

Guide for selection of cutting material

Type of tool		Tipped tool			Tipped tool		Tool set				Single tool Tipped tool Tool set				
Application		Sawing			Hogging		Planing				Cutting				
Cutting material		ST	HW	DP	HW	DP	HL	HS	MC	HW	SP	HL	HS	MC	
Workpiece material		Type													
Solidwood	Softwood		◆		◆		◇	◆	◆		◆	◆	◆	◆	
		◆					◆	◆	◆						
Hardwood	dry		◆		◆			◇	◆	◆			◆	◆	
	wet	◆						◆	◆						
Laminated wood (plywood etc.)	Plywood		◆		◆			◇		◆		◆	◆		
	Multiplex		◆		◆	◇		◇		◆		◆	◆		
	Particle board (Chipboard)		◆	◇	◆	◆						◆	◆		
		◆			◆	◆							◇	◆	
Panels	uncoated		◆		◆	◆						◆	◆		
	veneered		◆		◆	◆						◆	◆		
	plastic-coated		◆	◇	◆	◆									
	paper-coated		◆		◆	◆									
Fibre board (MDF)	uncoated		◆	◆	◆	◆									
	veneered		◆		◆	◆									
	plastic-coated		◆	◆	◆	◆									
	paper-coated		◆		◆	◆									
Hardboard		◆	◇	◆	◆										
Softboard		◆		◆	◆										
Laminated boards (HPL/CPL...)		◆	◆	◆	◆										
Plastics	Duromers (Pertinax...)		◆	◆	◆	◆									
	Plastomers (PA, PE, PP...)		◆		◆	◆			◆	◆				◆	
	Fibre reinforced (GFK, CFK...)		◆	◆		◆									
	Polymer compound (Corian...)		◆	◆											
Composite materials	Solid wood with HF, MDF...		◆	◇	◆	◆		◇							
	Wood materials with HPL, cork...		◆	◇	◆	◆									
	Gypsum plaster board		◆		◆	◆									
	Cement board		◆	◆	◆	◆									
Mineral wool		◆		◆	◆				◆						
Composite with aluminium		◆	◆	◆	◆										
Composite with steel		◆													
Metal	Aluminium		◆	◆											
	alloyed		◆	◆											
Lead alloy		◆	◇												
Copper, zinc, brass		◆	◇												

Type of tool		Single tool Tipped tool Tool set		Single tool Tipped tool Tool set					Single tool Tipped tool Tool set				
Application		Cutting		Routing					Drilling				
Cutting material		HW	DP	SP	HS	HW	HC	DP	ST	HS	HW	HC	DP
Workpiece material		Type											
Solidwood	Softwood	◆		◆	◆	◆	◆		◆	◆	◆	◆	
					◆	◆	◆		◇	◆	◆	◆	
Hardwood	dry	◆			◆	◆	◆			◆	◆	◆	
	wet				◆	◆	◆			◆	◆	◆	
Laminated wood (plywood etc.)	Plywood	◆			◆	◆	◆			◆	◆	◆	
	Multiplex	◆	◇		◆	◆	◆	◆		◆	◆	◆	
	Particle board (Chipboard)	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
		◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
Panels	uncoated	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	veneered	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	plastic-coated	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	paper-coated	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
Fibre board (MDF)	uncoated	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	veneered	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	plastic-coated	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	paper-coated	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
Hardboard	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆	
Softboard	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆	
Laminated boards (HPL/CPL...)	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆	
Plastics	Duromers (Pertinax...)	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	Plastomers (PA, PE, PP...)	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	Fibre reinforced (GFK, CFK...)	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	Solid surface materials (Corian...)	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
Composite materials	Solid wood with HF, MDF...	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	Wood materials with HPL, cork...	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	Gypsum plaster board	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	Cement board	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
Mineral wool	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆	
Composite with aluminium	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆	
Composite with steel	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆	
Metal	Aluminium alloy	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆
	Copper, zinc, brass	◆	◆		◆	◆	◆	◆		◆	◆	◆	◆

◆ Suitable

◇ Partly suitable