

THINK SMOOTH FINISH

ONSRUD'S SPOILBOARD/FINISHING CUTTERS

Introducing a complete line of cutters to maximize all flow through spoilboard systems and provide excellent finishing capabilities in plastic and aluminum material.

These dynamically balanced tools provide an exceptional surface to insure part rigidity in MDF, LDF, and Balsa core spoilboard material. In addition to spoilboard finishing, the radius edged cutters in carbide tipped and insert style can be used to plane to size, slot, and bottom finish in a variety of flat sheet plastic and aluminum. Regardless of the application, the entire process is accomplished with maximum productivity and outstanding finish quality.



91-000/90-000 – Spoilboard Surfacing Cutters



PART #	CED	SHK DIA	SHK LENGTH	# OF WINGS	USAGE
STRAIGHT CUTTERS					
91-000	1¼	½	1½	2	CARBIDE TIPPED/RADIUS EDGED FOR SMALLER MACHINES AND WORK AREAS
90-002	2½	½	2	2	MDF/LDF SPOILBOARD MATERIAL FOR FLAT SURFACE ON FLOW THROUGH
90-006	4	¾	2¼	3	LARGER DIAMETER FOR FASTER/SMOOTHER SURFACING IN MDF/LDF SPOILBOARDS
UPSHEAR CUTTERS					
90-004	2½	½	2	2	UPSHEAR ACTION FOR BALSA CORE SPOILBOARDS
90-008	4	¾	2¼	3	FASTER AND SMOOTHER SURFACING IN BALSA CORE SPOILBOARDS
90-014	4	¾	2¼	3	COMPLETE WITH RADIUS INSERTS FOR SURFACING PLASTIC AND ALUMINUM SHEET

Replacement Parts

PART #	DESCRIPTION	USAGE
90-052	INSERT 10/PK	Use w/90-002, 90-004, 90-006 & 90-008"
90-056	RADIUS INSERT 10/PK	Use w/90-014 ONLY
90-102	SCREWS	
90-104	WRENCH	

SPOILBOARD CUTTERS ARE ENGINEERED FOR CNC ROUTER APPLICATIONS. THE 1-1/4" AND 2-1/2" DIAMETER TOOLS SHOULD BE FED AT 200-600 IPM AT 12,000-16,000 RPM. 4" DIAMETER TOOLS SHOULD RUN AT 200-600 IPM AT 12,000-14,000 RPM. ONE-HALF TO THREE-QUARTERS OF THE TOOL DIAMETER SHOULD BE UTILIZED IN A STEP-OVER PROCESS TO MAXIMIZE SMOOTHNESS. MAXIMUM DEPTH OF CUT SHOULD NOT EXCEED 1/8".

THINK ONSRUD

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Leitz Metalworking Technology Group

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