

EP6 FINGER JOINT CUTTER

WITH REPLACEABLE KNIVES



Eric Paton Engineering

A DIVISION OF WE CAN PRECISION ENGINEERING

EP6 Finger Joint cutterhead with 4, 6, 8 or 12 HSS knives for 4mm, 8mm, 10mm and 15mm long fingers.

All knives are locked in dovetail pockets any may be easily replaced as or when required.

Application for Finger Jointing

End to end joints using defected or off cut timber in stressed wooden structure components and in the manufacture of joinery, flooring, framing, mouldings etc.

TITANIUM TREATMENT

improves wear **50%**
resistance by

Technical Details

For all cutter dimensions refer overleaf. Cutters may be "stacked" to suit width of timber being jointed.

Timber must be clamped and fed precisely throughout cutting operation.

Height adjustment to cut counter profile is half the pitch For those machines with length control we offer finger jointing profiles with finger joint lengths of 8/9mm, 10/11mm and 15/16mm.

By using a trim saw with these cutters, profile depth in the timber may be set to suite the fit required.

EP6 finger joint cutters may be used on spindle moulding machines as well as specialised finger jointing machines.

EPL Finger Joint Cutters can now be supplied with a treatment to enhance their performance.

Knives specially coated with titanium nitride have a minimum increase in wear resistance of 50%. The coating is a very thin layer (between 2 and 4 micron) of a very hard substance (2300 Hv). Even after sharpening, where the titanium nitride is ground from finger joint knife cutting face, the coating left on the outer profile will decrease the edge wear by more than 50%.

Production is increased because the down time due to sharpening is decreased. Cutters will stay on the finger jointer at least 50% longer between sharpening processes.

Titanium nitride coated EPL finger joint knives will cost less per cubic meter of finger jointed timber.



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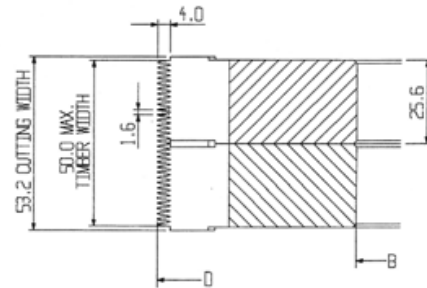
FINGER JOINT CUTTERS FOR USE ON MACHINES WITH OR WITHOUT A TRIM SAW

EP6 – 4/4mm FINGER JOINT CUTTERS

160mm diameter 4 knife and 6 knife cutters. 250mm diameter 6 knife and 8 knife cutters

Length of finger 4mm

Stack height of finger joint cutters excluding knife overlaps mm	Max. width of timber jointed mm	No. Cutters
25.6	24	1
51.2	50	2
76.8	75	3
102.4	101	4
128.0	127	5
153.6	152	6
179.2	178	7
204.8	203	8
230.4	229	9
256.0	255	10



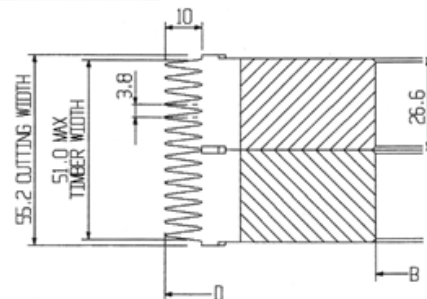
B = 50.0mm (other sizes on request) D = 160mm dia. or 250mm dia. Pitch = 1.6mm

EP6 – 10/10mm FINGER JOINT CUTTERS

160mm diameter 4 knife cutter and 250mm diameter 6 knife cutter

Length of finger 10mm

Stack height of finger joint cutters excluding knife overlaps mm	Max. width of timber jointed mm	No. Cutters
26.6	24	1
53.2	51	2
79.8	77	3
106.4	104	4
133.0	131	5
159.6	157	6
186.2	184	7
212.8	210	8
239.4	237	9
266.0	264	10



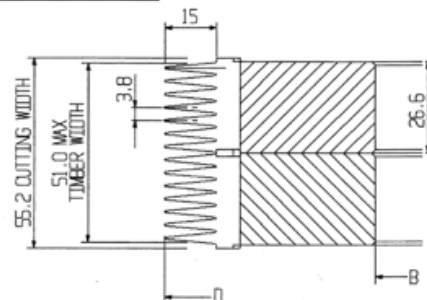
B = 50.0mm (other sizes on request) D = 160mm dia. or 250mm dia. Pitch = 3.8mm

EP6 – 15/15mm FINGER JOINT CUTTERS

160mm diameter 4 knife cutter and 250mm diameter 6 knife cutter

Length of finger 15mm

Stack height of finger joint cutters excluding knife overlaps mm	Max. width of timber jointed mm	No. Cutters
26.6	24	1
53.2	51	2
79.8	77	3
106.4	104	4
133.0	131	5
159.6	157	6
186.2	184	7
212.8	210	8
239.4	237	9
266.0	264	10



B = 50.0mm (other sizes on request) D = 160mm dia. or 250mm dia. Pitch = 3.8mm

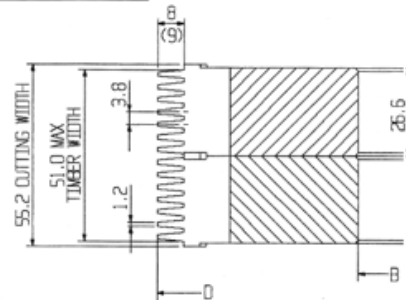
FINGER JOINT CUTTERS FOR USE ONLY ON MACHINES WITH A TRIM SAW

EP6 – 8/9mm FLAT TIP FINGER JOINT CUTTERS

160mm diameter 4 knife cutter and 250mm diameter 6 knife cutter

Length of finger 8/9mm

<i>Stack height of finger joint cutters excluding knife overlaps mm</i>	<i>Max. width of timber jointed mm</i>	<i>No. Cutters</i>
26.6	24	1
53.2	51	2
79.8	77	3
106.4	104	4
133.0	131	5
159.6	157	6
186.2	184	7
212.8	210	8
239.4	237	9
266.0	264	10



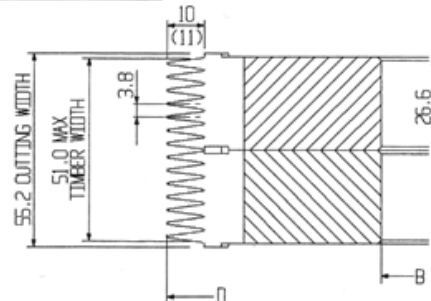
B = 50.0mm (other sizes on request) D = 160mm dia. or 250mm dia. Pitch = 3.8mm Tip Width = 1.2mm

EP6 – 10/11mm FINGER JOINT CUTTERS

160mm diameter 4 knife cutter and 250mm diameter 6 knife cutter

Length of finger 10/11mm

<i>Stack height of finger joint cutters excluding knife overlaps mm</i>	<i>Max. width of timber jointed mm</i>	<i>No. Cutters</i>
26.6	24	1
53.2	51	2
79.8	77	3
106.4	104	4
133.0	131	5
159.6	157	6
186.2	184	7
212.8	210	8
239.4	237	9
266.0	264	10



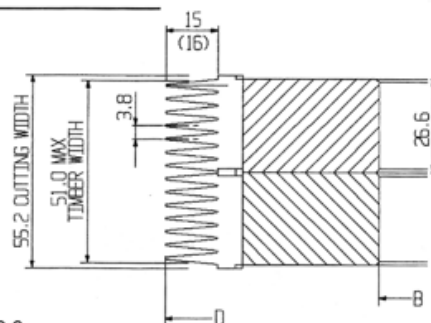
B = 50.0mm (other sizes on request) D = 160mm dia. or 250mm dia. Pitch = 3.8mm

EP6 – 15/16mm FINGER JOINT CUTTERS

160mm diameter 4 knife cutter and 250mm diameter 6 knife cutter

Length of finger 15/16mm

<i>Stack height of finger joint cutters excluding knife overlaps mm</i>	<i>Max. width of timber jointed mm</i>	<i>No. Cutters</i>
26.6	24	1
53.2	51	2
79.8	77	3
106.4	104	4
133.0	131	5
159.6	157	6
186.2	184	7
212.8	210	8
239.4	237	9
266.0	264	10



B = 50.0mm (other sizes on request) D = 160mm dia. or 250mm dia. Pitch = 3.8mm

Maintenance

Cutters must be cleaned and sharpened regularly to avoid variations in joint length and loss of joint strength.

Cutterheads with knives should be mounted on grinding machine spindle and correctly aligned with a dial gauge or straight edge (Fig. 1). Grind face to correct angle, refer sharpening details supplied with cutters.

Index knives accurately.

Sets of cutters should be ground in the one setting with 3mm (minimum) spacers between each cutter.

All grinding must be carried out using copious quantities of coolant. All cutters in a set **MUST** be the same diameter.

