



CUTTER EQUIPMENT
for
9" x 4" Planing and Moulding Machine
Type F B

BOOKLET No. 1132

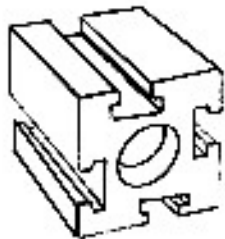
Wadkin

Cutter Equipment
for

9" x 4" Planing and Moulding Machine
type F. B.

A range of cutters and cutter equipment has been designed for use with this machine and is listed in the following pages.

The equipment listed is our standard range and we welcome enquiries for special items, please send sample moulds or dimensioned drawings when special cutters are required.



SQUARE CUTTERBLOCKS

These cutterblocks are specially made for the Wadkin Moulder. They are of the self centring type with cone ends, accurately machined and balanced, and have tee slots to take square headed bolts.

3 $\frac{3}{8}$ " (92 mm) Square x 6" (152 mm) Diameter

Minimum Cutting Circle

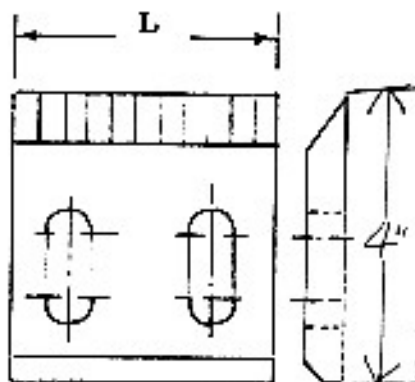
Length	No. of Bolts	Part No.
2 $\frac{3}{4}$ " (69 mm)	4	FAC 2
4 $\frac{1}{2}$ " (114 mm)	8	FAC 4
7 $\frac{1}{2}$ " (190 mm)	10	FAC 7
9 $\frac{1}{2}$ " (241 mm)	10	FBC 902



SQUARE HEADED CUTTERBLOCK BOLTS FOR ABOVE BLOCKS COMPLETE WITH NUTS AND WASHERS

For 3 $\frac{3}{8}$ " (92 mm) Square Blocks

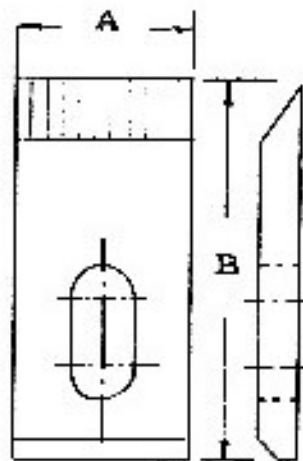
Part No. FCT 34



STANDARD H. S. S. on I. CHIPPING IRONS FOR SQUARE CUTTERBLOCKS

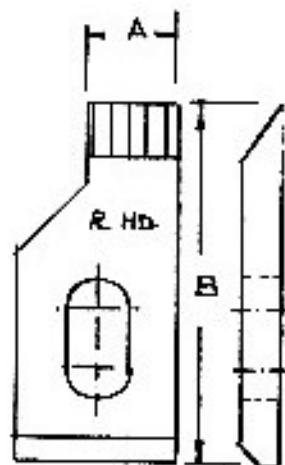
Length (L)	No. of Slots	Part No.
2 $\frac{1}{2}$ " (63 mm)	1	FCT 57
4 $\frac{1}{4}$ " (114 mm)	2	FCT 58
5 $\frac{1}{4}$ " (133 mm)	2	FCT 63
6 $\frac{1}{2}$ " (165 mm)	3	FCT 59
7 $\frac{1}{2}$ " (190 mm)	3	FCT 60
9 $\frac{1}{2}$ " (241 mm)	3	FDT 999

CUTTERS FOR SQUARE CUTTERBLOCKS

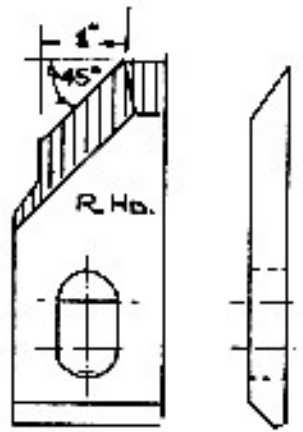


Dimension A	Dimension B	No. of Slots	Part No.
2" (50 mm)	4½" (114 mm)	1	158
2½" (63 mm)	4½" (114 mm)	1	159
4" (101 mm)	4½" (114 mm)	2	162
3" (76 mm)	4½" (103 mm)	1	151
2" (50 mm)	5" (127 mm)	1	165
2½" (63 mm)	5" (127 mm)	1	166
4" (101 mm)	5" (127 mm)	2	169
1½" (38 mm)	5½" (139 mm)	1	170
2" (50 mm)	5½" (139 mm)	1	171
2½" (38 mm)	5½" (139 mm)	1	172

HANDED CUTTERS

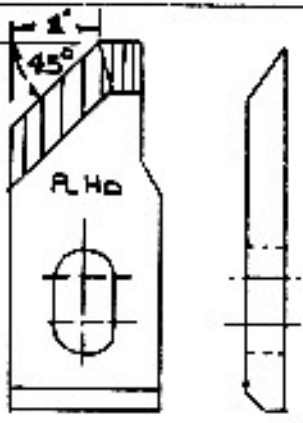


Dimension A	Dimension B	Part No. R. H.	Part No. L. H.
½" (12 mm)	4½" (114 mm)	149	150
¾" (19 mm)	4½" (114 mm)	152	153
1" (25 mm)	4½" (114 mm)	154	155
1½" (38 mm)	4½" (114 mm)	156	157
3" (76 mm)	4½" (114 mm)	160	161
1½" (38 mm)	5" (127 mm)	163	164
3" (76 mm)	5" (127 mm)	167	168



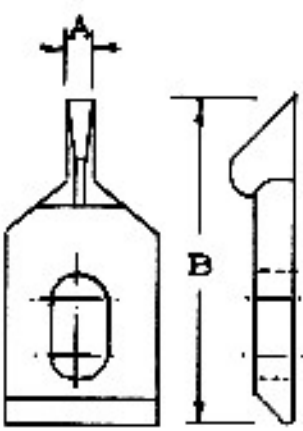
CUTTERS FOR SQUARE CUTTERBLOCKS (Continued)
BEVELLED CUTTERS

Part No. R. H.	180
Part No. L. H.	181



BEVELLED CUTTERS (Continued)

Part No. R. H.	182
Part No. L. H.	183

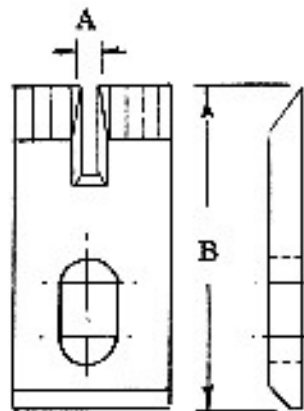


GROOVING CUTTERS

Dimension A	Dimension B	Part No. Central	Part No. R. H.	Part No. L. H.
$\frac{1}{8}$ " (3 mm)	$4\frac{1}{2}$ " (114 mm)	701	701R	701L
$\frac{3}{16}$ " (4 mm)	$4\frac{1}{2}$ " (114 mm)	702	702R	702L
$\frac{1}{4}$ " (6 mm)	$4\frac{1}{2}$ " (114 mm)	703	703R	703L
$\frac{5}{16}$ " (7 mm)	$4\frac{1}{2}$ " (114 mm)	704	704R	704L
$\frac{3}{8}$ " (9 mm)	$4\frac{1}{2}$ " (114 mm)	705	705R	705L

N. B. Grooving cutters can be supplied with cutting edge, right hand, left hand, or central.

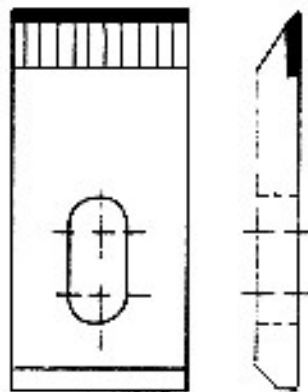
CUTTERS FOR SQUARE CUTTERBLOCKS (Continued)



TONGUING CUTTERS

Dimension A	Dimension B	Part No.
$\frac{1}{8}$ " (3.18 mm)	$4\frac{1}{2}$ " (114 mm)	711
$\frac{3}{16}$ " (4.76 mm)	$4\frac{1}{2}$ " (114 mm)	712
$\frac{1}{4}$ " (6.35 mm)	$4\frac{1}{2}$ " (114 mm)	713
$\frac{5}{16}$ " (7.94 mm)	$4\frac{1}{2}$ " (114 mm)	714
$\frac{3}{8}$ " (9.53 mm)	$4\frac{1}{2}$ " (114 mm)	715

TUNGSTEN CARBIDE TIPPED CUTTERS



This class of cutter is in increasing demand for machining difficult hardwoods such as Jarrah and Teak, on which satisfactory runs cannot be obtained with high speed steel or similar cutters. Although more costly than other types of cutter, the savings effected by the elimination of constant stoppages of high production machines for regrinding cutters, make them an economical proposition. Their principle characteristic is the extreme hardness of the Tungsten Carbide tip enabling continuous runs to be made on the most difficult materials without resharping. All the flat cutters in this catalogue can be supplied with Tungsten Carbide tips on request.

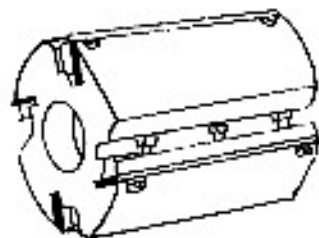
COXCOMB CUTTERS AND BRACKETS



R. H. Bracket

Standard Coxcomb Cutters (in pairs) for $3\frac{1}{8}$ " sq. block.....Part No. FCT339
 Right Hand Brackets (in pairs) Part No. FCT340
 Left Hand Brackets (in pairs) Part No. FCT341

CIRCULAR CUTTERBLOCKS (WEDGE TYPE)

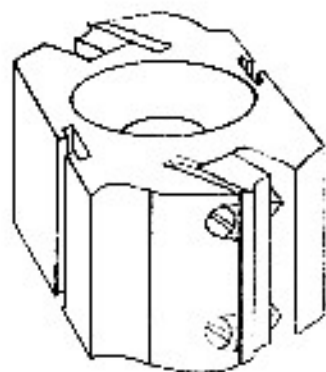


These cutterblocks have a 6" (152 mm) diameter cutting circle and are supplied complete with high speed steel cutters.

Four Knife

Length	Part No.	Length	Part No.
2 $\frac{3}{4}$ " (69 mm)	FAC 22	7 $\frac{1}{2}$ " (190 mm)	FAC 27
4 $\frac{1}{2}$ " (114 mm)	FAC 24	9 $\frac{1}{2}$ " (241 mm)	FBC 912

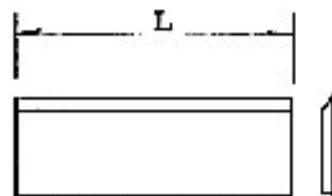
COMBINED MOULDING AND THIN KNIFE BLOCK



This block provides the means of using standard square block moulding irons on a circular block without reducing its efficiency. The moulding irons can be used at the same time as the planing knives and thus save an additional head on certain types of work. The thin knives are secured by wedges.

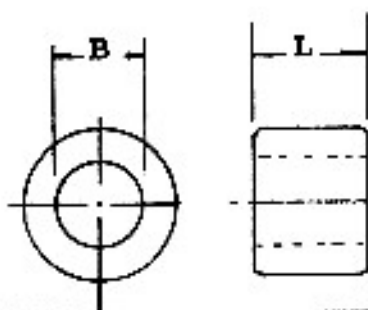
6" (152 mm) diameter minimum cutting circle

Length	Part No.	Length	Part No.
4 $\frac{1}{2}$ " (114 mm)	FBC 28	7 $\frac{1}{2}$ " (190 mm)	FBC 29
9 $\frac{1}{2}$ " (241 mm)	FBC 914		



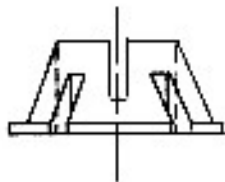
SPARE H. S. S. CUTTERS FOR THE ABOVE CUTTERBLOCKS

Length (L)	Part No.	Length (L)	Part No.
2 $\frac{3}{4}$ " (69 mm)	FCT 130	4 $\frac{1}{2}$ " (114 mm)	FAC 14
7 $\frac{1}{2}$ " (190 mm)	FCT 124	9 $\frac{1}{2}$ " (241 mm)	FDT 1084



MAKING UP COLLARS (B) 40 mm

L	Part No.	Blocks requiring collars	Side Heads	Horizontal Heads
1 $\frac{3}{4}$ " (44mm)	FAC 10	2 $\frac{3}{4}$ " long (69 mm)	1 $\frac{3}{4}$ " (44 mm)	1 $\frac{3}{4}$ " (44 mm) 2" (50 mm) 3" (76 mm)
2" (50 mm)	FBC 909	4 $\frac{1}{2}$ " long (114 mm)		2" (50 mm) 3" (76 mm)
3" (76 mm)	FAC 11	7 $\frac{1}{2}$ " long (190 mm)		2" (50 mm)

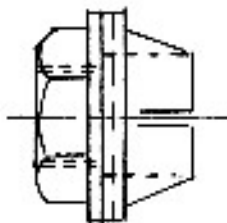


CONED COLLARS

These are supplied with the machine, one for each 40 mm diameter spindle and used with all standard cutterblocks and mounting sleeves.

For 40 mm diameter Spindles

Part No. FAC 13



COMBINED LOCKNUT AND CONE

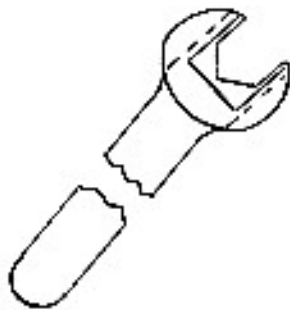
By combining the locknut with the cone, the cone is automatically withdrawn from the cutterblock when the spindle locknut is unscrewed. The cone is self aligning and able to rotate independent to the locknut. These can only be used where the cutterblock takes up the full capacity of the spindle.

Left hand for bottom and near side spindles

Part No. FBC 14

Right hand for top and fence side spindles

Part No. FBC 15



COMBINED LOCKNUT SPANNER

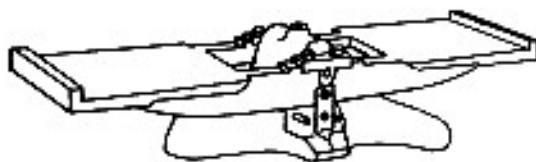
This spanner is for use when the machine operator is not in possession of the above combined locknuts and cones.

Part No.

FBC 1

BALANCING AND SETTING

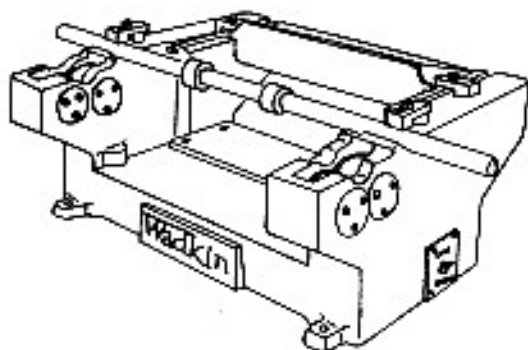
CUTTER BALANCER



The high cutting speeds of the Wadkin F. B. type moulder make it essential that all cutters are in proper balance. The balance of any pair of cutters can be ascertained with accuracy on this unit.

Part No. KS.

COMBINED SETTING AND BALANCING STAND F. D. T.



For efficient working of any high speed machine it is essential that all cutters are both accurately set and balanced. This is particularly important with a multi-head machine such as the Wadkin moulder.

The combined setting and balancing stand illustrated has been specially designed to meet these requirements.

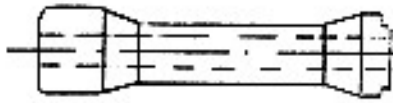
The stand is entirely self-contained. The knife-edged balancing rollers are mounted between ball bearings for frictionless operation. The rollers are shrouded in the stand to give protection against accidental damage to knife edges. Aluminium scribing plate is reversible

and can be turned top to bottom thus giving four edges from which the moulds can be scribed. The base of the stand houses two electric lamps to illuminate beneath the blocks and thus facilitates accurate setting.

A 1" diameter arbor F. D. T. 215 is required to take the sleeve for mounting the F. B. cutter-blocks.

When ordering this stand please state voltage of lighting supply.

SETTING AND BALANCING SLEEVE



Sleeve complete with locknut making up collar and coned collar for use with the F. B. cutterblocks.

For 40 mm diameter bore equipment

Part No. FDT 582

GRINDING ARBOR

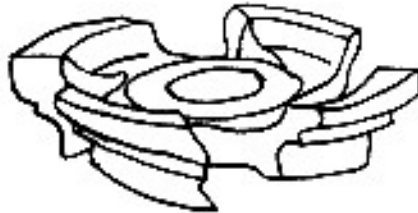


Arbor complete with coned collar and locknut for up to 12½" (317 mm) long F. B. type cutterblocks for use on the Wadkin Universal Grinding Machine N. H.

For 40 mm diameter arbor

Part No. N. H. 921

SOLID PROFILE CUTTERS

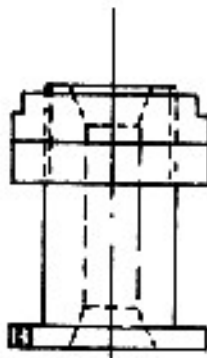


Their use ensures quick set-ups and guarantees a high standard of quality. With this type of cutter the profile remains unaltered by re-sharpening, and the uniformity of the pattern is retained during the entire life of the cutter.

Cutters for tonguing and grooving can be supplied to give tight or loose fits, with square or tapered tongue and groove.

Prices and details on request. When enquiring please send drawing or sample mould and state method of working.

SOLID PROFILE CUTTER MOUNTING SLEEVE



Sleeve for 60 mm bore solid profile cutter on near or fence side spindles, complete with making up collar and locknut.

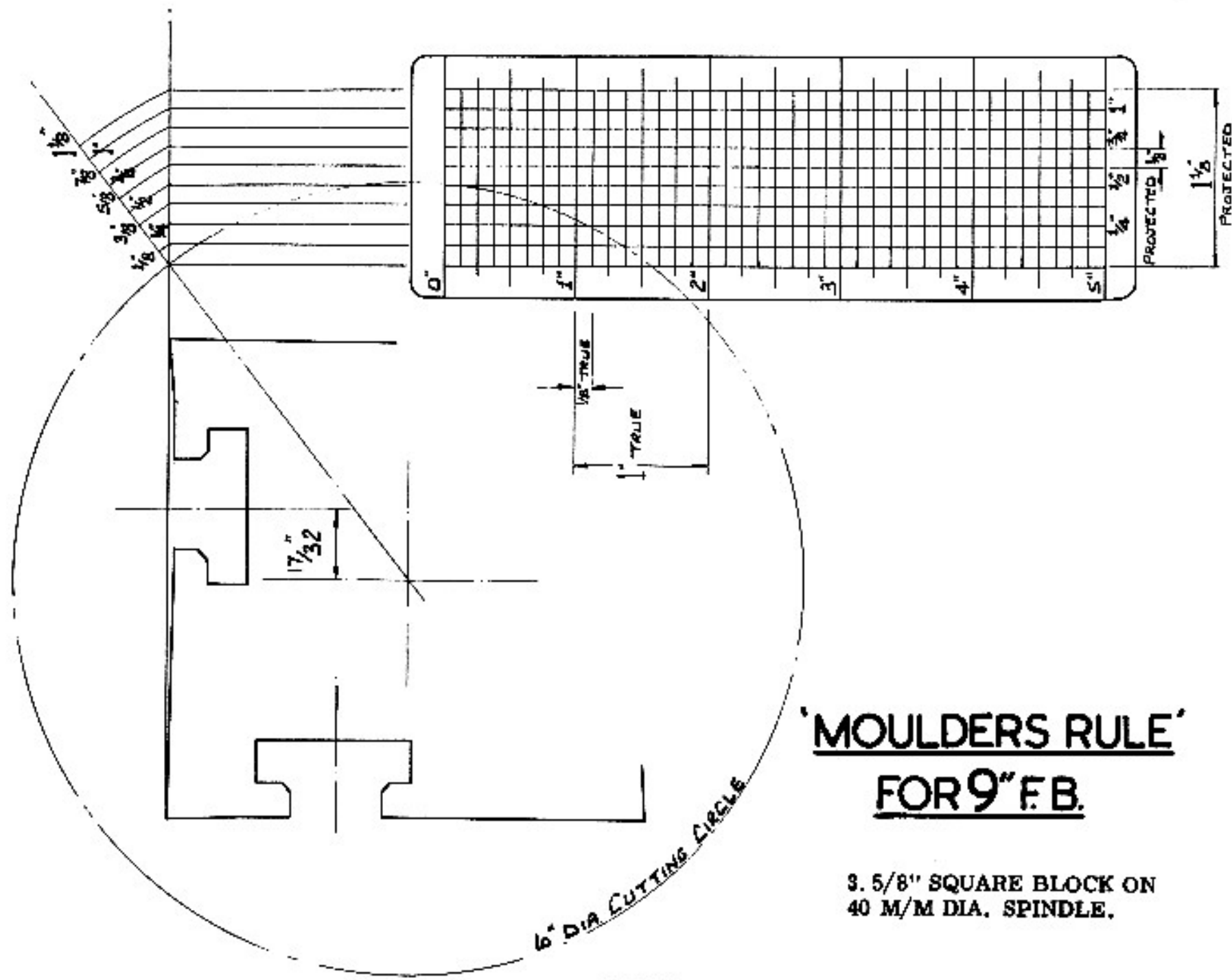
Sleeve for fence side spindle Part No. FAC 32

Sleeve for near side spindle Part No. FAC 34

Sleeve for top spindle Part No. FBC 52

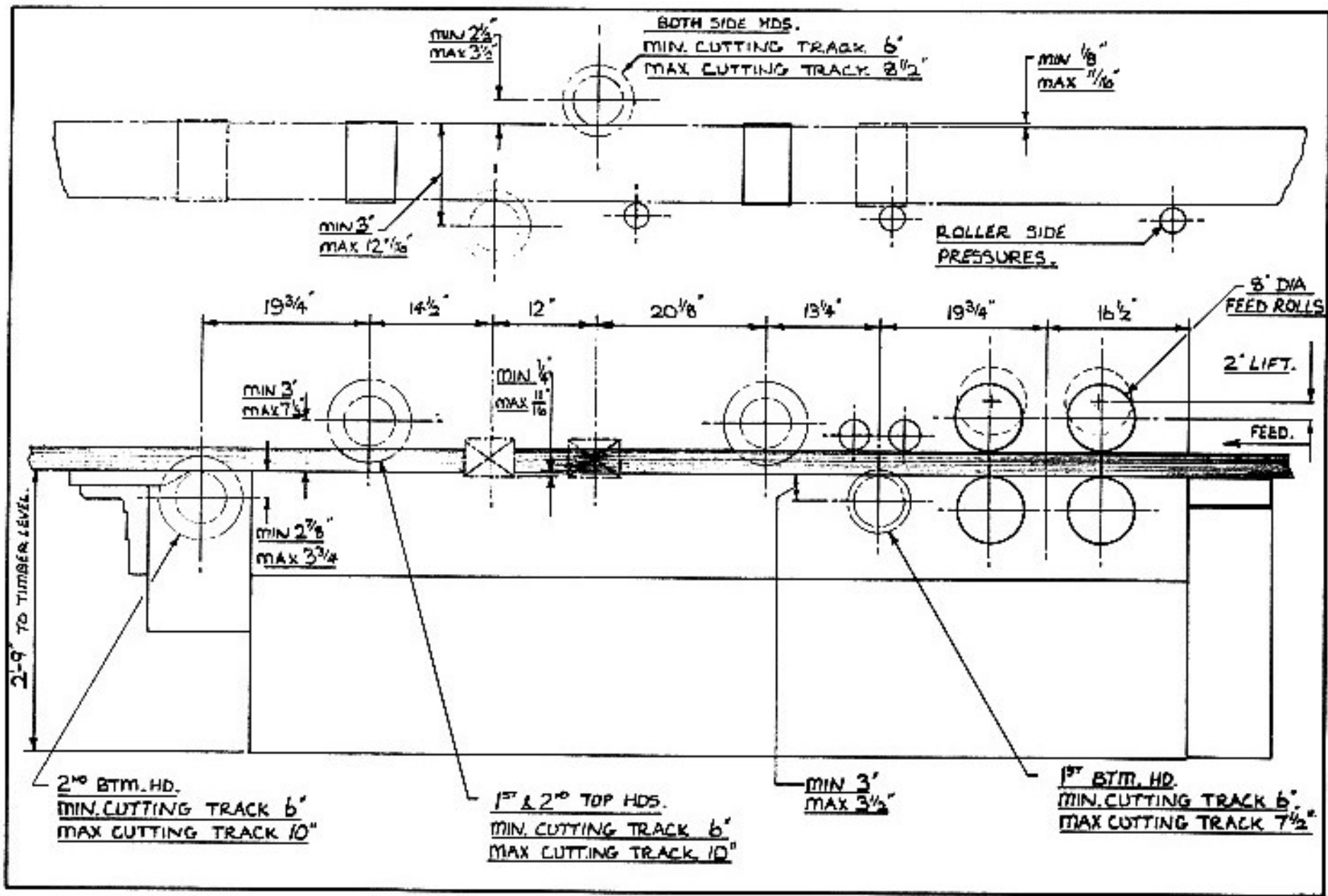
Sleeve for bottom spindle Part No. FBC 51

Making up collar for use with FBC 51 and 52 FBC 909

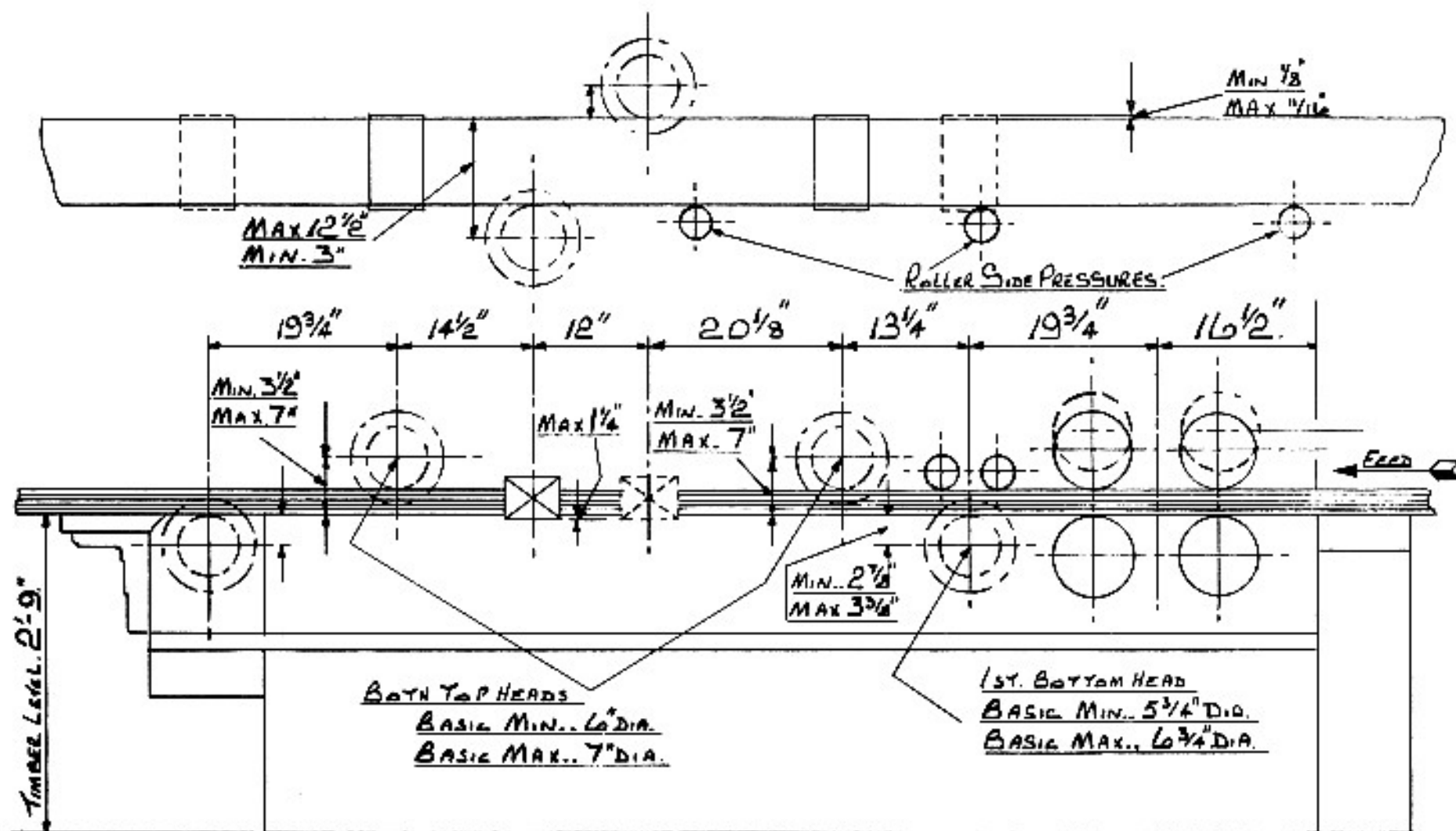


'MOULDERS RULE'
FOR 9" F.B.

3. 5/8" SQUARE BLOCK ON
 40 M/M DIA. SPINDLE.



CAPACITY DIAGRAM FOR 9" x 4" MOULDER, TYPE FB.



BASIC CUTTER TRACKS FOR 9" F.B.

Wadkin Ltd.

Green Lane Works · Leicester LE5 4PF · England

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