

Your Advantage



<http://www.kanefusa.net>

Finger Joint Cutter

Structural Finger Joints



Advanced Material Technology cutting edges stay sharper longer

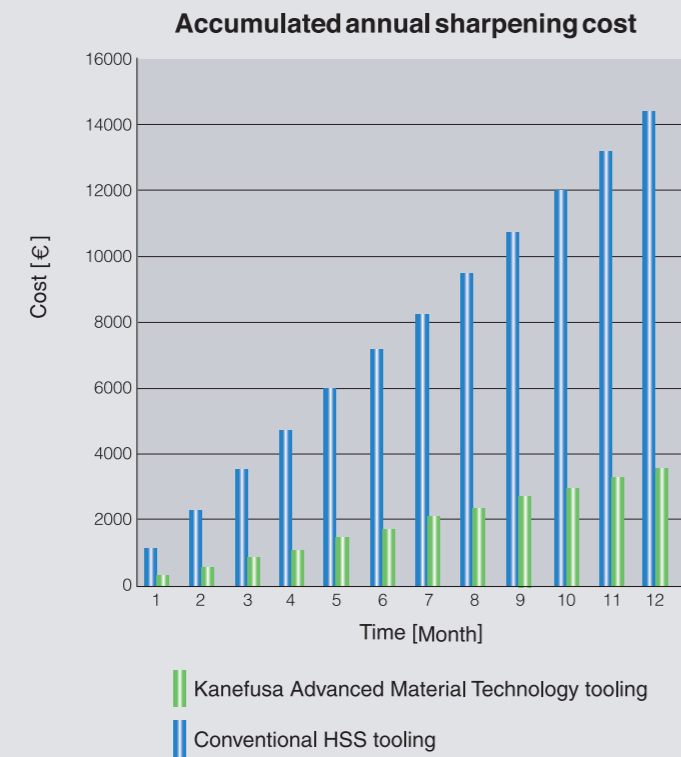
- Longer machine run-time, due to fewer head removals
- Lower ongoing grinding cost
- Less spending for new tooling

Advanced Material Technology cutting edges cut cleaner and finger joint length doesn't grow longer

- More precise finger joint provides higher joint strength
- Less trim saw adjustments ensure high process reliability
- Tremendous fiber savings are possible

Advanced Material Technology cutting edges cut smoother

- Increased cycle times
- Less power consumption
- Run quieter



KANEFUSA CORPORATION

Head Office / Factory
 1-1 Nakaoguchi, Ohguchi-cho, Niwa-Gun
 Aichi-ken, Japan, Postal Code 480-0192
 Tel : +81 587 95 7221
 Fax : +81 587 95 7226
 E-mail: sales-ex@kanefusa.co.jp

P.T. KANEFUSA INDONESIA

EJIP Industrial Park, Plot 8D, Cikarang Selatan,
 Bekasi 17550, West Java, Indonesia
 Tel : +62 21 897 0360
 Fax: +62 21 897 0286
 +62 21 897 0287
 E-mail : kfisales@cbn.net.id

KANEFUSA EUROPE B.V.

Europe Office
 De Witbogt, 5652 AG, Eindhoven, The Netherlands
 Tel : +31 40 2900901
 Fax: +31 40 2900908
 E-mail : rocky.hayashi@kanefusa.nl

German Office
 Radlerstrasse 78, 87600 Kaufbeuren, Germany
 Tel : +49 8341 95 59 659
 Fax: +49 8341 95 59 661
 E-mail : office@kanefusa.de

KANEFUSA USA, INC.

2762 Circleport Drive, Erlanger, KY 41018, USA
 Tel : +1 859 283 1450
 Fax: +1 859 283 5256
 E-mail : kanefusa@hotmail.com

KANEFUSA CHINA CORPORATION KUNSHAN KANEFUSA CORPORATION

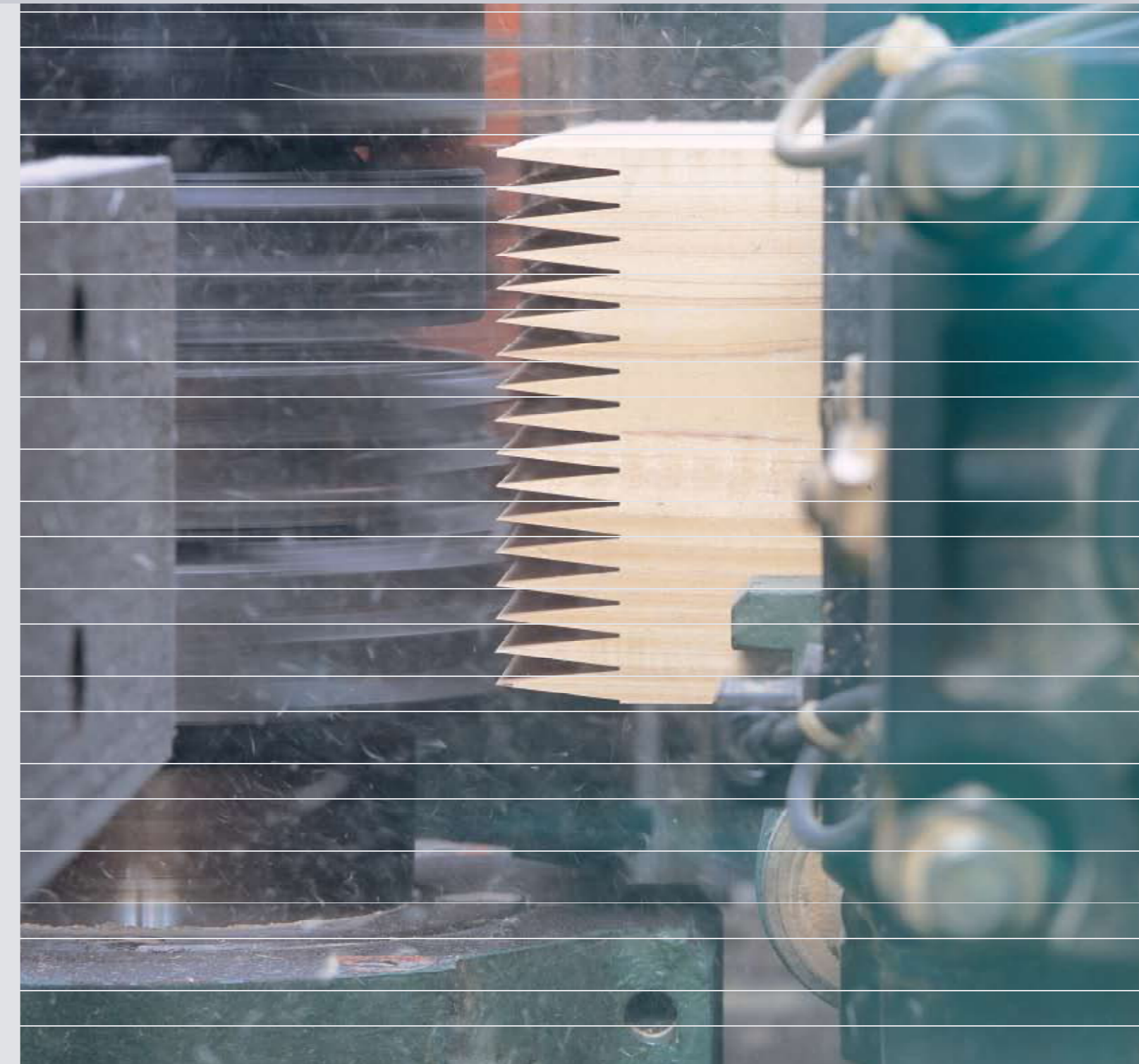
NO.50 Zhuzhu Road, Lujia Town Kunshan city, Jiangsu, China
 Tel : +86 512 57875072
 Fax: +86 512 57875073
 E-mail : yy@kfcn.szbnet.com

MALAYSIA OFFICE

Suite 839 Level 8, Pavilion KL 168
 Jalan Bukit Bintang 55100 Kuala Lumpur, Malaysia
 Tel : +60 3 92057721
 Fax: +60 3 92057720
 E-mail : kanefusamal@myjaring.net



Kanefusa TAF-C finger joint inserts and TAF-Pro finger joint cutter are used in the production of load bearing and sub-structural timber made from softwoods. They are available for machines with and without trim saws. Advanced Material Technology treated trim and scoring saws are available upon request. For production of millwork components made from softwoods, hardwoods and tropical woods, we carry the EN2RO finger joint cutter head and disc type finger joint cutters in our program.



Kanefusa - A New Dimension of Performance



Specifications and appearance are subject to change without notice. Photographs and illustrations may vary from actual products.

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 [Class] [Article] [Revision]





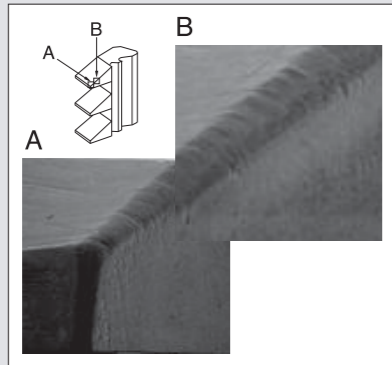
Kanefusa is the pioneer and worldwide leader in the development of advanced cutting edge materials for the woodworking industry. The result of extensive research and development has been a revolutionary new material called Advanced Material Technology.

Advanced Material Technology changes the wear characteristics of the cutting edge and reduces residue adhesion.

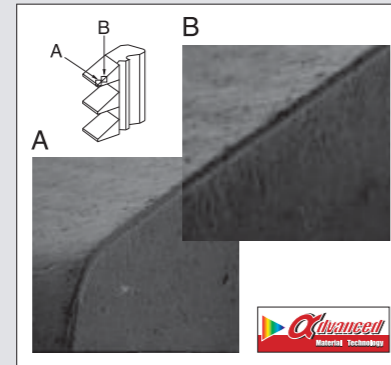
The first products treated with Advanced Material Technology were ST-1 planer knives in 1995. Two treatments which are marketed under Advanced Material Technology have been developed since:

HS-HP is applied to cutting edges with a High Speed Steel substrate.

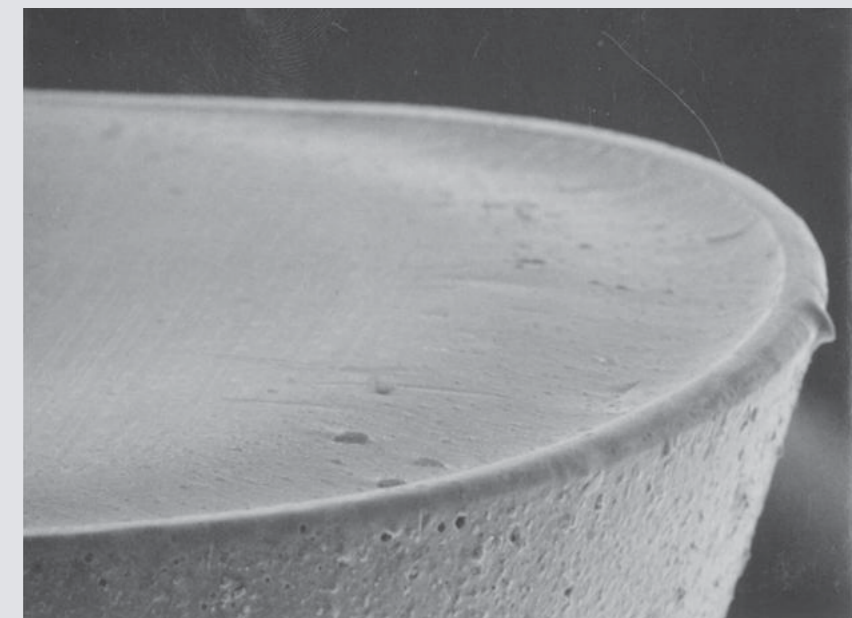
HC-UP is applied to cutting edges with a Carbide substrate.



A conventional High Speed Steel cutting edge is blunt after cutting only 1000m of spruce.



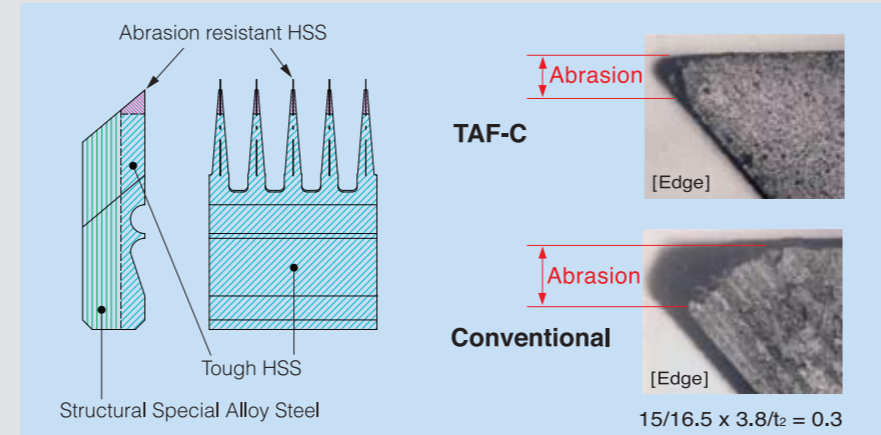
The Advanced Material Technology treated cutting edge does not show much trace of wear even after cutting 4000 m of spruce.



The picture aside shows the top of the cutting edge of a finger joint cutter. Advanced Material Technology is applied to the back and the wear that can be seen is best described as crater wear. Though the rake side hollows out slowly, the cutting edge itself is still sharp.

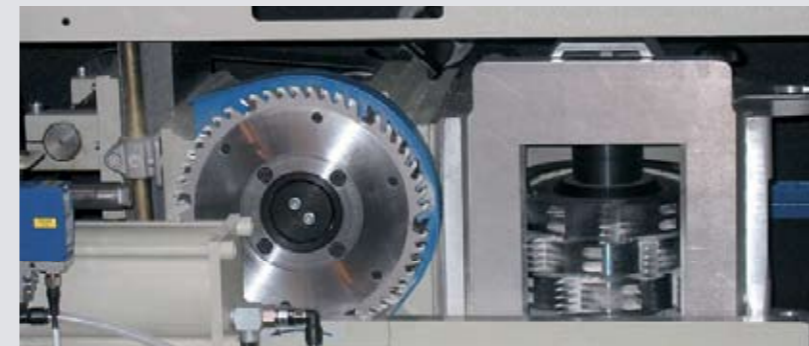
Regrinding

Advanced Material Technology is applied only to the back of the cutting edge. The finger joint cutter can be reground on any conventional grinding machine. Though Advanced Material Technology cutting edges with regular High Speed Steel substrate or a TAF-C substrate outlast regular cutting edges many times, stock removal during grinding is less than that of regular tooling. Less stock removal leads to more regrinds per cutter.



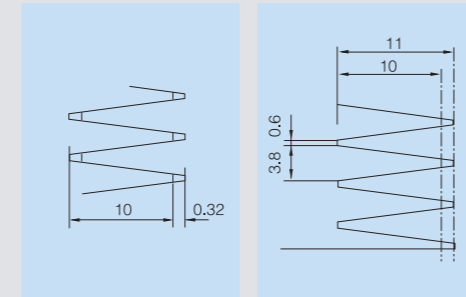
The new TAF-C finger joint knives are built from multi-layered steel. The top of the finger is made from highly abrasion resistant High Speed Steel, while the bottom has a higher toughness. This structure is forged on special alloy steel with high shock resistance. The inserts are furthermore treated with Advanced Material Technology. As a result, the inserts outlast conventional Advanced Material Technology cutter and are less subject to breakage. Only inserts are available in TAF-C quality.

Cutter with finger joint length 10/11, 15/16.5 and 20/22 are for machines with trim saws. On these machines the finger joint length can be set from anywhere in between the two figures. I.e., between 10 mm and 11 mm. Through the variable finger joint length the fitting conditions can be set according to the wood species or press.



Profile examples

Finger Joint Length 10/10 Without trim saw Finger Joint Length 10/11 With trim saw



Theoretical size of tip gap = 0.32 mm Size of tip gap is variable by 1 mm

Typical finger joint profiles

Finger Joint Length [mm]	Pitch [mm]	Base Size [mm]	Tip gap [mm]
10	3.8	0.6	0.3-0.5
15	3.8	0.4	0.45-0.75
20	5.0	0.5	0.6-1.0
20	6.2	1.0	0.6-1.0
30	6.2	0.6	0.9-1.5

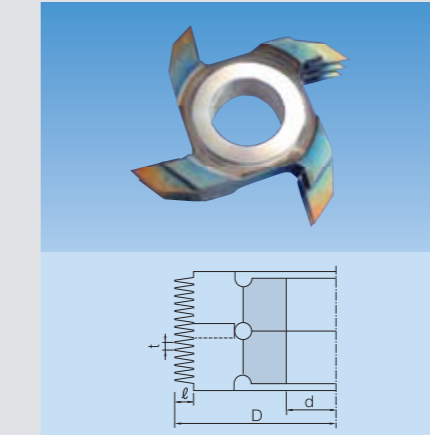
Maximum timber height [mm] which can be cut according to the number of cutters

Number of tools	TAF-Pro		TAF-C	
	[t]	[ℓ]	[t]	[ℓ]
1	3.8	10/10	3.8	10/10
	6.2	10/11	6.2	20/20
	6.2	15/15	6.2	20/22
2	7.7	15/15	7.7	15/16.5
	7.7	15/16.5	7.7	15/16.5
3	24	31	28	24
4	51	69	59	62
5	77	107	90	99
6	104	145	121	136
7	131	183	152	173
8	157	221	183	210
9	184	259	214	248
10	210	297	245	285
11	237	335	276	322
12	264	373	307	359

t = Pitch ℓ = Finger Joint Length

PAT.EP0739697
PAT.EP1043129
PAT.US6644896
PAT.CNZL02815463

※HS-HP coating requires a special resharpening method



TAF-Pro Cutter

Grade : HS-HP / ℓ=Finger Joint Length

Order No.	D [mm]	d [mm]	B [mm]	ℓ [mm]	Z	t	F
1	120	40	28.6	15/15	2+2	3.8	7
2	160	50	28.6	10/10	2+2	3.8	7
3	160	50	28.6	10/11	3+3	3.8	7
4	170	50	28.6	15/15	2+2	3.8	7
5	170	50	28.6	15/16.5	2+2	3.8	7
6	180	50	33.0	15/16.5	2+2	3.8	7
7	180	50	33.0	20/20	2+2	6.2	5
8	250	50	28.6	10/11	3+3	3.8	7
9	260	50	28.6	15/16.5	3+3	3.8	7
10	260	50	33.0	20/20	3+3	6.2	5
11	260	50	33.0	20/22	3+3	6.2	5

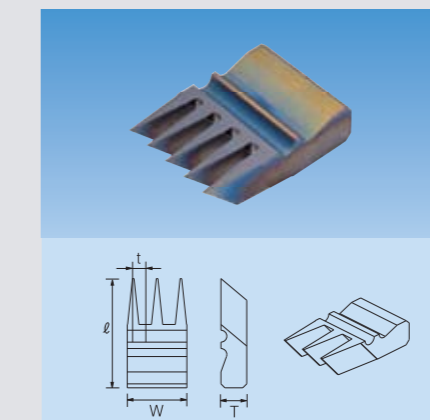
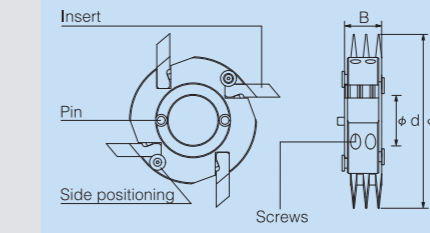
t = Pitch F = Number of Finger



Cutter Heads

Grade : HS-HP / ℓ=Finger Joint Length

Order No.	D [mm]	B [mm]	d [mm]	Z	ℓ [mm]	
1	887-A015-500	160	x 38	x 50	x 4	10/10
2	887-A020-500	160	x 38	x 50	x 4	10/11
3	887-A072-500	170	x 38	x 50	x 4	15/15
4	887-A036-500	170	x 38	x 50	x 4	15/16.5
5	887-A205-500	180	x 37.2	x 50	x 4	20/20
6	887-A206-500	180	x 37.2	x 50	x 4	20/22
7	887-A004-500	250	x 38	x 50	x 6	10/10
8	887-A207-500	250	x 38	x 50	x 6	10/11
9	887-A022-500	260	x 38	x 50	x 6	15/15
10	887-A021-500	260	x 38	x 50	x 6	15/16.5



Inserts TAF-C Quality

Grade : HS-HP / ℓ=Finger Joint Length

Order No.	W [mm]	L [mm]	T [mm]	ℓ [mm]	t [mm]	F	
1	779-0034-611	35	x 45	x 13	10/10	3.8	10
2	779-0068-611	35	x 45	x 13	10/11	3.8	10
3	779-0042-611	35	x 50	x 13	15/15	3.8	10
4	779-1503-611	35	x 50	x 13	15/16.5	3.8	10
5	779-0050-611	32.5	x 55	x 13	20/20	6.2	6
6	779-0109-611	30	x 55	x 13	20/22	6.0	6

t = Pitch F = Number of Finger

Carbide tipped and Advanced Material Technology treated trim saws and hogger are available upon request