





Determining Cutting Speed

Material	Cutting	Cutting Speed (m/sec)	
 Natural Wood	Soft Wood	along 60 - 100 across 60 - 100	
	Hard Wood	along	60 - 100
		across	60 - 100
	Veneers	along	70 - 100
		across	70 - 100
 Boards	Plywoods	50 - 80	
	MDF	60 - 100	
	Particle Board with PVC Coating	60 - 80	
	Particle Board with Melamine Coating	60 - 80	
	Particle Board with Veneer Coating	60 - 80	
	High Pressure Laminated Particle Board	60 - 80	
	Soft Fibre Board	70 - 100	
	Cemented Bonded Board	50 - 80	
	Hard Paper / Hard Fibre	45 - 70	
 Plastics	Duroplastic® Board, Corian®	15 - 50	
	High Pressure Laminated Bakelite®	30 - 70	
	Thermoplastic Profiles	50 - 80	
	 Aluminium	Aluminium Profiles	40 - 70

LEADER™

The Innovative Scoring System

- Unique patented blade
- Adjusts easily from 2.8mm - 3.6mm.
- Cost saving benefits.
- Fits all common machines - including Altendorf.

Look out for the  blades on page 29.

Eliminates the need for spacers, endless measuring, re-assembling, testing and adjusting to obtain the required width.

