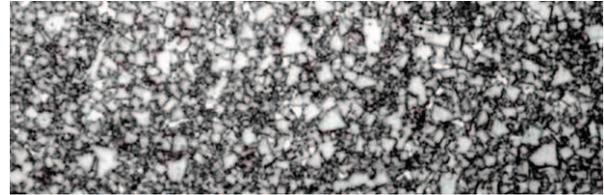


TECHNICAL INFORMATION AND PRODUCT INFORMATION

Engraving cutters made from solid carbide K10F

K10F SOLID CARBIDE

Fine-grain carbide is best suited for processing steel, grey cast iron, non-ferrous metals and plastics and offers excellent stability.



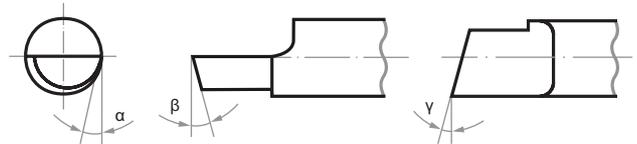
ENGRAVING CUTTER FROM LUKAS

LUKAS has the right engraving cutter for virtually every engraving task. Whether you're working with plastic, acrylic, stainless steels, non-ferrous metals or other materials, we can help you get the job done cleanly, quickly and professionally. We have a variety of engraving cutters in different shapes and hardnesses,

so that you always have the right tool for the job. All LUKAS engraving cutters are designed and produced to last, thus keeping your production costs down. We deliver our LUKAS engraving cutters as semi-finished products with a pre-ground profile (+0.1 mm) or finished and ground to your specifications.

CUSTOMISATIONS

We can customise the application parameters to the respective material to make sure you get perfect results. The values in the following tables are reference values.



Material to be machined	Recommended cutting and lead angles			Recommended cutting speeds in v_c m/min	Recommended feed rates f_z mm
	α	β	γ		
Cast material, cast steel	25°	15°	5°	60–100	0.04–0.10
Steel up to 900 N/mm ²	25°	15°	5°	120–160	0.05–0.08
Steel above 900 N/mm ²	25°	15°	5°	50–70	0.04–0.08
Brass, aluminium	30°	15°	5°	200–400	0.08–0.15
Plastic, reinforced and non-reinforced	35°	15°	5°	200–600	0.05–0.20

PERFECT ENGRAVINGS WITH

LUKAS ENGRAVING CUTTERS

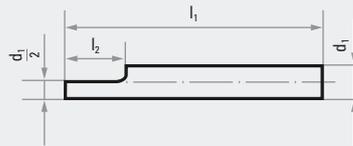
MADE TO LAST



Engraving cutters made from solid carbide

Note on the listed dimensions:

- as semi-finished cutting edge with 0.1 mm tolerance
- optional: precise halving with tolerance of +0.02 mm (10% surcharge)
- optional: relief grinding (25% surcharge)
- optional: finished cut on request



Applications for spiral-fluted engraving cutters (HGS):

- zero-burr engraving of non-ferrous metals and plastics



Product number	Description	Shape	Profile	d ₁ mm	l ₁ mm	l ₂ mm	Pack contains		
A1300404012	HGA 04.040			4	40	6	1		
A1300405012	HGA 04.060			4	60	6	1		
A1300407012	HGA 06.070			6	70	8	1		
A1300408112	HGA 08.100			8	100	12	1		
A1300409112	HGA 10.100			10	100	14	1		
A1300410112	HGA 12.100			12	100	16	1		
A1300403042	HGA 03.040					3	40	6	1
A1300405042	HGA 04.060					4	60	6	1
A1300407042	HGA 06.070					6	70	8	1
A1300404062	HGA 04.040					4	40	6	1
A1300484071	HGS 03.040					3	40	15	1
A1300485071	HGS 04.040					4	40	20	1
A1300486071	HGS 06.050			6	50	22	1		

Recommended for: ● Steel ● Aluminium ● Cast material ● Plastic/Wood