary. ADJUSTABLE REBATE CUTTER Interlocks with Post Form cutters to allow rebate on board to allow flush fit of laminate. **Recommended for mechanical feed.**



Sizes Available

CODE	D	d	W	Radius	Insert
SPFF-150 4030-R4-1¼ or 40	150	1¼ or 40	40	4	40x35x2 FT-P1064
SPFF-150 4030-R6-1¼ or 40	150	1¼ or 40	40	6	40x35x2 FT-P1063
SPFF-150 4030-R8-1¼ or 40	150	1¼ or 40	40	8	40x35x2 FT-P1062
SPFF-150 4030-R10-1¼ or 40	150	1¼ or 40	40	10	40x35x2 FT-P1061
SPFF-150 4030-R16.5-1¼ or 40	150	1¼ or 40	40	16.5	40x35x2 FT-P186
ADJUSTABLE REBATE CUTTER					
SPFARC-15014-1¼ or 40	150	1¼ or 40	14		14x14x2

Technical Details:

High Tensile aluminum.
Balanced design for smooth running.
Positive insert location.
Bores to H7 tolerance.

Spare Parts:

Wedge WFFF4030-T2
Wedge Screw M6 x16x7HD
End Stop M4x9HD
Key 5A/F TEE
Rebate Cutter
Scribe Screw SS M5 x12

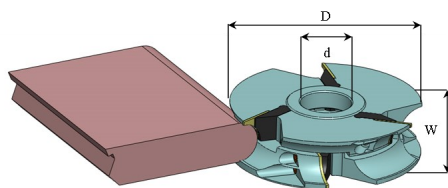
LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 1¼ OR 40

Post Forming Cutters

2 + 2 Wing

Application:

For producing a full bull nose on 32 mm to 33 mm boards prior to sanding and post forming operations. By adding additional rebate cutter a rebate for flush finish laminate can be achieved.



Special Features

SPF Cutters = Special two piece construction allows for variations in board thickness.

A third cutter can be added to produce a rebate on the lower face of the board, to allow flush finishing of the laminate. ADJUSTABLE REBATE CUTTER See Above **Recommended for mechanical feed.**

Sizes Available

CODE	D	d	W	Radius	Insert	WEDGE
SPF-1504030-R4-1¼ or 40	150	1¼ or 40	40	4	20x30x2 FT-P1448	WFPA-R4-BS
SPF-1504030-R6-1¼ or 40	150	1¼ or 40	40	6	20x30x2 FT-P1756	WFPA-R6-BS
SPF-1504030-R8-1¼ or 40	150	1¼ or 40	40	8	20x30x2 FT-P1758	WFPA-R8-BS
SPF-1504030-R10-1¼ or 40	150	1¼ or 40	40	10	20x30x2 FT-P1076	WFPA-R10-BS
SPF-1504030-R16.5-1¼ or 40	150	1¼ or 40	40	16.5	20x30x2 FT-P585	WFPA-R16.5-BS
REBATE CUTTER						
SPFFRC-15014-1¼ or 40	150	1¼ or 40	14		14x14x2	

Technical Details:

All steel construction.
Anti-rust finish on all parts.
Balanced design for smooth running.
Positive insert location Bores to H7 tolerance.

Spare Parts:

Screw M6 x25 SHCS
Key 5A/F-TEE
End Stop Screw M4 x 9HD
Rebate Cutter
Scribe Screw SS M5 x12
Lock Screw M6 x 12 SHGS
STATE L/H OR R/H
WHEN ORDERING WEDGES.
Inserts Must Be Ordered As a Set.

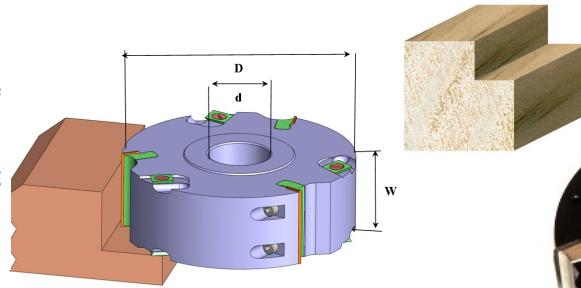
LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 1¼ OR 40.

Jointing & Rebating Cutters. 3 + 3 Wing



Application:

Allows jointing and or rebating operations to be carried out on spindle moulders or multi head machines. Both sides of head have seats for scribes, allowing LH & RH operation, producing sharp clean cuts. Recommended for mechanical feed.



Technical Details:

All steel construction. Anti-rust finish on all parts. Balanced design for smooth running. Bores to H7 tolerance. Positive insert location.

Sizes Available

CODE	D	d	W	Insert Size	Insert Size
SJR-1253012-1¼	125	1¼	30	30 x 12 x 1.5	14 x 14 x 2
SJR-1254012-1¼	125	1¼	40	40 x 12 x 1.5	14 x 14 x 2
SJR-1255012-1¼	125	1¼	50	50 x 12 x 1.5	14 x 14 x 2
SJR-1253012-40	125	40	30	30 x 12 x 1.5	14 x 14 x 2
SJR-1254012-40	125	40	40	40 x 12 x 1.5	14 x 14 x 2
SJR-1255012-40	125	40	50	50 x 12 x 1.5	14 x 14 x 2
SJR-1503012-1¼	150	1¼	30	30 x 12 x 1.5	14 x 14 x 2
SJR-1504012-1¼	150	1¼	40	40 x 12 x 1.5	14 x 14 x 2
SJR-1505012-1¼	150	1¼	50	50 x 12 x 1.5	14 x 14 x 2
SJR-1503012-40	150	40	30	30 x 12 x 1.5	14 x 14 x 2
SJR-1504012-40	150	40	40	40 x 12 x 1.5	14 x 14 x 2
SJR-1505012-40	150	40	50	50 x 12 x 1.5	14 x 14 x 2
SJR-1804012-SHR-1¼	180	1¼	40	40 x 12 x 1.5	14 x 14 x 2
SJR-1804012-SHR-40	180	40	40	40 x 12 x 1.5	14 x 14 x 2

Spare Parts:

Scribes 14 x 14 x 2 Scribe
 Insert screw M6 x 20 DPGS
 Wedge 30 x 12 W3012BS-T3
 Wedge 40 x 12 W4012BS-T3
 Wedge 50 x 12 W5012BS-T3
 Scribe Screw SS-M5-12
 Key 3A/F-TEE

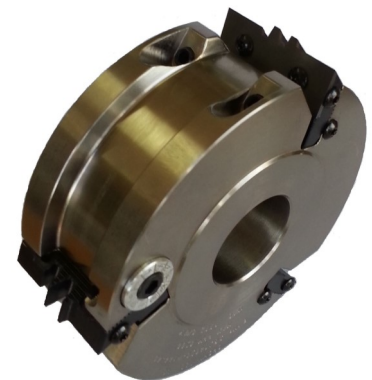
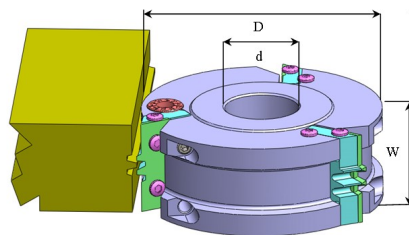
Glue Joint Cutters 3 Wing

Application:

For cutting of edge glue joints when joining solid timber boards. Wood thickness from 16mm to 60mm. Particularly suitable for "brittle" timbers where glue butt joints may not be strong enough. Recommended for mechanical feed.

Technical Details:

All aluminum construction. Anti-rust finish on all parts. Balanced design for smooth running. Bores to H7 tolerance. Positive insert location.



Sizes Available

CODE.	D	d	W	Teeth	Insert
SGJ-140 5025-2T-1¼ or 40	140	1¼ or 40	50	2	50 x 25 x 2 P144
SGJ-150 5025-3T-1¼ or 40	150	1¼ or 40	50	3	50 x 25 x 2 P1772
SGJ-150 6025-4T-1¼ or 40	150	1¼ or 40	60	4	60 x 25 x 2 P1773

Spare Parts:

Wedge WSGJ 5025-TS-T3
 Clamp Screw M6 x 20
 End Stop M4x9HD
 Key 5A/F TEE
 Adjust Screw M6 x 16 GJS

LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 1¼ OR 40.

Special Features

Tongue and groove profile ensures positive location of boards. Micro adjustment of profile inserts allows tight, standard or loose fit as required. Precision ground profile knives ensure consistent profile accuracy.

Adjustable Grooving Cutters. 3 + 3 Wing



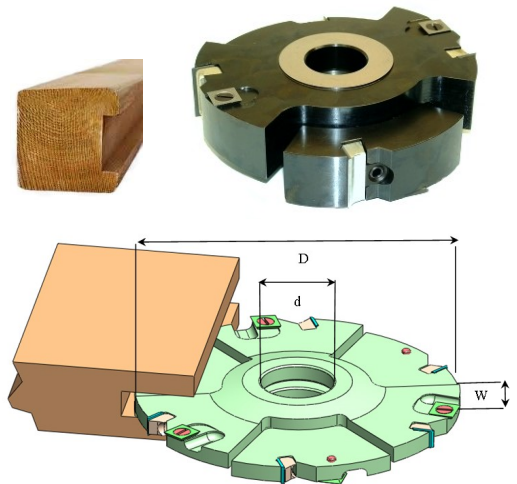
Application:

A two piece cutter which allows various widths to be obtained by use of spacers and shims. Can be used for **grooving and trenching operations** as well as **jointing and rebating**.

Both sides of head have seats for scribes, allowing LH & RH operation as required, producing sharp clean edges. **Recommended for mechanical feed**

Sizes Available

CODE	D	d	W	Insert size	Insert size
SAG-1501020-1¼	150	1¼	10 - 20	9 x 12 x 1.5	14x14x2
SAG-1501428-1¼	150	1¼	14 - 28	12 x 12 x 1.5	14x14x2
SAG-1502244-1¼	150	1¼	22 - 44	20 x 12 x 1.5	14x14x2
SAG-1503264-1¼	150	1¼	32 - 64	30 x 12 x 1.5	14x14x2
SAG-1501020-40	150	40	10 - 20	9 x 12 x 1.5	14x14x2
SAG-1501428-40	150	40	14 - 28	12 x 12 x 1.5	14x14x2
SAG-1502244-40	150	40	22 - 44	20 x 12 x 1.5	14x14x2
SAG-1503264-40	150	40	32 - 64	30 x 12 x 1.5	14x14x2
SAG-15050100-40	150	40	50-100	50 x 12 x 1.5	14x14x2
SAG-1801020-1¼	180	1¼	10 - 20	9 x 12 x 1.5	14x14x2
SAG-1801428-1¼	180	1¼	14 - 28	12 x 12 x 1.5	14x14x2
SAG-1802244-1¼	180	1¼	22 - 44	20 x 12 x 1.5	14x14x2
SAG-1803264-1¼	180	1¼	32 - 64	30 x 12 x 1.5	14x14x2
SAG-1801020-40	180	40	10 - 20	9 x 12 x 1.5	14x14x2
SAG-1801428-40	180	40	14 - 28	12 x 12 x 1.5	14x14x2
SAG-1802244-40	180	40	22 - 44	20 x 12 x 1.5	14x14x2
SAG-1803264-40	180	40	32 - 64	30 x 12 x 1.5	14x14x2
SAG-18050100-40	180	40	50 - 100	50 x 12 x 1.5	14x14x2



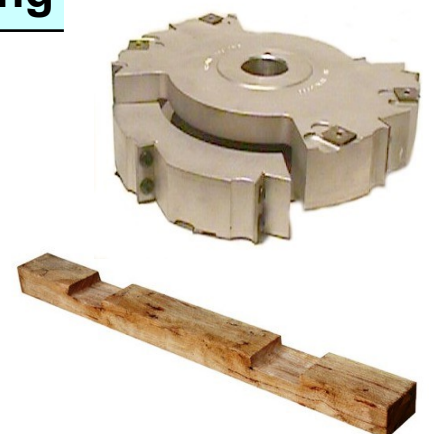
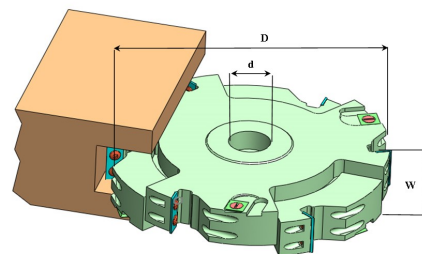
Spare Parts:

Wedge	09 mm = W0912-TS-T3 10 mm = W1012-TS-T3 12 mm = W1212-TS-T3 20 mm = W2012-TS-T3 30 mm = W3012-TS-T3 50 mm = W5012-TS-T3
Scribes	14 x 14 x 2 Scribe
Scribe Screw	SS-M5-06 up to 10mm thick
Scribe Screw	SS-M5-09 up to 12mm thick
Scribe Screw	SS-M5-12 over 12mm thick
Screws	M5 x 16 TH. M6 x 16 TH.
Key	4A/F-TEE
Key	5A/F-TEE

Adjustable Trenching Heads 3 + 3 Wing

Application:

Specifically designed for trenching operations, on house frame top and bottom plates, using suitable docking saws. Also can be used on general trenching and grooving operations on all types of spindle moulders.



A wide range of bushes are available to suite all types of trenching and docking machines .
ALL TOOLS COME WITH BUSHES

A

Sizes Available

CODE	D	d	W	Insert size	Insert size
SATH-200-2240-30	200	30	22-40	20 x 12 x 1.5	14x14x2
SATH-200-3260-30	200	30	32-60	30 x 12 x 1.5	14x14x2
SATH-250-2240-30	250	30	22-40	20 x 12 x 1.5	14x14x2
SATH-250-3260-30	250	30	32-60	30 x 12 x 1.5	14x14x2

Spare Parts:

Wedge	W2012-TS-T3 W3012-TS-T3
Screw	M5 x 12 -TH M6 x 16 -TH
Scribe	14 x 14 x 2 Scribe
Scribe Screw	SS-M5-12
Key	4AF-TEE 5AF-TEE

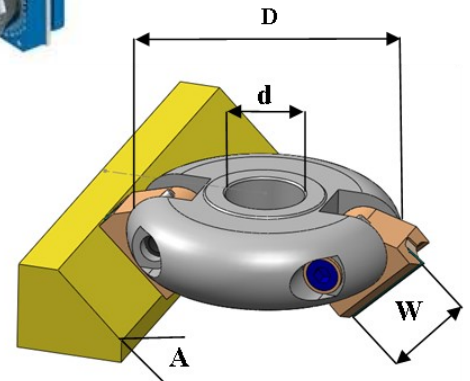
Adjustable Chamfer Cutters

2 Wing



Application:

For the production of various angled timber, MDF and chipboard moldings up to 50 mm profile width.
 Angle adjustable from Minus 30 degrees from horizontal to plus 30 degrees horizontal.
 Total 120 degrees movement.
 50 mm wide or 60 mm wide cut.
 Precision turnover knife for high quality finish with long life and quick changeover.
Recommended for mechanical feed.



Sizes Available:

Code	D	W	A	d
SAAC 15050- 1¼	150	50	+ - 60 deg	1¼
SAAC 15050-40	150	50	+ - 60 deg	40mm
SAAC 15060-1¼	150	60	+ - 60 deg	1¼
SAAC 15060-40	150	60	+ - 60 deg	40mm

Spare Parts:

- Inserts. 50 x 12 x 1.5
60 x 12 x 1.5
- Wedge W5012-TS-T3
W6012-TS-T3
- Screw M8 X 20 LHSC
M6 X 10 DPGS
- Key 5ALEEN KEY
3 ALLEN KEY

U' Profile Cutters

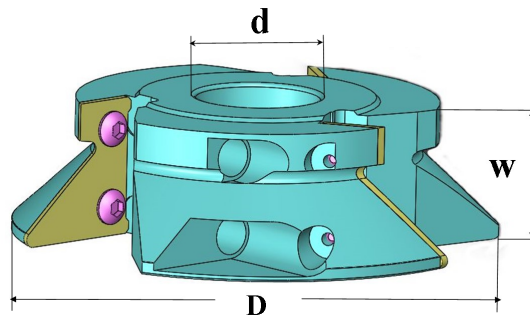
3 Wing

Application:

A low cost cutter for low to medium volume production of 'U' and 'L' shape profiles on panels, timber products and other materials.
 Used on Spindle Moulders, D.E.T and 4-6 head machines.
 The cutter comes as a fully machined body ready for profiling to your particular profile.
 The cutter is fitted with 3 blank inserts.
 Additional inserts can be supplied.
Recommended for mechanical feed.

Technical Details:

All Aluminum construction.
 Balanced design for smooth running.
 Bores to H7 tolerance.



Sizes Available

Code	D	W	w	d	Insert
SUP130 2030- 1¼" or 40	130	20	20	1¼" or 40mm	20 x 30 x 2 FT
SUP130 2535- 1¼" or 40	130	25	25	1¼" or 40mm	25 x 35 x 2 FT
SUP130 3535- 1¼" or 40	130	35	35	1¼" or 40mm	35 x 35 x 2 FT
SUP130 4035- 1¼" or 40	130	40	40	1¼" or 40mm	40 x 35 x 2 FT
SUP130 5035- 1¼" or 40	130	50	50	1¼" or 40mm	50 x 35 x 2 FT

Spare Parts :

- Screw. M4 x 9HD
- End Stop M4x9HD
- Key. T15—SD

LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 1¼ inch OR 40MM.

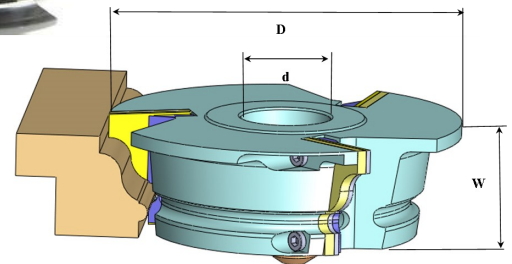
Multi Profile Cutters

3 Wing



Application:

For the production of various mouldings in long length TIMBER, MDF and CHIPBOARD moldings up to 80 mm profile width. 30 mm deep cut.
 Precision carbide inserts for high quality finish with long life and quick changeover.
 Interchangeable backing plates accommodate various profiles for efficient cutter use.
Recommended for mechanical feed.



Sizes Available

Code	D	W	Bore	Backing Plate	Insert
SMPC 1605040-LH-40 or 1¼	160	50	40 or 1¼	SMPC-BP-50	50x40x2 FT
SMPC 1605040-RH-40 or 1¼	160	50	40 or 1¼	SMPC-BP-50	50x40x2 FT
SMPC 1605040-40 or 1¼	160	50	40 or 1¼	SMPC-BP-50	50x40x2 FT
SMPC 1606040-LH-40 or 1¼	160	60	40 or 1¼	SMPC-BP-60	60x40x2 FT
SMPC 1606040-RH-40 or 1¼	160	60	40 or 1¼	SMPC-BP-60	60x40x2 FT
SMPC 1606040-40 or 1¼	160	60	40 or 1¼	SMPC-BP-60	60x40x2 FT

Spare Parts :

- Wedge WMPC-BS-40
- WMPC-BS-50
- WMPC-BS-60
- Screw M5 x 25 SHCS
- End Stop M4x9HD
- Key 4AF TEE

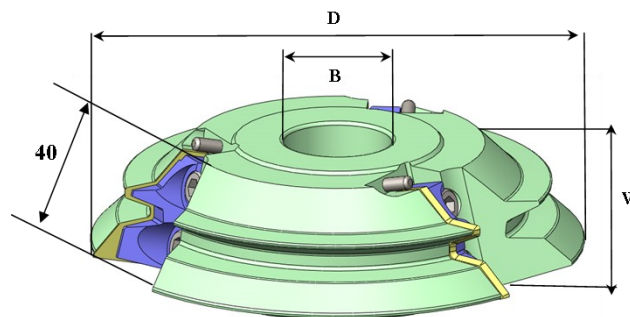
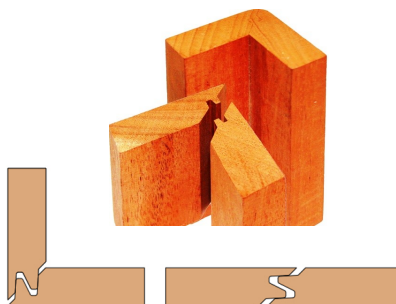
LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 40 OR 1¼.

Lock Mitre Cutters

3 Wing

Application:

For the production of Miter lock joints in SOLID TIMBER, MDF and CHIPBOARD. Tool will cut either a 90 degree miter lock joint or will cut a strong straight flush joint .
 150mm cutter will cut 30mm timber. 160mm cutter will cut 40mm timber.
 Precision turnover knife for high quality finish with long life and quick changeover.
Recommended for mechanical feed only.



Sizes Available

Code	D	W	Bore	Insert	Max Width Of Timber
SMLC 1503530-1¼ OR 40	150	40	1¼ OR 40MM	35 x 30 x 2 LM	18-30mm
SMLC 1605040-1¼ OR 40	160	55	1¼ OR 40MM	50 x 40 x 2 LM	22-35mm
SMLC 1706040-1¼ OR 40	170	65	1¼ OR 40MM	60 x 40 x 2 LM	25-40mm

Spare Parts :

- Wedge: WMLC-150-TS-T3
- WMLC-160-TS-T3
- WMLC-170-TS-T3
- Screw: M6x16 TH
- Key: 5AF TEE

45 Degree Cutters

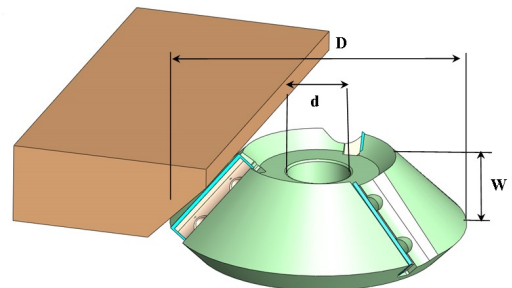
3 Wing



Application:

For the production of various 45 degree angled timber, MDF and chipboard moldings up to 50 mm profile width and 60 mm wide cut depending on tool. Precision turnover knife for high quality finish with long life and quick change over.

Recommended for mechanical feed.



Sizes Available

Code	D	W	A	d	Insert
S45C 1505012- 1¼	150	50	45 deg	1¼	50x12x1.5
S45C 1505012-40	150	50	45 deg	40mm	50x12x1.5
S45C 1506012- 1¼	150	60	45 deg	1¼	60x12x1.5
S45C 1506012-40	150	60	45 deg	40mm	60x12x1.5

Spare Parts :-

- Wedge W5012-TS-T3
- Wedge W6012-TS-T3
- Screw M6 X 16 TH
- Key 5AF-TEE

Hand Rail Cutters

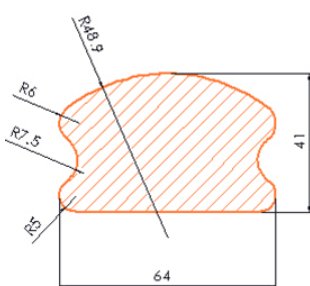
3 Wing

Application:

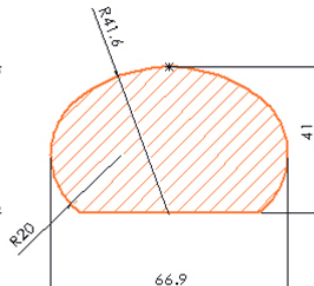
A precision cutter for the production of timber handrails for use on all spindle moulder and 4 or 6 head machines.

Various profiles available for mechanical feed only.

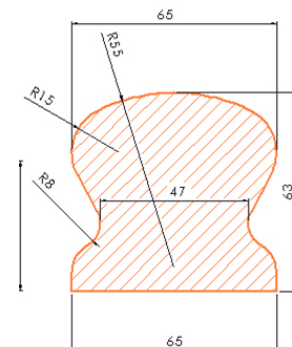
Recommended for mechanical feed.



PROFILE 1746



PROFILE 1757



PROFILE P1756

Technical Details:

Aluminum construction. Balanced design for smooth running. Bores to H7 tolerance. Positive accurate insert location.

Code	D	H	d	Profile	Insert
SHRC18080-1¼ P1756	180	80	1¼	Profile P1756	80x40x2
SHRC18080-40 P1756	180	80	40	Profile P1756	80x40x2
SHRC17060-1¼ P1757	170	60	1¼	Profile P1757	60x35x2
SHRC17060-40 P1757	170	60	40	Profile P1757	60x35x2
SHRC17060-1¼ P1746	170	60	1¼	Profile P1746	60x40x2
SHRC17060-40 P1746	170	60	40	Profile P1746	60x40x2

Spare Parts :-

- Wedge WHRC 8040-TS-T3-P1756
- Wedge WHRC 6035-TS T3-P1757
- Wedge WHRC 6035-TS-T3-P1746
- SCREW M6 x 16 TH

FLANGED WASHERS

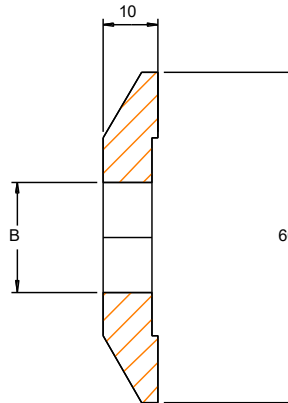


Crown Tooling supplies an extensive range of Bushes, Washers, Flanged Washers, Headed Bushes and Spacers. All bores and diameters are precision machined to accommodate all precision shafts and bores on woodworking tooling.

Flanged Washers

Sizes Available

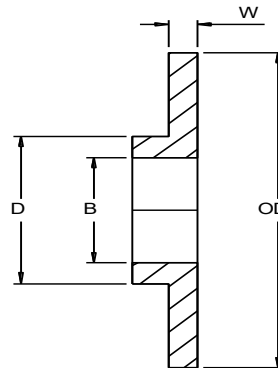
CODE	D	B	L
FW6010-19.05	60	19.05	10
FW6010-20	60	20	10
FW6010-22.22	60	22.22	10
FW6010-25	60	25	10
FW6010-25.4	60	25.4	10
FW6010-30	60	30	10
FW6010-31.75	60	31.75	10



Headed Bushes

Sizes Available

CODE	OD	B	D	W
HB6040-19.05	60	19.05	40	3
HB6040-20	60	20	40	3
HB6040-22.22	60	22.22	40	3
HB6040-25	60	25	40	3
HB6040-25.4	60	25.4	40	3
HB6040-30	60	30	40	3
HB6040-31.75	60	31.75	40	3



Bushes

Sizes Available

CODE	OD	B	W
BSH 4019-WIDTH	40	19.05	
BSH 4020-WIDTH	40	20	40
BSH 4022.22-WIDTH	40	22.22	40
BSH 4025-WIDTH	40	25	40
BSH 4025.4-WIDTH	40	25.4	40
BSH 4030-WIDTH	40	30	40
BSH 4031.75-WIDTH	40	31.75	40

Bushes come in widths of 10,15,20,25,30,and 40 mm.

Spacers

Sizes Available

CODE	OD	B	THICK
SPCR6020-THICKNESS	60	20	1-10 mm
SPCR6022-THICKNESS	60	22	1-10 mm
SPCR6025-THICKNESS	60	25	1-10 mm
SPCR6025.4-THICKNESS	60	25.4	1-10 mm
SPCR6030-THICKNESS	60	30	1-10 mm
SPCR6031.75-THICKNESS	60	31.75	1-10 mm
SPCR6040-THICKNESS	60	40	1-10 mm

Spacers come in widths of 1,1.5,2,3,4,5 and 10 mm.



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SECTION II

Heli-Cutter Finish

6 x Spiral Wing



Application:

This style is used where a better finish is required. Suitable for most applications. Can also be used on '4 sided' and copying machines. Wear on the inserts can be quickly remedied by rotation of the insert. Due to the spread of load over a large number of inserts a smooth cutting action is achieved, resulting in lower loads on the machine. This in turn gives longer machine and tool life.

Available in 40 and 50 bore

Code	Dia.	Bore.	Length	Insert
SHPF 125100-40 or 50	125	40 or 50	100	15x15x2.5 R150
SHPF 125150-40 or 50	125	40 or 50	150	15x15x2.5 R150
SHPF 125180-40 or 50	125	40 or 50	180	15x15x2.5 R150
SHPF 125200-40 or 50	125	40 or 50	200	15x15x2.5 R150
SHPF 125230-40 or 50	125	40 or 50	230	15x15x2.5 R150
SHPF 125310-40 or 50	125	40 or 50	310	15x15x2.5 R150
SHPF 150100-40 or 50	150	40 or 50	100	15x15x2.5 R150
SHPF 150150-40 or 50	150	40 or 50	150	15x15x2.5 R150
SHPF 150180-40 or 50	150	40 or 50	180	15x15x2.5 R150
SHPF 150200-40 or 50	150	40 or 50	200	15x15x2.5 R150
SHPF 150230-40 or 50	150	40 or 50	230	15x15x2.5 R150
SHPF 150310-40 or 50	150	40 or 50	310	15x15x2.5 R150



Spare Parts

Inserts 15x15x 2.5 R150
 Insert Screw RSS-M6-16
 Key T15 SD

LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 40 OR

Heli-Cutter HD (Heavy Duty) 6 x Spiral Wing

Application:

This style is used where a maximum material removal is required. Suitable for most applications in hardwood and softwood. Can also be used on '4 sided' and copying machines. Wear on the inserts can be quickly remedied by rotation of the insert. Due to the spread of load over a large number of inserts a smooth cutting action is achieved, resulting in lower loads on the machine. This in turn gives longer machine and tool life.



Available in 40 and 50 bore

Code	Dia.	Bore.	Length	Insert
SHPHD 125100-40 or 50	125	40 or 50	100	30x12x1.5 BE
SHPHD 125150-40 or 50	125	40 or 50	150	30x12x1.5 BE
SHPHD 125180-40 or 50	125	40 or 50	180	30x12x1.5 BE
SHPHD 125200-40 or 50	125	40 or 50	200	30x12x1.5 BE
SHPHD 125230-40 or 50	125	40 or 50	230	30x12x1.5 BE
SHPHD 125310-40 or 50	125	40 or 50	310	30x12x1.5 BE
SHPHD 150100-40 or 50	150	40 or 50	100	30x12x1.5 BE
SHPHD 150150-40 or 50	150	40 or 50	150	30x12x1.5 BE
SHPHD 150180-40 or 50	150	40 or 50	180	30x12x1.5 BE
SHPHD 150200-40 or 50	150	40 or 50	200	30x12x1.5 BE
SHPHD 150230-40 or 50	150	40 or 50	230	30x12x1.5 BE
SHPHD 150310-40 or 50	150	40 or 50	310	30x12x1.5 BE

Spare Parts

Screw 5/16 x 18 DE
 Clamp WC-5/16 DE
 Wedge WHPHD-3012-T3
 Allen Key 3/16 AF

LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 40 OR 50.

Spiral Thicknesser Heads

4 - 6 Wing



Application:

Planer and Thicknesser Spiral Planer heads used for all types of timbers on all types of machines. The multiple carbide inserts greatly reduces cutting resistance and requires less horse power to remove material.

Capable of cutting knotty wood, stringy wood and hard wood. If one insert edge is dull or damaged, rotate it to another edge. Replace only the inserts when all four edges are dull or damaged.

These features greatly reduces down time.

The spiral cutter heads produce smaller chips, enhance chip extraction and much less noise.

TOOL TAKES 15 x 15 x 2.5 RAD 150 Screw RSS-M6-16



PRICE ON REQUEST
CONTACT C.T.A

Crown Tooling Manufacturers all Spiral Thicknesser to order

Centriclump Planer Heads

4 Wing

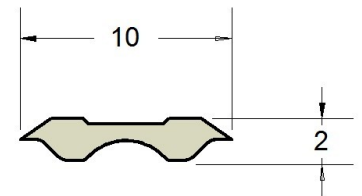
Application:

Centriclump Planer heads are used where a perfect finish is required. Suitable for most moulder and thicknesser applications.

Can also be used on '4 sided' and copying machines.

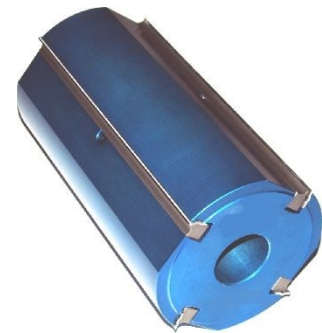
Wear on the Carbide inserts can be quickly remedied by rotation of the insert.

Due to the extremely high edge quality an extremely good surface finish is achieved.



Sizes Available

Code	Dia.	Bore.	Length	Insert
SCCP 125100-40	125	40	100	SCC 10x2.3x100
SCCP 125150-40	125	40	150	SCC 10x2.3x150
SCCP 125180-40	125	40	180	SCC 10x2.3x180
SCCP 125200-40	125	40	200	SCC 10x2.3x200
SCCP 125230-40	125	40	230	SCC 10x2.3x230
SCCP 125310-40	125	40	310	SCC 10x2.3x310



T.O.K Carbide Planer Heads

Application:

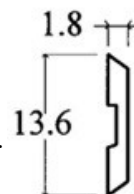
Aluminum Planer Heads are used where a perfect finish is required and long life due to carbide inserts.

Suitable for most moulder and thicknesser applications.

Can also be used on '4 sided' and copying machines.

Wear on the Carbide inserts can be quickly remedied by rotation of the insert.

Carbide inserts are 2 edged producing good surface finish with long life.



Sizes Available

Code	Dia.	Bore.	Length	Insert
SAPH 125100-40 or 50	125	40 or 50	100	BDZ 100x14x2.55
SAPH 125150-40 or 50	125	40 or 50	150	BDZ 150x14x2.55
SAPH 125180-40 or 50	125	40 or 50	180	BDZ 180x14x2.55
SAPH 125200-40 or 50	125	40 or 50	200	BDZ 200x14x2.55
SAPH 125240-40 or 50	125	40 or 50	240	BDZ 240x14x2.55
SAPH 125260-40 or 50	125	40 or 50	260	BDZ 260x14x2.55

Spare Parts

Wedge	WAPH-100-TS WAPH-150-TS WAPH-180-TS WAPH-200-TS WAPH-240-TS WAPH-260-TS
Insert Screw	M6x16 TH
Hex Key	M5-TEE

LAST DIGITS ON CODE NUMBER DENOTES BORE SIZE CHOOSE EITHER 40 OR 50.

Referencing Heads

3 Wing



Application:

For the accurate creating a referencing edge on first bottom spindle of all 4 –6 head machines to create a smooth straight edge to guide timber through the whole machining process.
Suitable for mechanical feed spindle 4 & 6 head through feed spindle moulders.



Sizes Available

CODE	D	d	Width	No Wings	Insert	Insert
SRH 15014-1¼	150	1¼	14	3	12x12x1.5	14x14x2
SRH 15014-40	150	40	14	3	12x12x1.5	14x14x2
SRH 15014-50	150	50	14	3	12x12x1.5	14x14x2

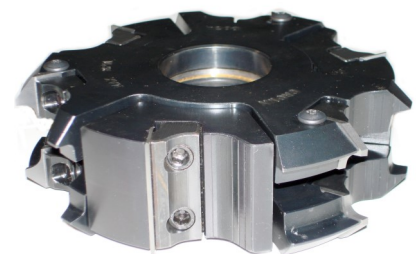
Spare Parts

Screw M4x9HD
Scribe Screw SS M5x12
Key T15 SD

Pencil Radius & Chamfer Cutter 3+3 Wing

Special Features

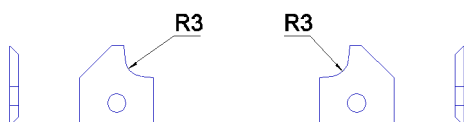
Top and Bottom Pencil Round edges or Chamfer edges.
Range of standard radius available. 3mm, 4mm and 5mm.
Suitable for use on spindle moulders using power feed.



Sizes Available

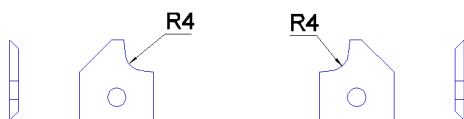
CODE	D	d	W	Radius	Insert	Insert RH	Insert LH
SPFCR-1502050-3W-40	150	40	50	3mm to 5mm	40x12x1.5	16x20x2 R3-R5	16x20x2 R3-R5
SPFCR-1502050-3W-50	150	50	50	3mm to 5mm	40x12x1.5	16x20x2 R3-R5	16x20x2 R3-R5

WIDTH FROM 16-44mm



P1410

P1412



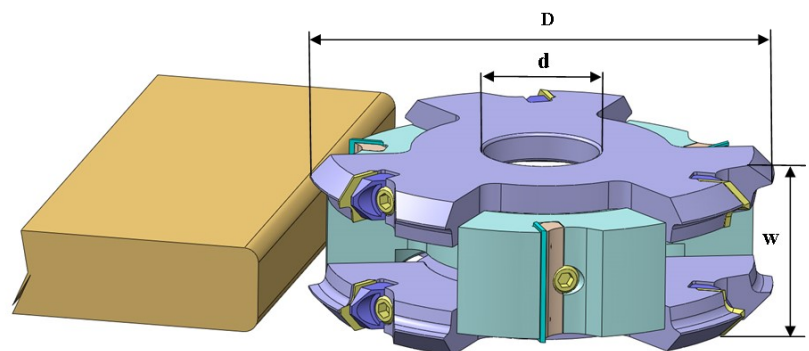
P613

P615



P1406

P1408



Spare Parts -Straight Cutter

Wedge W4012-TS-T3
Wedge Screw M6 x 12 TH
Key 5A/F-TEE

Spare Parts -Radius Cutter

Wedge W1620-TS-T3
Wedge Screw M6 x 12 TH
End Stop M4x9HD
Key 5A/F



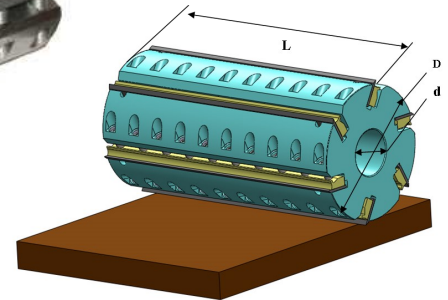
Planer Heads

4 Wing



Application:

For precision High Speed Steel planing on all, long length, solid timbers.
Suitable for mechanical feed spindle moulders and all 4 & 6 head through feed spindle moulders.



Sizes Available

CODE	D	d	L	No Wings
SPH12540-40	125	40	40	4
SPH12560-40	125	40	60	4
SPH12580-40	125	40	80	4
SPH125100-40	125	40	100	4
SPH125120-40	125	40	120	4
SPH125130-40	125	40	130	4
SSPH125150-40	125	40	150	4
SPH125180-40	125	40	180	4
SPH125200-40	125	40	200	4
SPH 125230-40	125	40	230	4
SPH125240-40	125	40	240	4

Special Features

High strength steel construction with precision high strength clamping of planer knife.
Excellent machining results and good surface finish due to precision construction.
Planer Knife changeover is quick, accurate and easy.

Spare Parts

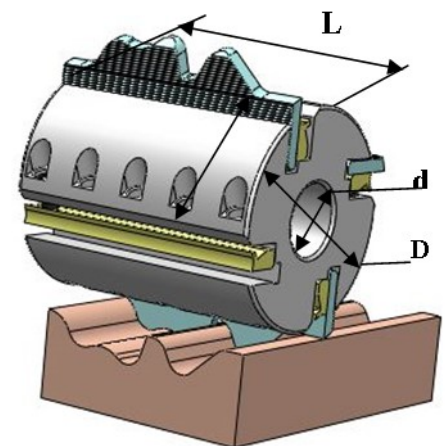
Clamp Strip SGB2510-Length
Clamp Screw M12 x 20 DPGS
Allen Key 6 mm AF

Serrated Back Knife Heads

4 Wing

Application:

For High Speed Steel knife profile planing on all long length solid timbers.
Suitable for mechanical feed spindle moulders and all 4 & 6 head through feed spindle moulders.



Sizes Available

CODE	D	d	L	No Wings
TOOL TAKES 6 OR 8mm MATERIAL				
SSBH 11040-1¼	110	1¼	40	3 or 4
SSBH 11060-1¼	110	1¼	60	3 or 4
SSBH 11080-1¼	110	1¼	80	3 or 4
TOOL TAKES 8 OR 10mm MATERIAL				
SSBH 12240-40	122	40	40	4
SSBH 12260-40	122	40	60	4
SSBH 12280-40	122	40	80	4
SSBH 122100-40	122	40	100	4
SSBH 122120-40	122	40	120	4
SSBH 122130-40	122	40	130	4
SSBH 122150-40	122	40	150	4
SSBH 122180-40	122	40	180	4
SSBH 122200-40	122	40	200	4
SSBH 122230-40	122	40	230	4
SSBH122240-40	122	40	240	4

Spare Parts

Gib Strip SGB2510-Length
Clamp Screw M12 x20DPGS
Allen Key 6mmA/F

Floor & Panel Cutter Sets

2 + 2 Wing



Application:

For production of tongue and groove flooring and wall paneling on all 4 to 8 head moulding machines. Tools use economical inserts for low production running costs.

Tools come in Top Nail, Secret Nail & Shiplap design.

Chamfer cartridges available to allow for adjustable chamfers on both tongue and groove boards.



The width of the tongue and groove is adjustable by means of spacers and shims up to 8 mm wide tongue & groove.

An additional 3rd. Cutter set can be supplied if an edge bevel is required.

The size of the bevel is adjustable to max. of 10 mm.

Sizes Available

CODE	D	W	w	d	DESCRIPTION	Insert	Insert	Chamfer Insert
FLOOR TOP NAIL								
SFBT-15040-40	150	40	4-8	40	TOP NAIL TENON SET	25x12x1.5	14x14x2	TKM45-22165
SFBG-15040-40	150	40	4-8	40	TOP NAIL GROOVER SET	25x12x1.5	14x14x2	TKM45-22165
FLOOR TOP NAIL 1mm GAP								
SFBT-1M-15040-40	150	40	4-8	40	TOP NAIL 1mm GAP TENON SET	25x12x1.5	14x14x2	TKM45-22165
SFBG-1M-15040-40	150	40	4-8	40	TOP NAIL 1 mm GAP GROOVER SET	25x12x1.5	14x14x2	TKM45-22165
FLOOR SECRET NAIL								
SSNG-15040-40	150	40	4-8	40	SECRET NAIL GROOVER SET	25x12x1.5	14x14x2	TKM45-22165
SSNT-15040-40	150	40	4-8	40	SECRET NAIL TENON SET	25x12x1.5	14x14x2	TKM45-22165
FLOOR SECRET NAIL 1 mm GAP								
SSNG-1M-15040-40	150	40	4-8	40	SECRET NAIL 1mm GAP GROOVER SET	25x12x1.5	14x14x2	TKM45-22165
SSNT-1M-15040-40	150	40	4-8	40	SECRET NAIL 1mm GAP TENON SET	25x12x1.5	14x14x2	TKM45-22165
FLOOR SHIP LAP								
SSLG-18040-40	180	40	4-8	40	SHIPLAP GROOVER SET	25x12x1.5	14x14x2	TKM45-22165
SSLT-18040-40	180	40	4-8	40	SHIPLAP TENNON SET	25x12x1.5	14x14x2	TKM45-22165

SPARE PARTS

Wedge W2512-TS-T3 Wedge Screw M6 x 16 TH Special Groover TPSG8 LH Special Groover TPSG8 RH Groover Screw M6 x12 CSNK Scribe Screw SS-M5-12 Tennon Chamfer Screw RSS-M6-16W

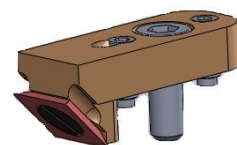
Onboard Chamfer Cutters

Special Onboard Chamfer Cutters are available to allow for adjustable chamfers on both top and bottom timber. This creates the ability to machine VEE JAY type Wall Paneling.

P/No SFBCC1616-42

ONBOARD CHAMFER SPARES

Cartridge SFBCC1616-42 Screw M8 x 16LHCS Screw M8 x 20LHCS
Screw M8 x 25 LH Jack Screw M5 x 12 DPGS Jack Screw M5 x 16 DPGS
Shim SFBCCS15001 Allen Key M2.5 Allen Key M5 Allen Key M6

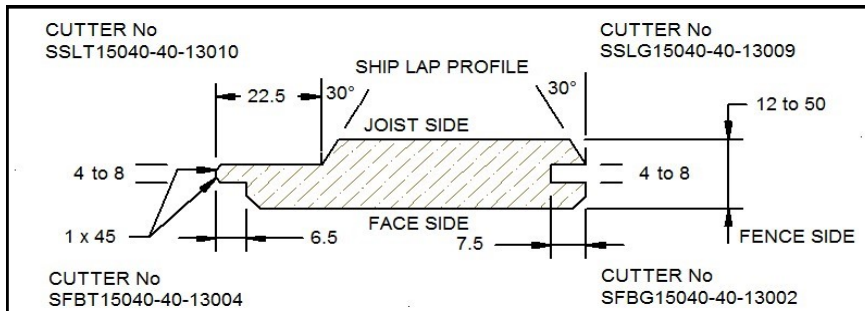
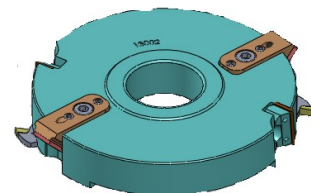
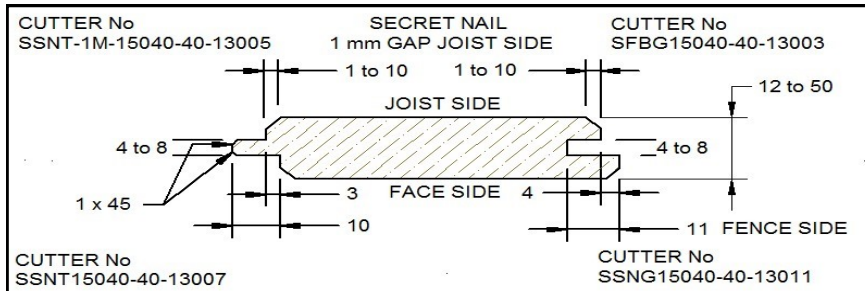
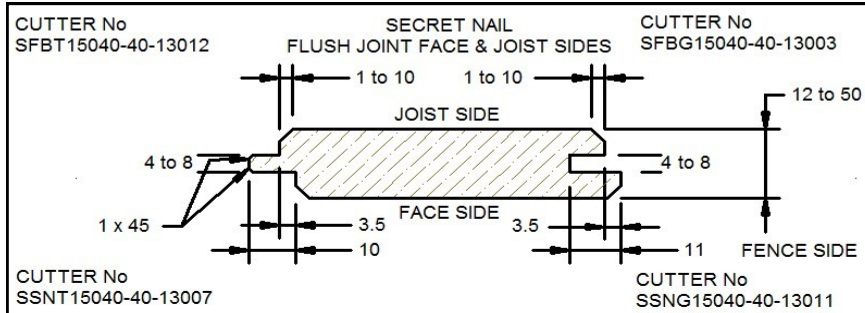
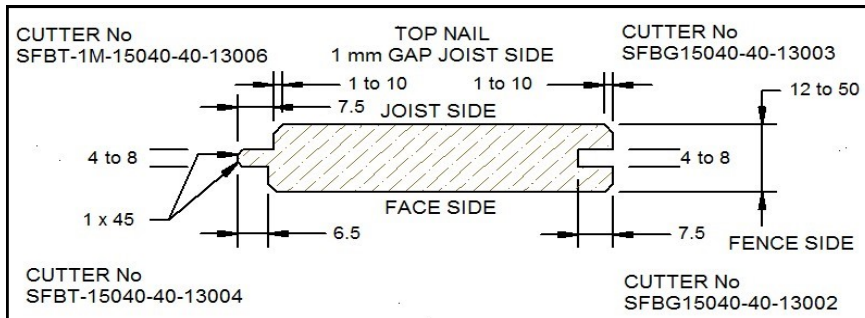
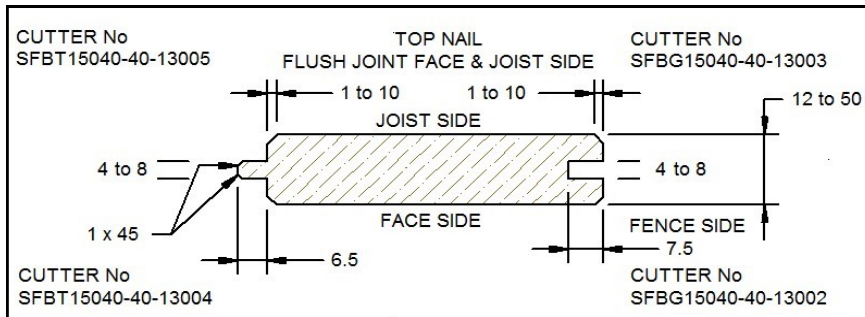


Floor Board & Wall Panel Profiles

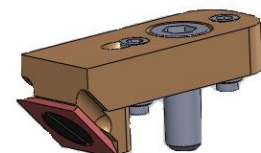


FLOOR BOARD CUTTER COMBINATIONS

Choose individual cutter numbers 13001 to 13012 to produce profile required. Additional tools can be added at a later date to enable production of additional profiles.



P/No SFBCC1616-42



FLOOR BOARD CHAMFER CUTTERS

Choose individual onboard chamfer cartridges that bolt on to the outer surfaces of flooring cutters to allow for adjustable chamfering of timber flooring.

High Speed Floor & Panel Cutter Sets 6-8 Wing



Application:

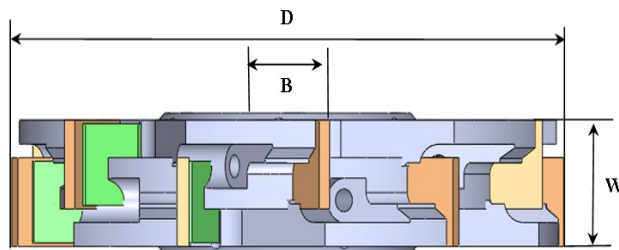
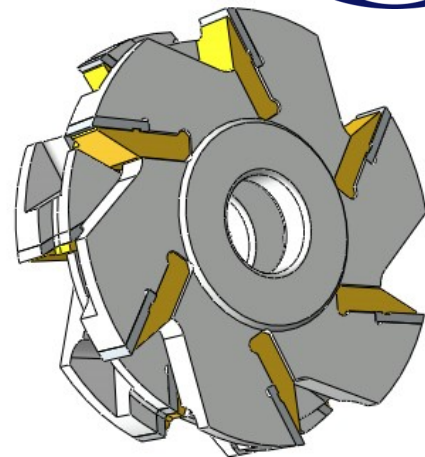
For production of tongue and groove flooring and wall paneling on all 4 to 8 head moulding machines.

Tools use economical inserts for low production running costs. High feed rates on machines achievable due to rigid clamping of inserts and high number of inserts on 1 cutter.

Special Features

The width of the tongue and groove is adjustable by means of spacers and shims up to 12 mm wide tongue & groove.

Tools come in 6 or 8 wing and take 25 x 30 x 2 Carbide Inserts.



Spare Parts

Wedge	WC25303-SL-BS
Wedge Screw	M6 x 25 SHCS
Wedge	W1620-TS-T3
Wedge Screw	M6 x 12 TH
End Stop	M4x9HD



Sizes Available

CODE	D	W	Wings	B	DESCRIPTION	Insert	Clamp
HIGH SPEED FLOOR 4 WING 150mm DIAMETER							
SHSFBT150 2025-Z4-50 OR 40	150	40	4 + 4	50/40	F.BOARD TENON	20 x 25 x 2	W2025G-M8-BS
SHSFBG150 2025-Z4-50 OR 40	150	40	4 + 4	50/40	F.BOARD GROOVER	20 x 25 x 2	W2025G-M8-BS
HIGH SPEED FLOOR 6 WING 150mm DIAMETER							
SHSFBT150 2025-Z6-50 OR 40	150	40	6 + 6	50/40	F. BOARD TENON	20 x 25 x 2	W2025G-M8-BS
SHSFBG150 2025-Z6-50 OR 40	150	40	6 + 6	50/40	F. BOARD GROOVER	20 x 25 x 2	W2025G-M8-BS
HIGH SPEED FLOOR 6 WING 200mm DIAMETER							
SHSFBT200 2530-Z6-50 OR 40	200	50	6 + 6	50/40	F.BOARD TENON	25 x 30 x 3	W2530G-M8-BS
SHSFBG200 2530-Z6-50 OR 40	200	50	6 + 6	50/40	F. BOARD GROOVER	25 x 30 x 3	W2530G-M8-BS
HIGH SPEED FLOOR 8 WING 200mm DIAMETER							
SHSFBT200 2530-Z8-50 OR 40	200	50	8 + 8	50/40	F. BOARD TENON	25 x 30 x 3	W2530G-M8-BS
SHSFBG200 2530-Z8-50 OR 40	200	50	8 + 8	50/40	F. BOARD GROOVER	25 x 30 x 3	W2530G-M8-BS

Hydro Planer Heads



Application:

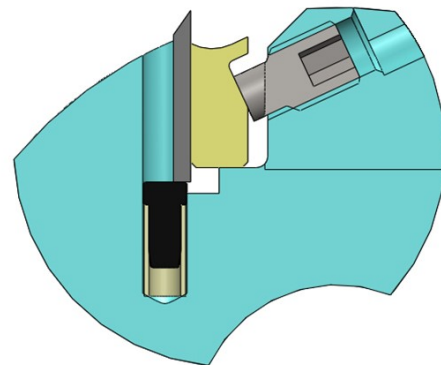
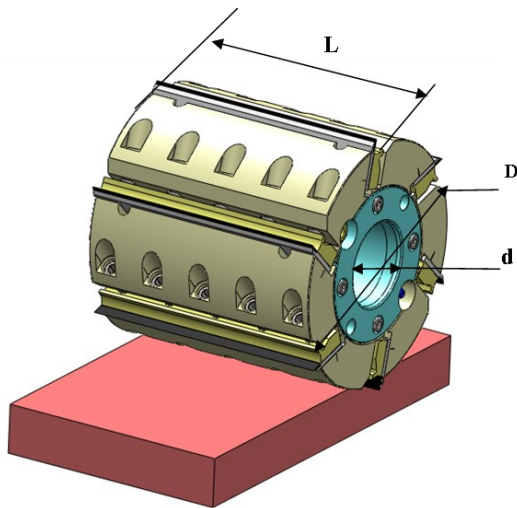
For precision High Speed Steel planing on all long length solid timbers.

Suitable for mechanical feed spindle moulders and all 4, 6 & 8 head through feed spindle moulders.

Technical Details:

All steel construction. All tools are dynamically balanced for smooth running.

Bores



Special Features

High strength steel construction with precision high strength clamping of planer knife.

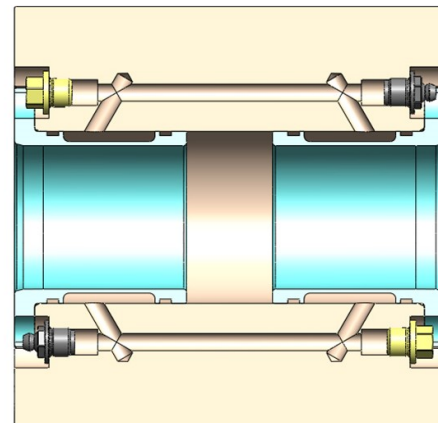
The precise cutting circle ensures high speeds and superb finish.

Fully sealed Hydro clamping system for precise concentricity.

No vibration resulting in the ultimate cut.

Technical Information

Diameter	Max Rpm
122	9000
125	9000
136	8500
150	8000
163	8000
203	7500
250	6000
300	6000
350	6000



Bore Size	Psi	Bar Rating
40	3970	270
45	3970	270
50	4400	300
76.2	4400	300
88.9	4700	320
101.6	4700	320

Hydro Planer Heads



Application:

For precision High Speed Steel planing on all long length solid timbers. Suitable for mechanical feed spindle moulders and all 4 & 6 head through feed spindle moulders.

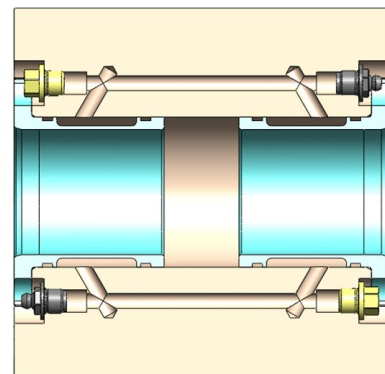
Special Features

High strength steel construction.
Fully sealed Hydro clamping system for precise concentricity.
No vibration resulting in the ultimate cut.



150 mm Dia x 4 Wing x 40 Bore Z=No of Wings

CODE	D	d	L
HSPH 15040-Z4-40	150	40	40
HSPH 15060-Z4-40	150	40	60
HSPH 15080-Z4-40	150	40	80
HSPH 150100-Z4-40	150	40	100
HSPH 150120-Z4-40	150	40	120
HSPH 150130-Z4-40	150	40	130
HSPH 150150-Z4-40	150	40	150
HSPH 150180-Z4-40	150	40	180
HSPH 150200-Z4-40	150	40	200
HSPH 150230-Z4-40	150	40	230
HSPH 150240-Z4-40	150	40	240
HSPH 150310-Z4-40	150	40	310



Spare Parts

Clamp Strip SGB2510-Length
Clamp Screw M12 x 20 DPGS
Allen Key 6mm A/F

150 mm Dia x 6 Wing x 40 Bore Z=No of Wings

CODE	D	d	L
HSPH 15040-Z6-40	150	40	40
HSPH 15060-Z6-40	150	40	60
HSPH 15080-Z6-40	150	40	80
HSPH 150100-Z6-40	150	40	100
HSPH 150120-Z6-40	150	40	120
HSPH 150130-Z6-40	150	40	130
HSPH 150150-Z6-40	150	40	150
HSPH 150180-Z6-40	150	40	180
HSPH 150200-Z6-40	150	40	200
HSPH 150230-Z6-40	150	40	230
HSPH 150240-Z6-40	150	40	240
HSPH 150310-Z6-40	150	40	310

150 mm Dia x 4 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSPH 15040-Z4-50	150	50	40
HSPH 15060-Z4-50	150	50	60
HSPH 15080-Z4-50	150	50	80
HSPH 150100-Z4-50	150	50	100
HSPH 150120-Z4-50	150	50	120
HSPH 150130-Z4-50	150	50	130
HSPH 150150-Z4-50	150	50	150
HSPH 150180-Z4-50	150	50	180
HSPH 150200-Z4-50	150	50	200
HSPH 150230-Z4-50	150	50	230
HSPH 150240-Z4-50	150	50	240
HSPH 150310-Z4-50	150	50	310

Hydro Planer Heads



150 mm Dia x 6 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSPH 15040-Z6-50	150	50	40
HSPH 15060-Z6-50	150	50	60
HSPH 15080-Z6-50	150	50	80
HSPH 150100-Z6-50	150	50	100
HSPH 150120-Z6-50	150	50	120
HSPH 150130-Z6-50	150	50	130
HSPH 150150-Z6-50	150	50	150
HSPH 150180-Z6-50	150	50	180
HSPH 150200-Z6-50	150	50	200
HSPH 150230-Z6-50	150	50	230
HSPH 150240-Z6-50	150	50	240
HSPH 150310-Z6-50	150	50	310

163 mm Dia x 6 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSPH 16340-Z6-50	163	50	40
HSPH 16360-Z6-50	163	50	60
HSPH 16380-Z6-50	163	50	80
HSPH 163100-Z6-50	163	50	100
HSPH 163120-Z6-50	163	50	120
HSPH 163130-Z6-50	163	50	130
HSPH 163150-Z6-50	163	50	150
HSPH 163180-Z6-50	163	50	180
HSPH 163200-Z6-50	163	50	200
HSPH 163230-Z6-50	163	50	230
HSPH 163240-Z6-50	163	50	240
HSPH 163310-Z6-50	163	50	310

203 mm Dia x 12 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSPH 20340-Z12-50	203	50	40
HSPH 20360-Z12-50	203	50	60
HSPH 20380-Z12-50	203	50	80
HSPH 203100-Z12-50	203	50	100
HSPH 203120-Z12-50	203	50	120
HSPH 203130-Z12-50	203	50	130
HSPH 203150-Z12-50	203	50	150
HSPH 203180-Z12-50	203	50	180
HSPH 203200-Z12-50	203	50	200
HSPH 203230-Z12-50	203	50	230
HSPH 203240-Z12-50	203	50	240
HSPH 203310-Z12-50	203	50	310

163 mm Dia x 4 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSPH 16340-Z4-50	163	50	40
HSPH 16360-Z4-50	163	50	60
HSPH 16380-Z4-50	163	50	80
HSPH 163100-Z4-50	163	50	100
HSPH 163120-Z4-50	163	50	120
HSPH 163130-Z4-50	163	50	130
HSPH 163150-Z4-50	163	50	150
HSPH 163180-Z4-50	163	50	180
HSPH 163200-Z4-50	163	50	200
HSPH 163230-Z4-50	163	50	230
HSPH 163240-Z4-50	163	50	240
HSPH 163310-Z4-50	163	50	310

163 mm Dia x 8 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSPH 16340-Z8-50	163	50	40
HSPH 16360-Z8-50	163	50	60
HSPH 16380-Z8-50	163	50	80
HSPH 163100-Z8-50	163	50	100
HSPH 163120-Z8-50	163	50	120
HSPH 163130-Z8-50	163	50	130
HSPH 163150-Z8-50	163	50	150
HSPH 163180-Z8-50	163	50	180
HSPH 163200-Z8-50	163	50	200
HSPH 163230-Z8-50	163	50	230
HSPH 163240-Z8-50	163	50	240
HSPH 163310-Z8-50	163	50	310

225 mm Dia x 16 Wing x 50 Bore Z=No of Wings

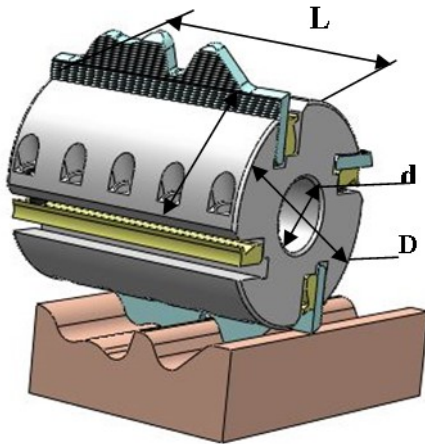
CODE	D	d	L
HSPH 22540-Z16-50	225	50	40
HSPH 22560-Z16-50	225	50	60
HSPH 22580-Z16-50	225	50	80
HSPH 225100-Z16-50	225	50	100
HSPH 225120-Z16-50	225	50	120
HSPH 225130-Z16-50	225	50	130
HSPH 225150-Z16-50	225	50	150
HSPH 225180-Z16-50	225	50	180
HSPH 225200-Z16-50	225	50	200
HSPH 225230-Z16-50	225	50	230
HSPH 225240-Z16-50	225	50	240
HSPH 225310-Z16-50	225	50	310

Hydro Serrated Back Knife Heads



Application:

Hydro Serrated back cutter heads at high feed speeds gives superb finish to soft and hardwoods. To be used on spindle machines with precision spindles and outrigger bearings. Mechanical Feed.

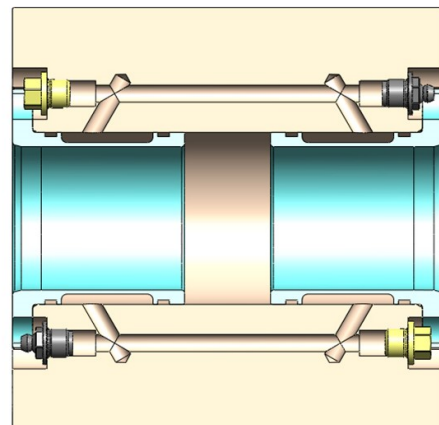
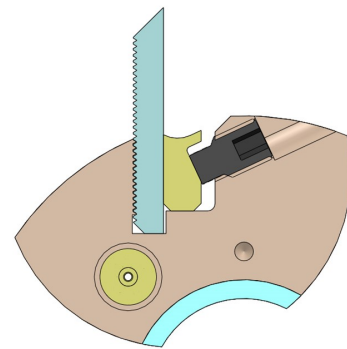


Technical Details:

All steel construction. All tools are dynamically balanced for smooth running. Bores to H7 tolerance.

Special Features

High strength steel construction with precision form lock clamping on the back of corrugated profile knives.
 Profile Knife changeover is quick, accurate and easy.
 Fully sealed Hydro clamping system for precise concentricity.
 No vibration resulting in the ultimate cut.



Technical Information

Diameter	Max Rpm
122	9000
125	9000
136	8500
150	8000
163	8000
203	7500
250	6000
300	6000
350	6000

Bore Size	Psi	Bar Rating
40	3970	270
45	3970	270
50	4400	300
76.2	4400	300
3-1/4 Inch	4700	320
4 Inch	4700	320

Hydro Serrated Back Knife Heads



Application:

Hydro serrated cutter heads suitable for high feeds and speeds gives superb finish to soft and hard woods.

The serrated form lock ensures precision fit and adjustment on all ground profile knife steel from 6 to 10 mm thick and from 40mm 50mm and 60 mm high.

Suitable for straight planer cutting

Special Features

High strength steel construction with precision lock clamping on 6mm-10 mm serrated knives.

Serrated Knife Steel is suitable for quick changeover , accurate knife location and ease of use.

Fully sealed Hydro clamping system for precise concentricity.

No vibration resulting in the ultimate cut.

Sizes Available.

150 mm Dia x 4 Wing x 40 Bore Z=No of Wings

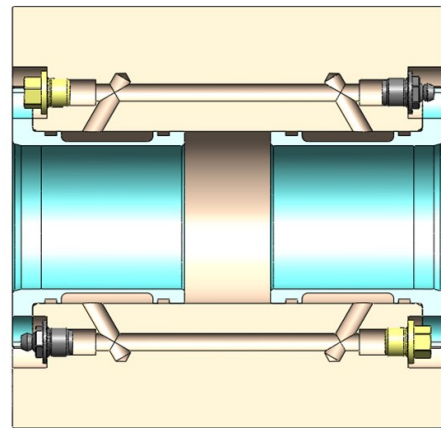
CODE	D	d	L
HSSBH 15040-Z4-40	150	40	40
HSSBH 15060-Z4-40	150	40	60
HSSBH 15080-Z4-40	150	40	80
HSSBH 150100-Z4-40	150	40	100
HSSBH 150120-Z4-40	150	40	120
HSSBH 150130-Z4-40	150	40	130
HSSBH 150150-Z4-40	150	40	150
HSSBH 150180-Z4-40	150	40	180
HSSBH 150200-Z4-40	150	40	200
HSSBH 150230-Z4-40	150	40	230
HSSBH 150240-Z4-40	150	40	240
HSSBH 150310-Z4-40	150	40	310

150 mm Dia x 4 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSSBH 15040-Z4-50	150	50	40
HSSBH 15060-Z4-50	150	50	60
HSSBH 15080-Z4-50	150	50	80
HSSBH 150100-Z4-50	150	50	100
HSSBH 150120-Z4-50	150	50	120
HSSBH 150130-Z4-50	150	50	130
HSSBH 150150-Z4-50	150	50	150
HSSBH 150180-Z4-50	150	50	180
HSSBH 150200-Z4-50	150	50	200
HSSBH 150230-Z4-50	150	50	230
HSSBH 150240-Z4-50	150	50	240
HSSBH 150310-Z4-50	150	50	310

150 mm Dia x 6 Wing x 40 Bore Z=No of Wings

CODE	D	d	L
HSSBH 15040-Z6-40	150	40	40
HSSBH 15060-Z6-40	150	40	60
HSSBH 15080-Z6-40	150	40	80
HSSBH 150100-Z6-40	150	40	100
HSSBH 150120-Z6-40	150	40	120
HSSBH 150130-Z6-40	150	40	130
HSSBH 150150-Z6-40	150	40	150
HSSBH 150180-Z6-40	150	40	180
HSSBH 150200-Z6-40	150	40	200
HSSBH 150230-Z6-40	150	40	230
HSSBH 150240-Z6-40	150	40	240
HSSBH 150310-Z6-40	150	40	310



Spare Parts

Clamp Strip SGB2510-Length

Clamp Screw M12 x 20 DPGS

Allen Key 6mm A/F

Hydro Serrated Back Knife Heads



150 mm Dia x 6 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSSBH 15040-Z6-50	150	50	40
HSSBH 15060-Z6-50	150	50	60
HSSBH 15080-Z6-50	150	50	80
HSSBH 150100-Z6-50	150	50	100
HSSBH 150120-Z6-50	150	50	120
HSSBH 150130-Z6-50	150	50	130
HSSBH 150150-Z6-50	150	50	150
HSSBH 150180-Z6-50	150	50	180
HSSBH 150200-Z6-50	150	50	200
HSSBH 150230-Z6-50	150	50	230
HSSBH 150240-Z6-50	150	50	240
HSSBH 150310-Z6-50	150	50	310

163 mm Dia x 4 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSSBH 16340-Z4-50	163	50	40
HSSBH 16360-Z4-50	163	50	60
HSSBH 16380-Z4-50	163	50	80
HSSBH 163100-Z4-50	163	50	100
HSSBH 163120-Z4-50	163	50	120
HSSBH 163130-Z4-50	163	50	130
HSSBH 163150-Z4-50	163	50	150
HSSBH 163180-Z4-50	163	50	180
HSSBH 163200-Z4-50	163	50	200
HSSBH 163230-Z4-50	163	50	230
HSSBH 163240-Z4-50	163	50	240
HSSBH 163310-Z4-50	163	50	310

163mm Dia x 6 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSSBH 16340-Z6-50	163	50	40
HSSBH 16360-Z6-50	163	50	60
HSSBH 16380-Z6-50	163	50	80
HSSBH 163100-Z6-50	163	50	100
HSSBH 163120-Z6-50	163	50	120
HSSBH 163130-Z6-50	163	50	130
HSSBH 163150-Z6-50	163	50	150
HSSBH 163180-Z6-50	163	50	180
HSSBH 163200-Z6-50	163	50	200
HSSBH 163230-Z6-50	163	50	230
HSSBH 163240-Z6-50	163	50	240
HSSBH 163310-Z6-50	163	50	310

163 mm Dia x 8 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSSBH 16340-Z8-50	163	50	40
HSSBH 16360-Z8-50	163	50	60
HSSBH 16380-Z8-50	163	50	80
HSSBH 163100-Z8-50	163	50	100
HSSBH 163120-Z8-50	163	50	120
HSSBH 163130-Z8-50	163	50	130
HSSBH 163150-Z8-50	163	50	150
HSSBH 163180-Z8-50	163	50	180
HSSBH 163200-Z8-50	163	50	200
HSSBH 163230-Z8-50	163	50	230
HSSBH 163240-Z8-50	163	50	240
HSSBH 163310-Z8-50	163	50	310

203 mm Dia x 12 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSSBH 20340-Z12-50	203	50	40
HSSBH 20360-Z12-50	203	50	60
HSSBH 20380-Z12-50	203	50	80
HSSBH 203100-Z12-50	203	50	100
HSSBH 203120-Z12-50	203	50	120
HSSBH 203130-Z12-50	203	50	130
HSSBH 203150-Z12-50	203	50	150
HSSBH 203180-Z12-50	203	50	180
HSSBH 203200-Z12-50	203	50	200
HSSBH 203230-Z12-50	203	50	230
HSSBH 203240-Z12-50	203	50	240
HSSBH 203310-Z12-50	203	50	310

225 mm Dia x 16 Wing x 50 Bore Z=No of Wings

CODE	D	d	L
HSSBH 22540-Z16-50	225	50	40
HSSBH 22560-Z16-50	225	50	60
HSSBH 22580-Z16-50	225	50	80
HSSBH 225100-Z16-50	225	50	100
HSSBH 225120-Z16-50	225	50	120
HSSBH 225130-Z16-50	225	50	130
HSSBH 225150-Z16-50	225	50	150
HSSBH 225180-Z16-50	225	50	180
HSSBH 225200-Z16-50	225	50	200
HSSBH 225230-Z16-50	225	50	230
HSSBH 225240-Z16-50	225	50	240
HSSBH 225310-Z16-50	225	50	310

High Speed Hydro Planer Heads 24 Wing



Application:

Hydro planer cutter heads for high speed high feed machines.

CODE	D	d	L
HSSPH330120-Z24-3¼	330	3¼	120
HSSPH330240-Z24-3¼	330	3¼	240
HSSPH330300-Z24-3¼	330	3¼	300
HSSPH330330-Z24-3¼	330	3¼	330
HSSPH330120-Z24-4in	330	4 Inch	120
HSSPH330240-Z24-4in	330	4 Inch	240
HSSPH330300-Z24-4in	330	4 Inch	300
HSSPH330330-Z24-4in	330	4 Inch	330

Available in 3¼ inch and 4 inch hydro bores for all hard wood and softwood planing applications.

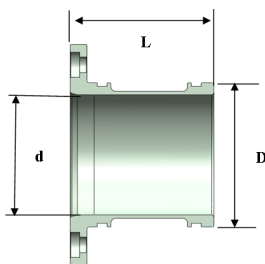


Spare Parts

Clamp Strip SGB2510- Length
 Clamp Screw M12 x 20 DPGS
 Allen Key 6mm A/F

Hydro Spare Parts

HYDRO SLEEVES	Bore	Dia	Length
HYDRO 40 BORE			
HS4050-40	40	50	40
HS4050-50	40	50	50
HS4050-60	40	50	60
HS4060-60	40	60	60
HS4060-80	40	60	80
HYDRO 50 BORE			
HS5060-40	50	60	40
HS5060-50	50	60	50
HS5060-60	50	60	60
HS5060-80	50	60	80
HYDRO 3¼ in BORE			
HS82.552101	3¼ in	89.49	101
HS82.552120	3¼ in	89.49	120
HYDRO 4 in BORE			
HS101.6101	4 in	114.89	101
HS101.6120	4 in	114.89	120



SERRATED WEDGES	LENGTH
CLAMP PART NUMBER x CUTTER LENGTH	
SGB2510-LENGTH	L

PLANER WEDGES	LENGTH
CLAMP PART NUMBER x CUTTER LENGTH	
SGB2510-LENGTH	L

SCREWS	P/No
DOG POINT GRUB SCREWS	M12 x 20 DPGS
M6 SHCS LOW HEAD	M6 x 20 LH-SHCS

SAFETY LOCK COLLARS	PART NUMBER
40 mm PLAIN BORE	SLC-PB-40
40 mm THREADED BORE	SLC-TB-40
50 mm PLAIN BORE	SLC-PB-50
50 mm THREADED BORE	SLC-TB-50

HYDRO GREASE FITTINGS	PART NUMBER
GREASE ZERK	HGN-M10
PRESSURE RELEASE	HPR-M10
BONDED SEAL WASHER	BSW-M10



Steel Feed Rollers



Application:

For precision High Speed feeding of all Hardwoods Softwoods and Green Timber on most popular moulders and all 4, 6 & 8 head through feed spindle moulders.



Sizes Available

DESCRIPTION	CODE	OD	W	Bore	KN
STEEL FEED ROLLER	SFR14015-35 10KN	140	15	35	10
STEEL FEED ROLLER	SFR14020-35 10KN	140	20	35	10
STEEL FEED ROLLER	SFR14025-35 10KN	140	25	35	10
STEEL FEED ROLLER	SFR14050-35 10KN	140	50	35	10
STEEL FEED ROLLER-6 HOLES	SFR14015-35-6H 10KN	140	15	35	10
STEEL FEED ROLLER-6 HOLES	SFR14020-35-6H 10KN	140	20	35	10
STEEL FEED ROLLER-6 HOLES	SFR14025-35-6H 10KN	140	25	35	10
STEEL FEED ROLLER-6 HOLES	SFR14050-35-6H 10KN	140	50	35	10

Rubber Feed Rollers

Application:

For precision High Speed feeding of all hardwoods and softwoods on most popular moulders and all 4, 6 & 8 head through feed spindle moulders.



Green Rollers
Polyurethane Roller
manufactured for long
durable life.



Brown Rollers
Rubber roller manufactured
for high abrasion resistance
and high gripping force

Sizes Available

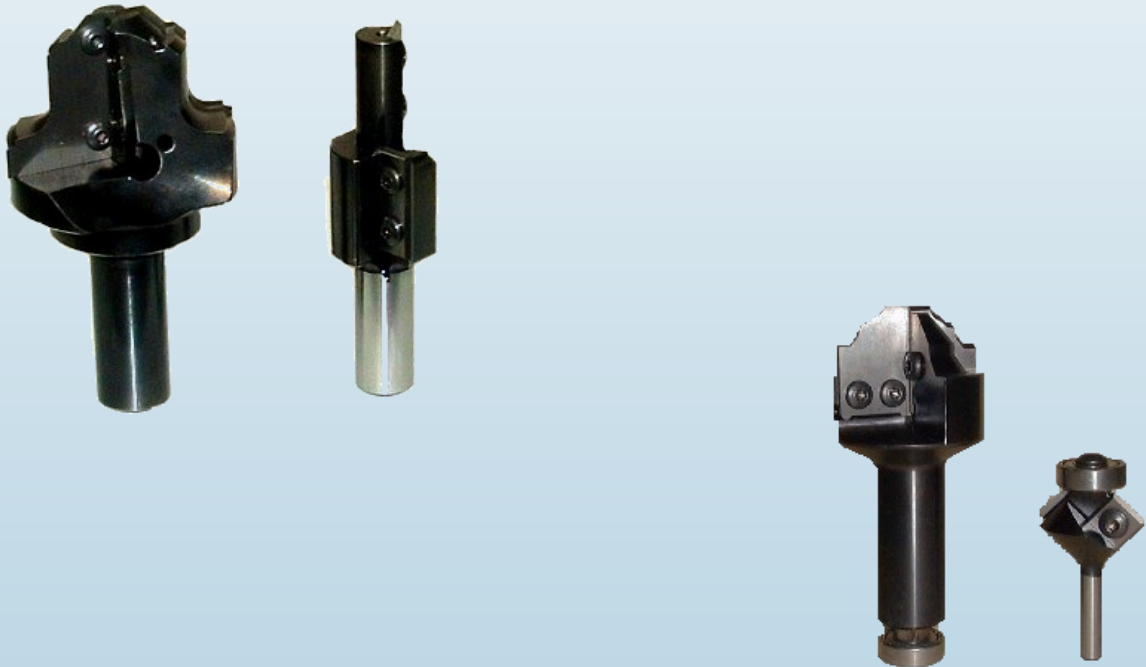
DESCRIPTION	CODE	OD	W	Bore	KN
URETHANE FEED ROLLER GREEN	FRG14025-35-10KN	140	25	35	10
RUBBER FEED ROLLER BROWN	FRB14025-35-10KN	140	25	35	10
URETHANE FEED ROLLER GREEN	FRG14050-35-10KN	140	50	35	10
RUBBER FEED ROLLER BROWN	FRB14050-35 10KN	140	50	35	10
URETHANE FEED ROLLER-6 HOLES GREEN	FRG14025-35-6H 10KN	140	25	35	10
RUBBER FEED ROLLER-6 HOLES BROWN	FRB14025-35-6H 10KN	140	25	35	10
URETHANE FEED ROLLER-6 HOLES GREEN	FRG14050-35-6H 10KN	140	50	35	10
RUBBER FEED ROLLER-6 HOLES BROWN	FRB14050-35-6H 10KN	140	50	35	10



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SECTION III

C.N.C Router Chucks



Application:

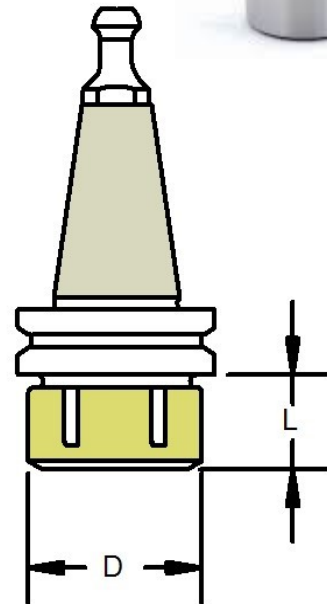
For extremely accurate clamping of all shank tools for C.N.C routers. Chucks are Hardened, Precision ground and Balanced to G2.5 for smooth vibration free running. Suitable for Right Hand and Left Hand rotation. One piece nut for easy maintenance and cleaning. No ball bearing in nut so nut does not get clogged up dust and dirt.

Both ISO 30 and HSK 63F Tapers available. A range of various pull studs available for various I.S.O 30 C.N.C Machines. Also available are 27 MM parallel shank tools for Groove or Saw cutting applications as well as special cutter adaptations.



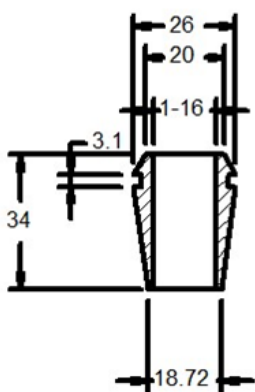
Sizes Available

CODE	COLET SIZE	RANGE	D	L
ISO 30 ER25	ER25	1mm-16mm	42	20
ISO 30 ER32	ER32	3mm-20mm	50	22.5
ISO 30 ER 40	ER40	3 mm-25mm	63	25.5
HSK63F ER32	ER32	3mm-20mm	50	22.5
HSK63F ER40	ER40	4mm-25mm	63	25.5
ISO 30-27 SNK			27	
HSK63F-27 SNK			27	

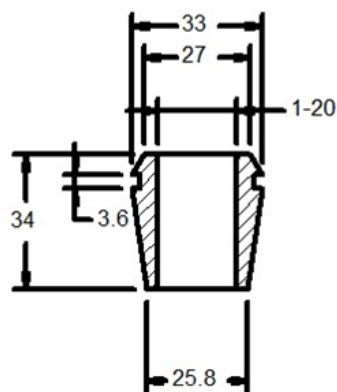


Collets Available

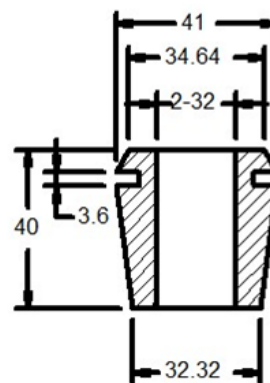
CODE	D	d - min	d- max	L
ER25 1 mm TO 16 mm	26	1	16	30
ER 32 2 mm TO 20 mm	33	2	20	34
ER 40 3 mm TO 26 mm	41	3	26	40



ER25 COLLET RANGES FROM 1mm BORE TO 16mm BORE



ER32 COLLET RANGES FROM 2mm BORE TO 20mm BORE



ER40 COLLET RANGES FROM 3mm BORE TO 26mm BORE



CNC Router Profile Spiral Routers



Application:

For use with all CNC routing machines.
Normally used for routing of edge profiles.
Rebating and all 5 Axis CNC Router work on furniture and custom timber work.

TYPE 1 AND TYPE 2

Available in shank type 20 or 25 mm diameter or DIRECT COUPLING to taper shank.
Suffix at end of CODE.

20 or 25 or IS means either 20 mm or 25 mm or INTEGRAL SHANK.



TYPE 1



TYPE 2

Spare Parts

Screw RSS-M6-16

Torx Key T15SD

Allen Key 5 mm

Sizes Available

TYPE	Router type	Code	D	CL	Shank	Wings	Insert Used
1	ROUGHING SPIRAL HOGGER	DRSH 80100-20 or 25 or IS	80	100	20 or 25 or IS	4	14 x 14 x 2
1	ROUGHING SPIRAL HOGGER	DRSH 80150-20 or 25 or IS	80	150	20 or 25 or IS	4	14 x 14 x 2
2	FINISHING SPIRAL REBATE	DSHR 80100-20 or 25 or IS	80	100	20 or 25 or IS	4	15x15x2.5 Rad 150
2	FINISHING SPIRAL REBATE	DSHR 80150-20 or 25 or IS	80	150	20 or 25 or IS	4	15x15x2.5 Rad 150

CNC Radius Router Bits

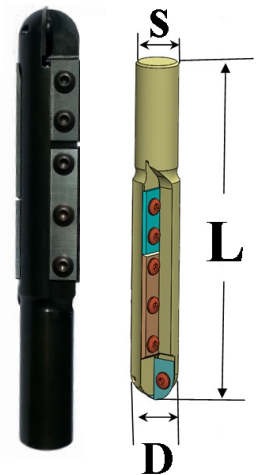
Application:

For full 3D Profiling on all 3 to 5 axis CNC routers.
For all mould work Pattern making and 3D profiling.

Spare Parts :

Screw M4 x 8HD

Key T15 Flag



BALL END ROUTER

Sizes Available

CODE	D	L	Shank	Wings	Radius Insert	Insert	Insert
DBE25100-20	25	160	20	2+2	20x12x2-P748	30x12x1.5	50x12x1.7
DBE25100-25	25	160	25	2+2	20x12x2-P748	30x12x1.5	50x12x1.7
DBE25120-20	25	180	20	2+2	20x12x2-P748	50x12x1.7	50x12x1.7
DBE25120-25	25	180	25	2+2	20x12x2-P748	50x12x1.7	50x12x1.7

ROUND INSERT ROUTER

Sizes Available

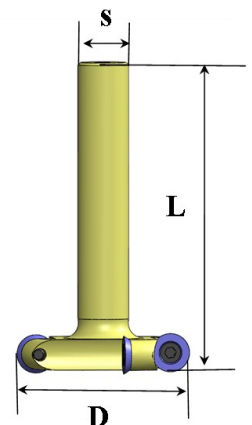
CODE	D	L	Shank	Wings	Insert
DRIC7015R7.5-16	70	120	16	4	R15x2
DRIC7015R7.5-20	70	120	20	4	R15x2
DRIC10015R7.5-16	100	120	16	5	R15x2
DRIC10015R7.5-20	100	120	20	5	R15x2

Spare Parts :

Screw RSS M6-12W

Key T15 SD

Key T15



Plunging Router Bits 1 Flute 12 mm-20mm



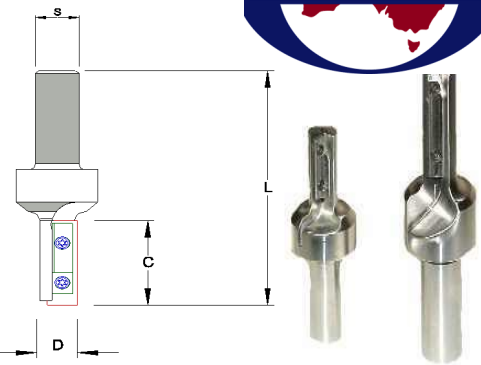
Application:

For use on overhead, C.N.C and some hand routers or similar machines where a vertical plunge feed is required as well as lateral feed.

AVAILABLE IN BOTH LEFT AND RIGHT HAND ROTATION.

Sizes Available

CODE	D	C	L	S	Wings	Inserts
DSP1230-1/2 or 16	12	30	86	1/2 or 16	1	30x9x1.5 EC
DSP1240-1/2 or 16	12	40	96	1/2 or 16	1	40x9x1.5 EC
DSP12.730-1/2 or 16	12.7	30	86	1/2 or 16	1	30x9x1.5 EC
DSP12.740-1/2 or 16	12.7	40	96	1/2 or 16	1	40x9x1.5 EC
DSP1430-1/2 or 16	14	30	86	1/2 or 16	1	30x9x1.5 EC
DSP1440-1/2 or 16	14	40	96	1/2 or 16	1	40x9x1.5 EC
DSP1530-1/2 or 16	15	30	86	1/2 or 16	1	30x9x1.5 EC
DSP1540-1/2 or 16	15	40	96	1/2 or 16	1	40x9x1.5 EC
DSP1630-1/2 or 16	16	30	86	1/2 or 16	1	30x9x1.5 EC
DSP1640-1/2 or 16	16	40	96	1/2 or 16	1	40x9x1.5 EC
DSP1650-1/2 or 16	16	50	120	1/2 or 16	1	50x12x1.5 EC
DSP1830-16 or 20	18	30	86	16 or 20	1	30x12x1.5 EC
DSP1840-16 or 20	18	40	96	16 or 20	1	40x12x1.5 EC
DSP1850-16 or 20	18	50	120	16 or 20	1	50x12x1.5 EC



Special Features

DSP... Routers have 1 insert and large gullet area for high feed rates and rapid material removal.

Spare Parts

Screws BFTX 0306A
Key T10 FLAG

ADD "LH" TO END OF CODE TO DENOTE LEFT HAND ROTATION e.g. DSP1840-20 LH

LAST DIGITS ON CODE NUMBER DENOTES SHANK SIZE CHOOSE EITHER 1/2 OR 16

Plunging Router Bits 2 Flute 18 mm-40mm

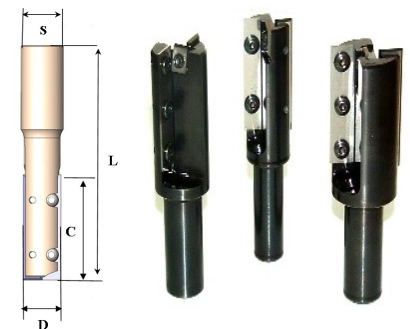
Application:

For use on overhead and C.N.C routers or similar machines where a vertical plunge infeed is required as well as lateral feed.

AVAILABLE IN BOTH LEFT AND RIGHT HAND ROTATION.

Sizes Available in both LH and RH Rotation

CODE	D	C	L	S	Wings	Inserts
DPL1650-1/2 *	16	50	103	1/2	2	50x5.5x1.1 EC
DPL1850-1/2 *	18	50	103	1/2	2	50x5.5x1.1 EC
DPL1850-M3-1/2 *	18	50	103	1/2	2	50x9x1.5 EC
DPL2030-16 or 20	20	30	96	16 or 20	2+1	30x9x1.5 EC
DPL2040-16 or 20	20	40	96	16 or 20	2+1	40x9x1.5 EC
DPL2050-16 or 20	20	50	106	16 or 20	2+1	50x9x1.5 EC
DPL2240-16 or 20	22	40	106	16 or 20	2+1	40x9x1.5 EC
DPL2250-16 or 20	22	50	120	16 or 20	2+1	50x9x1.5 EC
DPL2540-16 or 20	25	40	106	16 or 20	2+1	40x9x1.5 EC
DPL2550-16 or 20	25	50	120	16 or 20	2+1	50x9x1.5 EC
DPL3050-3W-16 or 20*	30	50	120	16 or 20	3+1	50x12x1.5 EC
DPL3530-3W-16 or 20*	35	30	110	16 or 20	3+1	30x12x1.5 EC
DPL3550-3W-16 or 20*	35	50	120	16 or 20	3+1	50x12x1.5 EC
DPL4050-3W-16 or 20*	40	50	120	16 or 20	3+1	50x12x1.5 EC



Special Features

DPL Routers have 2 Inserts that run the full length of cut with a 3rd insert across centerline allowing plunge capability. Large gullet area for high feed rates and large material removal.

Spare Parts

Screws M 3.5 x 7HD / BFTX0306A
M4 x 7 HD / M4 x 8HD

Wedges WR50-5.5-1.1

Central Insert: 7.5x12x1.5
9.5x12x1.5
10.5x12x1.5 / 10.5x10.5x1.5

Key T15 FLAG / T8 FLAG

* DPL1850 do not have a centre insert, ramp plunge only

* 3W Denotes 3 wing.

LAST DIGITS ON CODE NUMBER DENOTES SHANK SIZE CHOOSE EITHER 1/2 OR 16 OR 20.

ADD LH TO END OF P/No TO DENOTE LEFT HAND ROTATION EG.... 2 PIECES x DPL2040-16 LH

Planer Router Bits

2 + 3 + 4 Wing

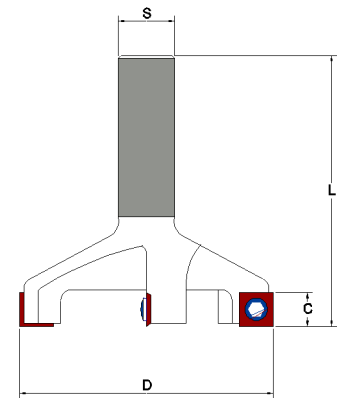


Application :

For planing of large work pieces, flat surfaces and large rebates in one pass and other heavy cutting application. Very suitable for machining of spoil -boards on flat bed C N C machines.

Sizes Available

CODE	D	C	L	S	No Wings	Insert size
DP5012-1/2	50	12	63	1/2	3	12 x 12 x 1.5
DP5512-1/2	55	12	80	1/2	3	12 x 12 x 1.5
DP8012-16	80	12	83	16	4	12 x 12 x 1.5
DP8012-20	80	12	83	20	4	12 x 12 x 1.5
DP9012-20	90	12	100	20	5	12 x 12 x 1.5
DP9220-20	92	20	100	20	4	20 x 12 x 1.5 EC
DP10012-20	100	12	100	20	5	12 x 12 x 1.5
DP12512-25	125	12	140	25	6	12 x 12 x 1.5
Plunge Planers						
DPP4012-16	40	12	75	16	2	20 x 12 x 1.5 EC
DPP4012-20	40	12	75	20	2	20 x 12 x 1.5 EC
DPP5012-16	50	12	75	16	2	25 x 12 x 1.5 EC
DPP5012-20	50	12	75	20	2	25 x 12 x 1.5 EC
DPP6012-16	60	12	75	16	2	30 x 12 x 1.5 EC
DPP6012-20	60	12	75	20	2	30 x 12 x 1.5 EC



SPARE PARTS.

Screws
Key

M4 x 8 HD
T15 Flag

Vee Bits.

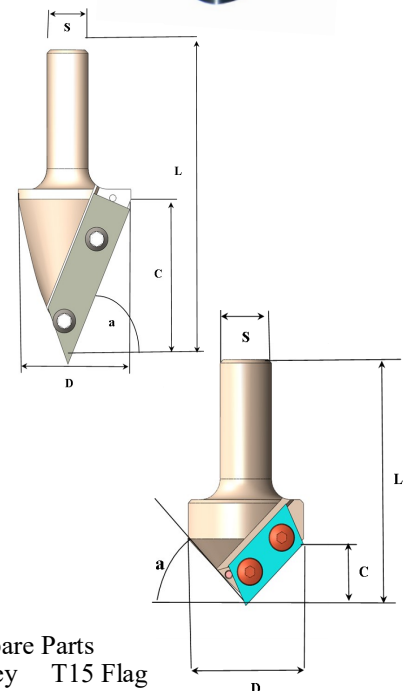
1 Wing and 2 Wing

Application:

For a wide range of usage in both woodworking and sign writing industries. Widely used in overhead C.N.C routing machines for chamfering and decorative vee grooves.

Sizes Available

CODE	Incl Angle	D	C	L	S	Insert	Screws
DV4540-1/2	45	42	40	91	1/2	V45 50 x 12	M3.5 x 6 HD
DV4540-16	45	42	40	91	16	V45 50 x 12	M3.5 x 6 HD
DV6016-1/2	60	20	16	68	1/2	V60 20 x 12	M3.5 x 6 HD
DV6040-16	60	48	40	102	16	V60 50 x 12	M4 x 8 HD
DV9010-1/2	90	26	10	66	1/2	V90 20 x 12	M3.5 x 6 HD
DV9016-1/2	90	36	16	70	1/2	V90 30 x 12	M4 x 8 HD
DV9016-16	90	36	16	70	16	V90 30 x 12	M4 x 8 HD
DV9034-20	90	70	34	105	20	V45 50 x 12	M4 X 8 HD
DV91-1/2	91	18	8	60	1/2	12 x 12 x 1.5	M4 X 8 HD
DV10010-1/2	100	44	10	76	1/2	20 x 12 x 1.5	M4 X 8 HD
DV12010-1/2	120	46	10	75	1/2	20 x 12 x 1.5	M4 X 8 HD
DV12010-16	120	46	10	75	16	20 x 12 x 1.5	M4 X 8 HD
DV12016-16	120	46	16	75	16	30 x 12 x 1.5	M4 X 8 HD
DV12712-16	127	54	12	85	16	V60 30 x 12	M4 X 8 HD
DV12712-20	127	54	12	85	20	V60 30 x 12	M4 X 8 HD
DV13512-16	135	54	12	85	16	V60 30 x 12	M4 X 8 HD
DV13512-20	135	54	12	85	20	V60 30 x 12	M4 X 8 HD
DV14010-20	140	60	10	70	20	V60 30 x 12	M4 X 8 HD



Spare Parts

Key T15 Flag
Screws See Table
DV4540 also takes M3.5 x 6 HD ES screw.

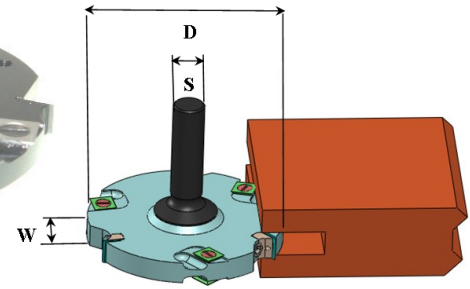
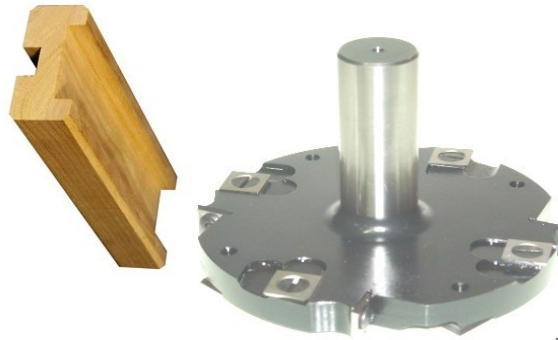
Tee Slot Cutters

4+4 Wing



Application:

For use on overhead routing machines to produce edge grooves or full tee slots in timbers or MDF board. Where full tee slot is required material must be pre slotted. Minimum width of Pre slot is 30 mm.



Sizes Available

CODE	D	Shank	W	No. Wings	Insert	Scribe
DTSC5512-1/2	55	12.7	12	4	12x12x1.5	14x14x2
DTSC10010-20	100	20	10	4+4	9x12x1.5	14x14x2
DTSC10012-20	100	20	12	4+4	11x12x1.5	14x14x2
DTSC10016-20	100	20	16	4+4	15x12x1.5	14x14x2
DTSC12010-20	120	20	10	4+4	9x12x1.5	14x14x2
DTSC12012-20	120	20	12	4+4	10x12x1.5	14x14x2
DTSC12016-20	120	20	16	4+4	15x12x1.5	14x14x2
DTSC12020-20	120	20	20	4+4	18x12x1.5	14x14x2
DTSC14016-20	140	20	16	4+4	15x12x1.5	14x14x2
DTSC14018-20	140	20	18	4+4	17x12x1.5	14x14x2
DTSC14020-20	140	20	20	4+4	18x12x1.5	14x14x2

Special Features:

Scribes give accurate width and smooth faces to slot. Inserts positively located.

Spare Parts

- Wedge W0912-TS-T3
- W1012-TS-T3
- W1212-TS-T3
- W1512-TS-T3
- W1812-TS-T3
- W2012-TS-T2
- Screw M5x 12 TH
- Key 4AF TEE
- Scribe Screw Short SS-M5 x 9
- Scribe Screw Long SS-M5 x 12

Edge Mould Router

2 Wing

Application:

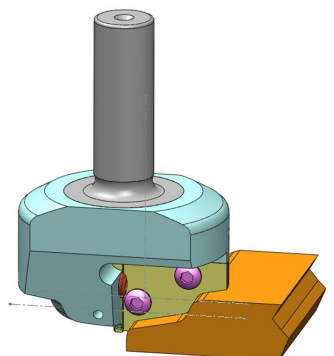
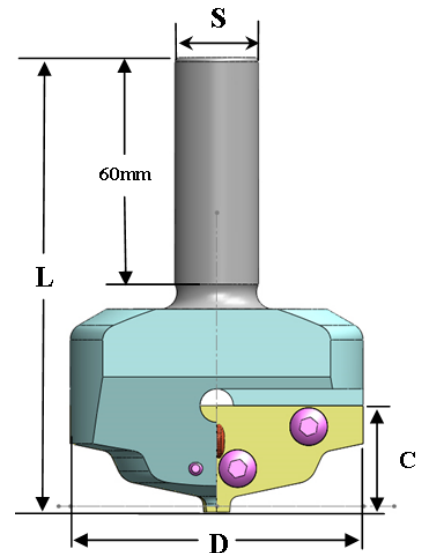
For production of various edge profiles on CNC routing machines. Can be used for routing of edge profiles on MDF kitchen doors, particle board, & solid timber doors.

Special Features

Large range of standard profiles, together with special profiles, are available to suite a large variety of applications. Inserts can be re-sharpened. Profiles and details of insert sizes available upon request.

Sizes Available

CODE	D	C	L	Shank	No. Wings	Blank Insert
DPR7025-16 or 20	70	25	110	16 or 20	2	35 x 25 x2 OS
DPR7035-16 or 20	70	35	120	16 or 20	2	35 x 35 x 2 OS
DPR8040-16 or 20	80	40	130	16 or 20	2	40 x 40 x 2 OS
DPR9820-16 or 20	98	20	110	16 or 20	2	50 x 20 x 2
DPR9825-16 or 20	98	25	120	16 or 20	2	50 x 25 x 2
DPR9835-16 or 20	98	35	130	16 or 20	2	50 x 35 x 2
DPR9840-16 or 20	98	40	130	16 or 20	2	50 x 40 x 2



- Spare Parts
- Screw M4 x 9HD
- Key T15 Flag

LAST DIGITS ON CODE NUMBER DENOTES SHANK SIZE CHOOSE EITHER 16 OR 20.

Joint And Rebate Router

3 + 3 Wing

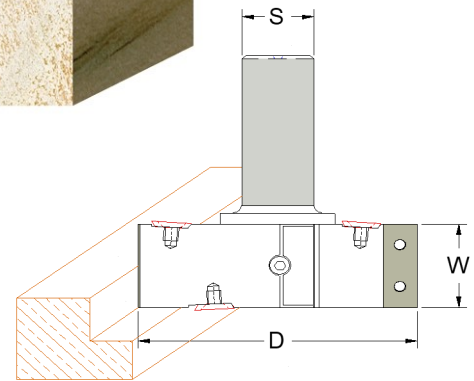


Application:

For use on CNC and overhead routing machines to produce a rebates in edge of timber or sizing and edge profiling up to 50 mm thick board.
Tool has 3 cutting edges + 3 scribes on bottom.

Special Features:

Ground Steel shank and Heat Treated aluminium body ensures precision running with light weight.
Scribes give accurate width and smooth faces on slot sides.
Tools are 3+3 wing for smooth running and high chip clearance.



Sizes Available

CODE	D	S	W	No. Wings	Inserts	Scribes
DJR 8030-20 or 25	80	20 or 25	30	3+3	30x12x1.5	14x14x2
DJR 8040-20 or 25	80	20 or 25	40	3+3	40x12x1.5	14x14x2
DJR 8050-20 or 25	80	20 or 25	50	3+3	50x12x1.5	14x14x2
DJR 12530-20 or 25	125	20 or 25	30	3+3	30x12x1.5	14x14x2
DJR 12540-20 or 25	125	20 or 25	40	3+3	40x12x1.5	14x14x2
DJR 12550-20 or 25	125	20 or 25	50	3+3	50x12x1.5	14x14x2

Spare Parts

Wedge W3012-TS-T3
W4012-TS-T3
W5012-TS-T3
Screw M6 x 16 TH
Scribe Screw SS-M5 x 12
Key 5AF TEE

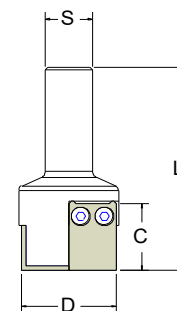
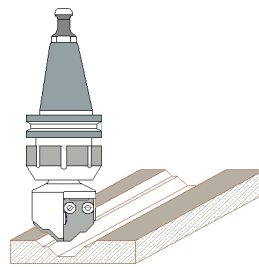
LAST DIGITS ON CODE NUMBER DENOTES SHANK SIZE CHOOSE EITHER 20 OR 25.

Profile Router Bits

2 Wing

Application:

For use on C.N.C routers or similar machines where a special profile is required to be machined on all solid woods, man made composite panels, plastics. and some aluminum composite panels.
Particularly suitable for door and panel production.



Sizes Available.

CODE	D	C	L	Shank	No Wings	Inserts
DPR 4016-16 or 20	40	20	100	16 or 20	2	20x30x2 FT
DPR 5021-16 or 20	50	25	110	16 or 20	2	25x35x2 FT
DPR6040-16 or 20	60	40	120	16 or 20	2	40x30x2FT
DPR6050-16 or 20	60	50	130	16 or 20	2	50x30x2FT
DPR8050-16 or 20	80	50	130	16 or 20	2	50x40x2FT
DPR5025-16 or 20	50	25	100	16 or 20	2	25x25x2 OS
DPR6030-16 or 20	60	30	110	16 or 20	2	30x30x2 OS
DPR7035-16 or 20	70	35	140	16 or 20	2	35x35x2 OS
DPR 8040-16 or 20	80	40	140	16 or 20	2	40x40x2 OS
DPR 10050-16 or 20	100	50	140	16 or 20	2	50x50x2 OS

Tools come complete with blank inserts ready for profiling. Alternatively, CROWN TOOLING will profile tool ready for use. Specials tools to suite certain applications can be manufactured on short delivery.

Spare Parts

Screw M4 x 8HD
Key T15 Flag

LAST DIGITS ON CODE NUMBER DENOTES SHANK SIZE CHOOSE EITHER 16 OR 20.

Profile Edge Mould

2 Wing

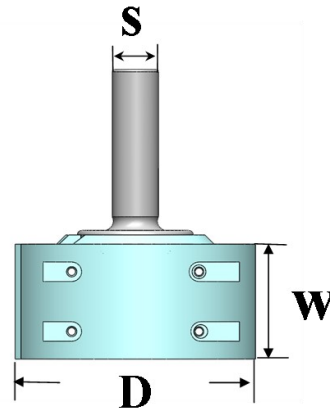


Application:

For producing various profiles on the edge of timber from 16mm to 50mm thick.
Excellent for both Solid Timber and MDF.

Special Features:

Ground Steel shank and Heat Treated aluminium body ensures precision running, high strength, rigidity, and light weight.
Inserts held by secure heavy duty screws for easy change over and minimal spare parts.
Tools are 2 wings for smooth running and high chip clearance.



Sizes Available

CODE	D	S	W	No. Wings	Inserts	Screws
DEM 110 3030-25	110	25	30	2	30 x 30 x 2	M4 x 9 HD
DEM 110 3530-25	110	25	35	2	35 x 30 x 2	M4 x 9 HD
DEM 110 5030-25	110	25	50	2	50 x 30 x 2	M4 x 9 HD
DEM 110 5035-25	110	25	50	2	50 x 35 x 2	M4 x 9 HD

Spare Parts

- Insert 30 x 30 x 2 PROFILED
- 35 x 30 x 2 PROFILED
- 50 x 30 x 2 PROFILED
- 50 x 35 x 2 PROFILED
- Screw M4 x 9 HD
- Key T15—TORX

ALL TOOLS ARE CUSTOM PROFILED TO REQUIREMENTS.

Solid Door Profile Router

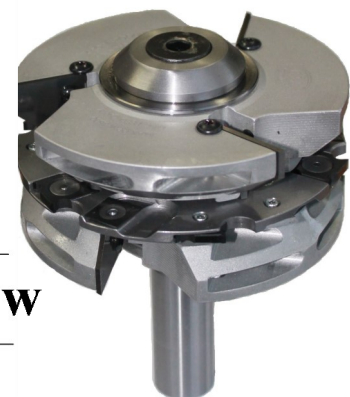
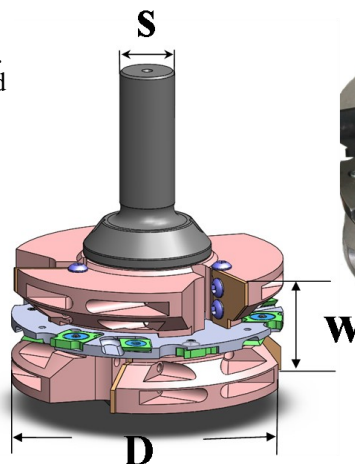
3+3 Wing

Application:

For use on C.N.C routers or similar machines where a solid timber door profile is required to be machined.
Suitable on all solid woods, to produce both cabinet and entry door profiles.
All profiles to customer's requirements.

Special Features:

Ground Steel shank and Heat Treated aluminium body ensures precision running high strength, rigidity, and light weight.
Inserts held by secure heavy duty screws for easy change over and minimal spare parts.
Tools are 3 wings for smooth running and high chip clearance.



Sizes Available.

CODE	D	S	W	No Wings	Inserts
DFDP 125-2530-25	125	25	80	3+3	25 x 35 x 2 FT
DFDCP 125-2530-25	125	25	80	3+3	25 x 35 x 2 FT
DCDP 125-2530-25	125	25	80	3+3	25 x 35 x 2 FT
DCDCP 125-2530-25	125	25	80	3+3	25 x 35 x 2 FT

Spare Parts

Profile Cutter:

- Insert 25 x 35 x 2 FT PROFILED
- Screw M4 x 8HD
- Key T15 Flag

Groover Cutter:

- Insert 18 x 18 x 3.6
- 14 x 14 x 2 scribe insert
- Washer: WSHR 18
- WSHR 14
- Screw M3 x 6 CSNK-TX

ALL TOOLS ARE CUSTOM PROFILED TO REQUIREMENTS.

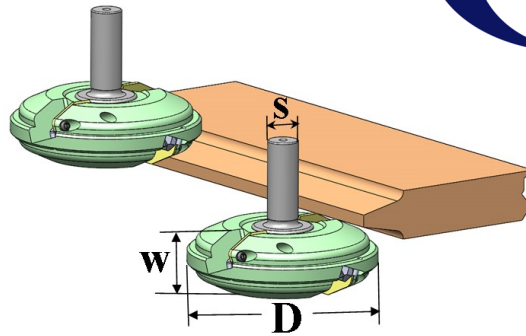
Raised Panel Router

2 Wing / 3 Wing



Application:

For producing various raised panel profiles on timber from 16mm to 50mm thick.
 Excellent for both Solid Timber and MDF.
 Double raised panel router available for producing entry door center panel in 1 set up.



Special Features:

Ground steel shank and Heat Treated aluminium body ensures precision running, high strength, rigidity and light weight.

TWO TYPES AVAILABLE:

Single Raised Panel

CODE	D	S	W	No. Wings	Inserts	Screws
DRP-110 4025-20	110	20	35	3	40 x 25 x 2	M5 x 16 LTHS
DRP-110 4025-25	110	25	35	3	40 x 25 x 2	M5 x 16 LTHS

TOOLS ARE PROFILED TO CUSTOMS REQUIREMENTS

Double Raised Panel

CODE	D	S	W	No. Wings	Inserts	Screws
DRP-DB 140 4025-25	140	25	50	2+2	40 x 25 x 2	M5 x 16 LTHS

TOOLS ARE PROFILED TO CUSTOMS REQUIREMENTS



Spare Parts

- Insert 40 x 25 x 2 PROFILED
- Screw M5 x 16 LTHS
- Key M4 ALLEN KEY
- Wedge: CRP 4025-T3

Rebate Router

2 Wing

Application:

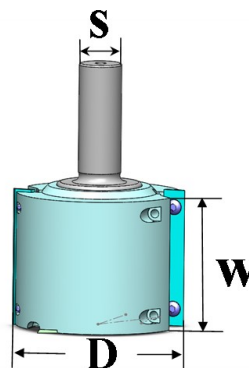
For use on C.N.C routers for trimming edges or machining a full rebate. 2 wings tool with scribes to ensure a clean cut in both left hand and right hand rotation for long gain on end gain routing as well as long gain on end gain rebating.

Special Features:

Ground steel shank and Heat Treated aluminium body ensures precision running, high strength, rigidity and light weight.

Sizes Available.

CODE	D	L	Shank	No Wings	Inserts
DRR-100 5012-25	100	50	25	2	50 x 12 x 1.5 / 14 x 14x 2
DRR-100 5012-LH-25	100	50	25	2	50 x 12 x 1.5 / 14 x 14x 2
DRR-100 6012-25	100	60	25	2	60 x 12 x 1.5 / 14 x 14x 2
DRR-100 6012-LH-25	100	60	25	2	60 x 12 x 1.5 / 14 x 14x 2
DRR-100 8013-25	100	80	25	2	80 x 13 x 2.2 / 14 x 14x 2
DRR-100 8013-LH-25	100	80	25	2	80 x 13 x 2.2 / 14 x 14x 2



Spare Parts

- Insert: 50 x 12 x 1.5
- 60 x 12 x 1.5
- 80 x 13 x 2.2
- 14 x 14 x 2
- Screw M4 x 9 HD
- SS M5 x 12
- Key T15 Torx

NOTE:
 "LH" FOR LEFT
 HAND ROTATION.

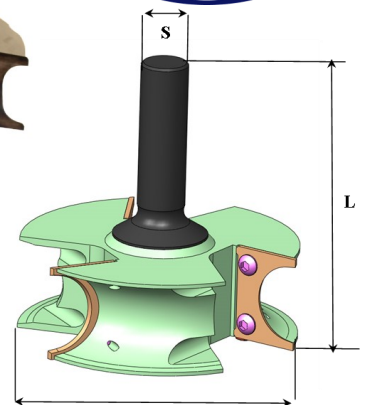
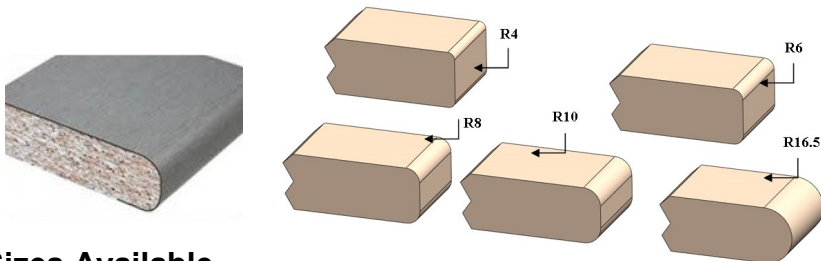
Post Forming Router Profiles

2 Wing



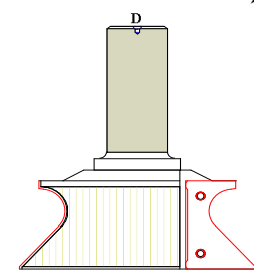
Application:

For production of various Post-forming profiles on CNC routing machines.
 Normally used for routing of edge profiles and kitchen bench tops.
 Also can be set for rebate on lower surface of board.
 Uses 40mm wide inserts.



Sizes Available

CODE	D	L	Shank	Wings	Insert Used
DPFF 1004035-R4-16 or 20	100	40	16 or 20	2	40 x 35 x 2 FT P1064
DPFF 1004035-R6-16 or 20	100	40	16 or 20	2	40 x 35 x 2 FT P1063
DPFF 1004035-R8-16 or 20	100	40	16 or 20	2	40 x 35 x 2 FT P1062
DPFF 1004035-R10-16 or 20	100	40	16 or 20	2	40 x 35 x 2 FT P1061
DPFF 1004035-R16.5-16 or 20	100	40	16 or 20	2	40 x 35 x 2 FT P186
DPFF 1004035-SN-16 or 20 Shark Nose Profile	100	40	16 or 20	2	40 x 35 x 2 FT P1092



SHARK NOSE

Spare Parts

Screw M4 x 9HD
 Key T15 Torx SD

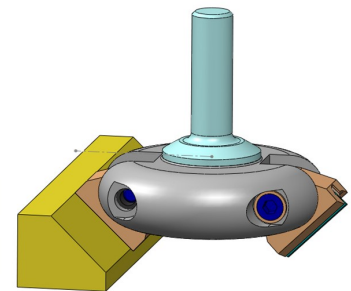
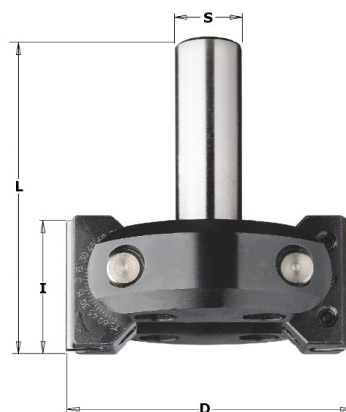
LAST DIGITS ON CODE NUMBER DENOTES SHANK SIZE CHOOSE EITHER 16 OR 20.

Adjustable Angle Router

2 Wing

Application:

For production of various angled profiles on CNC routing machines.
 Normally used for routing of edge profiles on long length timber, also can be set for angled rebate on top surface of board.
 Uses 40 or 50 mm wide inserts.



Sizes Available

CODE	D	L	I	Shank	Wings	Insert used
DAAR 12540-20	125	120	40	20	2	40 x 12 x 1.5
DAAR 12540-25	125	120	40	25	2	40 x 12 x 1.5
DAAR 12550-20	125	130	50	20	2	50 x 12 x 1.5
DAAR 12550-25	125	130	50	25	2	50 x 12 x 1.5

Spare Parts :

Wedge W4012-TS-T3
 W5012-TS-T3
 Screw M6 x 10 DPGS
 M8 x 20 LSHSCS
 Key M5 ALLEN KEY
 M3 ALLEN KEY

Dowel Drills and Hinge Bore Bits



Dowel Drills

Dowel Drills are used for the precision drilling of either through and blind holes for inserting dowels and pins on all types of timber and man made materials. Tools made from high tensile steel with Carbide tips and are precision ground on both the 10mm shank and the cutting tips for consistent concentric drilling.

Available in both LEFT HAND and RIGHT HAND rotation



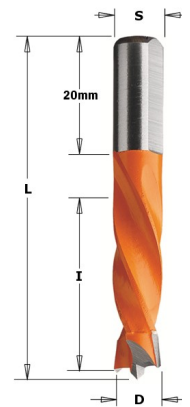
V-THROUGH HOLE DRILLS 57mm and 70mm

57 mm RH	57 mm LH	D	L	S	I	70 mm RH	70 mm LH	D	L	S	I
DDT1057-3-RH	DDT1057-3-LH	3	57	10	30	DDT1070-3-RH	DDT1070-3-LH	3	70	10	30
DDT1057-3.5-RH	DDT1057-3.5-LH	3.5	57	10	30	DDT1070-3.5-RH	DDT1070-3.5-LH	3.5	70	10	30
DDT1057-4-RH	DDT1057-4-LH	4	57	10	30	DDT1070-4-RH	DDT1070-4-LH	4	70	10	30
DDT1057-4.5-RH	DDT1057-4.5-LH	4.5	57	10	30	DDT1070-4.5-RH	DDT1070-4.5-LH	4.5	70	10	30
DDT1057-5-RH	DDT1057-5-LH	5	57	10	30	DDT1070-5-RH	DDT1070-5-LH	5	70	10	30
DDT1057-6-RH	DDT1057-6-LH	6	57	10	30	DDT1070-6-RH	DDT1070-6-LH	6	70	10	30
DDT1057-6.5-RH	DDT1057-6.5-LH	6.5	57	10	30	DDT1070-6.5-RH	DDT1070-6.5-LH	6.5	70	10	30
DDT1057-7-RH	DDT1057-7-LH	7	57	10	30	DDT1070-7-RH	DDT1070-7-LH	7	70	10	30
DDT1057-8-RH	DDT1057-8-LH	8	57	10	30	DDT1070-8-RH	DDT1070-8-LH	8	70	10	30
DDT1057-10-RH	DDT1057-10-LH	10	57	10	30	DDT1070-10-RH	DDT1070-10-LH	10	70	10	30
DDT1057-12-RH	DDT1057-12-LH	12	57	10	30	DDT1070-12-RH	DDT1070-12-LH	12	70	10	30
DDT1057-12.7-RH	DDT1057-12.7-LH	12.7	57	10	30	DDT1070-12.7-RH	DDT1070-12.7-LH	12.7	70	10	30



BRAD POINT DRILLS 57mm and 70mm

57 mm RH	57 mm LH	D	L	S	I	70 mm RH	70 mm LH	D	L	S	I
DDB1057-3-RH	DDB1057-3-LH	3	57	10	30	DDB1070-3-RH	DDB1070-3-LH	3	70	10	30
DDB1057-3.5-RH	DDB1057-3.5-LH	3.5	57	10	30	DDB1070-3.5-RH	DDB1070-3.5-LH	3.5	70	10	30
DDB1057-4-RH	DDB1057-4-LH	4	57	10	30	DDB1070-4-RH	DDB1070-4-LH	4	70	10	30
DDB1057-4.5-RH	DDB1057-4.5-LH	4.5	57	10	30	DDB1070-4.5-RH	DDB1070-4.5-LH	4.5	70	10	30
DDB1057-5-RH	DDB1057-5-LH	5	57	10	30	DDB1070-5-RH	DDB1070-5-LH	5	70	10	30
DDB1057-6-RH	DDB1057-6-LH	6	57	10	30	DDB1070-6-RH	DDB1070-6-LH	6	70	10	30
DDB1057-6.5-RH	DDB1057-6.5-LH	6.5	57	10	30	DDB1070-6.5-RH	DDB1070-6.5-LH	6.5	70	10	30
DDB1057-7-RH	DDB1057-7-LH	7	57	10	30	DDB1070-7-RH	DDB1070-7-LH	7	70	10	30
DDB1057-8-RH	DDB1057-8-LH	8	57	10	30	DDB1070-8-RH	DDB1070-8-LH	8	70	10	30
DDB1057-10-RH	DDB1057-10-LH	10	57	10	30	DDB1070-10-RH	DDB1070-10-LH	10	70	10	30
DDB1057-12-RH	DDB1057-12-LH	12	57	10	30	DDB1070-12-RH	DDB1070-12-LH	12	70	10	30
DDB1057-12.7-RH	DDB1057-12.7-LH	12.7	57	10	30	DDB1070-12.7-RH	DDB1070-12.7-LH	12.7	70	10	30



BRAD POINT DRILLS 90mm and 120mm

90 mm RH	90 mm LH	D	L	S	I	120 mm RH	120 mm LH	D	L	S	I
DDB1090-3-RH	DDB1090-3-LH	3	90	10	30	DDB10120-3-RH	DDB10120-3-LH	3	120	10	30
DDB1090-3.5-RH	DDB1090-3.5-LH	3.5	90	10	30	DDB10120-3.5-RH	DDB10120-3.5-LH	3.5	120	10	30
DDB1090-4-RH	DDB1090-4-LH	4	90	10	30	DDB10120-4-RH	DDB10120-4-LH	4	120	10	30
DDB1090-4.5-RH	DDB1090-4.5-LH	4.5	90	10	30	DDB10120-4.5-RH	DDB10120-4.5-LH	4.5	120	10	30
DDB1090-5-RH	DDB1090-5-LH	5	90	10	30	DDB10120-5-RH	DDB10120-5-LH	5	120	10	30
DDB1090-6-RH	DDB1090-6-LH	6	90	10	30	DDB10120-6-RH	DDB10120-6-LH	6	120	10	30
DDB1090-6.5-RH	DDB1090-6.5-LH	6.5	90	10	30	DDB10120-6.5-RH	DDB10120-6.5-LH	6.5	120	10	30
DDB1090-7-RH	DDB1090-7-LH	7	90	10	30	DDB10120-7-RH	DDB10120-7-LH	7	120	10	30
DDB1090-8-RH	DDB1090-8-LH	8	90	10	30	DDB10120-8-RH	DDB10120-8-LH	8	120	10	30
DDB1090-10-RH	DDB1090-10-LH	10	90	10	30	DDB10120-10-RH	DDB10120-10-LH	10	120	10	30
DDB1090-12-RH	DDB1090-12-LH	12	90	10	30	DDB10120-12-RH	DDB10120-12-LH	12	120	10	30
DDB1090-12.7-RH	DDB1090-12.7-LH	12.7	90	10	30	DDB10120-12.7-RH	DDB10120-12.7-LH	12.7	120	10	30

HINGE BORE BITS



Hinge Bore Bits

Hinge Bore Bits are used for the precision drilling of blind hinge holes for inserting hinges into all types of timber and man made materials.

Tools made from high tensile steel with Carbide tips and are precision ground on both the 10mm shank and the cutting tips for consistent concentric drilling.

Available in both LEFT HAND and RIGHT HAND rotation

HINGE BORE BITS 57mm and 70mm

57 mm RH	57 mm LH	D	L	S	I	70 mm RH	70 mm LH	D	L	S	I
DBB1057-15-RH	DBB1057-15-LH	15	57	10	26	DBB1070-15-RH	DBB1070-15-LH	15	70	10	26
DBB1057-20-RH	DBB1057-20-LH	20	57	10	26	DBB1070-20-RH	DBB1070-20-LH	20	70	10	26
DBB1057-25-RH	DBB1057-25-LH	25	57	10	26	DBB1070-25-RH	DBB1070-25-LH	25	70	10	26
DBB1057-30-RH	DBB1057-30-LH	30	57	10	26	DBB1070-30-RH	DBB1070-30-LH	30	70	10	26
DBB1057-35-RH	DBB1057-35-LH	35	57	10	26	DBB1070-35-RH	DBB1070-35-LH	35	70	10	26
DBB1057-40-RH	DBB1057-40-LH	40	57	10	26	DBB1070-40-RH	DBB1070-40-LH	40	70	10	26
DBB1057-45-RH	DBB1057-45-LH	45	57	10	26	DBB1070-45-RH	DBB1070-45-LH	45	70	10	26
DBB1057-50-RH	DBB1057-50-LH	50	57	10	26	DBB1070-50-RH	DBB1070-50-LH	50	70	10	26
DBB1057-55-RH	DBB1057-55-LH	55	57	10	26	DBB1070-55-RH	DBB1070-55-LH	55	70	10	26



Dowel Drill Adaptors LH + RH ROTATION

M10 RH	M10 LH	D3	D2	S	M10-11RH	M10-11RH	D3	D2	S
DDA-M10-RH	DDA-M10-LH	10	20	M10	DBB-M1011-RH	DBBM1011-LH	15	70	M10
M10x30RH	M10x30LH	D3	D2	S	M10-11RH	M10-11RH	D3	D2	S
DDA-M1030-RH	DDA-M1030-LH	10	M10x30						



DIGITAL TOOL PRESETTER

The Crown Tool presetter allows for the precise setting of tool lengths on all CNC router bits held in collet chucks.

Digital read-out gives quick, easy reliable measurements.

The Tool presetter is adjustable to suit different diameter cutters, as it is mounted on cast iron slide ways.

Precision taper in tool holder always gives positive location.

Made to suit all popular collet chuck tapers.

Greatly reduce set up time.





C.T.A
SPECIALISTS IN
WOODWORKING TOOLS

DISPOSABLE TIP STRAIGHT ROUTERS

**Hand Held Routers Table Routers
CNC Routing Machines**



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Unit 1, 2 Warrior Place
St Marys N.S.W 2760 Australia
Ph. 02 9833 0150 - Email: tooling@crowntooling.com
www.crowntooling.com.au

SECTION IV

Straight Bits with 2 Flutes

Non Plunge



Sizes Available

CODE	D	C	L	S	Inserts
D1830-1/2 or 16	18	30	74	1/2 or 16 mm	30x12x1.5
D1840-1/2 or 16	18	40	84	1/2 or 16 mm	40x12x1.5
D1850-1/2 or 16	18	50	84	1/2 or 16 mm	50x12x1.5
D1912-1/4	19	12	48	1/4	12x12x1.5
D1912-1/2	19	12	57	1/2	12x12x1.5
D1930-1/2 or 16	19	30	74	1/2 or 16 mm	30x12x1.5
D1940-1/2 or 16	19	40	84	1/2 or 16 mm	40x12x1.5
D1950-1/2 or 16	19	50	94	1/2 or 16 mm	50x12x1.5
D2030-1/2 or 16	20	30	74	1/2 or 16 mm	30x12x1.5
D2040-1/2 or 16	20	40	84	1/2 or 16 mm	40x12x1.5
D2050-1/2 or 16	20	50	84	1/2 or 16 mm	50x12x1.5

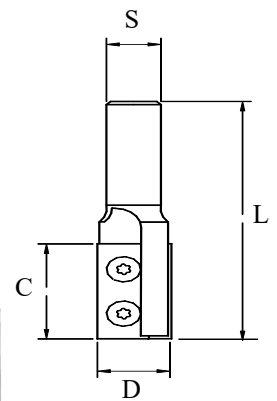
LAST DIGITS ON CODE NUMBER DENOTES SHANK SIZE CHOOSE EITHER 1/2 OR 16.

Application :

For general routing operations, e.g. Jointing, edge trimming, grooving, rebating and slots if end cutting inserts fitted. Takes standard inserts, end cutting if required.

SPARE PARTS

Screw M4 X 8HD
Key T15 Flag



Trimming Bits

2 Flutes 1 or 2 Bearings

Sizes Available

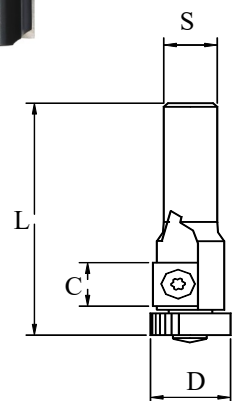
CODE	D	C	L	S	Insert
D1912B-1/4	19	12	55	1/4	12x12x1.5
D1912BB-1/4	19	12	61	1/4	12x12x1.5
D1912B-1/2	19	12	55	1/2	12x12x1.5
D1912BB-1/2	19	12	61	1/2	12x12x1.5
D1930B-1/2	19	30	63	1/2	30x12x1.5
D1930BB-1/2	19	30	81	1/2	30x12x1.5
D1940B-1/2	19	40	73	1/2	40x12x1.5
D1940BB-1/2	19	40	91	1/2	40x12x1.5
D1950B-1/2	19	50	100	1/2	50x12x1.5
D1950BB-1/2	19	50	100	1/2	50x12x1.5

Application :

For general trimming operations, where a ball bearing follower is required. Also used for profiling work with a template. Takes standard TOK. 2 bearing (BB) design for use with softer materials.

SPARE PARTS

Screw M4 X 8HD
Bearing 626-ZZ
Key T15 Flag



Inverted Trimming Bits 2 & 3 Flutes With Bearing

Sizes Available

CODE	D	C	L	S	Insert	Bearing
DI 1920B-1/4	19	20	60	1/4	20x12x1.5	R1212-ZZ
DI 1930B-1/2	19	30	78	1/2	30x12x1.5	R1212-ZZ
DI1940B-1/2	19	40	88	1/2	40x12x1.5	R1212-ZZ
DI 1950B-1/2	19	50	98	1/2	50x12x1.5	R1212-ZZ
DI 2440B-1/2	24	40	91	1/2	40x12x1.5	6802-ZZ
DI 2450B-1/2	24	50	98	1/2	50x12x1.5	6802-ZZ
DI 2830B-1/2	28.6	30	78	1/2	30x12x1.5	R8-ZZ
DI 2840B-1/2	28.6	40	86	1/2	40x12x1.5	R8-ZZ
DI 2850B-1/2	28.6	50	96	1/2	50x12x1.5	R8-ZZ
DI 2450B-3W-1/2	24	50	98	1/2	50x12x1.5	6802-ZZ

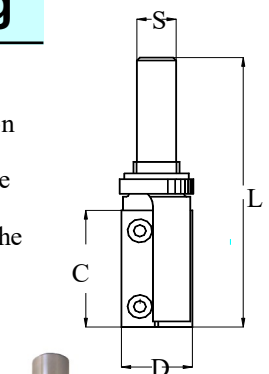
Application:

Ideal for copy routing on large components or assemblies, where the template can be placed between the work and the router. Takes standard TOK.

SPARE PARTS

Screw M4 X 8HD
Retainer Ring
BRR12.7186
Key T15 Flag

PART NUMBER WITH 3W IS FOR 3 FLUTE



Mortise Bits

2 Wing



Application :

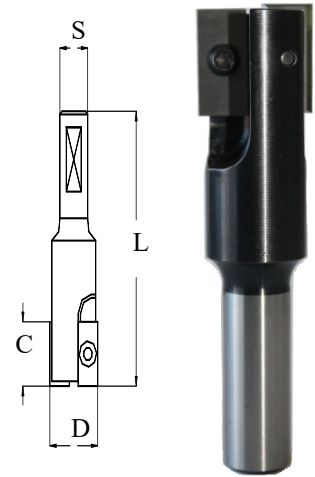
Specifically for stair tread mortises. Made in R.H and L.H. styles for Piles,/Robinson, and similar mortise machines. Can be used for general mortise production.

SPARE PARTS

Insert: 20 x 9 x 1.5 EC
 30 x 9 x 1.5 EC
 Screw M3.5 X 6HD
 Key T15 Flag

Sizes Available

CODE	D	C	L	S	ROTATION	Insert
DM20.620-1/2	20.6	20	84	1/2	R/Hand	20x9x1.5 EC
DM20.620-1/2 LH	20.6	20	84	1/2	L/Hand	20x9x1.5 EC
DM22.220-1/2	22.2	20	84	1/2	R/Hand	20x9x1.5 EC
DM22.220-1/2 LH	22.2	20	84	1/2	L/Hand	20x9x1.5 EC
DM22.230-1/2	22.2	30	94	1/2	R/Hand	30x9x1.5 EC
DM22.230-1/2 LH	22.2	30	94	1/2	L/Hand	30x9x1.5 EC



Straight Bits Plunge Cutting

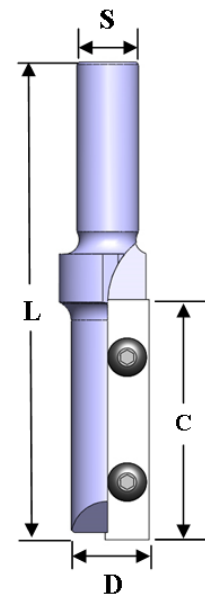
1 Wing

Application:

As the insert extends beyond the center line these router bits can be used for plunge cutting of recesses, closed end slots as well as open end grooves and rebates.

Sizes Available

CODE	D	C	L	S	Insert
DSP1230-1/2	12	30	84	1/2	30x9x1.5 EC
DSP12.730-1/2	12.7	30	84	1/2	30x9x1.5 EC
DSP1430-1/2	14	30	84	1/2	30x9x1.5 EC
DSP1630-1/2	16	30	84	1/2	30x9x1.5 EC
DSP1640-1/2	16	40	94	1/2	40x9x1.5 EC
DSP1640-16	16	40	94	16	40x9x1.5 EC
DSP1830-1/2	18	30	84	1/2	30x9x1.5 EC
DSP1840-1/2	18	40	94	1/2	40x9x1.5 EC
DSP1850-1/2	18	50	104	1/2	50x9x1.5 EC
DSP1930-1/2	19	30	84	1/2	30x9x1.5 EC
DSP1940-1/2	19	40	94	1/2	40x9x1.5 EC
DSP1940-16	19	40	94	16	40x9x1.5 EC
DSP2030-1/2	20	30	84	1/2	30x9x1.5 EC
DSP2040-1/2	20	40	94	1/2	40x9x1.5 EC
DSP2040-16	20	40	94	16	40x9x1.5 EC
DSP2050-1/2	20	50	104	1/2	50x9x1.5 EC
DSP2050-16	20	50	104	16	50x9x1.5 EC



SPARE PARTS

Screw M3.5 X 6HD
 Key T15 Flag

Trimming Cutter

3 Wing With Bearing



Application:

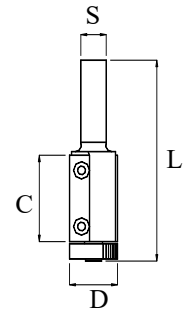
For an extra smooth edge or where a high rate of material removal is required.

Sizes Available

CODE	D	L	S	Insert
D2440-3W-B-1/2	24	94	1/2	40x12x1.5

Spare Parts

Screw M4 X 8HD
Key T15 Flag
Bearing 609 ZZ
Screw M5 x 12 CSNK



12° Trim Bits. For Small Edge Banding Machines

Application:

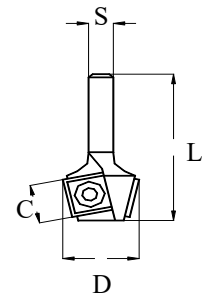
For trimming of edge banding tapes on the smaller sizes of machines.
Takes inserts 12x12x1.5

Sizes Available

CODE	D	C	L	S	ROTATION	Insert
D12-1/4 R.H.	20	12	46	1/4	RIGHT HAND	12x12x1.5
D12-1/4 L.H.	20	12	46	1/4	LEFT HAND	12x12x1.5

Spare Parts

Screw
M4 X 8HD
Key T15 Flag



22° Trimming Bits.

2 Wing With Bearing

Application :

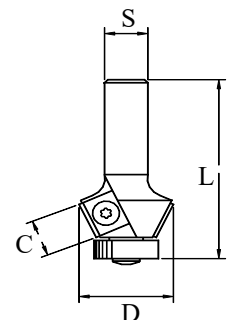
For trimming of laminates after application to substrate board.

Sizes Available

CODE	D	C	L	S	Inserts
D22B-1/4	26	12	52	1/4	12x12x1.5
D22B-1/2	26	12	58	1/2	12x12x1.5

SPARE PARTS

Screw M4 X 8HD
Bearing 626 ZZ
Key T15 Flag



45° Trim Bits

2 Wing With Bearing

Application:

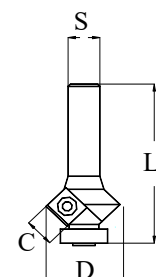
For edge beveling of boards, with or without laminate or veneer.

Sizes Available

CODE	D	C	L	S	Inserts
D45B-1/4	29	12	55	1/4	12x12x1.5
D45B-1/2	29	12	67	1/2	12x12x1.5

SPARE PARTS

Screw M4 X 8HD
Bearing 626 ZZ
Key T15 Flag



Indexable Carbide Inserts Turn over knife (TOK)



Carbide Inserts.

Replaceable carbide inserts for all Crown Tooling cutters.

Inserts come in a variety of grades and sizes.

**Many other sizes and styles available,
please contact Crown Tooling.**

Sizes Available

CODE 9 mm Insert	L	W	T	No Holes	P
7.6 x 9 x 1.5	7.6	9	1.5	1	-
9.6 x 9 x 1.5	9.6	9	1.5	1	-
12 x 9 x 1.5	12	9	1.5	1	-
15 x 9 x 1.5	15	9	1.5	1	-
20 x 9 x 1.5	20	9	1.5	1	-
25 x 9 x 1.5	25	9	1.5	2	14
30 x 9 x 1.5	30	9	1.5	2	14
40 x 9 x 1.5	40	9	1.5	2	26
50 x 9 x 1.5	50	9	1.5	2	26

CODE 12 mm Insert	L	W	T	No Holes	P
7.6 x 12 x 1.5	7.6	12	1.5	1	-
9.6 x 12 x 1.5	9.6	12	1.5	1	-
12 x 12 x 1.5	12	12	1.5	1	-
15 x 12 x 1.5	15	12	1.5	1	-
20 x 12 x 1.5	20	12	1.5	1	-
25 x 12 x 1.5	25	12	1.5	2	14
30 x 12 x 1.5	30	12	1.5	2	14
40 x 12 x 1.5	40	12	1.5	2	26
50 x 12 x 1.5	50	12	1.5	2	26
50 x 12 x 1.7	50	12	1.7	3	26
60 x 12 x 1.5	60	12	1.5	2	26

CODE SCRIBE INSERT	L	W	T
14 x 14 X 1.7	14	14	1.7
14 x 14 x 2	14	14	2
14.3 x 14.3 x 2.5	14.3	14.3	2.5
14.6 x 14.6 x 2.5	14.6	14.6	2.5
15 x 15 x 2.5	15	15	2.5

MINI REVERSIBLE KNIVES 2 EDGE BACK GROOVE
12 x 5.5 x 1.1
20 x 5.5 x 1.1
30 x 5.5 x 1.1
40 x 5.5 x 1.1
50 x 5.5 x 1.1

2 EDGE FACE GROOVE
12 x 5.5 x 1.1-2E
20 x 5.5 x 1.1-2E
30 x 5.5 x 1.1-2E
40 x 5.5 x 1.1-2E
50 x 5.5 x 1.1-2E

4 EDGE FACE GROOVE
20 x 5.5 x 1.1-4E
30 x 5.5 x 1.1-4E
40 x 5.5 x 1.1-4E
50 x 5.5 x 1.1-4E

4 EDGE BACK & CROSS GROOVE
20 x 5.5 x 1.1-CG
25 x 5.5 x 1.1-CG
30 x 5.5 x 1.1-CG
40 x 5.5 x 1.1-CG
50 x 5.5 x 1.1-CG

Inserts sold in boxes of 10
Please specify if END CUT required.

C.T.A

Unit 1, 2 Warrior Place

St Marys N.S.W 2760 Australia

Ph. 02 9833 0150 - Email: tooling@crowntooling.com

www.crowntooling.com.au



C.T.A SPECIALISTS IN WOODWORKING TOOLS

Technical Information

NOTE

These notes cover only some of the aspects of machine and tool safety and are designed to supplement your company's existing Occupational Health and Safety Procedures, which are a legal requirement under State Law.

As the exact conditions of running cutters is outside the control of CROWN TOOLING, customers must take full responsibility for the safe running of all machinery, equipment and tooling.

See **CONDITIONS OF SALE** which is part of this catalogue.

This portion of the notes covers aspects of safety which applies to all tooling.

All tools from Crown Tooling are manufactured to strict safety rules.

Tools are for use with mechanical feed only.



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SECTION V



The determination of the correct speeds and feeds to be used with disposable tipped cutters cannot be given exactly as it depends on a large number of inter-related factors which vary from job to job. However, general guidelines can be given which should result in a good starting point for further refinement.

The basic starting point is to determine the cutting speed to be used. The table below shows a range of materials commonly encountered, with a range of cutting speeds for each group of materials. Where natural timbers are being used, consideration should be given to the hardness of the timber, the structure of the timber in terms of the tendency of the fibres to lift or split, the abrasive quality of the material, and so on. Your timber supplier can often give detailed information on the features of the material they are supplying and recommend suitable cutting speeds and feeds.

Man-made materials are very much more consistent in their machining characteristics and similar speeds and feeds can be used from batch to batch.

MATERIAL	CUTTING SPEED (Meters/sec)
Hardwood	60-100
Softwood	50-90
Chipboard	50-80
MDF	40-65
Plywood	50-80
Plastic laminated board	40-60

Diameter	Rotational Speed R.P.M.				
	40M/sec	50M/sec.	60M/sec	70M/sec	80M/sec
25	20,000	20,000	20,000	20,000	20,000
50	15,000	19,000	20,000	20,000	20,000
75	10,000	12,500	15,000	18,000	18,000
100	7,500	9,500	11,500	13,000	13,000
125	6,000	7,500	9,000	9,000	9,000
150	5,000	6,500	7,500	7,500	7,500
175	4,500	5,500	6,500	6,500	6,500
200	3,500	4,500	5,500	5,500	5,500

Important Notes.

1. The spindle speeds shown above have been rounded to the nearest 500 R.P.M.
2. On the larger diameter cutters, and the higher cutting speeds, the spindle speeds have been reduced from the theoretical value to allow for the higher stresses caused by the high rotational speed.
3. **DO NOT EXCEED THE ROTATIONAL SPEED MARKED ON THE CUTTER BODY .**



Determination of Feed Speed

The calculation of the optimum feed is dependent on a number of factors and these must be taken into consideration in order to reach a satisfactory solution. The factors affecting the feed rate will be the size and rigidity of the cutter together with the chip space available. On very small cutters, the cutting edge has limited chip space and lower rates of feed are necessary otherwise breakage will occur.

On the other hand, too low a feed rate will cause the cutter to rub rather than cut.

Machine and job rigidity is another factor which must be considered. Parts must be adequately located and rigidly held down so that cutting forces cannot move the part. This will ensure a safe operation as well as allow maximum feed rates to be achieved commensurate with the required surface finish. Low feed rates will create a better finish than high feed rates.

The proposed feed rate can be easily calculated as shown below.

Suggested Chip Thickness

MATERIAL	CHIP THICKNESS (mm / Tooth)
Hardwood	0.2 - 0.7
Softwood	0.3 - 0.8
Chipboard	0.3 - 0.8
MDF	0.3 - 0.6
Plywood	0.3 - 0.6
Plastic laminated board	0.3 - 0.7

Let N = Rotational speed of cutter in R.P.M.

Z = number of wings on the cutter.

C = Chip thickness

$$\text{Then FEED RATE} = \frac{N \times Z \times C}{1000}$$

in Meters /Min

For example.

For a 2 wing cutter, rotating at 9000 r.p.m, with a proposed chip thickness of 0.3 mm, the feed rate will be:

$$\begin{aligned} \text{Feed rate} &= \frac{9000 \times 2 \times 0.3 \text{ Metres}}{1000} / \text{min} \\ &= 5.4 \text{ Metres/ min} \end{aligned}$$

Spindle Speeds:

The majority of our tools are marked with a maximum tool r.p.m. Therefore before mounting the tools, it is always better to compare the tool's maximum r.p.m. with the machine's r.p.m. settings. The tool **MUST NEVER** be run above the specified r.p.m.

Please pay particular attention to worn or damaged tooling where the damaged tool could be out of balance and therefore dangerous. Remove and replace immediately.

If in doubt, below are some general r.p.m. rules:

- 1 Solid carbide routers to a maximum diameter of 20 mm max 22,000 r.p.m.
 - 2 Routers with 1/2 inch or 16 mm shank with a cut diameter of 25 mm or less. max 18,000 r.p.m.
 - 3 Routers with a 20 or 25 mm shank with a cut diameter of 50 mm or less max 16,000 r.p.m.
 - 4 Routers with a 20 or 25 mm shank with a cut diameter of 125 mm or less max 12,000 r.p.m.
 - 5 Routers with 1/4 inch shank with a cut diameter of 20 mm or less max 20,000 r.p.m.
- Please note 1/4 inch shank routers are for hand trimming only and need extra special care when setting up and using.*
- 6 All spindle moulder cutters with a cut diameter of 125 mm or less max 12,000 r.p.m.
 - 7 All spindle moulder cutters with a cut diameter of 180 mm or less max 9,000 r.p.m.
 - 8 All spindle moulder cutters with a cut diameter of 250 mm or less max 6,000 r.p.m.
 - 9 All spindle moulder cutters with a cut diameter of 270 mm or larger max 4,200 r.p.m.



General Advice

Start Up:

Before using a tool for the first time, and prior to starting, check that the tool and inserts are running true to the spindle and that spindle nuts or collet chuck's are suitably tightened. Replace worn collets, spacers, nuts and clamping equipment. Replace all machine guarding and remove all loose tools before starting.

Protective Clothing:

Protective clothing and personal safety equipment **MUST** always be worn when using any router or spindle cutter.

No loose clothing should be worn near any machine; hair should be covered or tied well back; ear, eye, and face protection must always be worn.

Handling and Cleaning Tools:

Hand protection should be worn when handling tools during maintenance cleaning inspection, insert replacement, etc., by protecting hands with gloves.

Periodical tool cleaning should become a normal service operation. To do this, a light detergent with a soft cloth is adequate. Use a clean cloth with a light oil to protect surfaces from corrosion. Do not use harsh chemicals or solvents. Before using a tool for the first time, and prior to starting any spindle, the accuracy of the tool assembly should be inspected both visually and mechanically to ensure correct mounting of tools onto the machine and correct mounting of inserts.

Detail Instructions:

1) Fixing hardware.

Inserts for disposable tipped tooling are held in position by either clamps or Torx screws. Clamps are generally used in large diameter cutters whilst Torx screws are favoured for router bits and small spindle cutters.

The design choice depends on the size of the insert and the rotational speed of the cutter. All cutters should be periodically checked for damage or wear. This should include the screw threads on tool bodies, the associated fixing screws, as well as all other items on the tool body. Any damage found should be rectified or replaced immediately. Particular care should be taken to check that the socket on the Torx screw and the Torx driver is not damaged and that the key fits snugly.

Scribes are fixed by screws with straight screwdriver slots. These should be free of burrs and the slots undamaged, so that proper engagement with the correct size screwdriver will occur.

2) Tools.

The range of tools required to change inserts is minimal and will normally be restricted to the following:-

T15 Torx wrench, T12 Torx wrench, 4 A/F Tee handle Hex Key, Screwdriver with 10 x 1 mm blade.

The ends of these tools should be square to the axis of the tool and no rounding over should be present. Any minor damage can be removed by grinding back the key, but ensuring that the key does not become overly hot so that the hardness of the key is reduced. A number of very light grinds should be sufficient. Screwdriver ends can be treated in the same way. The objective is to ensure the correct fit of the tool at all times.



3) Changing Inserts.

Inserts should be changed when it is apparent that they are blunt. That inserts have become blunt generally shows itself as a degradation of surface finish on the component material and an increase in power needed to drive the cutter.

When inserts need to be changed, the cutter should be removed from the machine, and all dust and chips cleaned off with a suitable soft cloth, particularly around the insert seat area. Undo all clamping screws and remove inserts, paying particular attention to screws that are tight and could loosen suddenly, and without warning, cause injury. (Always wear protective gloves). Thoroughly clean all location faces and end stops. Fit new inserts and lightly clamp with fixing screws and wedges (as applicable) making sure that no dirt is behind the insert and that the insert is properly located in its seat and end stop. Tighten clamping screws by hand using the tools provided with the cutting tool. Do not use levers or anything that could over tighten the screws. Repeat until all inserts have been changed. Ensure that all replaced spare parts are original CROWN TOOLING spares. **DO NOT USE SUBSITUTE SPARES.**

For all cutter heads that have adjustable knife positions, ensure that knife protrusion is adjusted using the appropriate fixing gauge.

Carry out the following checks:

- a) All inserts are facing the correct way;
- b) All clamp screws are tight;
- c) Cutter bores, shanks and location faces are clean; and that
- d) Mating machine surfaces are clean and undamaged.

Once cutters have been replaced and locked into position, check that tool rotation is correct and replace all guards before restarting machine.

4) Speeds and Feeds.

Recommended speeds and feeds for various materials are shown in other data sheets contained in this publication. However, there may be times when the optimum cutting speed requires the cutter to be rotated at an unsafe spindle speed. On spindle cutters, safe working speeds are marked on the cutter body and should not be exceeded. For router bits, the maximum spindle speed is shown in the table in this publication.

Feed rates should be adjusted so that chips are of a reasonable size and thickness as indicated in the feed table shown in the specific section on speeds and feeds. Sufficient suction should be available to remove chips from the cutting area. Mechanical feed should be used wherever possible and on spindle cutters, the feed should always be against the rotation of the cutter, ***never with the rotation.***

5) Specific Notes for Spindle Cutters.

Hand-fed spindle moulders pose a particular safety hazard.

Although most modern spindle cutters have feed limiting capability, they do require care in their use. Material should be adequately guided and feed sticks used to push through small items. Generally the cutter configuration should be that the timber is over the cutter. The timber ***must*** be fed against the cutter rotation. Once the timber has fed past the cutter, some form of automatic guarding should come into play.



When setting up any form of moulding machine, it is important to check all spindles and tool location faces for damage. Any nicks or burrs, which may prevent proper seating of tools, should be carefully removed. In addition, tool location faces should be similarly checked. Prior to final fitting of tools to spindles, ensure that mating faces are clean. Clamp down with the appropriate nuts and ensure that they are tight. Correct fitting spanners or other tightening down tools are essential.

Before starting up, do a final check on spindle rotation. Replace all guards and remove loose tools.

6) Specific Notes for Routing Machines.

These notes are generally for overhead routing machines and do not refer to hand held routing machines, which normally have their own safety instructions.

Overhead routing machines have become very popular of the last few years and tend to use cutters up to 100 mm in diameter and in some cases even bigger.

Because of their open design, it is particularly important to ensure a safe working environment.

Tools should have the maximum size shank diameter possible, commensurate with the cutting diameter. Shanks should be free of damage, and the collet chuck in good condition.

The shank of the tool must engage the full length of the collet and the chuck fully tightened with the correct spanner provided with the chuck. The minimum 'hang out' of the tool is to be preferred.

Generally, feed of the tool will be against the rotation of the cutter. Feed with cutter rotation is sometimes used to prevent break out. In these cases, ensure that the board hold down system is adequate to prevent movement of the board.

With machines having automatic tool changers, it is recommended that only tools within the size limits of the changer be used. If a bigger cutter is required, it will require hand loading and may put unnecessary loads onto the machine spindle.

Where heavy material removal is required, ensure that the board holding system is adequate.

Inserts for router bits generally have 2 fixing screws and these must be in good condition.

The guidelines set out previously in Section 3 'Changing Inserts' should be rigorously applied.

In particular, dirt under the inserts should be avoided as this may cause cracking of the insert during the tightening of the fixing screws. Any insert with a crack should be discarded immediately.

Before starting the machine, ensure that all loose tools and other equipment are removed from the work area.



CROWN TOOLING **STANDARD CONDITIONS OF SALE.**

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2. **RESPONSIBILITY OF DELIVERY:** Our responsibility for delivery ceases on delivery to Courier, Post Office, or other Carrier etc. Any date given by CROWN TOOLING is intended only as an estimate and CROWN TOOLING shall not be held responsible for the consequences of any delayed delivery.
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