



# Leitz Lexicon

**Edition 7**

Dear customer,

For decades, Leitz tool solutions and services has guaranteed our customers sustainable success and competitiveness in the processing of wood, wood derived materials and innovative materials. As a world market leader, we set trends and develop highly efficient tools through innovative ideas and the most advanced technology. Leitz supplies solutions with vision, making production processes not only faster, more flexible and cost-effective, but which combine ecology and economy with excellent processing quality. This current seventh edition of the Leitz Lexicon also reflects our performance promise; that your business succeeds with the support of our products and services.

Sustainability, flexibility, quality, productivity and efficiency as well as suitability and reliability are subjects that are always in focus for Leitz as a company, and our tools, tooling systems and services. The Leitz Lexicon has underlined this for decades. With a new layout and user-oriented structure, we present you the whole world of our total tool know-how.

The increase in networked production processes is vital in the era of Industry 4.0. Along the entire value chain, intelligent tools assume an important and forward-looking role as an information medium. Each element of the process chain plays an important role, however, as we realized decades ago, as a shaping and quality-relevant element on the workpiece, the tool has exceptional functions.

Over more than 140 years of tradition and as a family enterprise in its fifth generation, the satisfaction of our customers - from small craft enterprises to global industrial companies - continues to be our main priority. As a manufacturing service provider and expert partner, with our worldwide net of wholly-owned sales and service companies, we have a centre near you providing expert support, along with highly qualified staff that undergo continual training.

With this new, compact edition of the Leitz-Lexicon, we provide you our comprehensive process and tool know-how so we can do our part for your economic success. We are glad to offer solutions in new dimensions.

Together, we will shape a successful future.

Yours sincerely



Dr. Cornelia Brucklacher  
Head of the Advisory Board  
and shareholder



Jürgen Köppel  
Spokesman of the Management



Leitz was founded in Oberkochen, Southern Germany in 1876. Precision tools and tooling systems developed and produced in house, meet the needs of the woodworking and plastic machining industries, Tooling plus complex tool services make Leitz a reliable partner for both industry and craft. Today Leitz is a global player with production plants, sales companies and service centres in 36 countries.

## Leitz Group

Leitz GmbH & Co. KG, with its headquarters in Oberkochen, Baden-Württemberg, Germany is a technological leading manufacturer of precision machine tools and tooling systems for industrial processing of solid wood, wood derived materials and plastic materials. In addition to a comprehensive product program, Leitz offers consultancy services using the company's 140 plus years experience of supplying tools to its customers.

## Leitz: facts and figures

The Leitz Group has 6 production facilities in Europe, America and Asia. The employees at Leitz design, make and deliver over 8000 precision tools from the standard tool program, in addition to tooling systems and numerous customer specific tools.

With many subsidiaries and over 120 service centres around the world Leitz is always close to the customer. Supported by local stocking Leitz delivers products quickly and reliably in over 150 countries and offers qualified consultancy support, and fast tool maintenance.





### Leitz: a producing service provider

Leitz has, at the head office in Oberkochen and at the subsidiaries in Unterschneidheim, Germany and Riedau, Austria, in-house research and development centres. There Leitz engineers work closely with customers and leading machine manufacturers to develop and test innovative and efficient machining and tooling solutions.

Leitz also co-operates closely with the renowned research institutes and universities to offer the best tooling solution to its customers. Optimised performance, reduced processing costs and consideration of the environmental impact of the machining solutions are three of the priorities for research and development at Leitz.

Leitz supplies much more than a special range of products: Leitz is a service provider; the product spectrum encompasses the entire range of precision machine tools for global industrial organisations and craftsman's shops in the wood and plastic processing industries and are, for example, used in window, timber construction, panel processing and furniture. Leitz offers the right solution for every process.

Leitz sees itself as an industrial partner and trouble shooter and offering first class consultancy services, project and process engineering, from traditional tool service to complex tool management and tool procurement, tool management, tool controlling, implementation and training. Leitz services are individually tailored and give each customer the opportunity to concentrate on his strengths and core business.

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## Service within hearing distance

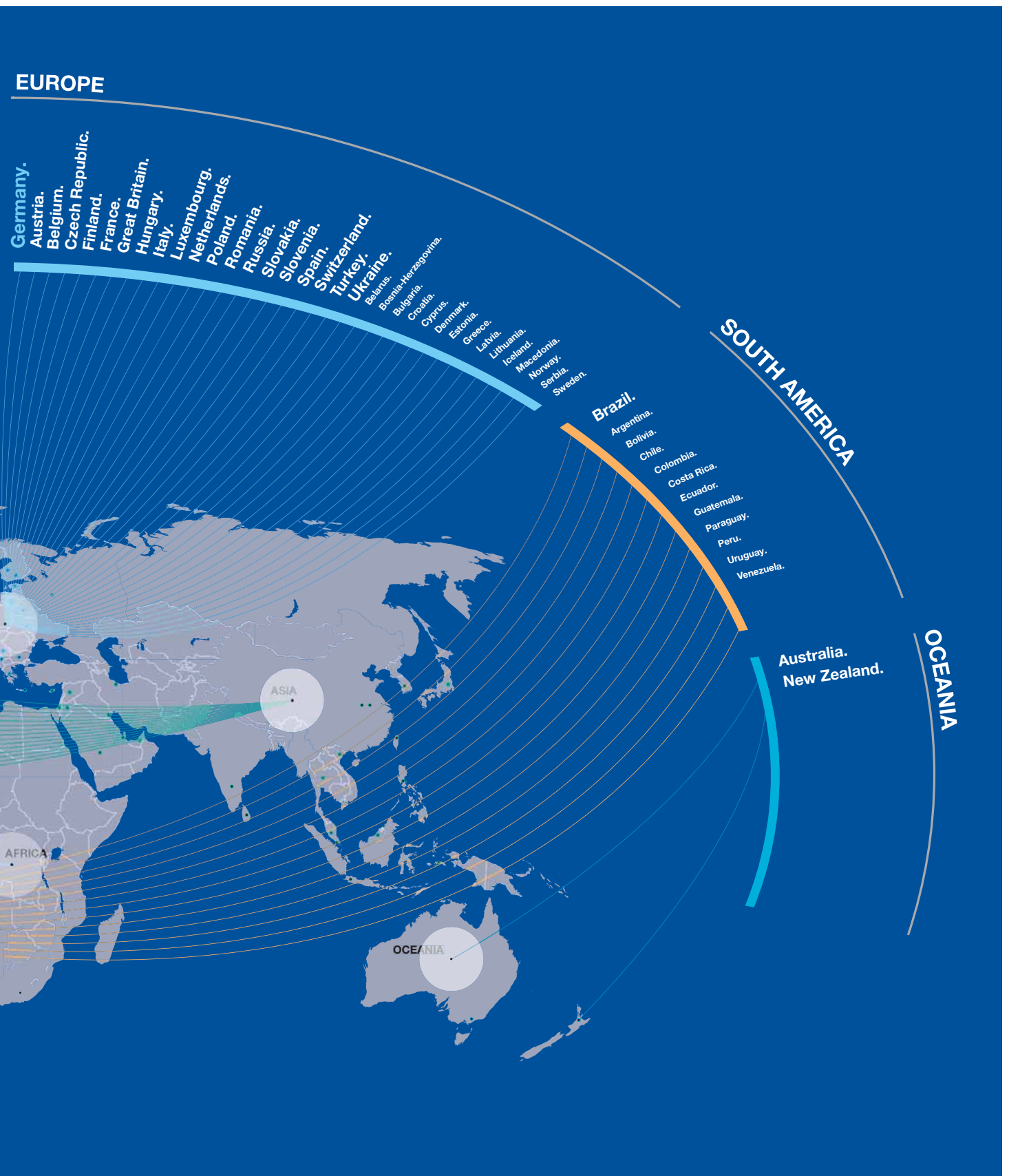
Even the best quality tool can only give of its best if regularly maintained by experts over its entire life. Leitz offers a global tool maintenance service servicing all tools to uniform and certified quality standards – service within hearing distance. The Leitz collection and delivery service complements this professional service and ensures customers' tools are returned to them quickly.

## From the edge to tool – an all in one solution

Leitz Group, Boehlerit GmbH & Co. KG of Kapfenberg, Austria and Bilz GmbH & Co. KG of Ostfildern, Germany work closely together developing and producing innovative tungsten carbide and diamond cutting materials; Here is foundation for the quality and inherent value of Leitz tools. Bilz's expertise is in tool clamping technology and is a leading manufacturer of thermal clamping systems for high speed machining of metal, wood and plastics. Bilz's products influence the economic success of Leitz tools. The knowledge and the development capability of Leitz, Boehlerit and Bilz opens up promise exciting prospects for the three companies and their customers.







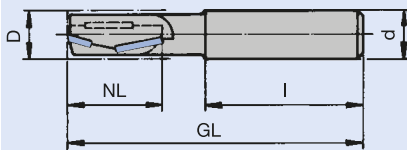


## Standard tools

The identification number clearly defines the tool. All the data the identification number, dimensions, direction of rotation and cutting material add to the information and help avoid wrong deliveries in case of an inaccurate identification number. Shank tools and tools with bore are detailed below as examples.

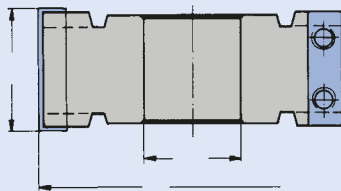
### Shank tool

Identification: Router cutter  
Diamaster Quattro  
Item number: WO 140 2  
Ident. no.: 091147  
Dimensions: D x GL/NL x (d x l)  
25 x 100/38 x (20 x 50)  
Dir. of rotation: LH (clockwise)  
Cutting material: DP (poly-crystalline diamond)



### Tool with bore

Identification: Rebating cutterhead  
Item number: WW 420 1 01  
Ident. no.: 024498  
Dimensions: D x SB x BO; Z/V  
125 x 50.4 x 30;  
Z2/V4  
Cutting material: HW  
(tungsten carbide)

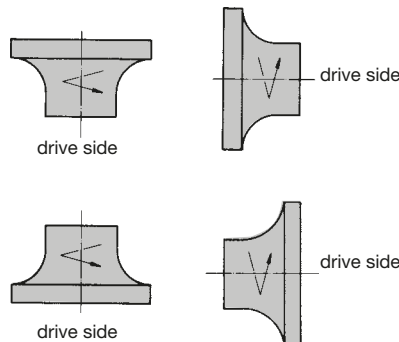


## Special tools

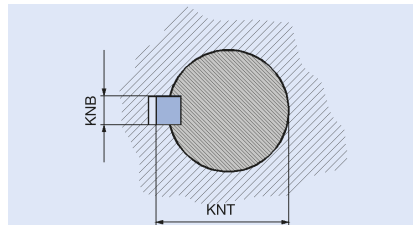
Smooth enquiry and order processing requires detailed information. – The enquiry and order forms aid the order process and prevent errors. The following information will help you complete the order form.

## Characteristic tool data

- Diameter x cutting width x bore (tools with bore)
- Diameter x working length x shank dimension (shank tools)
- Number of teeth
- Profile depth
- Direction of rotation (from the drive side)
- Speed of rotation
- Feed speed
- Keyway dimensions
- Tool design
- Quality of cutting material (HS, Stellite™, tungsten carbide, diamond)
- Type of feed: Manual feed (MAN) or Mechanical feed (MEC)



Direction of rotation right.



Keyway reference dimensions measured on the spindle

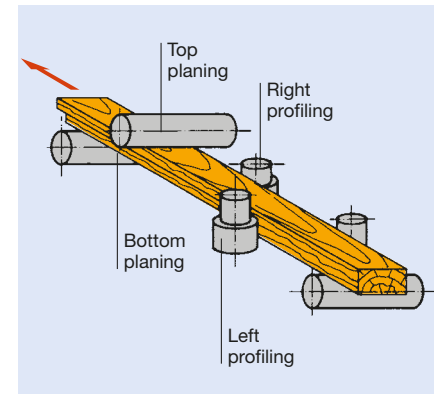
For bevelling, rebating and profiling tools we always supply:

Right hand rotation tools with the large diameter or spur to the top (unless specified differently at the time of order).

## Tool set data

- Material: e. g.: softwoods, hardwoods, tempered or compressed woods, plywood boards, wood core boards, wood chipboards, MDF boards, soft fibreboards, hard fibreboards, compressed glulam, laminated woods, plastics, etc.
- Surface finish of the material: veneered, plastic coated, lacquered, etc. (in case of doubt regarding the material or its characteristics: send a sample of the material to be processed).

- Direction of processing: processing along or across the grain. Processing with or against feed.
- Machine data: manufacturer and type, range of rotation, installed power, max. tool dimensions, interfaces, type of feed, etc.
- Position of the workpiece to the tool: support of the workpiece, position of the fence and feed direction.



Position of the workpiece relative to the tool

## Profile information

Profile sketches or profile drawings must clearly indicate if they refer to the material (wood) or cutter. Please specify motor side, direction of rotation, dimensions and working conditions on the material sample or drawing.

## Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions, and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.

## General Terms and Conditions

The sale of our tools is exclusively subject to our General Terms and Conditions in their respective valid version. Any sale conditions to the contrary will not be accepted by Leitz. The current version of OUR General Terms and Conditions you can find on [www.leitz.org/AGB](http://www.leitz.org/AGB).

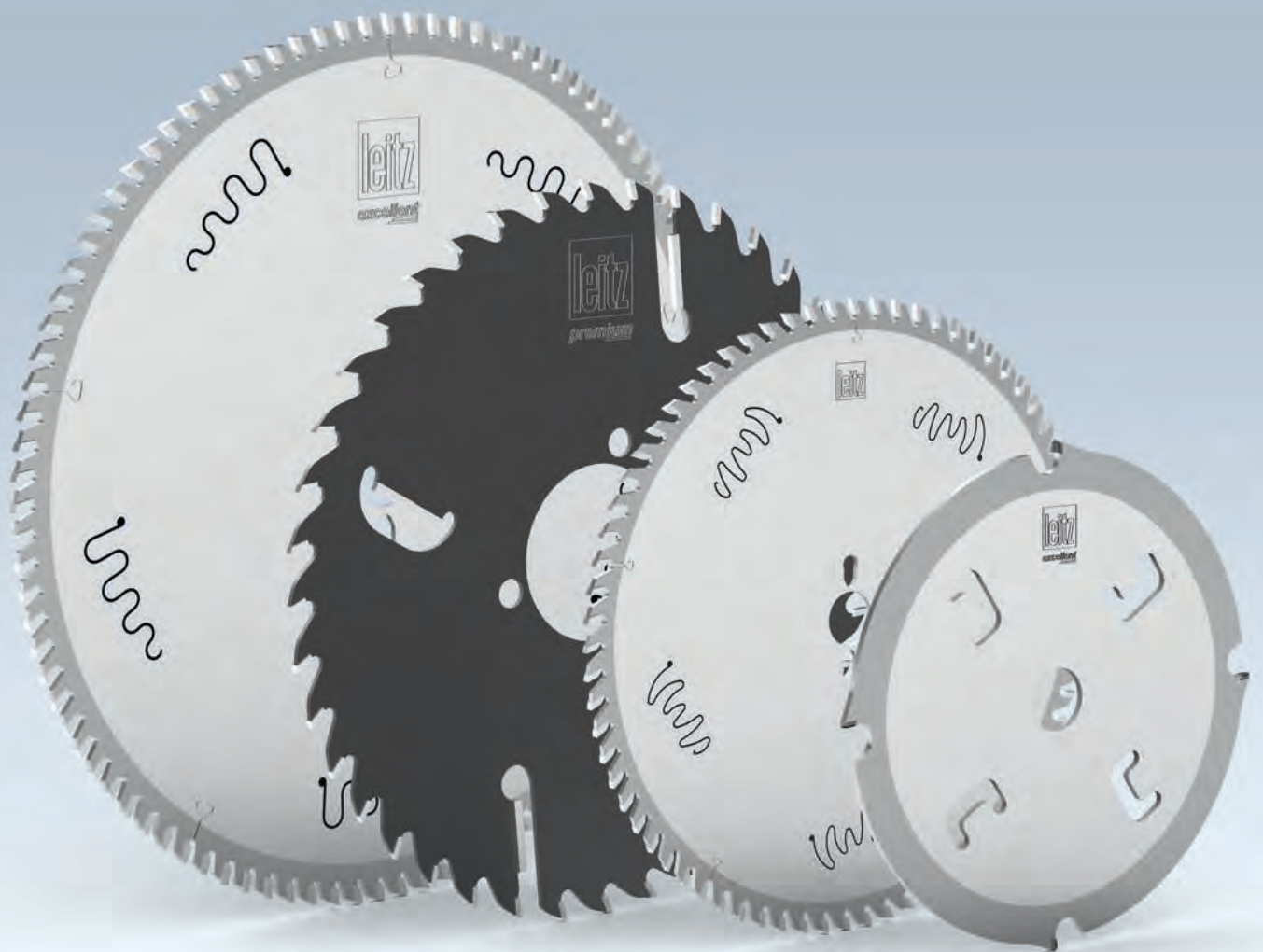


# Sawing

Leitz Lexicon Edition 7

Version 2

05/2022





## Explanation of abbreviations

A	= dimension A	LH	= left hand rotation
$a_e$	= cutting thickness (radial)	M	= metric thread
$a_p$	= cutting depth (axial)	MBM	= minimum order quantity
ABM	= dimension	MC	= multi-purpose steel, coated
APL	= panel raising length	MD	= thickness of knife
APT	= panel raising depth	$\text{min}^{-1}$	= revolutions per minute (RPM)
AL	= working length	MK	= morse taper
AM	= number of knives	$\text{m min}^{-1}$	= metres per minute
AS	= anti sound (low noise design)	$\text{m s}^{-1}$	= metres per second
b	= overhang	n	= RPM
B	= width	$n_{\text{max}}$	= maximum permissible RPM
BDD	= thickness of shoulder	NAL	= position of hub
BEM	= note	ND	= thickness of hub
BEZ	= description	NH	= zero height
BH	= tipping height	NL	= cutting length
BO	= bore diameter	NLA	= pinhole dimensions
CNC	= Computerized Numerical Control	NT	= grooving depth
d	= diameter	P	= profile
D	= cutting circle diameter	POS	= cutter position
D0	= zero diameter	PT	= profile depth
DA	= outside Diameter	PG	= profile group
DB	= diameter of shoulder	QAL	= cutting material quality
DFC	= Dust Flow Control (optimised chip clearance)	R	= radius
DGL	= number of links	RD	= right hand twist
DIK	= thickness	RH	= right hand rotation
DKN	= double keyway	RP	= radius of cutter
DP	= polycrystalline diamond	S	= shank dimension
DRI	= rotation	SB	= cutting width
FAB	= width of rebate	SET	= set
FAT	= depth of rebate	SLB	= slotting width
FAW	= bevel angle	SLL	= slotting length
FLD	= flange diameter	SLT	= slotting depth
$f_z$	= tooth feed	SP	= tool steel
$f_{z \text{ eff}}$	= effective tooth feed	ST	= Cobalt-basis cast alloys, e.g. Stellite™
GEW	= thread	STO	= shank tolerance
GL	= total length	SW	= cutting angle
GS	= Plunging edge	TD	= diameter of tool body
H	= height	TDI	= thickness of tool
HC	= tungsten carbide, coated	TG	= pitch
HD	= wood thickness (thickness of workpiece)	TK	= reference diameter
HL	= high-alloyed tool steel	UT	= cutting edges with irregular pitch
HS	= high-speed steel (HSS)	V	= number of spurs
HW	= tungsten carbide (TCT)	$v_c$	= cutting speed
ID	= ident number	$v_f$	= feed speed
IV	= insulation glazing	VE	= packing unit
KBZ	= abbreviation	VSB	= adjustment range
KLH	= clamping height	WSS	= workpiece material
KM	= edge breaker	Z	= number of teeth
KN	= single keyway	ZA	= number of fingers
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60	ZF	= tooth shape (cutting edge shape)
L	= length	ZL	= finger length
I	= clamping length		
LD	= left hand twist		
LEN	= Leitz standard profiles		

### Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.

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80	2,8 - 3,8	20	20	HW	FZ	10	<b>165401</b>	38
80	3,3	20	18	DP	HZ/WZ	10	<b>190700</b>	31
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100	2,4	22	30	HW	WZ	10	<b>166110</b>	75
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100	2,8 - 3,8	22	20	HW	FZ	10	<b>165403</b>	38
100	3,2	20	20	HW	KON/FZ	5	<b>165625</b>	49
100	3,2	22	20	HW	KON/FZ	5	<b>165626</b>	49
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100	3,5	30	35	HW	WZ/WZ/FZ	15	<b>166000</b>	72
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100	5,0	30	35	HW	WZ/WZ/FZ	15	<b>166001</b>	72
100	8,5	20	35	HW	WZ/WZ/FZ	15	<b>166013</b>	72
100	8,5	30	35	HW	WZ/WZ/FZ	15	<b>166017</b>	72
120	2,4	20	24	HW	WZ	15	<b>166111</b>	75
120	2,8 - 3,8	20	24	HW	FZ	10	<b>165404</b>	38
120	2,8 - 3,8	20	24	DP	FZ	10	<b>190731</b>	39
120	2,8 - 3,6	22	24	HW	FZ	10	<b>165405</b>	38
120	2,8 - 3,8	22	24	HW	FZ	10	<b>165406</b>	38
120	2,8 - 3,8	22	24	DP	FZ	10	<b>190694</b>	39
120	2,8 - 3,8	50	24	HW	FZ	10	<b>165412</b>	38
120	2,8 - 3,8	50	24	DP	FZ	10	<b>190704</b>	39
120	3,2	20	24	HW	KON/FZ	5	<b>165627</b>	49
120	3,3	20	18	DP	HZ/WZ	10	<b>190701</b>	31
120	3,3	22	18	DP	HZ/WZ	10	<b>190702</b>	31
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120	4,0	20	35	HW	WZ/WZ/FZ	15	<b>166009</b>	72
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120	5,0	20	35	HW	WZ/WZ/FZ	15	<b>166003</b>	72
120	5,0	35	35	HW	WZ/WZ/FZ	15	<b>166005</b>	72
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125	2,4	20	24	HW	WZ	15	<b>166112</b>	75
125	2,8 - 3,8	20	24	HW	FZ	10	<b>165407</b>	38
125	2,8 - 3,8	20	24	DP	FZ	10	<b>190695</b>	39
125	3,1	20	20	DP	KON/FZ	10	<b>190564</b>	50
125	3,2	20	24	HW	KON/WZ	5	<b>165550</b>	48
125	3,2	22	24	HW	KON/WZ	5	<b>165551</b>	48
125	3,3	20	18	DP	HZ/WZ	10	<b>190703</b>	31
125	3,5	30	35	HW	WZ/WZ/FZ	15	<b>166006</b>	72
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125	4,4	20	24	HW	KON/FZ	5	<b>165628</b>	49
125	4,4	45	24	HW	KON/WZ	5	<b>165553</b>	48
125	4,4	45	24	HW	KON/FZ	5	<b>165629</b>	49
125	5,0	30	35	HW	WZ/WZ/FZ	15	<b>166007</b>	72

D mm	SB mm	BO mm	Z	QAL	ZF	SW °	ID	Page
140	1,8	20	35	HW	WZ/WZ/ WZ/FZ	10	<b>166623</b>	74
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150	3,2	30	42	HW	FZ	10	<b>165375</b>	36
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150	4,4	20	24	HW	KON/WZ	5	<b>165554</b>	48
150	4,4	30	36	HW	KON/WZ	5	<b>165555</b>	48, 53
150	4,4	30	24	HW	KON/WZ	5	<b>165556</b>	48, 53
150	4,4	45	24	HW	KON/WZ	5	<b>165557</b>	48, 53
150	4,4	45	28	HW	KON/WZ	5	<b>165558</b>	48, 53
160	1,6	20	24	HW	WZ	25	<b>166100</b>	75
160	1,8	16	48	HW	WZ	10	<b>060574</b>	29
160	1,8	20	32	HW	WZ	5	<b>166102</b>	75
160	1,8	20	48	HW	FZ/TR	5	<b>166311</b>	78
160	1,8	20	42	HW	WZ/WZ/ WZ/FZ	10	<b>166620</b>	74
160	1,8	20	18	HW	WZ	25	<b>166101</b>	75
160	2,0	20	48	HW	FZFA/FZFA	0	<b>163529</b>	80
160	2,2	20	48	HW	FZFA/FZFA	5	<b>161008</b>	81
160	2,2	20	4	DP	FZ	5	<b>190752</b>	83
160	2,5	20	56	HW	FZ/TR	-5	<b>166350</b>	79
160	2,5	20	30	DP	HZFA/ WZFA	10	<b>190751</b>	71
160	2,5	20	24	HW	WZ	15	<b>166117</b>	75
160	2,5	20	48	HW	WZ	15	<b>166118</b>	75
160	2,5	20	12	HW	WZ	20	<b>166116</b>	75
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160	3,2	20	4	DP	P	5	<b>190302</b>	83
160	4,3	55	30	DP	KON/FZ	10	<b>190566</b>	50, 52
160	4,4	30	36	HW	KON/WZ	5	<b>165560</b>	48
160	4,4	45	36	HW	KON/WZ	5	<b>165561</b>	48
160	4,4	55	36	HW	KON/WZ	5	<b>165562</b>	48, 52
165	1,8	20	48	HW	FZ/TR	5	<b>166312</b>	78
165	1,8	20	42	HW	WZ/WZ/ WZ/FZ	10	<b>166621</b>	74
165	2,0	20	48	HW	FZFA/FZFA	0	<b>163530</b>	80
165	2,2	20	56	HW	FZ/TR	-5	<b>166351</b>	79
165	2,2	20	48	HW	FZFA/FZFA	5	<b>161009</b>	81
165	2,2	20	4	DP	FZ	5	<b>190753</b>	83
165	2,2	20	48	HW	WZ	10	<b>166104</b>	75
165	2,2	20	24	HW	WZ	15	<b>166119</b>	75
165	2,4	20	12	HW	WZ	15	<b>166103</b>	75
170	2,5	30	48	HW	WZ	10	<b>166120</b>	75
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180	1,8	60	32	HW	FZ	20	<b>057412</b>	12
180	1,8	60	21	HW	FZ	20	<b>057444</b>	12
180	2,2	30	18	HW	FZ	15	<b>165300</b>	18
180	2,4	16	58	HW	WZ	10	<b>059665</b>	29
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180	2,5	20	24	HW	WZ	15	<b>166121</b>	75

## 1. Sawing

## Quick search



D mm	SB mm	BO mm	Z	QAL	ZF	SW °	ID	Page
180	2,5	30	48	HW	WZ	10	<b>166105</b>	75
180	2,5	30	35	DP	HZFA/ WZFA	10	<b>190713</b>	71
180	2,5	30	24	HW	WZ	15	<b>166123</b>	75
180	2,5	40	35	DP	HZFA/ WZFA	10	<b>190714</b>	71
180	3,0 - 3,8	22	36	HW	WZ	10	<b>165410</b>	38
180	3,0	30	60	HW	WZ/WZ/FZ	10	<b>161250</b>	70
180	3,0	30	60	HW	WZ/WZ/FZ	10	<b>161267</b>	70
180	3,0	30	24	HW	WZ	10	<b>163102</b>	27
180	3,0	40	60	HW	WZ/WZ/FZ	10	<b>161251</b>	70
180	3,0 - 3,8	50	36	HW	FZ	10	<b>165413</b>	38
180	3,2	16	42	HW	FZ/TR	5	<b>166301</b>	78
180	3,2	20	42	HW	FZ/TR	-5	<b>166352</b>	79
180	3,2	20	36	HW	KON/WZ	5	<b>165563</b>	48
180	3,2	30	58	HW	WZ	10	<b>163103</b>	27
180	3,2	30	48	HW	FZ	10	<b>165378</b>	36
180	3,2	30	36	DP	DZ/TR	10	<b>190747</b>	67
180	3,2	65	48	HW	FZ	10	<b>165379</b>	36
180	3,2	65	48	HW	FZ	10	<b>165380</b>	36
180	3,2	65	58	HW	FZ	10	<b>165381</b>	36
180	3,2	65	58	HW	FZ	10	<b>165382</b>	36
180	3,2	65	24	DP	FZ	10	<b>190660</b>	37
180	3,2	65	24	DP	FZ	10	<b>190661</b>	37
180	3,2	65	36	DP	FZ	10	<b>190662</b>	37
180	3,2	65	36	DP	FZ	10	<b>190663</b>	37
180	3,2	65	48	DP	FZ	10	<b>190664</b>	37
180	3,2	65	48	DP	FZ	10	<b>190665</b>	37
180	3,5	30	30	HW	WZ	10	<b>163104</b>	27
180	3,8	60	24	HW	WZ	20	<b>165255</b>	13
180	4,3	30	30	DP	KON/FZ	10	<b>190567</b>	50, 52, 54-55
180	4,3	45	30	DP	KON/FZ	10	<b>190568</b>	50, 52-53
180	4,4	20	36	HW	KON/WZ	5	<b>165564</b>	48
180	4,4	20	28	HW	KON/FZ	5	<b>165630</b>	49
180	4,4	30	30	HW	KON/FZ	5	<b>165632</b>	49, 52, 54-55
180	4,4	45	30	HW	KON/WZ	5	<b>165565</b>	48, 52-53
180	4,4	45	36	HW	KON/WZ	5	<b>165566</b>	48, 52-53
180	4,4	45	36	HW	KON/FZ	5	<b>165633</b>	49, 52-53
180	4,5	50	36	HW	KON/WZ	5	<b>165567</b>	48
180	4,55	30	36	HW	WZFA	10	<b>165681</b>	51
180	4,7	45	30	DP	KON/FZ	10	<b>190569</b>	50, 53
180	4,8	45	36	HW	KON/FZ	5	<b>165634</b>	49, 53
180	5,8	20	36	HW	KON/FZ	5	<b>165631</b>	49
184	2,5	20	24	HW	WZ	15	<b>166124</b>	75
184	3,2	20	4	DP	P	5	<b>190696</b>	83
190	1,8	20	72	HW	FZFA/FZFA	-5	<b>060278</b>	62
190	1,8	30	54	HW	FZ/TR	5	<b>166313</b>	78
190	1,8	30	42	HW	WZ/WZ/ WZ/FZ	10	<b>166622</b>	74
190	2,0	30	54	HW	FZFA/FZFA	0	<b>163531</b>	80
190	2,2	30	4	DP	FZ	5	<b>190754</b>	83
190	2,4	20	58	HW	FZFA/FZFA	5	<b>161010</b>	81
190	2,5	30	24	HW	WZ	20	<b>166128</b>	75

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190	2,8	16	48	HW	WZ	10	<b>166126</b>	75
190	2,8	16	24	HW	WZ	15	<b>166125</b>	75
190	2,8	30	68	HW	FZ/TR	-5	<b>166354</b>	79
190	2,8	30	54	HW	FZ/TR	5	<b>166302</b>	78
190	2,8	30	48	HW	WZ	10	<b>166129</b>	75
190	2,8	30	16	HW	WZ	20	<b>166127</b>	75
190	3,2	20	4	DP	P	5	<b>190303</b>	83
190	3,2	30	4	DP	P	5	<b>190745</b>	83
200	1,5	60	36	HW	FZ	20	<b>057421</b>	12
200	1,5	60	21	HW	FZ	20	<b>057445</b>	12
200	1,8	20	80	HW	FZFA/FZFA	-5	<b>060274</b>	62
200	1,8	60	21	HW	FZ	20	<b>057446</b>	12
200	2,0	16	64	HW	WZ	10	<b>059666</b>	29
200	2,0	30	24	HW	FZ	20	<b>163575</b>	16
200	2,4	30	36	HW	WZ	10	<b>163105</b>	27
200	2,4	30	60	HW	WZ	10	<b>163106</b>	27
200	2,4	30	18	HW	FZ	15	<b>165302</b>	18
200	2,4	30	24	HW	FZ	15	<b>165303</b>	18
200	2,4	40	24	HW	FZ	20	<b>163550</b>	17
200	2,5	30	40	DP	HZFA/ WZFA	10	<b>190715</b>	71
200	2,5	30	40	DP	HZFA/ WZFA	10	<b>190716</b>	71
200	2,8	20	84	HW	FZ/TR	5	<b>166303</b>	78
200	3,0	30	65	HW	WZ/WZ/FZ	10	<b>161253</b>	70
200	3,0	30	65	HW	WZ/WZ/FZ	10	<b>161254</b>	70
200	3,0	30	24	HW	WZ	10	<b>163107</b>	27
200	3,0	30	48	HW	WZ	10	<b>163108</b>	27
200	3,0	30	60	HW	WZ	10	<b>163109</b>	27
200	3,0	30	34	HW	WZ	10	<b>166130</b>	75
200	3,0	30	48	HW	WZ	10	<b>166131</b>	75
200	3,2	18	80	HW	FZ/TR	-5	<b>166355</b>	79
200	3,2	30	60	HW	FZ/TR	-5	<b>166356</b>	79
200	3,2	30	60	HW	KON/WZ	5	<b>165571</b>	48
200	3,2	30	48	HW	FZ/TR	5	<b>166304</b>	78
200	3,2	30	54	HW	FZ	10	<b>165383</b>	36
200	3,2	30	18	HW	FZ	25	<b>165108</b>	19
200	3,8	60	24	HW	WZ	20	<b>165259</b>	13
200	4,3	20	30	DP	KON/FZ	10	<b>190570</b>	50, 54
200	4,3	30	30	DP	KON/FZ	10	<b>190571</b>	50
200	4,3	45	30	DP	KON/FZ	10	<b>190572</b>	50, 53
200	4,3	65	30	DP	KON/FZ	10	<b>190615</b>	50, 55
200	4,4	20	24	HW	KON/WZ	5	<b>165568</b>	54
200	4,4	20	36	HW	KON/WZ	5	<b>165569</b>	48, 54
200	4,4	30	36	HW	KON/WZ	5	<b>165572</b>	48
200	4,4	45	36	HW	KON/WZ	5	<b>165574</b>	48, 53
200	4,4	65	36	HW	KON/WZ	5	<b>165576</b>	48, 55
200	4,4	80	36	HW	KON/FZ	5	<b>165637</b>	49, 52
200	4,7	45	30	DP	KON/FZ	10	<b>190573</b>	50
200	4,7	65	30	DP	KON/FZ	10	<b>190574</b>	50, 55
200	4,8	20	36	HW	KON/WZ	5	<b>165573</b>	48, 54
200	4,8	45	36	HW	KON/FZ	5	<b>165636</b>	49
200	4,8	65	36	HW	KON/WZ	5	<b>165577</b>	48, 55
200	5,0	30	60	HW	WZ/WZ/FZ	15	<b>166012</b>	72
200	5,0	30	24	HW	FZ	20	<b>165250</b>	13
200	5,8	45	36	HW	KON/WZ	5	<b>165575</b>	48, 52
200	6,2	20	36	HW	KON/WZ	5	<b>165570</b>	48
200	6,8	20	36	HW	KON/FZ	5	<b>165635</b>	49
210	2,0	30	60	HW	FZFA/FZFA	0	<b>163532</b>	80
210	2,2	100	36	DP	FZ	3	<b>190676</b>	56

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210	2,4	30	64	HW	FZ/TR	-5	<b>166357</b>	79
210	2,4	30	68	HW	FZFA/FZFA	5	<b>161011</b>	81
210	2,4	30	64	HW	WZ	10	<b>166135</b>	75
210	2,4	30	24	HW	WZ	15	<b>166133</b>	75
210	2,4	30	42	HW	WZ	20	<b>166134</b>	75
210	2,8	30	60	HW	WZ	-5	<b>166252</b>	77
210	2,8	30	60	HW	FZ/TR	-5	<b>166358</b>	79
210	3,2	30	18	HW	FZ	20	<b>165109</b>	19
215	4,4	50	42	HW	KON/WZ	5	<b>165578</b>	48
216	1,8	30	48	HW	WZ	-5	<b>166260</b>	77
216	2,2	30	64	HW	FZ/TR	-5	<b>166366</b>	79
216	3,0	30	24	HW	WZ	-5	<b>166253</b>	77
216	3,0	30	48	HW	WZ	-5	<b>166254</b>	77
216	3,0	30	64	HW	WZ	-5	<b>166255</b>	77
216	3,0	30	64	HW	FZ/TR	-5	<b>166359</b>	79
220	1,2	60	27	HW	FZ	20	<b>057475</b>	12
220	1,2	65	24	HW	FZ	20	<b>057474</b>	12
220	1,3	60	24	HW	FZ	25	<b>057476</b>	12
220	1,3	60	32	HW	FZ	25	<b>057478</b>	12
220	1,3	65	24	HW	FZ	25	<b>057477</b>	12
220	1,3	65	32	HW	FZ	25	<b>057479</b>	12
220	1,4	60	32	HW	FZ	20	<b>057464</b>	12
220	1,4	60	24	HW	FZ	25	<b>057480</b>	12
220	1,4	65	32	HW	FZ	20	<b>057465</b>	12
220	1,4	65	24	HW	FZ	25	<b>057481</b>	12
220	2,4	40	24	HW	FZ	20	<b>163551</b>	17
220	2,5	30	45	DP	HZFA/ WZFA	10	<b>190717</b>	71
220	2,5	40	45	DP	HZFA/ WZFA	10	<b>190718</b>	71
220	3,0	30	70	HW	WZ/WZ/FZ	10	<b>161255</b>	70
220	3,0	40	70	HW	WZ/WZ/FZ	10	<b>161256</b>	70
220	3,1	45	48	DP	KON/FZ	10	<b>190744</b>	50
220	3,2	30	42	HW	HZ/DZ	-5	<b>163075</b>	33
220	3,2	30	72	HW	FZ/TR	-5	<b>166360</b>	79
220	3,2	30	64	HW	FZ/TR	10	<b>163000</b>	34
220	3,2	30	42	HW	HZ/DZ	10	<b>163050</b>	33
220	3,2	30	36	HW	WZ	10	<b>163110</b>	27
220	3,2	30	60	HW	WZ	10	<b>163111</b>	27
220	3,2	30	34	HW	WZ	15	<b>166136</b>	75
220	3,2	45	60	HW	KON/FZ	5	<b>165638</b>	49
220	3,35	30	48	HW	FZ/TR	10	<b>165676</b>	51
220	3,8	60	24	HW	WZ	20	<b>165260</b>	13
220	3,8	60	24	HW	WZ	20	<b>165262</b>	13
220	3,8	65	24	HW	WZ	20	<b>165261</b>	13
220	5,0	30	24	HW	FZ	20	<b>165251</b>	13
220	6,5	20	36	HW	KON/WZ	5	<b>165579</b>	48, 54
225	1,5	60	25	HW	FZ	20	<b>057447</b>	12
225	1,6	60	32	HW	FZ	25	<b>057482</b>	12
225	1,8	60	25	HW	FZ	20	<b>057448</b>	12
225	2,0	40	40	HW	FZ	20	<b>163600</b>	12
225	2,0	60	25	HW	FZ	20	<b>057449</b>	12
225	2,2	30	64	HW	FZFA/FZFA	0	<b>163533</b>	80
225	2,4	30	24	HW	FZ	15	<b>165304</b>	18
225	2,6	30	68	HW	FZ/TR	-5	<b>166361</b>	79
225	2,6	30	48	HW	WZ	10	<b>166138</b>	75
225	2,6	30	32	HW	WZ	20	<b>166137</b>	75
225	2,8	30	24	HW	FZ	15	<b>165305</b>	18

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225	3,2	30	6	DP	P	5	<b>190304</b>	83
225	3,8	60	24	HW	WZ	20	<b>165263</b>	13
225	5,0	30	24	HW	FZ	20	<b>165252</b>	13
225	5,0	60	40	HW	FZ	20	<b>165256</b>	13
230	2,5	30	48	HW	WZ	15	<b>166108</b>	75
230	2,5	30	24	HW	WZ	20	<b>166140</b>	75
230	3,2	30	34	HW	WZ	15	<b>166141</b>	75
235	2,5	30	24	HW	WZ	15	<b>166156</b>	75
235	2,5	30	56	HW	WZ	15	<b>166157</b>	75
235	2,5	30	12	HW	WZ	15	<b>166158</b>	75
235	3,2	30	24	HW	WZ	15	<b>166142</b>	75
235	3,2	30	34	HW	WZ	15	<b>166143</b>	75
240	2,5	30	50	DP	HZFA/ WZFA	10	<b>190719</b>	71
240	2,5	40	50	DP	HZFA/ WZFA	10	<b>190720</b>	71
240	2,8	40	24	HW	FZ	15	<b>165306</b>	18
240	3,0	30	75	HW	WZ/WZ/FZ	10	<b>161257</b>	70
240	3,0	30	75	HW	WZ/WZ/FZ	10	<b>161268</b>	70
240	3,0	30	48	HW	WZ	10	<b>166145</b>	75
240	3,0	30	30	HW	WZ	15	<b>165337</b>	25
240	3,0	30	34	HW	WZ	15	<b>166144</b>	75
240	3,0	40	75	HW	WZ/WZ/FZ	10	<b>161258</b>	70
250	1,7	30	80	HW	WZ	10	<b>058520</b>	29
250	1,7	60	36	HW	FZ	20	<b>057433</b>	12
250	1,7	60	25	HW	FZ	20	<b>057450</b>	12
250	2,0	30	100	HW	FZFA/FZFA	-5	<b>060275</b>	62
250	2,0	60	36	HW	FZ	20	<b>057434</b>	12
250	2,0	60	25	HW	FZ	20	<b>057451</b>	12
250	2,0	80	36	HW	WZ	15	<b>163576</b>	16
250	2,0	100	48	DP	FZ	3	<b>190678</b>	56
250	2,0	100	48	DP	FZ	3	<b>190679</b>	56
250	2,0	115	48	DP	FZ	3	<b>190680</b>	56
250	2,2	100	36	DP	FZ	3	<b>190681</b>	56
250	2,2	100	36	DP	FZ	3	<b>190682</b>	56
250	2,2	100	48	DP	FZ	3	<b>190684</b>	56
250	2,2	100	48	DP	FZ	3	<b>190685</b>	56
250	2,2	115	36	DP	FZ	3	<b>190683</b>	56
250	2,2	115	48	DP	FZ	3	<b>190686</b>	56
250	2,4	30	48	HW	WZ	-5	<b>166256</b>	77
250	2,4	30	60	HW	WZ	-5	<b>166257</b>	77
250	2,4	30	40	HW	WZ	10	<b>163112</b>	27
250	2,4	30	80	HW	WZ	10	<b>163113</b>	27
250	2,4	30	24	HW	FZ	20	<b>163558</b>	17
250	2,4	40	24	HW	FZ	20	<b>163552</b>	17
250	2,4	60	24	HW	FZ	20	<b>163700</b>	17
250	2,4	60	40	HW	FZ	20	<b>163701</b>	17
250	2,4	70	24	HW	FZ	20	<b>163553</b>	17
250	2,4	80	32	HW	WZ	15	<b>163577</b>	16
250	2,4	80	40	HW	WZ	15	<b>165309</b>	18
250	2,4	80	24	HW	FZ	20	<b>163554</b>	17
250	2,5	30	50	DP	HZFA/ WZFA	10	<b>190721</b>	71
250	2,8	30	72	HW	FZFA/FZFA	5	<b>161012</b>	81
250	2,8	30	24	HW	FZ	15	<b>165307</b>	18
250	2,8	30	60	HW	WZ	20	<b>166147</b>	75
250	2,8	30	24	HW	WZ	25	<b>166146</b>	75
250	2,8	70	24	HW	FZ	15	<b>165308</b>	18
250	3,0	30	80	HW	WZ/WZ/FZ	10	<b>161259</b>	70
250	3,2	30	48	HW	HZ/DZ	-5	<b>163076</b>	33
250	3,2	30	80	HW	WZ	-5	<b>163225</b>	28



## 1. Sawing

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250	3,2	30	60	HW	FZ/TR	-5	<b>166362</b>	79	300	2,2	30	80	HW	FZFA/FZFA	0	<b>163535</b>	80
250	3,2	30	80	HW	FZ/TR	-5	<b>166363</b>	79	300	2,4	30	48	HW	WZ	10	<b>163117</b>	27
250	3,2	30	60	HW	FZ/TR	5	<b>166305</b>	78	300	2,4	30	96	HW	WZ	10	<b>163118</b>	27
250	3,2	30	80	HW	FZ/TR	5	<b>166306</b>	78	300	2,8	30	30	HW	FZ	25	<b>163555</b>	17
250	3,2	30	54	HW	HZ/DZ	10	<b>161300</b>	32	300	2,8	80	28	HW	WZ	15	<b>163578</b>	16
250	3,2	30	60	HW	FZ/TR	10	<b>163002</b>	34	300	2,8	80	28	HW	WZFA	15	<b>165310</b>	18
250	3,2	30	80	HW	FZ/TR	10	<b>163003</b>	34	300	2,8	80	48	HW	TR/TR	15	<b>165311</b>	18
250	3,2	30	48	HW	HZ/DZ	10	<b>163051</b>	33	300	2,8	80	30	HW	FZ	25	<b>163556</b>	17
250	3,2	30	40	HW	WZ	10	<b>163114</b>	27	300	3,0	30	72	HW	FZFA/FZFA	5	<b>161005</b>	63
250	3,2	30	60	HW	WZ	10	<b>163115</b>	27	300	3,0	30	96	HW	FZFA/FZFA	5	<b>161006</b>	63
250	3,2	30	80	HW	WZ	10	<b>163116</b>	27	300	3,0	50	100	HW	WZ/WZ/FZ	10	<b>161266</b>	70
250	3,2	30	50	DP	HZFA/ WZFA	10	<b>190697</b>	31	300	3,2	30	96	HW	FZ/TR	-5	<b>161380</b>	61
250	3,2	30	48	DP	DZ/TR	10	<b>190748</b>	67	300	3,2	30	96	HW	FZ/TR	-5	<b>161381</b>	61
250	3,2	30	60	HW	TR/TR	15	<b>161135</b>	45	300	3,2	30	36	HW	WZ	-5	<b>165513</b>	23
250	3,2	30	18	HW	FZ	20	<b>165110</b>	19	300	3,2	30	60	HW	WZ	-5	<b>165514</b>	23
250	3,2	30	18	HW	FZ	20	<b>166050</b>	20	300	3,2	30	96	HW	WZ	-5	<b>165515</b>	23
250	3,2	30	24	HW	WZ	20	<b>166076</b>	20	300	3,2	30	72	HW	FZ/TR	-5	<b>165825</b>	60
250	3,2	32	60	HW	FZ/TR	5	<b>166307</b>	78	300	3,2	30	96	HW	FZ/TR	-5	<b>165826</b>	60
250	3,2	32	80	HW	FZ/TR	5	<b>166308</b>	78	300	3,2	30	120	HW	FZ/TR	-5	<b>165827</b>	60
250	3,2	40	80	HW	FZ/TR	5	<b>166309</b>	78	300	3,2	30	96	HW	FZ/TR	5	<b>161360</b>	59
250	3,2	70	20	HW	WZ	20	<b>165200</b>	15	300	3,2	30	96	HW	FZ/TR	5	<b>161361</b>	59
250	3,2	100	48	HW	FZ	10	<b>061434</b>	56	300	3,2	30	72	HW	KON/FZ	5	<b>165641</b>	49
250	3,5	30	18	HW	FZ	25	<b>165008</b>	14	300	3,2	30	72	HW	FZ/TR	5	<b>165726</b>	58
250	3,5	80	18	HW	FZ	25	<b>165009</b>	14	300	3,2	30	96	HW	FZ/TR	5	<b>165727</b>	58
250	3,8	60	24	HW	WZ	20	<b>165264</b>	13	300	3,2	30	8	DP	P	5	<b>190305</b>	83
250	4,0	30	18	HW	FZ	20	<b>165101</b>	19	300	3,2	30	72	HW	FZ/TR	10	<b>163005</b>	34
250	4,4	30	42	HW	KON/FZ	5	<b>165639</b>	49	300	3,2	30	96	HW	FZ/TR	10	<b>163006</b>	34
250	4,4	30	18	HW	FZ	25	<b>165000</b>	14	300	3,2	30	36	HW	WZ	10	<b>163119</b>	27
250	4,4	80	18	HW	FZ	25	<b>165001</b>	14	300	3,2	30	48	HW	WZ	10	<b>163120</b>	27
250	4,55	30	48	HW	FZ/TR	10	<b>165677</b>	51	300	3,2	30	72	HW	WZ	10	<b>163121</b>	27
250	5,0	30	24	HW	FZ	20	<b>165253</b>	13	300	3,2	30	96	HW	WZ	10	<b>163122</b>	27
250	5,0	30	36	HW	FZ	20	<b>165254</b>	13	300	3,2	30	72	HW	TR/TR	15	<b>161138</b>	45
250	8,0	80	24	HW	FZ	15	<b>165257</b>	13	300	3,2	30	72	HW	TR/TR	15	<b>161139</b>	45
254	2,2	30	72	HW	FZFA/FZFA	0	<b>163534</b>	80	300	3,2	30	72	HW	TR/TR	15	<b>163370</b>	44
255	2,8	30	60	HW	WZ	-5	<b>166259</b>	77	300	3,2	30	24	HW	FZ	20	<b>165111</b>	19
255	2,8	30	80	HW	WZ/WZ/FZ	10	<b>161200</b>	30	300	3,2	30	28	HW	WZ	20	<b>166077</b>	20
260	2,4	30	68	HW	FZ/TR	-5	<b>166364</b>	79	300	3,2	32	72	HW	FZ/TR	-5	<b>165828</b>	60
260	2,5	30	60	HW	WZ	-5	<b>166250</b>	77	300	3,2	32	96	HW	FZ/TR	-5	<b>165829</b>	60
260	2,5	30	80	HW	WZ	-5	<b>166251</b>	77	300	3,2	32	120	HW	FZ/TR	-5	<b>165830</b>	60
260	3,2	30	60	HW	WZ	10	<b>166148</b>	76	300	3,2	70	24	HW	WZ	20	<b>165201</b>	15
270	2,4	60	28	HW	FZ	20	<b>163702</b>	17	300	3,4	80	28	HW	FZ	15	<b>165312</b>	18
275	3,2	30	88	HW	FZ/TR	-5	<b>166365</b>	79	300	3,5	30	96	HW	WZ	-5	<b>161330</b>	24
275	3,4	40	72	HW	FZ/TR	5	<b>166310</b>	78	300	3,5	30	96	HW	WZ	-5	<b>161331</b>	24
280	2,5	30	55	DP	HZFA/ WZFA	10	<b>190722</b>	71	300	3,5	30	96	HW	WZ	5	<b>163200</b>	28
280	3,0	30	85	HW	WZ/WZ/FZ	10	<b>161260</b>	70	300	3,5	30	14	HW	FZ	20	<b>166051</b>	20
280	3,2	30	60	HW	FZ/TR	10	<b>163004</b>	34	300	3,5	30	20	HW	FZ	25	<b>165010</b>	14
280	3,2	30	48	HW	WZ	10	<b>166149</b>	76	300	3,5	70	20	HW	FZ	25	<b>165011</b>	14
280	3,2	30	60	HW	WZ	10	<b>166150</b>	76	300	3,5	80	20	HW	FZ	25	<b>165012</b>	14
280	3,2	30	60	HW	TR/TR	15	<b>161136</b>	45	300	3,6	30	20	HW	FZ/TR	10	<b>163500</b>	65
280	3,2	32	96	HW	FZ/TR	5	<b>165725</b>	58	300	3,6	30	42	HW	FZ/TR	10	<b>163501</b>	65
280	3,45	45	60	HW	FZ/TR	10	<b>165675</b>	51	300	4,0	30	24	HW	FZ	20	<b>165102</b>	19
280	4,4	30	48	HW	KON/FZ	5	<b>165640</b>	49	300	4,0	80	28	HW	TR/TR	15	<b>165313</b>	18
280	4,55	30	60	HW	FZ/TR	10	<b>165678</b>	51	300	4,0	80	48	HW	TR/TR	15	<b>165314</b>	18
280	4,55	45	84	HW	WZ	10	<b>165684</b>	51	300	4,3	30	48	DP	KON/FZ	10	<b>190743</b>	50
280	4,8	45	72	HW	KON/WZ	5	<b>165581</b>	48	300	4,4	30	48	HW	KON/WZ	5	<b>165582</b>	48, 54
280	4,95	45	84	HW	WZ	10	<b>165685</b>	51	300	4,4	30	60	DP	HRFA	5	<b>190666</b>	63
300	1,7	30	96	HW	WZ	10	<b>058521</b>	29	300	4,4	30	60	HW	TR/TR	15	<b>161137</b>	45, 53-54

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300	4,4	30	60	HW	FZ/TR	15	<b>163400</b>	42, 54
300	4,4	30	60	DP	TR/TR	15	<b>190706</b>	47
300	4,4	50	48	HW	KON/WZ	5	<b>165583</b>	48
300	4,4	60	72	HW	TR/TR	15	<b>161140</b>	45, 53
300	4,4	60	72	HW	TR/TR	15	<b>163371</b>	44, 53
300	4,4	60	72	HW	FZ/TR	15	<b>163401</b>	42, 53
300	4,4	65	72	HW	KON/WZ	5	<b>165584</b>	48
300	4,4	65	48	HW	KON/WZ	5	<b>165585</b>	48
300	4,4	65	60	HW	TR/TR	15	<b>161141</b>	45, 55
300	4,4	65	60	HW	TR/TR	15	<b>163372</b>	44, 55
300	4,4	65	60	HW	FZ/TR	15	<b>163402</b>	42, 55
300	4,4	75	60	HW	FZ/TR	15	<b>163403</b>	42
300	4,4	80	60	HW	TR/TR	15	<b>161142</b>	45, 52
300	4,4	80	60	HW	TR/TR	15	<b>163373</b>	44, 52
300	4,4	80	60	HW	FZ/TR	15	<b>163456</b>	42, 52
300	4,55	30	72	HW	WZFA	10	<b>165682</b>	51
300	4,55	65	72	HW	WZFA	10	<b>165683</b>	51
300	5,0	30	20	HW	FZ	25	<b>165002</b>	14
300	8,0	80	24	HW	FZ	15	<b>165258</b>	13
303	3,2	30	60	HW	HZ/DZ	-5	<b>163077</b>	33
303	3,2	30	100	HW	WZ/WZ/FZ	10	<b>161201</b>	30
303	3,2	30	68	HW	HZ/DZ	10	<b>161301</b>	32
303	3,2	30	60	HW	HZ/DZ	10	<b>163054</b>	33
303	3,2	30	60	DP	DZ/TR	10	<b>190673</b>	67
303	3,2	30	96	DP	DZ/TR	10	<b>190674</b>	67
303	3,2	30	60	DP	HZFA/ WZFA	10	<b>190698</b>	31
303	3,2	30	60	DP	HZFA/ WZFA	10	<b>190728</b>	71
303	3,5	30	96	HW	WZ	-5	<b>163226</b>	28
303	3,5	30	60	HW	TR/TR	10	<b>161028</b>	64
303	3,5	30	60	HW	HZ/DZ	10	<b>163052</b>	33
305	2,4	25,4	80	HW	FZFA/FZFA	0	<b>163536</b>	80
305	3,2	30	60	HW	WZ	-5	<b>165516</b>	23
308	3,2	60	96	DP	TR/TR	10	<b>190746</b>	47
308	3,2	60	96	HW	TR/TR	15	<b>161143</b>	45
308	3,2	60	96	HW	FZ/TR	15	<b>163404</b>	42
310	4,4	60	72	HW	TR/TR	15	<b>161144</b>	45
310	4,4	60	72	HW	FZ/TR	15	<b>163405</b>	42
315	3,0	30	48	HW	WZ	15	<b>166152</b>	76
315	3,2	30	72	HW	WZ	10	<b>166153</b>	76
315	3,2	30	28	HW	WZ	20	<b>166151</b>	76
320	3,2	30	84	HW	FZ/TR	5	<b>165728</b>	58
320	3,2	70	28	HW	WZ	20	<b>165202</b>	15
320	4,4	30	60	HW	FZ/TR	15	<b>163406</b>	42, 53
320	4,4	50	60	HW	TR/TR	15	<b>161145</b>	46
320	4,4	50	60	HW	TR/TR	15	<b>163374</b>	44
320	4,4	60	72	HW	TR/TR	15	<b>163394</b>	44
320	4,4	65	60	HW	TR/TR	15	<b>161146</b>	46, 55
320	4,4	65	60	HW	TR/TR	15	<b>163375</b>	44
320	4,4	65	60	HW	FZ/TR	15	<b>163407</b>	42, 55
320	4,4	75	60	HW	TR/TR	15	<b>163376</b>	44
320	4,4	80	60	HW	TR/TR	15	<b>161147</b>	46
320	4,4	80	60	HW	TR/TR	15	<b>163377</b>	44
320	4,4	80	60	HW	FZ/TR	15	<b>163457</b>	42
330	2,4	30	80	HW	FZFA/FZFA	0	<b>163537</b>	80
330	3,2	30	96	HW	FZ/TR	-5	<b>165831</b>	60
330	3,2	32	96	HW	FZ/TR	-5	<b>165832</b>	60

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340	4,4	80	72	HW	TR/TR	15	<b>163378</b>	44, 52
340	4,4	80	72	HW	FZ/TR	15	<b>163458</b>	42, 52
350	2,4	30	140	HW	FZFA/FZFA	-5	<b>060279</b>	62
350	2,8	30	30	HW	FZ	25	<b>163557</b>	17
350	3,2	30	108	HW	FZ/TR	-5	<b>161382</b>	61
350	3,2	30	108	HW	FZ/TR	-5	<b>161383</b>	61
350	3,2	30	36	HW	WZ	-5	<b>165517</b>	23
350	3,2	30	60	HW	WZ	-5	<b>165518</b>	23
350	3,2	30	108	HW	FZ/TR	-5	<b>165837</b>	60
350	3,2	30	108	HW	FZ/TR	5	<b>161362</b>	59
350	3,2	30	108	HW	FZ/TR	5	<b>161363</b>	59
350	3,2	30	108	HW	FZ/TR	5	<b>165730</b>	58
350	3,2	30	70	DP	HZFA/ WZFA	10	<b>190699</b>	31
350	3,2	30	70	DP	HZFA/ WZFA	10	<b>190729</b>	71
350	3,2	30	24	HW	FZ	20	<b>165113</b>	19
350	3,2	30	32	HW	WZ	20	<b>166078</b>	20
350	3,2	32	84	HW	FZ/TR	5	<b>165731</b>	58
350	3,4	30	84	HW	FZ/TR	-5	<b>165833</b>	60
350	3,4	30	84	HW	FZ/TR	5	<b>165729</b>	58
350	3,5	30	108	HW	WZ	-5	<b>161332</b>	24
350	3,5	30	108	HW	WZ	-5	<b>161333</b>	24
350	3,5	30	108	HW	WZ	-5	<b>165519</b>	23
350	3,5	30	96	HW	FZFA/FZFA	5	<b>161007</b>	63
350	3,5	30	108	HW	WZ	5	<b>163201</b>	28
350	3,5	30	110	HW	WZ/WZ/FZ	10	<b>161263</b>	70
350	3,5	30	80	HW	HZ/DZ	10	<b>161302</b>	32
350	3,5	30	84	HW	FZ/TR	10	<b>163007</b>	34
350	3,5	30	108	HW	FZ/TR	10	<b>163008</b>	34
350	3,5	30	72	HW	HZ/DZ	10	<b>163053</b>	33
350	3,5	30	54	HW	WZ	10	<b>163123</b>	27
350	3,5	30	72	HW	WZ	10	<b>163124</b>	27
350	3,5	30	84	HW	WZ	10	<b>163125</b>	27
350	3,5	30	108	HW	WZ	10	<b>163126</b>	27
350	3,5	30	32	HW	WZ	10	<b>163134</b>	27
350	3,5	30	24	HW	TR	10	<b>166025</b>	82
350	3,5	30	72	DP	DZ/TR	10	<b>190749</b>	67
350	3,5	30	72	HW	WZ	15	<b>165976</b>	69
350	3,5	30	12	HW	FZ	20	<b>163025</b>	35
350	3,5	30	16	HW	FZ	20	<b>166052</b>	20
350	3,5	70	28	HW	WZ	20	<b>165203</b>	15
350	3,6	30	16	HW	WZ	15	<b>165975</b>	69
350	3,6	40	108	HW	FZ/TR	-5	<b>165838</b>	60
350	3,8	30	84	HW	FZ/TR	-5	<b>165834</b>	60
350	3,8	30	24	HW	FZ/TR	10	<b>163502</b>	65
350	3,8	30	48	HW	FZ/TR	10	<b>163503</b>	65
350	3,8	30	48	HW	FZFA/FZFA	10	<b>165925</b>	66
350	3,8	32	84	HW	FZ/TR	-5	<b>165835</b>	60
350	3,8	40	84	HW	FZ/TR	-5	<b>165836</b>	60
350	4,0	30	24	HW	FZ	25	<b>165013</b>	14
350	4,0	80	24	HW	FZ	25	<b>165014</b>	14
350	4,4	30	70	DP	HRFA	5	<b>190667</b>	63
350	4,4	30	72	HW	WZ/FA	15	<b>161029</b>	64
350	4,4	30	72	HW	TR/TR	15	<b>161149</b>	46, 52-55
350	4,4	30	54	HW	WZ	15	<b>163301</b>	41, 52, 54-55
350	4,4	30	72	HW	WZ	15	<b>163302</b>	41, 52, 54-55

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350	4,4	30	72	DP	TR/TR	15	<b>190707</b>	47, 52-55
350	4,4	30	24	HW	FZ	20	<b>165104</b>	19
350	4,4	60	72	HW	WZ/FA	15	<b>161030</b>	64
350	4,4	60	72	HW	TR/TR	15	<b>161150</b>	46, 52-53
350	4,4	60	72	HW	WZ	15	<b>163304</b>	41, 52-53
350	4,4	60	72	HW	TR/TR	15	<b>163380</b>	44, 52-53
350	4,4	60	72	HW	FZ/TR	15	<b>163409</b>	42, 52-53
350	4,4	60	72	DP	TR/TR	15	<b>190708</b>	47, 52-53
350	4,4	75	72	HW	TR/TR	15	<b>161151</b>	46
350	4,4	75	72	HW	TR/TR	15	<b>163395</b>	44
350	4,4	75	72	HW	FZ/TR	15	<b>163410</b>	42
350	4,4	80	54	HW	WZ	15	<b>163305</b>	41
350	4,4	80	72	HW	FZ/TR	15	<b>163454</b>	42
350	4,55	75	72	HW	FZ/TR	10	<b>165679</b>	51
350	5,0	30	24	HW	FZ	25	<b>165003</b>	14
350	5,0	80	24	HW	FZ	25	<b>165004</b>	14
355	2,4	25,4	80	HW	FZFA/FZFA	0	<b>163538</b>	80
355	3,0	30	120	HW	WZ/WZ/FZ	10	<b>161202</b>	30
355	3,2	30	72	HW	WZ	-5	<b>165520</b>	23
355	3,2	30	16	HW	WZ	20	<b>166154</b>	76
355	3,2	30	32	HW	WZ	20	<b>166155</b>	76
355	4,4	30	72	HW	WZ	15	<b>163306</b>	41, 53
355	4,4	65	72	HW	TR/TR	15	<b>161152</b>	46, 55
355	4,4	65	72	HW	TR/TR	15	<b>163381</b>	44, 55
355	4,4	65	72	HW	FZ/TR	15	<b>163412</b>	42, 55
355	4,4	75	72	HW	FZ/TR	15	<b>163413</b>	42
355	4,4	80	72	HW	TR/TR	15	<b>161153</b>	46, 55
360	4,4	30	72	HW	TR/TR	15	<b>161154</b>	46, 54
360	4,4	30	72	HW	TR/TR	15	<b>163382</b>	44, 54
360	4,4	30	72	HW	FZ/TR	15	<b>163414</b>	42, 54
360	4,4	65	72	HW	FZ/TR	15	<b>163415</b>	42, 55
370	3,5	30	108	HW	WZ	10	<b>165338</b>	25
370	3,8	30	96	HW	FZ/TR	5	<b>165732</b>	58
370	4,4	30	72	HW	TR/TR	15	<b>161155</b>	46
370	4,4	30	72	HW	FZ/TR	15	<b>163416</b>	42
380	3,8	32	108	HW	FZ/TR	-5	<b>165839</b>	60
380	4,4	30	72	HW	TR/TR	15	<b>161156</b>	46
380	4,4	30	72	HW	TR/TR	15	<b>163383</b>	44, 52
380	4,4	50	72	HW	TR/TR	15	<b>161157</b>	46
380	4,4	50	72	HW	TR/TR	15	<b>163396</b>	44
380	4,4	50	72	HW	FZ/TR	15	<b>163417</b>	42
380	4,4	60	72	HW	TR/TR	15	<b>161158</b>	46, 53
380	4,4	60	72	HW	TR/TR	15	<b>163384</b>	44, 53
380	4,4	60	72	HW	FZ/TR	15	<b>163418</b>	42, 53
380	4,4	60	72	DP	TR/TR	15	<b>190709</b>	47
380	4,4	65	72	HW	TR/TR	15	<b>163386</b>	44
380	4,4	75	72	HW	FZ/TR	15	<b>163420</b>	42
380	4,4	80	72	HW	TR/TR	15	<b>161160</b>	46, 52
380	4,4	80	72	HW	FZ/TR	15	<b>163459</b>	43, 52
380	4,8	60	84	HW	WZ/FA	15	<b>161031</b>	64

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380	4,8	60	54	HW	WZ	15	<b>163307</b>	41, 53
380	4,8	60	72	HW	TR/TR	15	<b>163385</b>	44, 53
380	4,8	60	72	HW	FZ/TR	15	<b>163419</b>	42, 53
380	4,8	60	84	HW	TR/TR	15	<b>163750</b>	44
380	4,8	60	72	DP	TR/TR	15	<b>190710</b>	47
400	3,0	30	84	HW	FZFA/FZFA	0	<b>163539</b>	80
400	3,2	30	130	HW	WZ/WZ/FZ	20	<b>161203</b>	30
400	3,5	30	120	HW	WZ	-5	<b>161334</b>	24
400	3,5	30	120	HW	WZ	-5	<b>161335</b>	24
400	3,5	30	48	HW	WZ	10	<b>163127</b>	27
400	3,5	30	60	HW	WZ	10	<b>163128</b>	27
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




## 1. Sawing

## Quick search

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## 1. Sawing

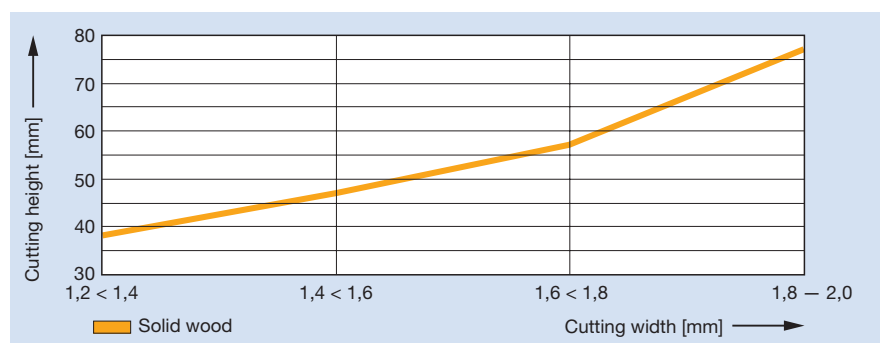
### 1.1 Solid wood cutting along grain

<b>Application</b>	For splitting or edging timber, for cutting lamellae on horizontal and vertical spindles.		
<b>Workpiece material</b>	Softwood and hardwood, wet, frozen, dry or long fibre materials.		
<b>Machine</b>	Edging, single blade, multi blade sawblades as well as sawblades with either one or two spindles. Circular saw benches or moulders.		
<b>Tooth shape</b>	 	<b>FZ (square teeth):</b> For multi-purpose application – particularly suitable for wet and dry wood.	
	 	<b>TR (trapezoidal teeth):</b> Recommended for cutting dry wood with minimum marking.	
	 	<b>WZ (alternative top bevel teeth):</b> Ideal for long-fibred wood. Higher quality on the exit surface.	

### Thin kerf sawblades

<b>Application area</b>	<ul style="list-style-type: none"> <li>– Sawmill industry (laminating strips, lumber etc.).</li> <li>– Solid board production (lamellos and core materials for multiple layer panels etc.).</li> <li>– Parquet flooring industry (for core and surface materials, lamellos).</li> <li>– Moulding products (mouldings, lippings, rulers etc.).</li> <li>– Sport industry (skis, table tennis rackets etc.).</li> </ul>
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#### Cutting height diagram



Thin kerf circular sawblades –  
Cutting height depends on the sawblade cutting width SB.

#### Technical notes

- Recommendations:
- Mount thin kerf sawblades on hydro sleeves.
  - Check the sawblade clamping flange diameter.
  - Check the cutting height and the tooth progression (feed rate).
  - Resharpen and clean resin residues regularly.

## 1. Sawing

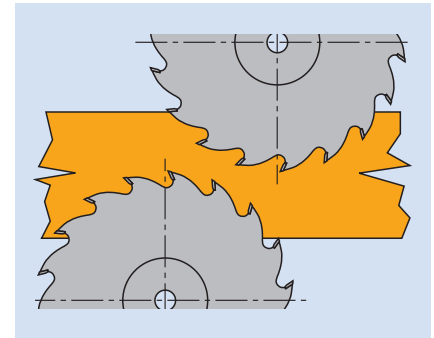
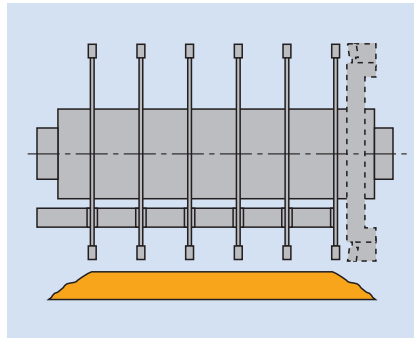
### 1.1 Solid wood cutting along grain

#### Advantages

- Environmentally friendly use of resources.
- Reduced chips and dust.
- Optimised timber usage.
- More strips from workpiece with standard cuts.

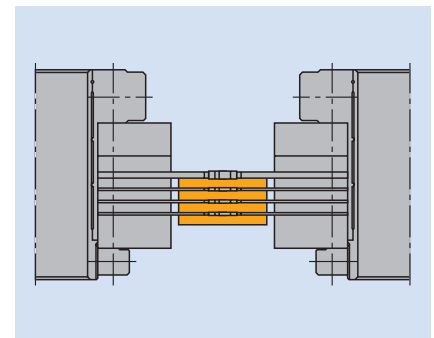
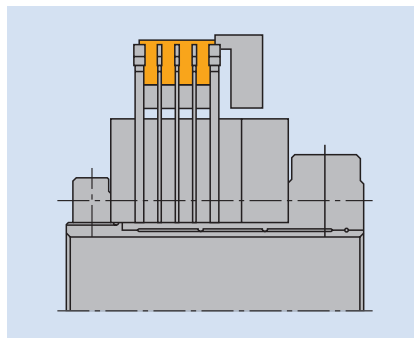
#### Machine types

##### Single or multi spindle multi blade machines without automatic feed



To avoid bending the sawblade, we recommend using wide sawblades or hoggers on the motorside. Riving knives are recommended when cutting thin lamella; a split machine table is necessary.

##### Multi spindle machines with automatic feed (for horizontal and vertical cutting)

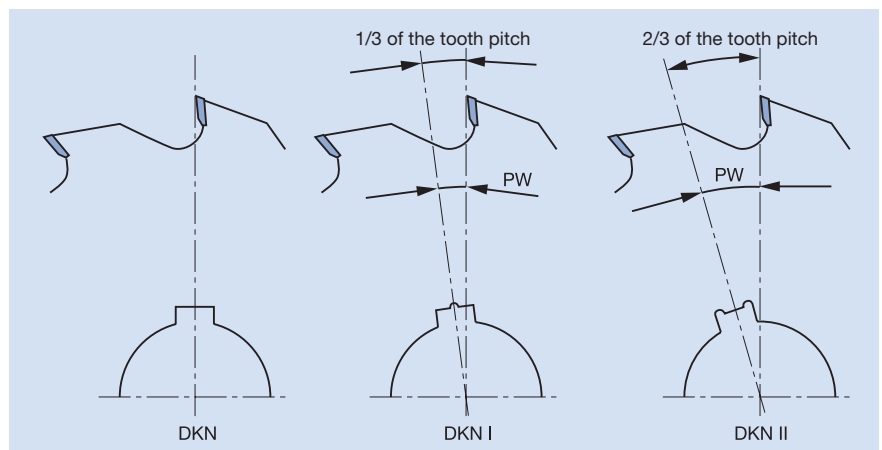


The saw spindle should have high precision bearings for accuracy.

Precise and stable feeding devices needed for bent, curved or twisted materials.

- Accurate adjustment of spindle and guide needed when sawing vertically (top and bottom side spindles).
- For horizontal cutting, the thickness of riving knives depends on the cutting width of the sawblades. The riving knives must be aligned 100% horizontal.

##### Position of double keyways for spiral arrangement of circular sawblades



## 1. Sawing

### 1.1 Solid wood cutting along grain

#### 1.1.1 Circular sawblades thin kerf



#### Premium lamella cut - middle cut with extremely reduced cutting width

##### Application:

For cutting strips and slats along grain on horizontal and vertical spindles.

##### Machine:

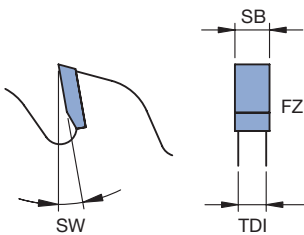
Moulders with/without forced guidance of workpieces. Application on single, double, horizontal or vertical spindles.

##### Workpiece material:

Softwood and hardwood, dry up to 10 % wood moisture content, quality category 0 to 1.

##### Technical information:

Noise-reduced and low vibration design due to irregular tooth pitch or odd number of teeth. Cutting width reduction for high wood savings and efficient energy utilisation. Continuous tool body without recess for max. cutting height. Different number of teeth for optimal tooth feeds with different feed speed. Higher cutting performance and less resinification due to special coating of the tool body. Use on hydro sleeves or clamping arbors is recommended, as is the use of high precision spacers to increase the performance of the saws. It is essential to pay attention to the setting of machines with riving knives.



##### Middle cut

WK 100 2 21

D	SB	TDI	BO	BO <sub>max</sub>	NLA	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
180	1.3	0.8	60	70	3/10/75	100	32	FZ	20	■	057418 ●
180	1.5	1.0	60	70	3/10/75	100	21	FZ	20	■	057443 ●
180	1.8	1.2	60	70	3/10/75	100	21	FZ	20	■	057444 ●
180	1.8	1.3	60	70	3/10/75	100	32	FZ	20	■	057412 ●
200	1.5	1.0	60	80	3/10/75	120	21	FZ	20	■	057445 ●
200	1.5	1.0	60	80	3/10/75	120	36	FZ	20	■	057421 ●
200	1.8	1.2	60	80	3/10/75	120	21	FZ	20	■	057446 ●
220	1.2	0.9	60	80	3/10/75	120	27	FZ	20	■	057475 ●
220	1.2	0.9	65	80	3/11/80	120	24	FZ	20	■	057474 ●
220	1.3	0.9	60	80	3/10/75	120	24	FZ	25	■	057476 ●
220	1.3	0.9	60	80	3/10/75	120	32	FZ	25	■	057478 ●
220	1.3	0.9	65	80	3/11/80	120	24	FZ	25	■	057477 ●
220	1.3	0.9	65	80	3/11/80	120	32	FZ	25	■	057479 ●
220	1.4	1.0	60	80	3/10/75	120	24	FZ	25	■	057480 ●
220	1.4	1.0	60	80	3/10/75	120	32	FZ	20	■	057464 ●
220	1.4	1.0	65	80	3/11/80	120	24	FZ	25	■	057481 ●
220	1.4	1.0	65	80	3/11/80	120	32	FZ	20	■	057465 ●
225	1.5	1.0	60	110	3/10/75	120	25	FZ	20	■	057447 ●
225	1.6	1.2	60	110	3/10/75	130	32	FZ	25	■	057482 ●
225	1.8	1.2	60	110	3/10/75	120	25	FZ	20	■	057448 ●
225	2.0	1.4	40	110	3/10/75	120	40	FZ	20	■	163600 ●
225	2.0	1.4	60	110	3/10/75	120	25	FZ	20	■	057449 ●
250	1.7	1.2	60	120	3/10/75	140	25	FZ	20	■	057450 ●
250	1.7	1.2	60	120	3/10/75	140	36	FZ	20	■	057433 ●
250	2.0	1.4	60	120	3/10/75	140	25	FZ	20	■	057451 ●
250	2.0	1.4	60	120	3/10/75	140	36	FZ	20	■	057434 ●

## 1. Sawing

### 1.1 Solid wood cutting along grain

#### 1.1.1 Circular sawblades thin kerf



#### Lamella cut - shoulder cut

##### Application:

For cutting along grain - shoulder cuts in combination with middle cut sawblades.

##### Machine:

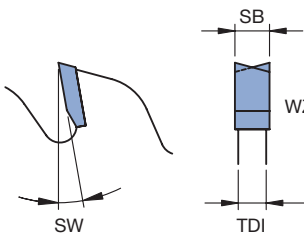
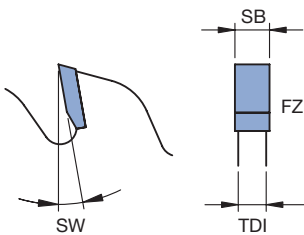
Moulders with/without forced guidance of workpieces. Application on single, double, horizontal or vertical spindles.

##### Workpiece material:

Softwood and hardwood, dry up to 10 % wood moisture content, quality category 0 to 1.

##### Technical information:

Suitable for utilisation as a set in combination with thin kerf sawblades for middle cuts. Solid design to increase the rigidity of the set. Higher cutting performance and less resin formation by special coated toolbody.



##### Shoulder cuts

WK 100 2 21

D	SB	TDI	BO	NLA	DKN	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
200	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165250 ●
220	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165251 ●
225	5.0	4.0	30	3/10/75		120	24	FZ	20	■	165252 ●
225	5.0	4.0	60	3/10/75		120	40	FZ	20	■	165256 ●
250	5.0	4.0	30	3/10/75		140	24	FZ	20	■	165253 ●
250	5.0	4.0	30	3/10/75		140	36	FZ	20	■	165254 ●
250	8.0	6.0	80	4/7/95	13/89	100	24	FZ	15	■	165257 ●
				2/13/100							
300	8.0	6.0	80	4/7/95	13/89	100	24	FZ	15	■	165258 ●
				2/13/100							

##### Technical information:

Suitable for utilisation as a set in combination with thin kerf sawblades for middle cuts. Special cutting edge geometry for cut pitch and lower cutting forces. For cutting pressure reduction and reduction of burn marks even at lower feed rates. Higher cutting performance and less resin formation by special coated toolbody.

##### Shoulder cuts - reduced number of teeth

WK 150 2, WK 150 2 21

D	SB	TDI	BO	NLA	FLD	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
180	3.8	3,0	60	3/10/75	100	24	WZ	20	■	165255 ●
				3/11/80						
200	3.8	3,0	60	3/10/75	100	24	WZ	20	■	165259 ●
				3/11/80						
220	3.8	3,0	60	3/10/75	120	24	WZ	20	■	165260 ●
				3/11/80						
220	3.8	3,0	65	3/10/75	120	24	WZ	20	■	165261 ●
				3/11/80						
220	3.8	3,0	60	3/10/75	120	24	WZ	20	■	165262 ●
				3/11/80						
225	3.8	3,0	60	3/10/75	120	24	WZ	20	■	165263 ●
				3/11/80						
250	3.8	3,0	60	3/10/75	120	24	WZ	20	■	165264 ●
				3/11/80						

## 1. Sawing

### 1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



#### Lamella cut with internal and external wiper teeth

##### Application:

For cutting along grain - shoulder and trimming cuts.

##### Machine:

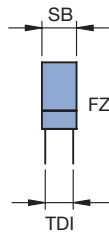
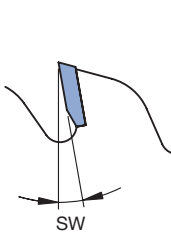
Edging, single blade, multi blade saws as well as saws with one or two spindles.

##### Workpiece material:

Softwood and hardwood wet, frozen, dry. Long fibre materials (poplar, balsa etc.)

##### Technical information:

With two internal and external (from D 280 mm) raker blades. Solid design especially for edge cuts. Large lateral tooth protrusions. For universal use in dry, wet and frozen soft and hard woods. Higher cutting performance and less resinification due to special coating of the tool body.



##### Square and shoulder cut

WK 150 2

D	SB	TDI	BO	BO <sub>max</sub>	NLA	DKN	FLD <sub>max</sub>	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm	mm			°		
250	4.4	2.8	30	80	KNL		130	18	FZ	25	■	165000 ●
250	4.4	2.8	80		6/5.5/91	19/89	130	18	FZ	25	■	165001 ●
					4/6.6/95	13/89						
					2/13/100							
300	5.0	3.2	30	80	KNL		130	20	FZ	25	■	165002 ●
350	5.0	3.2	30	100	KNL		130	24	FZ	25	■	165003 ●
350	5.0	3.2	80	100	6/5.5/91	19/89	130	24	FZ	25	■	165004 ●
					4/6.6/95	13/89						
					2/13/100							
400	5.0	3.2	30	120	KNL		150	28	FZ	25	■	165005 ●
400	5.0	3.2	80	120	6/5.5/91	19/89	150	28	FZ	25	■	165006 ●
					4/6.6/95	13/89						
					2/13/100							
450	5.0	3.2	30	120	KNL		160	28	FZ	25	■	165007 ●

##### Application:

For cutting along grain - middle cuts.

##### Middle cut

WK 100 2 43

D	SB	TDI	BO	BO <sub>max</sub>	NLA	DKN	FLD <sub>max</sub>	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm	mm			°		
250	3.5	2.2	30	80	KNL		130	18	FZ	25	■	165008 ●
250	3.5	2.2	80		6/5.5/91	19/89	130	18	FZ	25	■	165009 ●
					4/6.6/95	13/89						
					2/13/100							
300	3.5	2.2	30	80	KNL		110	20	FZ	25	■	165010 ●
300	3.5	2.2	70			21x83	110	20	FZ	25	■	165011 ●
300	3.5	2.2	80			23x90	110	20	FZ	25	■	165012 ●
						13x89						
350	4.0	2.8	30	100	KNL		130	24	FZ	25	■	165013 ●
350	4.0	2.8	80	100	6/5.5/91	19/89	130	24	FZ	25	■	165014 ●
					4/6.6/95	13/89						
					2/13/100							
400	4.0	2.8	30	120	KNL		150	28	FZ	25	■	165015 ●
400	4.0	2.8	80	120	6/5.5/91	19/89	150	28	FZ	25	■	165016 ●
					4/6.6/95	13/89						
					2/13/100							
450	4.4	3.0	30	120	KNL		160	28	FZ	25	■	165017 ●



## 1. Sawing

### 1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



#### Lamella cut with internal and external wiper teeth

##### Application:

For cutting along grain - middle cuts.

##### Machine:

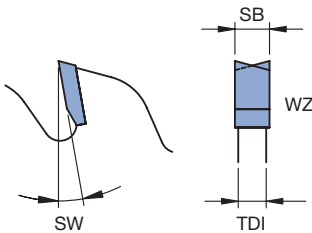
Edging, single blade, multi blade saws as well as saws with one or two spindles.

##### Workpiece material:

Softwood and hardwood, dry up to 15% wood moisture content. Long fibre materials (poplar, balsa etc.).

##### Technical information:

With two external and two or four (over D 320 mm) internal wiper teeth. Tooth shape WZ best suited for cuts in long-fibred woods such as poplar. Lower power consumption due to tooth shape WZ. Higher cutting performance and less resinification due to special coating of the tool body.



##### Middle cut

WK 150 2

D	SB	TDI	BO	BO <sub>max</sub>	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
250	3.2	2.2	70			20,6/83	20	WZ	20	■	165200 ●
300	3.2	2.2	70	80		20,6/83	24	WZ	20	■	165201 ●
320	3.2	2.2	70	80		20,6/83	28	WZ	20	■	165202 ●
350	3.5	2.5	70	100		20,6/83	28	WZ	20	■	165203 ●
400	4,0	2.8	70	100		20,6/83	24	WZ	20	■	165204 ●
500	5,0	3.5	30	100	KNL		28	WZ	20	■	165205 ●
550	5,0	3.2	80		2/13/100		36	WZ	25	■	165206 ●
600	5.4	3.8	80		2/13/100		42	WZ	25	■	165207 ●



## 1. Sawing

### 1.1 Solid wood cutting along grain 1.1.2 Circular sawblades with wiper teeth



#### Lamella cut with external wiper teeth *Premium*

##### Application:

For cutting of thin slats on horizontal spindles.

##### Machine:

Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

##### Workpiece material:

Softwood, dry up to 10% wood moisture content.

##### Technical information:

With two external raker blades giving better chip ejection. Higher cutting performance and less resinification due to special coating of the tool body. Special limiter shape for protection of the teeth when used in woods with loose knots and in cracked woods.

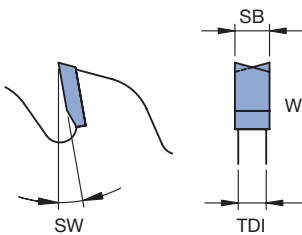
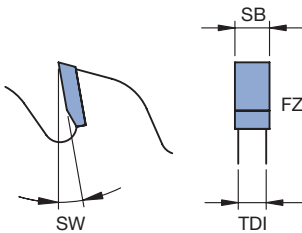


HW

##### Middle cut

WK 100 2, WK 150 2

D	SB	TDI	BO	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
200	2.0	1.4	30		24	FZ	20	■	163575 ●
250	2.0	1.4	80	19/89	36	WZ	15	■	163576 ●
250	2.4	1.6	80	19/89	32	WZ	15	■	163577 ●
300	2.8	1.8	80	19/89	28	WZ	15	■	163578 ●



## 1. Sawing

### 1.1 Solid wood cutting along grain

#### 1.1.2 Circular sawblades with wiper teeth



#### Lamella cut with internal wiper teeth *Premium* - reduced cutting width

##### Application:

For cutting of thin slats on horizontal spindles.

##### Machine:

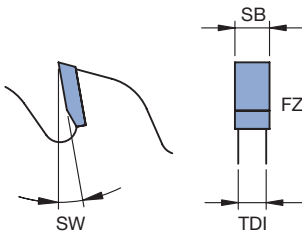
Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

##### Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

##### Technical information:

With internal raker blades for better dimensional stability. Efficient energy and wood utilisation due to reduced cutting widths. Special limiter shape (up to D 250 mm) to protect the teeth when used in wood with loose knots and cracked wood. From D 300 mm large gullet areas for better chip ejection. Higher cutting performance and less resinification due to special coating of the tool body.



##### Middle cut

WK 100 4 , WK 100 2

D	SB	TDI	BO	BO <sub>max</sub>	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
200	2.4	1.6	30			24	FZ	25	■	163560 ●
200	2.4	1.6	40	60		24	FZ	20	■	163550 ●
220	2.4	1.6	30			24	FZ	25	■	163559 ●
220	2.4	1.6	40	80		24	FZ	20	■	163551 ●
250	2.4	1.6	30			24	FZ	20	■	163558 ●
250	2.4	1.6	40	90		24	FZ	20	■	163552 ●
250	2.4	1.6	70		21/83	24	FZ	20	■	163553 ●
250	2.4	1.6	80		19x89 13x89	24	FZ	20	■	163554 ●
300	2.8	1.8	30	100		30	FZ	25	■	163555 ●
300	2.8	1.8	80		19x89 13x89	30	FZ	25	■	163556 ●
350	2.8	1.8	30	110		30	FZ	25	■	163557 ●



#### Lamella cut with internal and external wiper teeth *Premium* - reduced cutting width

##### Application:

For cutting of thin slats on vertical spindles.

##### Machine:

Edging, single blade, multi blade saws as well as saws or moulders with one or two spindles.

##### Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

##### Technical information:

With two external and internal raker blades for increased stability also for larger cutting depths. Efficient energy and wood utilization through reduced cutting widths. Higher cutting performance and less resinification through special coating of the tool body.



##### Middle cut

WK 100 2

D	SB	TDI	BO	BO <sub>max</sub>	NLA	FLD <sub>max</sub>	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm	mm			°		
250	2.4	1.6	60	80	3/10/75	100	24	FZ	20	■	163700 ●
250	2.4	1.6	60	80	3/10/75	120	40	FZ	20	■	163701 ●
270	2.4	1.6	60	80	3/10/75	120	28	FZ	20	■	163702 ●

- Solid wood
- Plastics
- Board, coated
- Mineral materials
- Board, uncoated
- Composites
- Non-ferrous metals
- Steel, thin-walled

## 1. Sawing

### 1.1 Solid wood cutting along grain

#### 1.1.3 Circular sawblades without wiper teeth



#### Lamella cut for glueable cuts

##### Application:

For cutting along grain - glueable middle and lamellae cuts on horizontal spindles.

##### Machine:

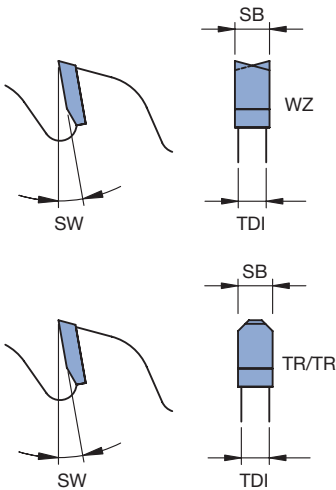
Single blade, multi blade saws as well as saws and moulders with one or two spindles.

##### Workpiece material:

Softwood and hardwood, dry up to 10% wood moisture content.

##### Technical information:

Special tooth geometry for glueable cutting areas. Noise-reduced design due to irregular tooth pitch. Continuous tool body without recess. Increased cutting performance and less resinification through special coating of the tool body.



##### Middle cut

WK 100 2, WK 150 2, WK 152 2, WK 158 2

Machine	D	SB	TDI	BO	BO <sub>max</sub>	NLA	DKN	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm	mm	mm			°		
	180	2.2	1.4	30	60	3/10/75		18	FZ	15	■	165300 ●
	180	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165301 ●
	200	2.4	1.6	30	60	3/10/75		18	FZ	15	■	165302 ●
	200	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165303 ●
	225	2.4	1.6	30	60	3/10/75		24	FZ	15	■	165304 ●
	225	2.8	2.0	30	60	3/10/75		24	FZ	15	■	165305 ●
	240	2.8	2.0	40	60	3/10/75		24	FZ	15	■	165306 ●
Raimann	250	2.4	1.6	80		6/5.5/91	19/89	40	WZ	15	■	165309 ●
						4/6.6/95		13/89				
						2/13/100						
	250	2.8	2.0	30	100	3/10/75		24	FZ	15	■	165307 ●
	250	2.8	2.0	70	100		21/80	24	FZ	15	■	165308 ●
Raimann	300	2.8	1.8	80		6/5.5/91	19/89	28	WZFA	15	■	165310 ●
						4/6.6/95		13/89				
						2/13/100						
Raimann	300	2.8	2.0	80		6/5.5/91	19/89	48	TR/TR	15	■	165311 ●
						4/6.6/95		13/89				
						2/13/100						
Raimann	300	3.4	2.2	80		6/5.5/91	19/89	28	FZ	15	■	165312 ●
						4/6.6/95		13/89				
						2/13/100						
Raimann	300	4.0	2.8	80		6/5.5/91	19/89	28	TR/TR	15	■	165313 ●
						4/6.6/95		13/89				
						2/13/100						
Raimann	300	4.0	2.8	80		6/5.5/91	19/89	48	TR/TR	15	■	165314 ●
						4/6.6/95		13/89				
						2/13/100						

## 1.1 Solid wood cutting along grain

### 1.1.3 Circular sawblades without wiper teeth



#### Lamella cut

##### Application:

For cutting along grain - shoulder and trimming cuts.

##### Machine:

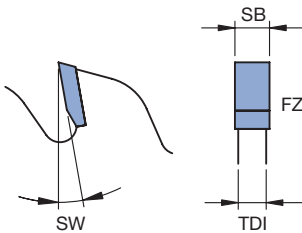
Edging, single blade, multi blade saws as well as saws with one or two spindles.

##### Workpiece material:

Softwood and hardwood wet and dry.

##### Technical information:

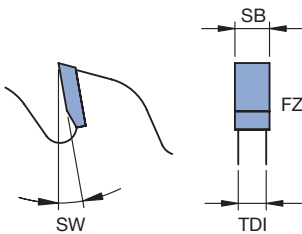
Large gullet area and large lateral tooth protrusion. Solid desing particularly for edge cuts. For universal use in dry and wet soft and hard woods. Design without raker blades. Partially suitable for larger cutting depths and the use in frozen woods.



#### Shoulder and square cut

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	4.0	2.6	30	KNL	18	FZ	20	■	165101 ●
300	4.0	2.6	30	KNL	24	FZ	20	■	165102 ●
350	4.4	3.0	30	KNL	24	FZ	20	■	165104 ●
400	5.0	3.2	30	KNL	28	FZ	20	■	165105 ●
450	5.0	3.2	30	KNL	28	FZ	20	■	165106 ●
500	5.0	3.2	30	KNL	32	FZ	20	■	165107 ●



#### Middle cut

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
200	3.2	2.2	30	KNL	18	FZ	25	■	165108 ●
210	3.2	2.2	30	KNL	18	FZ	20	■	165109 ●
250	3.2	2.2	30	KNL	18	FZ	20	■	165110 ●
300	3.2	2.2	30	KNL	24	FZ	20	■	165111 ●
350	3.2	2.2	30	KNL	24	FZ	20	■	165113 ●
400	4.0	2.8	30	KNL	28	FZ	20	■	165114 ●
450	4.0	2.8	30	KNL	28	FZ	20	■	165115 ●
500	4.0	2.8	30	KNL	32	FZ	20	■	165116 ●

## 1. Sawing

### 1.1 Solid wood cutting along grain

#### 1.1.3 Circular sawblades without wiper teeth



#### Sizing solid wood along grain

##### Application:

For cutting along grain - sizing wood.

##### Machine:

Edging, single blade, multi blade saws as well as saws with one or two spindles.

##### Workpiece material:

Softwood and hardwood, dry up to 15% wood moisture content.

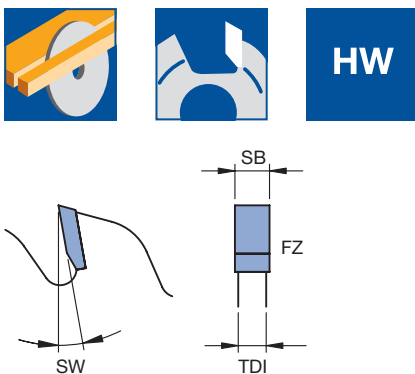
##### Technical information:

Design with chip thickness limitation for limited chip removal per tooth and reduced feed speeds.

##### Circular sawblade FZ with thickness limitation

WK 100 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.2	30	KNL	18	FZ	20	■	166050 ●
300	3.5	2.4	30	KNL	14	FZ	20	■	166051 ●
350	3.5	2.4	30	KNL	16	FZ	20	■	166052 ●
400	4.0	2.8	30	KNL	18	FZ	20	■	166053 ●
450	4.0	2.8	30	KNL	20	FZ	20	■	166054 ●
500	4.0	2.8	30	KNL	24	FZ	20	■	166055 ●



#### Universal sizing

##### Application:

For multi-purpose application in solid wood.

##### Machine:

Trimming and cross cutting saws.

##### Workpiece material:

Softwood and hardwood wet and dry.

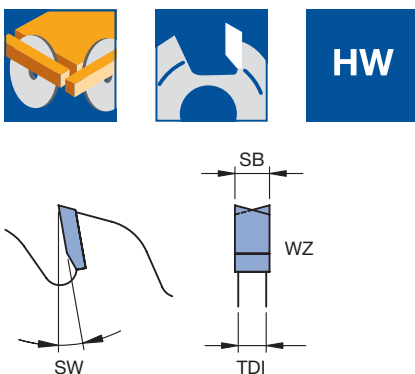
##### Technical information:

Design with chip thickness limitation for limited chip removal per tooth and reduced feed speeds. Tooth shape WZ for cuts in long-fibred woods such as poplar and for cuts in wet woods. Lower power consumption due to tooth shape WZ. Also suitable for cuts across the grain.

##### Circular sawblade WZ with thickness limitation

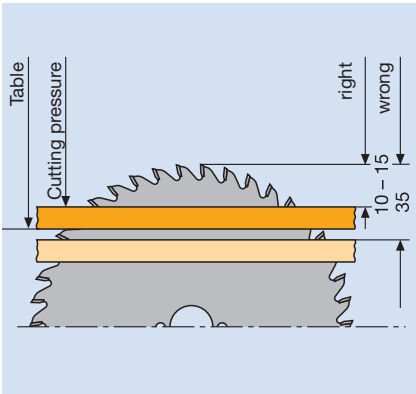
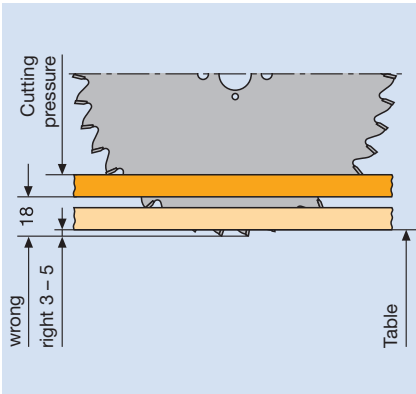
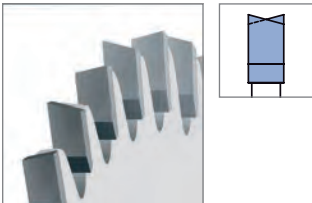
WK 150 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.2	30	KNL	24	WZ	20	■	166076 ●
300	3.2	2.2	30	KNL	28	WZ	20	■	166077 ●
350	3.2	2.2	30	KNL	32	WZ	20	■	166078 ●
400	4.0	2.8	30	KNL	36	WZ	20	■	166079 ●
450	4.0	2.8	30	KNL	42	WZ	20	■	166080 ●
500	4.0	2.8	30	KNL	48	WZ	20	■	166081 ●
550	4.8	3.5	30	KNL	54	WZ	20	■	166082 ●
600	4.8	3.5	30	KNL	60	WZ	20	■	166083 ●
700	4.8	3.5	30	KNL	60	WZ	20	■	166084 ●



# 1. Sawing

## 1.2 Solid wood cutting across grain

<b>Application area</b>	For trim, cross, mitre and sizing cuts.
<b>Workpiece material</b>	Solid wood with or without coating, plywood, glulam, solid surface materials.
<b>Machine</b>	Combined table, mitre, radial, underfloor and optimising saws.
<b>Application</b>	<div>  <p>The cutting force of sawblades with a positive cutting angle and the spindle below the workpiece or for sawblades with a negative cutting angle and the spindle above the workpiece. Press the material onto the table.</p> </div> <div>  <p>On radial saws, the use of sawblades with a negative cutting angle cutting against the feed is obligatory (see EN 1870-17). The negative cutting angle presses the material onto the table.</p> </div>
<b>Tooth shape</b>	<div>  <p>WZ (alternative top bevel teeth): Multi purpose tooth shape, economical to purchase and maintain – suitable for solid wood and wood derived materials.</p> </div>



## Trimming at high feed rates

### Application:

For trimming and cross cutting with cycle times of 0.3 - 1.0 sec.

### Machine:

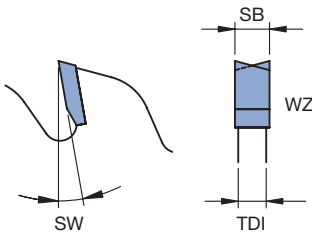
Cross, trimming and optimising saws.

### Workpiece material:

Solid wood wet and dry across grain, solid wood profiles across grain.

### Technical information:

For fast cross-cutting, sizing and optimizing machines. Large lateral tooth clearance and a high number of teeth. Stable corner angle of 20° for tear-free cutting results and long tool life.



### Trimming at high feed rates

WK 150 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Dimter, System TM	400	3.5	2.8	30	2/10/60 2/15/63 2/10/150 2/10/198	120	WZ	10	■	165450 ●
Dimter, System TM	400	3.5	2.8	30	2/10/60 2/15/63 2/10/150 2/10/198	140	WZ	10	■	165464 ●
Dimter, System TM	450	3.5	2.8	30	2/10/60 2/15/63 2/10/150 2/10/198	158	WZ	10	■	165465 ●
Dimter	450	4.8	3.5	30	2/10/60 2/15/63	138	WZ	10	■	165451 ●
Dimter	450	5.0	3.2	30	2/10/60 2/15/63	108	WZ	10	■	165452 ●
Dimter, System TM	500	4.8	3.5	30	2/10/60 2/15/63 2/10/150 2/10/198	144	WZ	10	■	165454 ●
Dimter	500	4.8	3.5	35	2/10/60 2/15/63	144	WZ	10	■	165455 □
Dimter	500	5.2	3.2	30	2/10/60 2/15/63	120	WZ	10	■	165453 ●
Dimter	520	4.6	3.4	30	2/10/60 2/15/63	144	WZ	10	■	165456 ●
Dimter	550	5.0	3.2	30	2/10/60 2/15/63	96	WZ	10	■	165457 ●
Dimter	550	5.2	3.2	30	2/10/60 2/15/63	120	WZ	10	■	165459 ●
Dimter, System TM	550	5.2	3.2	30	2/10/60 2/15/63 2/10/150 2/10/198	160	WZ	10	■	165458 ●
Dimter	600	5.4	4.0	30	2/10/60 2/15/63	172	WZ	10	■	165461 ●
Dimter	600	5.8	4.0	30	2/10/60 2/15/63	108	WZ	10	■	165460 ●
Dimter	630	5.4	4.0	30	2/10/60 2/15/63	180	WZ	10	■	165462 ●
Dimter	700	5.5	4.0	30	2/15/63	200	WZ	10	■	165463 ●



#### Trimming with negative cutting angle

##### Application:

For trimming and cross cutting - positioning of workpiece under the sawblade.

##### Machine:

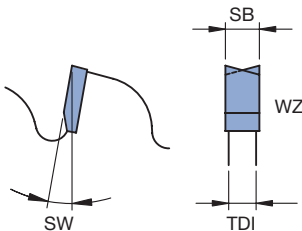
Cross, trimming, mitre and radial saws as well as double mitre cutting saws.

##### Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood).

##### Technical information:

Especially for machines with positioning of the saw shaft above the workpiece. Negative cutting angle for improved workpiece clamping.



#### Circular sawblade WZ with neg. cutting angle

WK 160 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3.2	2.4	30	KNL	36	WZ	-5	■	165513 ●
300	3.2	2.4	30	KNL	60	WZ	-5	■	165514 ●
300	3.2	2.4	30	KNL	96	WZ	-5	■	165515 ●
305	3.2	2.4	30	KNL	60	WZ	-5	■	165516 ●
350	3.2	2.4	30	KNL	36	WZ	-5	■	165517 ●
350	3.2	2.4	30	KNL	60	WZ	-5	■	165518 ●
350	3.5	2.8	30	KNL	108	WZ	-5	■	165519 ●
355	3.2	2.4	30	KNL	72	WZ	-5	■	165520 ●
400	3.8	2.8	30	KNL	42	WZ	-5	■	165521 ●
400	3.8	2.8	30	KNL	60	WZ	-5	■	165522 ●
400	3.8	2.8	30	KNL	120	WZ	-5	■	165523 ●
420	3.5	2.8	40		48	WZ	-5	■	165524 ●
450	3.8	2.8	30	KNL	48	WZ	-5	■	165525 ●
500	4.4	3.2	30	KNL	54	WZ	-5	■	165526 ●



## 1. Sawing

### 1.2 Solid wood cutting across grain

#### 1.2.2 Circular sawblades WZ with neg. cutting angle



#### Trimming with negative cutting angle *Excellent*

##### Application:

For trimming and cross cutting - positioning of workpiece under the sawblade.

##### Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws.

##### Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood).

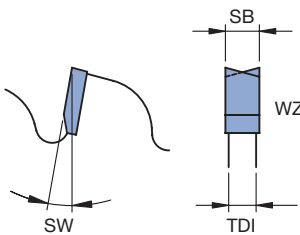
##### Technical information:

Especially for machines with positioning of the saw shaft above the workpiece.

Negative cutting angle for improved workpiece clamping. **Excellent** design.

Vibration-damping composite construction of the tool body by means of steel foil.

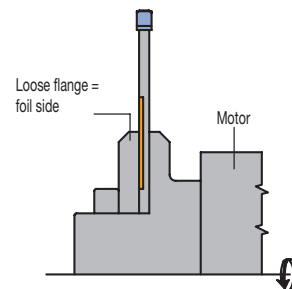
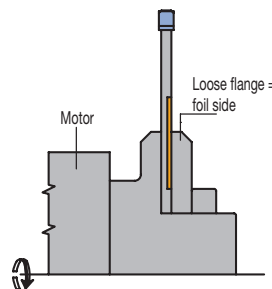
Extreme noise reduction even with increasing dulling of the tool.



#### Circular sawblade WZ with neg. cutting angle

WK 180 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3.5	2.6	30	KNL	96	WZ	-5	left	■	<b>161330</b> ●
300	3.5	2.6	30	KNL	96	WZ	-5	right	■	<b>161331</b> ●
350	3.5	2.6	30	KNL	108	WZ	-5	left	■	<b>161332</b> ●
350	3.5	2.6	30	KNL	108	WZ	-5	right	■	<b>161333</b> ●
400	3.5	2.6	30	KNL	120	WZ	-5	left	■	<b>161334</b> ●
400	3.5	2.6	30	KNL	120	WZ	-5	right	■	<b>161335</b> ●





## Trimming, crossing and mitre cuts

### Application:

For cross cutting, trimming and angled cuts.

### Machine:

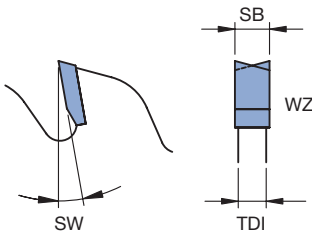
Cross and trimming saws and CNC controlled joinery machines, cross cutting twin saws.

### Workpiece material:

Solid wood beams wet and dry, cross-glued beams.

### Technical information:

Tooth shape for universal use and with large lateral tooth clearance.



### Circular sawblade WZ

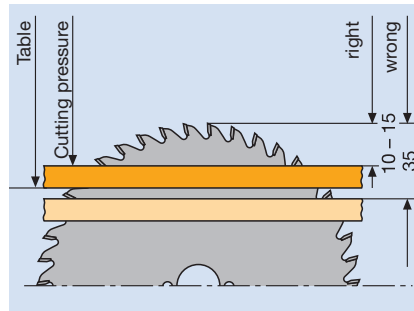
WK 150 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Weinmann	240	3,0	2,0	30	8/6/52	30	WZ	15	■	165337 ●
Weinmann	370	3,5	2,5	30	KNL	108	WZ	10	■	165338 ●
Routech	440	7,0	4,0	75	6/9/100	12+2+2	WZ	20	■	165326 ●
Routech	500	4,4	3,2	75	2/8,5/100 6/10,6/100	28+2+2+2	WZ	20	■	165328 ●
Routech	500	7,0	4,0	75	6/9/100	14+2+2+2	WZ	20	■	165327 ●
Essetre	520	5,4	3,5	60	8/6,5/100	72	WZ	20	■	165332 ●
Weinmann	555	5,2	3,6/6	55	6/7/75	54+2+2	WZ	20	■	165325 ●
Essetre	600	5,4	3,5	80	8/9,5/120	72	WZ	20	■	165333 ●
	600	6,0	4,0	30	2/14/400	48	WZ	15	■	057570 ●
Routech	600	7,0	4,0	75	6/9/125	16+2+2+2	WZ	20	■	165329 ●
Uniteam	640	5,4	3,6	30	2/8,5/125 8/6,5/160 8/6,5/130 4/10,5/90	36+2+2	WZ	20	■	165330 ●
	700	6,0	4,4	30		72	WZ	15	■	165334 ●
	750	6,0	4,4	30		72	WZ	15	■	165335 ●
	800	6,0	4,4	30		72	WZ	15	■	165336 ●
Uniteam	850	8,0	6,0	30	8/6,5/160 8/6,5/130 4/10,5/90	60+2+2+2	WZ	20	■	165331 ●

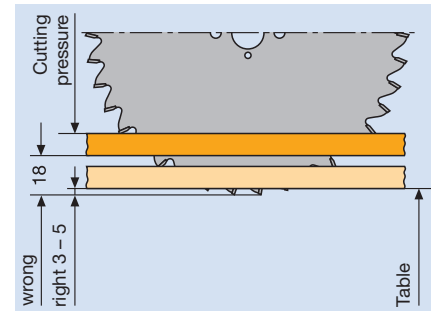
## 1. Sawing

### 1.3 Sizing

<b>Working process</b>	For cross cutting and sizing; grooving and cutting also possible if safety regulations are followed.
<b>Workpiece materials</b>	Solid wood, wood derived materials, synthetic materials and light metals.
<b>Machines</b>	Table saws, sizing machines with/without scoring saw, vertical panel sizing saws and twin sizing saws.
<b>Application</b>	Suitable for cutting from below against the feed. On vertical panel sizing machines and twin saw dimension saws cutting from either below or above against the feed.



The positive cutting angle presses the material onto the table for sawblades with a positive cutting angle and the spindle below the workpiece.



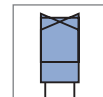
The negative cutting angle presses the material onto the table for sawblades with a negative cutting angle and the spindle above the workpiece.

On radial saw machines, sawblades must be used (see EN1870-17) with a negative cutting angle against the feed.

#### Tooth shape



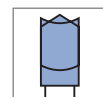
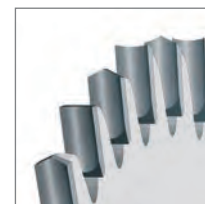
**WZ (alternative top bevel teeth):**  
Multi-purpose tooth shape, economical to purchase and maintain. Ideal for chipboard, veneered chipboard, solid wood, block board, plywood.



**WZ/WZ/FZ (alternative/square teeth):**  
Tooth shape for solid wood, glulam and coated or veneered wood derived materials; tear-free cutting edges and high cut quality. Combinations of tooth forms (WZre, WZli, WZre, WZli, FZ).



**FZ/TR (square/trapezoidal teeth):**  
Tooth shape for plastic and foil coated wood derived materials.  
**TR/TR (trapezoidal/trapezoidal teeth):**  
Best tooth shape for cutting hard and abrasive coatings – can be altered from the existing FZ/TR shape.



**HZ/DZ (hollow face/inverted V teeth):**  
Tooth shape for high cutting quality on plastic coated materials, with high upper and lower edge quality on machines without a scoring saw.

## 1. Sawing

### 1.3 Sizing

#### 1.3.1 Sizing sawblades WZ



#### Sizing *Premium*

##### Application:

For sizing and cross cutting with/without scoring.

##### Machine:

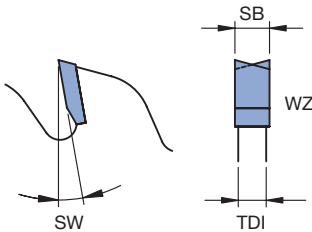
Table and sizing saws.

##### Workpiece material:

Solid wood across grain, chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood).

##### Technical information:

**Premium** design with vibration-damping laser ornaments (from D 200 mm). Marked dimensions with irregular tooth pitch (UT) for noise reduction and improved running behaviour.



#### Sizing sawblade WZ

WK 170 2

D	SB	TDI	BO	NLA	Z	ZF	Type	SW	WSS	ID
mm	mm	mm	mm	mm				°		
150	3.2	2.2	30		48	WZ		10	■ ■	163100 ●
180	2.4	1.6	30		30	WZ	UT	10	■ ■	163101 ●
180	3.0	2.0	30		24	WZ	UT	10	■ ■	163102 ●
180	3.2	2.2	30		58	WZ		10	■ ■	163103 ●
180	3.5	2.5	30		30	WZ	UT	10	■ ■	163104 ●
200	2.4	1.6	30	KNL	36	WZ	UT	10	■ ■	163105 ●
200	2.4	1.6	30	KNL	60	WZ		10	■ ■	163106 ●
200	3.0	2.0	30	KNL	24	WZ	UT	10	■ ■	163107 ●
200	3.0	2.0	30	KNL	48	WZ	UT	10	■ ■	163108 ●
200	3.0	2.0	30	KNL	60	WZ		10	■ ■	163109 ●
220	3.2	2.2	30	KNL	36	WZ	UT	10	■ ■	163110 ●
220	3.2	2.2	30	KNL	60	WZ		10	■ ■	163111 ●
250	2.4	1.6	30	KNL	40	WZ	UT	10	■ ■	163112 ●
250	2.4	1.6	30	KNL	80	WZ		10	■ ■	163113 ●
250	3.2	2.2	30	KNL	40	WZ	UT	10	■ ■	163114 ●
250	3.2	2.2	30	KNL	60	WZ	UT	10	■ ■	163115 ●
250	3.2	2.2	30	KNL	80	WZ		10	■ ■	163116 ●
300	2.4	1.6	30	KNL	48	WZ	UT	10	■ ■	163117 ●
300	2.4	1.6	30	KNL	96	WZ		10	■ ■	163118 ●
300	3.2	2.2	30	KNL	36	WZ	UT	10	■ ■	163119 ●
300	3.2	2.2	30	KNL	48	WZ	UT	10	■ ■	163120 ●
300	3.2	2.2	30	KNL	72	WZ	UT	10	■ ■	163121 ●
300	3.2	2.2	30	KNL	96	WZ		10	■ ■	163122 ●
350	3.5	2.5	30	KNL	32	WZ	UT	10	■ ■	163134 ●
350	3.5	2.5	30	KNL	54	WZ	UT	10	■ ■	163123 ●
350	3.5	2.5	30	KNL	72	WZ	UT	10	■ ■	163124 ●
350	3.5	2.5	30	KNL	84	WZ	UT	10	■ ■	163125 ●
350	3.5	2.5	30	KNL	108	WZ		10	■ ■	163126 ●
400	3.5	2.5	30	KNL	48	WZ	UT	10	■ ■	163127 ●
400	3.5	2.5	30	KNL	60	WZ	UT	10	■ ■	163128 ●
400	3.5	2.5	30	KNL	84	WZ	UT	10	■ ■	163129 ●
400	3.5	2.5	30	KNL	96	WZ	UT	10	■ ■	163130 ●
400	3.5	2.5	30	KNL	120	WZ		10	■ ■	163131 ●
450	3.8	2.8	30	KNL	66	WZ	UT	10	■ ■	163132 ●
500	3.8	2.8	30	KNL	72	WZ	UT	10	■ ■	163133 ●

## 1. Sawing

### 1.3 Sizing

#### 1.3.1 Sizing sawblades WZ



#### Sizing without scoring *Premium* - Mamba

##### Application:

For sizing and cross cutting without scoring.

##### Machine:

Table and sizing saws. Vertical panel sizing saws without scoring unit.

##### Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), thin walled plastic profiles (thickness < 2 mm), thin walled plastic honeycomb boards.

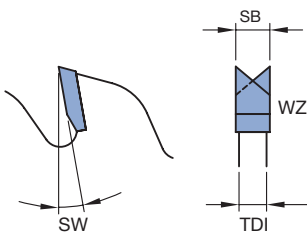
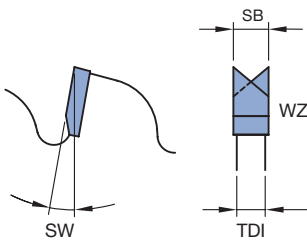
##### Technical information:

Special WZ with 40° corner angle for tear-free cuts on both sides. **Premium** design with vibration damping laser ornaments. Particularly for machines with positioning of the saw shaft above the workpiece. Negative cutting angle for improved workpiece clamping.

##### Circular sawblade Mamba, negative cutting angle

WK 880 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.2	30	KNL	80	WZ	-5	■	163225 ●
303	3.5	2.5	30	KNL	96	WZ	-5	■	163226 ●



##### Technical information:

Extremely strong alternate tooth WZ with 40° corner angle for tear-free cuts in coated wood derived materials on both sides. **Premium** design with vibration-damping laser ornaments.

##### Circular sawblade Mamba, positive cutting angle

WK 870 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3.5	2.5	30	KNL	96	WZ	5	■	163200 ●
350	3.5	2.5	30	KNL	108	WZ	5	■	163201 ●



### Sizing and veneer stack cut - reduced cutting width

#### Application:

For sizing and cross cutting with and without scoring.

#### Machine:

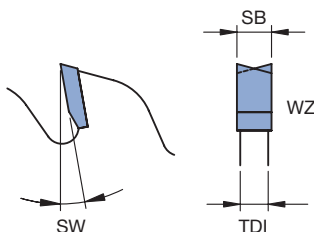
Table, sizing and veneer cutting saws.

#### Workpiece material:

Solid wood across grain, chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood), veneered board stacks, plastic or derived material honeycomb boards.

#### Technical information:

Reduced cutting width for better material utilization and lower cutting forces.  
Marked ID numbers with recessed tool body and thus limited cutting depth.



#### Circular sawblade WZ

WK 250 2, WK 850 2, WK 850 2 10, WK 850 2 22

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	1.8	1.0/2.5	16	1/6/33	48	WZ	10	■	060574 ●
180	1.6	1.0/2.5	16	1/6/33	56	WZ	10	■	060591 ●
180	2.4	1.6	16		58	WZ	10	■	059665 ●
200	2.0	1.4	16		64	WZ	10	■	059666 ●
250	1.7	1.0/2.4	30	KNL	80	WZ	10	■	058520 ●
300	1.7	1.0/2.4	30	KNL	96	WZ	10	■	058521 ●
450	3.0	2.2	30	2/14/125 KNL	120	WZ	20	■	058461 ●



## 1. Sawing

### 1.3 Sizing

#### 1.3.2 Sizing sawblades Katana



#### Sizing cut *Excellent* - Katana

##### Application:

For sizing and cross cutting without scoring.

##### Machine:

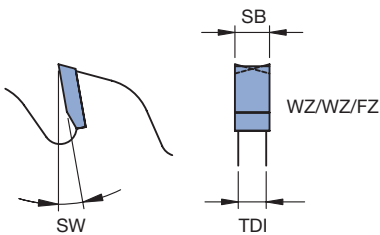
Table and sizing saws, vertical panel sizing machines without scoring unit, cross, trimming and mitre cutting saws.

##### Workpiece material:

Solid wood across grain, laminated veneer lumber (e.g. plywood, multiplex plywood), honeycomb boards, thin walled plastic and non-ferrous metal profiles.

##### Technical information:

Katana tooth combination with alternating rake face bevel for highest cutting quality. High number of teeth for perfect edges and very smooth surfaces. **Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level.



##### Circular sawblade Katana

WK 879 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
255	2.8	2.0	30	KNL	80	WZ/WZ/FZ	10		<b>161200</b> ●
303	3.2	2.2	30	KNL	100	WZ/WZ/FZ	10		<b>161201</b> ●
355	3.0	2.2	30	KNL	120	WZ/WZ/FZ	10		<b>161202</b> ●
400	3.2	2.5	30	KNL	130	WZ/WZ/FZ	20		<b>161203</b> ●
				2/15/63					
450	3.6	2.8	30	KNL	140	WZ/WZ/FZ	20		<b>161204</b> ●
				2/15/63					
500	4.0	3.5	30	KNL	150	WZ/WZ/FZ	20		<b>161205</b> ●
				2/15/63					
550	4.0	3.5	30	KNL	160	WZ/WZ/FZ	20		<b>161206</b> ●
				2/15/63					

## 1. Sawing

### 1.3 Sizing

#### 1.3.3 Sizing sawblades WhisperCut



#### Sizing *Excellent* - WhisperCut

##### Application:

For sizing and trimming with scoring.

##### Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit. Cross, trimming and mitre saws.

##### Workpiece material:

Solid wood across grain, laminated veneer lumber (e.g. plywood, multiplex plywood), chipboard and fibre materials plastic and paper coated, veneered and honeycomb boards.

##### Technical information:

Extreme noise reduction. Particularly developed group serration for perfect cutting pitch and reduction of the cutting forces. Universally applicable for most different materials. Standard cutting width of 3.2 mm allows use with standard scoring circular sawblades and standard splitting wedges. 2-fold resharpenable. **Excellent** design with filled laser ornaments for vibration damping and reduction of the noise level.

##### Circular sawblade WhisperCut

WK 879 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.4	30	KNL	50	HZFA/WZFA	10		<b>190697 •</b>
303	3.2	2.4	30	KNL	60	HZFA/WZFA	10		<b>190698 •</b>
350	3.2	2.4	30	KNL	70	HZFA/WZFA	10		<b>190699 •</b>

##### Application:

For scoring with feed.

##### Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

##### Technical information:

Hollow tooth for tear-free cuts in coated wood materials on both sides. **Excellent** design with filled laser ornaments for vibration damping and reduction of the noise level.

##### Scoring sawblade WhisperCut

WK 272 2

D	SB	BO	Z	ZF	SW	WSS	ID
mm	mm	mm			°		
80	3.3	20	18	HZ/WZ	10		<b>190700 •</b>
120	3.3	20	18	HZ/WZ	10		<b>190701 •</b>
120	3.3	22	18	HZ/WZ	10		<b>190702 •</b>
125	3.3	20	18	HZ/WZ	10		<b>190703 •</b>

## 1. Sawing

### 1.3 Sizing

#### 1.3.4 Sizing sawblades HZ/DZ



#### Sizing without scoring *Excellent*

##### Application:

For sizing and cross cutting without scoring.

##### Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

##### Workpiece material:

Chipboard and fibre materials plastic and paper coated, veneered.

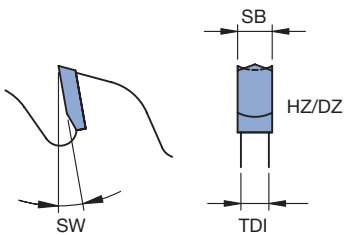
##### Technical information:

**Excellent** design with plastic filled laser ornaments for vibration damping and reduction of noise level.

##### Circular sawblade

WK 874 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
250	3.2	2.2	30	KNL	54	HZ/DZ	10	■	161300 ●
303	3.2	2.2	30	KNL	68	HZ/DZ	10	■	161301 ●
350	3.5	2.5	30	KNL	80	HZ/DZ	10	■	161302 ●



## 1. Sawing

### 1.3 Sizing

#### 1.3.4 Sizing sawblades HZ/DZ



#### Sizing without scoring *Premium*

##### Application:

For sizing and cross cutting without scoring.

##### Machine:

Table and sizing saws, vertical panel sizing saws without scoring unit.

##### Workpiece material:

Chipboard and fibre materials plastic and paper coated, veneered.

##### Technical information:

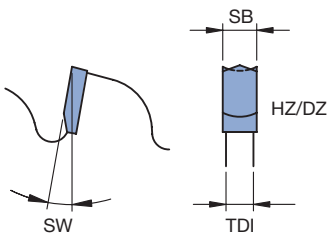
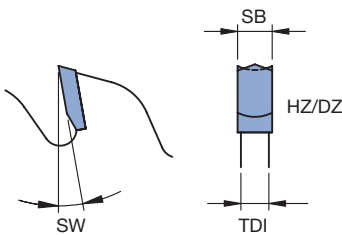
Hollow tooth for tear-free cuts in coated wood materials on both sides. **Premium** version with vibration-damping laser ornaments.



##### Circular sawblade, positive cutting angle

WK 274 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
220	3.2	2.2	30	KNL	42	HZ/DZ	10	■	163050 ●
250	3.2	2.2	30	KNL	48	HZ/DZ	10	■	163051 ●
303	3.2	2.2	30	KNL	60	HZ/DZ	10	■	163054 ●
303	3.5	2.5	30	KNL	60	HZ/DZ	10	■	163052 ●
350	3.5	2.5	30	KNL	72	HZ/DZ	10	■	163053 ●



##### Machine:

Vertical panel sizing saws without scoring unit.

##### Technical information:

Hollow tooth for tear-free cuts in coated wood materials on both sides. **Premium** version with vibration-damping laser ornaments. Especially for machines with positioning of the saw shaft above the workpiece. Negative cutting angle for improved workpiece clamping.

##### Circular sawblade, negative cutting angle

WK 864 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
220	3.2	2.2	30	KNL	42	HZ/DZ	-5	■	163075 ●
250	3.2	2.2	30	KNL	48	HZ/DZ	-5	■	163076 ●
303	3.2	2.2	30	KNL	60	HZ/DZ	-5	■	163077 ●

## 1. Sawing

### 1.3 Sizing

#### 1.3.5 Sizing sawblades FZ/TR



#### Sizing with scoring *Premium*

##### Application:

For sizing and trimming with scoring.

##### Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

##### Workpiece material:

Chipboard and fibre materials, paper and plastic coated.

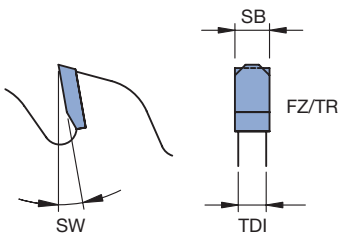
##### Technical information:

**Premium** version with vibration-damping laser ornaments. Marked dimensions with irregular tooth pitch (UT) for noise reduction and improved running behaviour.

##### Circular sawblade

WK 852 2

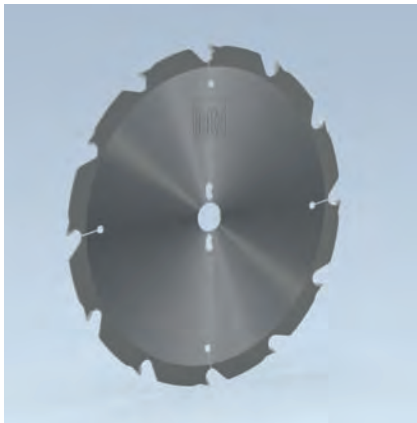
D	SB	TDI	BO	NLA	Z	ZF	Type	SW	WSS	ID
mm	mm	mm	mm	mm				°		
220	3.2	2.2	30	KNL	64	FZ/TR		10	■	163000 ●
250	3.2	2.2	30	KNL	60	FZ/TR	UT	10	■	163002 ●
250	3.2	2.2	30	KNL	80	FZ/TR		10	■	163003 ●
280	3.2	2.2	30	KNL	60	FZ/TR	UT	10	■	163004 ●
300	3.2	2.2	30	KNL	72	FZ/TR	UT	10	■	163005 ●
300	3.2	2.2	30	KNL	96	FZ/TR		10	■	163006 ●
350	3.5	2.5	30	KNL	84	FZ/TR	UT	10	■	163007 ●
350	3.5	2.5	30	KNL	108	FZ/TR		10	■	163008 ●



## 1. Sawing

### 1.3 Sizing

#### 1.3.6 Sizing sawblades FZ



### Sizing

#### Application:

For sizing and cross cutting with and without scoring.

#### Machine:

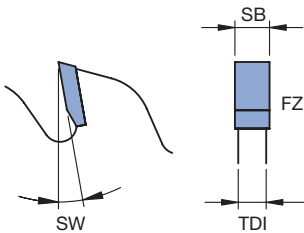
Table and sizing saws.

#### Workpiece material:

Solid wood along grain.

#### Technical information:

Low number of teeth for reduction of feed forces and lower power consumption at large cutting depths especially in solid wood longitudinal.



#### Circular sawblade FZ

WK 120 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
350	3.5	2.5	30	KNL	12	FZ	20	■	163025 ●
400	3.5	2.5	30	KNL	14	FZ	20	■	163026 ●
450	3.8	2.8	30	KNL	16	FZ	20	■	163027 ●



## 1. Sawing

### 1.3 Sizing

#### 1.3.6 Sizing sawblades FZ



### Sizing, scoring, hogging

#### Application:

For sizing, cross cutting and scoring with feed, for mounting on hoggers or segment hoggers.

#### Machine:

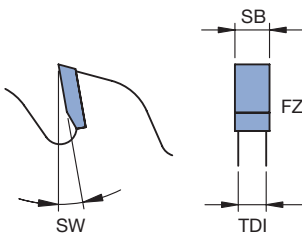
Table, sizing and vertical panel sizing saws.

#### Workpiece material:

Solid wood along grain, chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

#### Technical information:

Suitable for mounting on spindle, flange sleeve or mounting flange on quick-clamping elements.

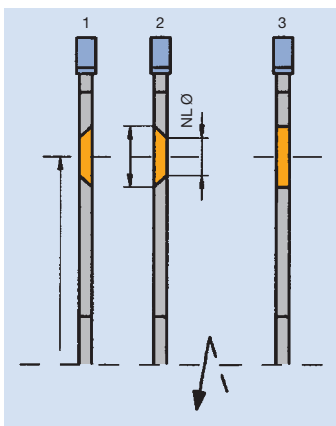


#### Scoring sawblade respectively circular sawblade for the use with hoggers.

##### TC-version.

WK 100 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
150	3.2	2.2	30			42	FZ	10	■ ■	165375 ●
180	3.2	2.2	30			48	FZ	10	■ ■	165378 ●
180	3.2	2.2	65	6/6/90	2	48	FZ	10	■ ■	165379 ●
180	3.2	2.2	65	6/6/90	1	48	FZ	10	■ ■	165380 ●
180	3.2	2.2	65	6/6/90	2	58	FZ	10	■ ■	165381 ●
180	3.2	2.2	65	6/6/90	1	58	FZ	10	■ ■	165382 ●
200	3.2	2.2	30			54	FZ	10	■ ■	165383 ●



#### Type 1:

Countersink right

#### Type 2:

Countersink left

#### Type 3:

Pinhole without countersink

## 1. Sawing

### 1.3 Sizing

#### 1.3.6 Sizing sawblades FZ



#### Sizing, scoring, hogging *Excellent*

##### Application:

For sizing, cross cutting and scoring with feed, for mounting on hoggers or segment hoggers.

##### Machine:

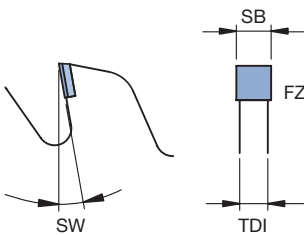
Table, sizing and vertical panel sizing saws.

##### Workpiece material:

Solid wood along grain, chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

##### Technical information:

Suitable for mounting on spindle, flange sleeve or mounting flange on quick-clamping elements.

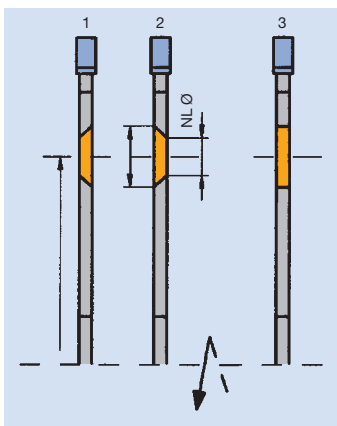


##### Scoring sawblade respectively circular sawblade for the use with hoggers.

##### DP-version.

WK 800 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
180	3.2	2.2	65	6/6/90	2	24	FZ	10		<b>190660</b> □
180	3.2	2.2	65	6/6/90	1	24	FZ	10		<b>190661</b> □
180	3.2	2.2	65	6/6/90	2	36	FZ	10		<b>190662</b> □
180	3.2	2.2	65	6/6/90	1	36	FZ	10		<b>190663</b> □
180	3.2	2.2	65	6/6/90	2	48	FZ	10		<b>190664</b> □
180	3.2	2.2	65	6/6/90	1	48	FZ	10		<b>190665</b> □



##### Type 1:

Countersink right

##### Type 2:

Countersink left

##### Type 3:

Pinhole without countersink



### Scoring sawblades with adjustable cutting width

#### Application:

For scoring with feed.

#### Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

#### Workpiece material:

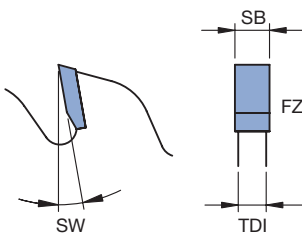
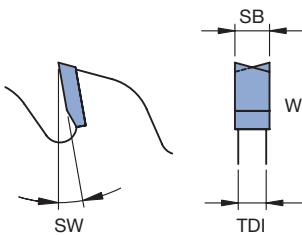
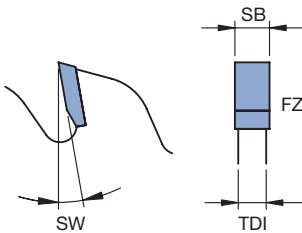
Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

#### Technical information:

2 part design, adjustable with spacers. Scoring depth 1.50 - 2.00 mm.



HW



#### Scoring sawblades adjustable, TC-version

WK 200 2, WK 250 2

Machine	D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
Felder, Striebig	80	2.8 - 3.8	20	10+10	FZ	10	■	165401 ●
Schelling	100	2.8 - 3.8	20	10+10	FZ	10	■	165402 ●
Altendorf	100	2.8 - 3.8	22	10+10	FZ	10	■	165403 ●
SCM, Felder	120	2.8 - 3.8	20	12+12	FZ	10	■	165404 ●
Altendorf	120	2.8 - 3.8	22	12+12	FZ	10	■	165406 ●
Felder	125	2.8 - 3.8	20	12+12	FZ	10	■	165407 ●
Martin	140	2.8 - 3.8	36	12+12	WZ	10	■	165408 ●
Altendorf	180	3.0 - 3.8	22	18+18	WZ	10	■	165410 ●

#### Scoring sawblades for stepless adjustment, TC-version

WK 200 2

Machine	D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
Altendorf	120	2.8 - 3.8	50	12+12	FZ	10	■	165412 ●
Martin T74 Automatic	120	2.8 - 3.6	22	12+12	FZ	10	■	165405 ●
Altendorf	180	3.0 - 3.8	50	18+18	FZ	10	■	165413 ●

## 1. Sawing

### 1.3 Sizing

#### 1.3.7 Scoring sawblades for table and panel saws



#### Scoring sawblades with adjustable cutting width *Excellent*

##### Application:

For scoring with feed.

##### Machine:

Table and sizing saws, vertical panel sizing saws with scoring unit.

##### Workpiece material:

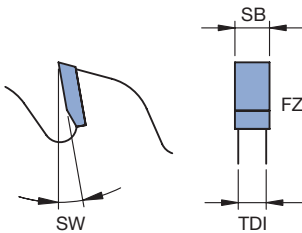
Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

##### Technical information:

2 part design, adjustable with spacers. Scoring depth 1.50 - 2.00 mm.



DP



##### Scoring sawblades adjustable, DP-version

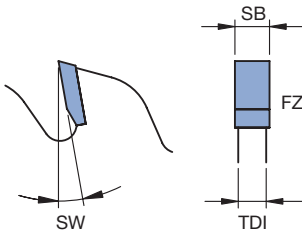
WK 200 2

D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
120	2.8 - 3.8	20	12+12	FZ	10	■	190731 ●
120	2.8 - 3.8	22	12+12	FZ	10	■	190694 ●
125	2.8 - 3.8	20	12+12	FZ	10	■	190695 ●

##### Scoring sawblades for stepless adjustment, DP-version

WK 200 2

D mm	SB mm	BO mm	Z	ZF	SW °	WSS	ID
120	2.8 - 3.8	50	12+12	FZ	10	■	190704 ●



## 1. Sawing

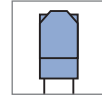
### 1.4 Panel sizing

<b>Working process</b>	For sizing single boards or boards in stacks.
<b>Workpiece materials</b>	Solid wood, wood derived materials and plastic.
<b>Machines</b>	Table saws and panel sizing saws with pressure clamping beam.
<b>Type of application</b>	Scoring sawblades cut with the feed main sawblades cut against the feed.

#### Tooth shape



**WZ (alternative top bevel teeth):**  
Multi-purpose tooth shape, economical to purchase and maintain. Ideal for chipboard, veneered chipboard, solid wood, block board, plywood and similar materials.



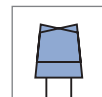
**FZ/TR (square/trapezoidal teeth):**  
Tooth shape for plastic coated and foil coated wood derived materials.



**TR/TR (trapezoidal/trapezoidal teeth):**  
Tooth shape for especially abrasive materials such as HPL or CPL coated wood derived materials.



**KON/FZ (flat teeth – conical):**  
For scoring sawblades. Prevents splitting of the cut edge by the main sawblade as it passes through the bottom surface of the panel.



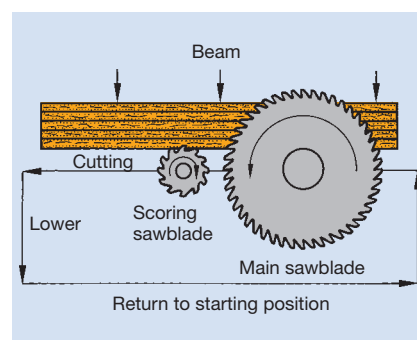
**KON/WZ (alternative top bevel teeth – conical):** For scoring sawblades. Prevents splitting of the cut edge by the main sawblade as it passes through the bottom surface of the panel with low cutting pressure.

#### Scoring sawblades

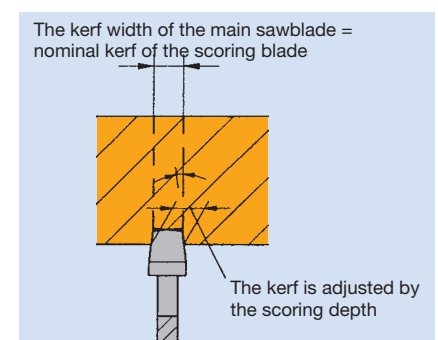
A scoring saw is recommended for a high cut edge quality on both sides of coated panels. The scoring sawblade cutting width (kerf) is slightly larger than the width (kerf) of the main sawblade so the exiting tooth of the main sawblade does not touch the bottom surface cut edge.

As precise, flat workpiece positioning is only possible with pressure clamping, split scoring sawblades are used on table and panel saw.

#### Schematic representation



Panel sizing machine with scoring saw and top pressure beam.



Setting of conical scoring sawblade. The cutting width (kerf) has to be matched to the cutting width (kerf) of the main saw during maintenance of the tools.

## 1. Sawing

### 1.4 Panel sizing

#### 1.4.1 Panel sizing sawblades WZ



#### Sizing of single boards and stacks of boards *Premium*

##### Application:

For panel sizing of single boards and stacks of boards with and without scoring.

##### Machine:

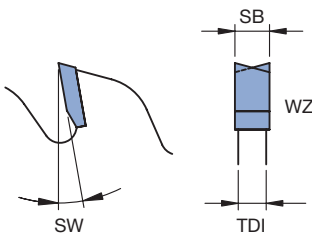
Panel sizing saws with pressure beam.

##### Workpiece material:

Chipboard and fibre materials, laminated veneer lumber (e.g. plywood, multiplex plywood).

##### Technical information:

**Premium** version with vibration-damping laser ornaments.



##### Circular sawblade

WK 250 2

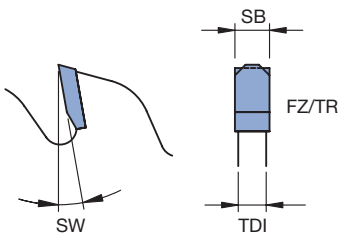
Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	4.4	3.2	30	KNL	48	WZ	15	■	163300 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	54	WZ	15	■	163301 ●
					2/13/94					
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	WZ	15	■	163302 ●
					2/13/94					
Homag	350	4.4	3.2	60	2/14/100	72	WZ	15	■	163304 ●
Gabbiani, SCM	350	4.4	3.2	80	4/9/100	54	WZ	15	■	163305 ●
					2/14/110					
					2/7/110					
Mayer, Schelling	355	4.4	3.2	30	KNL	72	WZ	15	■	163306 ●
					2/13/94					
Homag	380	4.8	3.5	60	2/14/100	54	WZ	15	■	163307 ●
					2/14/125					
Mayer, Schelling	400	4.4	3.2	30	KNL	60	WZ	15	■	163308 ●
					2/13/94					
Mayer, Schelling	400	4.4	3.2	30	KNL	72	WZ	15	■	163309 ●
					2/13/94					
Schelling	430	4.4	3.2	30	KNL	72	WZ	15	■	163310 ●
Mayer, Schelling	450	4.4	3.2	30	KNL	54	WZ	15	■	163311 ●
					2/13/94					
Mayer, Schelling	450	4.4	3.2	30	KNL	72	WZ	15	■	163312 ●
					2/13/94					
Schelling	480	4.4	3.2	30	KNL	72	WZ	15	■	163313 ●
					2/13/94					
Schelling	500	5.2	3.5	30	KNL	60	WZ	15	■	163314 ●
	500	5.2	3.5	80		60	WZ	15	■	163315 ●
Schelling	520	4.4	3.2	30	2/13/94	72	WZ	15	■	163316 ●
	550	5.2	3.5	30	KNL	60	WZ	15	■	163317 ●
	550	5.2	3.5	80	2/13/100	60	WZ	15	■	163318 ●



## 1. Sawing

### 1.4 Panel sizing

#### 1.4.2 Panel sizing sawblades FZ/TR



### Sizing of single boards and stacks of boards *Premium*

#### Application:

For panel sizing of single boards and stacks of boards with scoring.

#### Machine:

Panel sizing saws with scoring unit and pressure beam.

#### Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered.

#### Technical information:

**Premium** design with vibration damping laser ornaments.

#### Circular sawblade

WK 852 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Homag	300	4.4	3.2	30	KNL	60	FZ/TR	15	■	163400 ●
Homag	300	4.4	3.2	60	2/14/100	72	FZ/TR	15	■	163401 ●
Selco	300	4.4	3.2	65	2/9/110	60	FZ/TR	15	■	163402 ●
Homag	300	4.4	3.2	75		60	FZ/TR	15	■	163403 ●
Gabbiani, SCM	300	4.4	3.2	80	2/14/110	60	FZ/TR	15	■	163456 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Homag	308	3.2	2.4	60	2/14/100	96	FZ/TR	15	■	163404 ●
Homag	310	4.4	3.2	60	2/14/100	72	FZ/TR	15	■	163405 ●
Felder, Mayer	320	4.4	3.2	30	KNL	60	FZ/TR	15	■	163406 ●
Selco	320	4.4	3.2	65	2/9/110	60	FZ/TR	15	■	163407 ●
Gabbiani, SCM	320	4.4	3.2	80	2/14/110	60	FZ/TR	15	■	163457 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Gabbiani, SCM	340	4.4	3.2	80	2/14/110	72	FZ/TR	15	■	163458 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	FZ/TR	15	■	163408 ●
					2/13/94					
Homag	350	4.4	3.2	60	2/14/100	72	FZ/TR	15	■	163409 ●
Homag	350	4.4	3.2	75		72	FZ/TR	15	■	163410 ●
Gabbiani, SCM	350	4.4	3.2	80	4/9/100	72	FZ/TR	15	■	163454 ●
					2/7/110					
					2/14/110					
Selco	355	4.4	3.2	65	2/9/110	72	FZ/TR	15	■	163412 ●
					2/9/100					
Giben, Homag	355	4.4	3.2	75		72	FZ/TR	15	■	163413 ●
Schelling	360	4.4	3.2	30	2/13/94	72	FZ/TR	15	■	163414 ●
Selco	360	4.4	3.2	65	2/9/100	72	FZ/TR	15	■	163415 ●
					2/9/110					
	370	4.4	3.2	30	2/13/94	72	FZ/TR	15	■	163416 ●
					KNL					
Giben	380	4.4	3.2	50	2/13/80	72	FZ/TR	15	■	163417 ●
					6/13/80					
Homag	380	4.4	3.2	60	2/14/100	72	FZ/TR	15	■	163418 ●
					2/14/125					
Homag	380	4.8	3.5	60	2/14/100	72	FZ/TR	15	■	163419 ●
					2/14/125					
Giben	380	4.4	3.2	75	3/15/75	72	FZ/TR	15	■	163420 ●
					2/7/110					

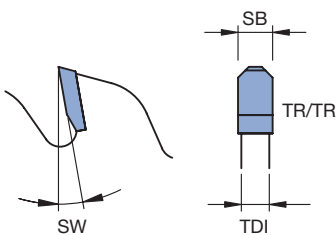


## 1. Sawing

### 1.4 Panel sizing

#### 1.4.2 Panel sizing sawblades FZ/TR

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Gabbiani, SCM	380	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	FZ/TR	15	■	163459 ●
Mayer, Schelling	400	4.4	3.2	30	KNL 2/13/94	72	FZ/TR	15	■	163421 ●
Anthon	400	4.4	3.2	60	2/11/85	72	FZ/TR	15	■	163422 ●
Giben, Homag	400	4.4	3.2	75	4/15/105 2/7/110	72	FZ/TR	15	■	163423 ●
Gabbiani, Selco, SCM	400	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	FZ/TR	15	■	163455 ●
Homag	420	4.8	3.5	60	2/14/125 2/19/120	72	FZ/TR	15	■	163426 ●
Schelling	430	4.4	3.2	30	KNL	72	FZ/TR	15	■	163427 ●
Giben	430	4.4	3.2	75	4/15/105 2/7/110	72	FZ/TR	15	■	163428 ●
Selco, Gabbiani, SCM	430	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	FZ/TR	15	■	163429 ●
Mayer, Schelling	450	4.4	3.2	30	KNL 2/13/94	72	FZ/TR	15	■	163430 ●
Homag	450	4.8	3.5	60	2/14/125 2/19/120	72	FZ/TR	15	■	163431 ●
Gabbiani, SCM	450	4.4	3.2	80	2/9/100 2/14/110 2/7/110	72	FZ/TR	15	■	163432 ●
Selco	450	4.8	3.6	80	2/9/130 4/19/120	72	FZ/TR	15	■	163433 ●
Schelling	460	4.4	3.2	30	2/13/94	72	FZ/TR	15	■	163434 ●
Giben	470	4.4	3.2	75	4/15/105	96	FZ/TR	15	■	163435 ●
Schelling	480	4.4	3.2	30	KNL 2/13/94	72	FZ/TR	15	■	163436 ●
Homag	480	4.8	3.5	60	2/19/120	72	FZ/TR	15	■	163437 ●
Selco	480	4.8	3.5	80	2/9/130 4/19/120	72	FZ/TR	15	■	163438 ●
Schelling	500	5.2	3.5	30	KNL	60	FZ/TR	15	■	163439 ●
Anthon, Homag	500	5.2	3.5	60	2/11/115 2/19/120	60	FZ/TR	15	■	163440 □
Selco	510	4.8	3.5	80	2/9/130 4/19/120	72	FZ/TR	15	■	163441 ●
Schelling	520	4.4	3.2	30	2/13/94	72	FZ/TR	15	■	163442 ●
Homag	520	4.8	3.5	60	2/11/115 2/19/120	72	FZ/TR	15	■	163443 ●
Selco	520	4.8	3.5	70	4/11/130	72	FZ/TR	15	■	163444 ●
Gabbiani, SCM	530	4.8	3.5	80	4/9/100 2/14/110 2/7/110	72	FZ/TR	15	■	163460 ●
Homag	570	4.8	3.5	60	2/11/115 2/19/120	60	FZ/TR	22	■	163445 ●
Homag, Anthon	600	5.8	4,0	60	2/19/120 2/11/115 2/11/85	60	FZ/TR	22	■	163446 ●
Homag, Anthon	600	5.8	4,0	60	2/19/120 2/11/115 2/11/85	72	FZ/TR	22	■	163447 ●
Homag	670	5.8	4.2	60	2/11/148 2/19/120	42	FZ/TR	22	■	163448 ●
Schelling	680	6.2	4.2	40	2/13/114 2/13/140	60	FZ/TR	22	■	163449 ●
Anthon	700	6.2	4.4	80	1/17/110	60	FZ/TR	22	■	163450 ●
Schelling	720	6.5	4.5	40	2/13/140 2/13/114	60	FZ/TR	22	■	163451 ●
Homag	730	6.2	4.2	60	2/11/148 2/19/120	60	FZ/TR	22	■	163452 ●
Anthon	750	7,0	5,0	80	1/17/110	70	FZ/TR	22	■	163453 ●



## Sizing of single boards in finish cut quality - RazorCut

### Application:

For panel sizing of single boards and stacks of boards with low cutting heights (up to 60 mm) with scoring.

### Machine:

Panel sizing saws with scoring unit and pressure beam.

### Workpiece material:

Chipboard and fibre materials plastic coated, duroplastics (compact laminate panels, e.g. HPL).

### Technical information:

Special cutting geometry for excellent cutting results in finish cut quality. Suitable for high feed speeds in batch size 1 production. Design with irregular pitch and vibration damping laser ornaments for optimal running behaviour.

### Circular sawblade RazorCut

WK 878 2 87

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	3.2	2.2	30	KNL	72	TR/TR	15	■	163370 ●
	300	4.4	3.2	30	KNL	60	TR/TR	15	■	163369 ●
Homag	300	4.4	3.2	60	2/14/100	72	TR/TR	15	■	163371 ●
Selco	300	4.4	3.2	65	2/9/110	60	TR/TR	15	■	163372 ●
SCM, Gabbiani	300	4.4	3.2	80	2/14/110	60	TR/TR	15	■	163373 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Giben	320	4.4	3.2	50	3/15/80	60	TR/TR	15	■	163374 ●
Homag	320	4.4	3.2	60	2/14/100	72	TR/TR	15	■	163394 ●
Selco	320	4.4	3.2	65	2/9/110	60	TR/TR	15	■	163375 ●
Giben	320	4.4	3.2	75	3/13/95	60	TR/TR	15	■	163376 ●
					3/7/100					
SCM, Gabbiani	320	4.4	3.2	80	2/14/110	60	TR/TR	15	■	163377 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
SCM, Gabbiani	340	4.4	3.2	80	2/14/110	72	TR/TR	15	■	163378 ●
					2/7/110					
					4/9/100					
					4/19/120					
					2/9/130					
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15	■	163379 ●
					2/13/94					
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15	■	163380 ●
Giben	350	4.4	3.2	75		72	TR/TR	15	■	163395 ●
Selco	355	4.4	3.2	65	2/9/100	72	TR/TR	15	■	163381 ●
					2/9/110					
Schelling	360	4.4	3.2	30	2/13/94	72	TR/TR	15	■	163382 ●
Holz-Her	380	4.4	3.2	30	KNL	72	TR/TR	15	■	163383 ●
Giben	380	4.4	3.2	50	4/13/80	72	TR/TR	15	■	163396 ●
Homag	380	4.4	3.2	60	2/14/100	72	TR/TR	15	■	163384 ●
					2/14/125					
Selco	380	4.4	3.2	65	2/9/110	72	TR/TR	15	■	163386 ●
Homag	380	4.8	3.5	60	2/14/100	72	TR/TR	15	■	163385 ●
					2/14/125					
Homag	380	4.8	3.5	60	2/14/100	84	TR/TR	15	■	163750 ●
					2/14/125					



## 1. Sawing

### 1.4 Panel sizing

#### 1.4.3 Panel sizing sawblades TR/TR



Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Mayer, Schelling	400	4.4	3.2	30	KNL 2/13/94	72	TR/TR	15	■ ■	163387 ●
Selco	400	4.4	3.2	65	2/9/110	72	TR/TR	15	■ ■	163388 ●
Selco	430	4.4	3.2	65	2/9/110	72	TR/TR	15	■ ■	163389 ●
SCM, Gabbiani, Selco	430	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	TR/TR	15	■ ■	163397 ●
Homag	450	4.8	3.5	60	2/14/125 2/19/120	72	TR/TR	15	■ ■	163390 ●
Selco	450	4.8	3.5	80	2/9/130 4/19/120	72	TR/TR	15	■ ■	163398 ●
Schelling	460	4.4	3.2	30	2/13/94	72	TR/TR	15	■ ■	163391 ●
Selco	470	4.8	3.5	70	4/11/130	72	TR/TR	15	■ ■	163392 ●
Anthon, Homag	500	4.8	3.5	60	2/11/115 2/19/20	72	TR/TR	15	■ ■	163393 ●
Homag	520	4.8	3.5	30	2/19/120	72	TR/TR	15	■ ■	163399 ●



#### Sizing of single boards in finish cut quality - RazorCut PLUS

##### Application:

For panel sizing of single boards and stacks of boards with low cutting heights (up to 60 mm) with scoring.

##### Machine:

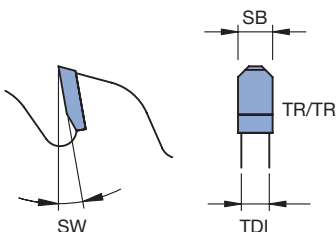
Panel sizing saws with scoring unit and pressure beam.

##### Workpiece material:

Chipboard and fibre materials plastic coated, duroplastics (compact laminate panels, e.g. HPL).

##### Technical information:

Optimal cutting quality due to special cutting edge geometry and maximal quiet running. Suitable for high feed speeds in batch size 1 production. Design with irregular pitch and vibration damping laser ornaments for optimal running behaviour. Maximal tool life through extremely wear-resistant cutting material.



##### Circular sawblade RazorCut PLUS

WK 878 2 87

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
	250	3.2	2.2	30	KNL	60	TR/TR	15	■ ■	161135 ●
	280	3.2	2.2	30	KNL	60	TR/TR	15	■ ■	161136 ●
	300	3.2	2.2	30	KNL	72	TR/TR	15	■ ■	161138 ●
Schelling	300	3.2	2.5	30	2/13/94	72	TR/TR	15	■ ■	161139 ●
	300	4.4	3.0	30	KNL	60	TR/TR	15	■ ■	161137 ●
Homag	300	4.4	3.0	60	2/14/100	72	TR/TR	15	■ ■	161140 ●
Selco	300	4.4	3.0	65	2/9/110	60	TR/TR	15	■ ■	161141 ●
SCM, Gabbiani	300	4.4	3.0	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	60	TR/TR	15	■ ■	161142 ●
Homag	308	3.2	2.4	60	2/14/100	96	TR/TR	15	■ ■	161143 ●
Homag	310	4.4	3.2	60	2/14/100	72	TR/TR	15	■ ■	161144 ●
Giben	320	4.4	3.2	50	3/15/80	60	TR/TR	15	■ ■	161145 ●
Selco	320	4.4	3.2	65	2/9/110	60	TR/TR	15	■ ■	161146 ●

- Solid wood
- Board, coated
- Board, uncoated
- Non-ferrous metals
- Plastics
- Mineral materials
- Composites
- Steel, thin-walled

## 1. Sawing

### 1.4 Panel sizing

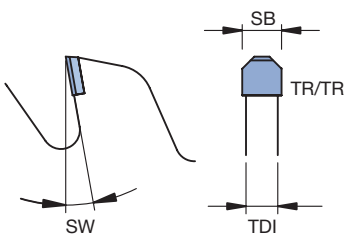
#### 1.4.3 Panel sizing sawblades TR/TR

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
SCM, Gabbiani	320	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	60	TR/TR	15	■ ■	161147 ●
SCM, Gabbiani	340	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	TR/TR	15	■ ■	161148 ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL 2/13/94	72	TR/TR	15	■ ■	161149 ●
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15	■ ■	161150 ●
Giben	350	4.4	3.2	75		72	TR/TR	15	■ ■	161151 ●
Selco	355	4.4	3.2	65	2/9/100 2/9/110	72	TR/TR	15	■ ■	161152 ●
Selco	355	4.4	3.2	80	2/9/130 4/19/120	72	TR/TR	15	■ ■	161153 ●
Schelling	360	4.4	3.2	30	2/13/94	72	TR/TR	15	■ ■	161154 ●
	370	4.4	3.2	30	KNL	72	TR/TR	15	■ ■	161155 ●
Holz-Her	380	4.4	3.2	30	KNL	72	TR/TR	15	■ ■	161156 ●
Giben	380	4.4	3.2	50	4/13/80	72	TR/TR	15	■ ■	161157 ●
Homag	380	4.4	3.2	60	2/14/100 2/14/125	72	TR/TR	15	■ ■	161158 ●
SCM, Gabbiani	380	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	TR/TR	15	■ ■	161160 ●
Homag	380	4.8	3.5	60	2/14/100 2/14/125	72	TR/TR	15	■ ■	161159 ●
Mayer, Schelling	400	4.4	3.2	30	KNL 2/13/94	72	TR/TR	15	■ ■	161161 ●
Giben, Homag	400	4.4	3.2	75	4/15/105 2/7/110	72	TR/TR	15	■ ■	161162 ●
SCM, Gabbiani, Selco	400	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	TR/TR	15	■ ■	161163 ●
Homag	420	4.8	3.5	60	2/14/125 2/19/120	72	TR/TR	15	■ ■	161164 ●
Schelling	430	4.4	3.2	30	KNL	72	TR/TR	15	■ ■	161165 ●
Giben	430	4.4	3.2	75	4/15/105 2/7/110	72	TR/TR	15	■ ■	161166 ●
SCM, Gabbiani, Selco	430	4.4	3.2	80	2/14/110 2/7/110 4/9/100 4/19/120 2/9/130	72	TR/TR	15	■ ■	161167 ●
Mayer, Schelling	450	4.4	3.2	30	KNL 2/13/94	72	TR/TR	15	■ ■	161168 ●
Homag	450	4.8	3.5	60	2/14/125 2/19/120	72	TR/TR	15	■ ■	161169 ●
Schelling	460	4.4	3.2	30	2/13/94	72	TR/TR	15	■ ■	161170 ●
Schelling	520	4.8	3.5	30	2/13/94	72	TR/TR	15	■ ■	161171 ●

## 1. Sawing

### 1.4 Panel sizing

#### 1.4.3 Panel sizing sawblades TR/TR



#### Sizing of single boards and stacks of boards *Excellent*

##### Application:

For panel sizing of single boards and stacks of boards with scoring.

##### Machine:

Panel sizing saws with scoring unit and pressure beam.

##### Workpiece material:

Chipboard and fibre materials plastic coated, duroplastics (compact laminate panels, e.g. HPL), fibre reinforced materials (e.g. GFRP, CFRP).

##### Technical information:

DP equipment for long tool life. **Excellent** version with irregular tooth pitch and filled laser ornaments for vibration damping and reduction of noise level. Coating of the tool body for higher running performance. Mounting height 6 mm for multiple resharping.

##### Panel sizing sawblade TR/TR, Diamaster PLUS

WK 278 2, WK 858 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	4.4	3.2	30	KNL	60	TR/TR	15		<b>190706</b> ●
Homag	308	3.2	2.4	60	2/14/100	96	TR/TR	10		<b>190746</b> ●
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	KNL	72	TR/TR	15		<b>190707</b> ●
					2/13/94					
Homag	350	4.4	3.2	60	2/14/100	72	TR/TR	15		<b>190708</b> ●
					2/14/125					
Homag	380	4.4	3.2	60	2/14/100	72	TR/TR	15		<b>190709</b> ●
					2/14/125					
Homag	380	4.8	3.5	60	2/14/100	72	TR/TR	15		<b>190710</b> ●
					2/14/125					
Mayer, Schelling	400	4.4	3.2	30	KNL	72	TR/TR	15		<b>190711</b> ●
					2/13/94					
Homag	450	4.8	3.5	60	2/14/125	72	TR/TR	15		<b>190712</b> ●
					2/19/120					





### Scoring sawblade KON/WZ

**Application:**

For scoring with feed.

**Machine:**

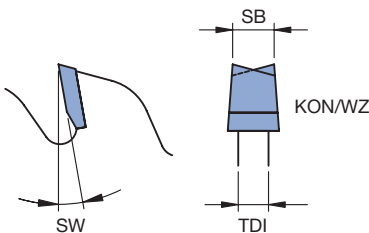
Panel sizing saws with scoring unit and pressure beam.

**Workpiece material:**

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

**Technical information:**

Scoring depth 1.50 - 2.00 mm. For universal use in any surface coating. The suitable scoring circular sawblade must be selected depending on the cutting width of the main saw.


**Scoring sawblade KON/WZ, TC design**

WK 856 2 01, WK 856 2 05

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	125	3.2	2.5	20		24	KON/WZ	5	■	165550 ●
	125	3.2	2.5	22		24	KON/WZ	5	■	165551 ●
Giben, Homag, Mayer	125	4.4	3.5	45		24	KON/WZ	5	■	165553 ●
Schelling	150	4.4	3.5	20		24	KON/WZ	5	■	165554 ●
Felder, Mayer	150	4.4	3.5	30		36	KON/WZ	5	■	165555 ●
Felder, Mayer	150	4.4	3.5	30		24	KON/WZ	5	■	165556 ●
Homag	150	4.4	3.5	45		24	KON/WZ	5	■	165557 ●
Homag	150	4.4	3.5	45		28	KON/WZ	5	■	165558 ●
	160	3.2	2.5	20		32	KON/WZ	5	■	165559 ●
Steton	160	4.4	3.5	30		36	KON/WZ	5	■	165560 ●
Giben	160	4.4	3.5	45	3/11/70	36	KON/WZ	5	■	165561 ●
Gabbiani	160	4.4	3.5	55	3/7/66 3/6/84	36	KON/WZ	5	■	165562 ●
	180	3.2	2.5	20		36	KON/WZ	5	■	165563 ●
	180	4.4	3.5	20		36	KON/WZ	5	■	165564 ●
Anthon, Homag	180	4.4	3.5	45		30	KON/WZ	5	■	165565 ●
Anthon, Homag	180	4.4	3.5	45		36	KON/WZ	5	■	165566 ●
Giben	180	4.5	3.2	50	3/13/80	36	KON/WZ	5	■	165567 ●
Schelling	200	4.4	3.5	20	2/11/66	36	KON/WZ	5	■	165569 ●
	200	6.2	4.5	20	2/11/66	36	KON/WZ	5	■	165570 ●
	200	3.2	2.5	30	2/10/60	60	KON/WZ	5	■	165571 ●
	200	4.4	3.5	30	2/10/60	36	KON/WZ	5	■	165572 ●
Schelling	200	4.8	3.5	20		36	KON/WZ	5	■	165573 ●
Homag	200	4.4	3.5	45		36	KON/WZ	5	■	165574 ●
Homag	200	5.8	4.6	45		36	KON/WZ	5	■	165575 ●
Selco	200	4.4	3.5	65	2/9/100	36	KON/WZ	5	■	165576 ●
					2/9/110					
Selco	200	4.8	3.5	65	2/9/100	36	KON/WZ	5	■	165577 ●
					2/9/110					
Giben	215	4.4	3.5	50	3/15/80	42	KON/WZ	5	■	165578 ●
					2/7/80					
Schelling	220	6.5	4.5	20	2/11/66	36	KON/WZ	5	■	165579 ●
Homag	280	4.8	3.5	45		72	KON/WZ	5	■	165581 ●
Schelling	300	4.4	3.5	30	2/11/73	48	KON/WZ	5	■	165582 ●
					2/13/94					
Giben	300	4.4	3.5	50	3/15/80	48	KON/WZ	5	■	165583 ●
Selco	300	4.4	3.5	65	2/9/100	72	KON/WZ	5	■	165584 ●
					2/9/110					
Selco	300	4.4	3.5	65	3/15/80	48	KON/WZ	5	■	165585 □
					2/9/110					

## 1. Sawing

### 1.4 Panel sizing

#### 1.4.4 Scoring sawblades for panel saws KON



#### Scoring sawblades KON/FZ

##### Application:

For scoring with feed.

##### Machine:

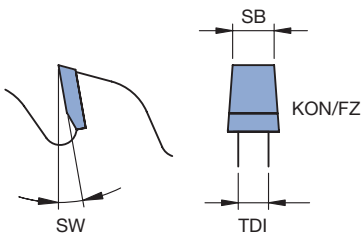
Panel sizing saws with scoring unit and pressure beam.

##### Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

##### Technical information:

Scoring depth 1.50 - 2.00 mm. Recommended especially for use in plastic and HPL-coated panels. The suitable circular scoring sawblade must be selected depending on the cutting width of the main saw.



#### Scoring sawblades KON/FZ, TC design

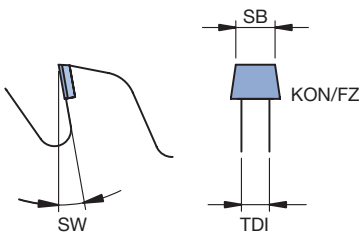
WK 804 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
SCM	100	3.2	2.5	20		20	KON/FZ	5	■	165625 ●
	100	3.2	2.5	22		20	KON/FZ	5	■	165626 ●
	120	3.2	2.5	20		24	KON/FZ	5	■	165627 ●
	125	4.4	3.5	20		24	KON/FZ	5	■	165628 ●
Holz-Her	125	4.4	3.5	45		24	KON/FZ	5	■	165629 ●
Anthon	180	4.4	3.5	20		28	KON/FZ	5	■	165630 ●
Anthon	180	5.8	4.0	20		36	KON/FZ	5	■	165631 ●
Holz-Her	180	4.4	3.5	30	2/10/60	30	KON/FZ	5	■	165632 ●
Homag	180	4.4	3.5	45		36	KON/FZ	5	■	165633 ●
Homag	180	4.8	3.5	45		36	KON/FZ	5	■	165634 ●
Anthon	200	6.8	4.2	20		36	KON/FZ	5	■	165635 ●
Homag	200	4.8	3.5	45		36	KON/FZ	5	■	165636 ●
SCM	200	4.4	3.5	80	2/14/110	36	KON/FZ	5	■	165637 ●
Homag	220	3.2	2.4	45		60	KON/FZ	5	■	165638 ●
	250	4.4	3.5	30	2/10/60	42	KON/FZ	5	■	165639 ●
Holz-Her	280	4.4	3.5	30	2/10/60	48	KON/FZ	5	■	165640 ●
Schelling	300	3.2	2.8	30	2/13/94	72	KON/FZ	5	■	165641 ●

## 1. Sawing

### 1.4 Panel sizing

#### 1.4.4 Scoring sawblades for panel saws KON



#### Scoring sawblades KON/FZ *Excellent*

##### Application:

For scoring with feed.

##### Machine:

Panel sizing saws with scoring unit and pressure beam.

##### Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), alu composite panels (e.g. Alucobond®), duroplastics (compact laminate panels, e.g. HPL), fibre reinforced materials (e.g. GFRP, CFRP)

##### Technical information:

Scoring depth 2.00 - 2.50 mm. Recommended especially for use in plastic and HPL-coated panels. Long tool life due to DP tipping. The suitable circular scoring sawblade must be selected depending on the cutting width of the main saw. Can be used in combination with HW- and DP-tipped main circular sawblades. The cutting width (SB) of the scoring circular sawblades is 0.1 mm less for use in combination with resharpened TC-tipped main circular sawblades.

#### Scoring sawblades KON/FZ, Diamaster PLUS

WK 804 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	125	3.1	2.5	20		20	KON/FZ	10		190564 ●
Felder, Mayer	150	4.3	3.2	30		24	KON/FZ	10		190565 ●
Gabbiani	160	4.3	3.5	55	3/ 7/ 66	30	KON/FZ	10		190566 ●
Holz-Her	180	4.3	3.5	30	2/10/ 60	30	KON/FZ	10		190567 ●
Homag	180	4.3	3.5	45		30	KON/FZ	10		190568 ●
Homag	180	4.7	3.5	45		30	KON/FZ	10		190569 ●
Schelling	200	4.3	3.5	20	2/11/66	30	KON/FZ	10		190570 ●
	200	4.3	3.5	30	2/10/ 60	30	KON/FZ	10		190571 ●
Homag	200	4.3	3.5	45		30	KON/FZ	10		190572 ●
Selco	200	4.3	3.5	65	2/9/100	30	KON/FZ	10		190615 ●
					2/9/110					
					2/14/110					
Homag	200	4.7	3.5	45		30	KON/FZ	10		190573 ●
Selco	200	4.7	3.5	65	2/9/110	30	KON/FZ	10		190574 ●
					2/9/100					
Homag	220	3.1	2.4	45		48	KON/FZ	10		190744 ●
Schelling	300	4.3	3.5	30	2/11/73	48	KON/FZ	10		190743 ●
					2/13/94					

## 1. Sawing

### 1.4 Panel sizing

#### 1.4.5 Scoring sawblades - softforming / postforming



#### Scoring sawblade - softforming / postforming

##### Application:

For scoring with feed at high feed rates and deep cutting depths.

##### Machine:

Panel sizing saws with adjustable soft and postforming units and pressure beam.

##### Workpiece material:

Chipboard and fibre materials paper and plastic coated.

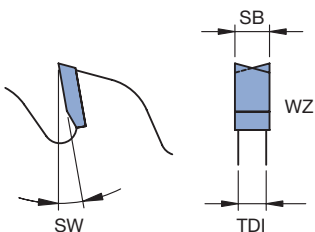
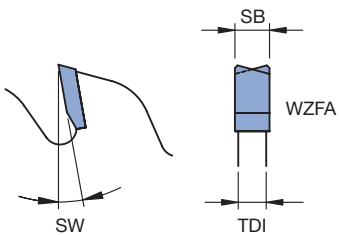
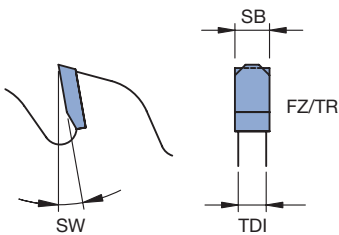
##### Technical information:

Dimension and tooth shape according to machine manufacturers' specification.

##### Circular sawblade FZ/TR

WK 852 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n <sub>max</sub>	WSS	ID
	mm	mm	mm	mm	mm			°	min <sup>-1</sup>		
	220	3.35	2.5	30		48	FZ/TR	10	10400	■	165676 ●
	250	4.55	3.2	30	2/10/60	48	FZ/TR	10	9100	■	165677 ●
Holz-Her	280	4.55	3.2	30	2/10/60	60	FZ/TR	10	8100	■	165678 ●
Homag	280	3.45	2.4	45		60	FZ/TR	10	8100	■	165675 ●
Homag	350	4.55	3.2	75		72	FZ/TR	10	6500	■	165679 ●
	450	4.8	3.5	30	2/10/60	72	FZ/TR	10	4200	■	165680 ●



##### Circular sawblade WZFA

WK 251 2, WK 851 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n <sub>max</sub>	WSS	ID
	mm	mm	mm	mm	mm			°	min <sup>-1</sup>		
	180	4.55	3.2	30		36	WZFA	10	12700	■	165681 ●
Schelling	300	4.55	3.2	30	2/11/73	72	WZFA	10	7600	■	165682 ●
					2/13/94						
Selco	300	4.55	3.2	65	2/9/110	72	WZFA	10	7600	■	165683 ●

##### Circular sawblade WZ

WK 850 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	n <sub>max</sub>	WSS	ID
	mm	mm	mm	mm	mm			°	min <sup>-1</sup>		
Homag	280	4.55	3.2	45		84	WZ	10	8100	■	165684 ●
Homag	280	4.95	3.5	45		84	WZ	10	8100	■	165685 ●

## 1. Sawing

### 1.4 Panel sizing

#### 1.4.6 Overview scoring and main sawblades

Machine-Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
<b>Gabbiani- P60</b>	Main sawblade	300x4.4x80	60	HW	TR/TR	RazorCut	<b>163373 ●</b>
	Main sawblade	300x4.4x80	60	HW	TR/TR	RazorCut PLUS	<b>161142 ●</b>
	Main sawblade	300x4.4x80	60	HW	FZ/TR		<b>163456 ●</b>
	Scoring sawblade	200x4.4x80	36	HW	KON/FZ		<b>165637 ●</b>
<b>Gabbiani- P80</b>	Main sawblade	340x4.4x80	72	HW	TR/TR	RazorCut	<b>163378 ●</b>
	Main sawblade	340x4.4x80	72	HW	TR/TR	RazorCut PLUS	<b>161148 ●</b>
	Main sawblade	340x4.4x80	72	HW	FZ/TR		<b>163458 ●</b>
	Scoring sawblade	200x4.4x80	36	HW	KON/FZ		<b>165637 ●</b>
<b>Gabbiani- G2 115</b>	Main sawblade	400x4.4x80	72	HW	TR/TR	RazorCut PLUS	<b>161163 ●</b>
	Main sawblade	400x4.4x80	72	HW	FZ/TR		<b>163455 ●</b>
	Scoring sawblade	200x4.4x80	36	HW	KON/FZ		<b>165637 ●</b>
<b>Gabbiani- G2 130</b>	Main sawblade	430x4.4x80	72	HW	TR/TR	RazorCut PLUS	<b>161167 ●</b>
	Main sawblade	430x4.4x80	72	HW	FZ/TR		<b>163429 ●</b>
	Scoring sawblade	200x4.4x80	36	HW	KON/FZ		<b>165637 ●</b>
<b>Gabbiani- S95</b>	Main sawblade	380x4.4x80	72	HW	TR/TR	RazorCut PLUS	<b>161160 ●</b>
	Main sawblade	380x4.4x80	72	HW	FZ/TR		<b>163459 ●</b>
	Scoring sawblade	160x4.4x55	36	HW	KON/WZ		<b>165562 ●</b>
	Scoring sawblade	160x4.3/5.1x55	30	DP	KON/FZ		<b>190566 ●</b>
<b>Gabbiani- S115</b>	Main sawblade	400x4.4x80	72	HW	TR/TR	RazorCut PLUS	<b>161163 ●</b>
	Main sawblade	400x4.4x80	72	HW	FZ/TR		<b>163455 ●</b>
	Scoring sawblade	160x4.4x55	36	HW	KON/WZ		<b>165562 ●</b>
	Scoring sawblade	160x4.3/5.1x55	30	DP	KON/FZ		<b>190566 ●</b>
<b>Holz-Her- Tectra 6120 Classic</b>	Main sawblade	350x4.4x30	54	HW	WZ		<b>163301 ●</b>
	Main sawblade	350x4.4x30	72	HW	WZ		<b>163302 ●</b>
	Main sawblade	350x4.4x30	72	HW	FZ/TR		<b>163408 ●</b>
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	<b>163379 ●</b>
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	<b>161149 ●</b>
	Main sawblade	350x4.4x30	72	DP	TR/TR		<b>190707 ●</b>
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		<b>165632 ●</b>
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		<b>190567 ●</b>
<b>Holz-Her- Tectra 6120 Dynamic, Lift, Power</b>	Main sawblade	380x4.4x30	72	HW	TR/TR	RazorCut	<b>163383 ●</b>
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		<b>165632 ●</b>
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		<b>190567 ●</b>
<b>Holz-Her- Zentrex 6220 Classic</b>	Main sawblade	380x4.4x30	72	HW	TR/TR	RazorCut	<b>163383 ●</b>
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		<b>165632 ●</b>
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		<b>190567 ●</b>
<b>Holz-Her- Zentrex 6220 Dyna- mic, Lift, Power</b>	Main sawblade	430x4.4x30	72	HW	WZ		<b>163310 ●</b>
	Main sawblade	430x4.4x30	72	HW	FZ/TR		<b>163427 ●</b>
	Main sawblade	400x4.4x80	72	HW	TR/TR	RazorCut PLUS	<b>161163 ●</b>
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		<b>165632 ●</b>
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		<b>190567 ●</b>
<b>Homag- HKL300</b>	Main sawblade	350x4.4x60	72	HW	WZ		<b>163304 ●</b>
	Main sawblade	350x4.4x60	72	HW	FZ/TR		<b>163409 ●</b>
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut	<b>163380 ●</b>
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut PLUS	<b>161150 ●</b>
	Main sawblade	350x4.4x60	72	DP	TR/TR		<b>190708 ●</b>
	Scoring sawblade	180x4.4x45	30	HW	KON/WZ		<b>165565 ●</b>
	Scoring sawblade	180x4.4x45	36	HW	KON/WZ		<b>165566 ●</b>
	Scoring sawblade	180x4.4x45	36	HW	KON/FZ		<b>165633 ●</b>
	Scoring sawblade	180x4.3/5.1x45	30	DP	KON/FZ		<b>190568 ●</b>
<b>Homag- HKL600</b>	Main sawblade	600x5.8x60	60	HW	FZ/TR		<b>163446 ●</b>
	Main sawblade	600x5.8x60	72	HW	FZ/TR		<b>163447 ●</b>
	Scoring sawblade	200x5.8x45	36	HW	KON/WZ		<b>165575 ●</b>



## 1. Sawing

### 1.4 Panel sizing

#### 1.4.6 Overview scoring and main sawblades

Machine-Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
<b>Homag-</b> HPP130	Main sawblade	300x4.4x60	72	HW	FZ/TR		<b>163401 ●</b>
	Main sawblade	300x4.4x60	72	HW	TR/TR	RazorCut PLUS	<b>161140 ●</b>
	Main sawblade	300x4.4x60	72	HW	TR/TR	RazorCut	<b>163371 ●</b>
	Scoring sawblade	150x4.4x45	24	HW	KON/WZ		<b>165557 ●</b>
	Scoring sawblade	150x4.4x45	28	HW	KON/WZ		<b>165558 ●</b>
<b>Homag-</b> HPP200	Main sawblade	350x4.4x60	72	HW	WZ		<b>163304 ●</b>
	Main sawblade	350x4.4x60	72	HW	FZ/TR		<b>163409 ●</b>
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut	<b>163380 ●</b>
	Main sawblade	350x4.4x60	72	HW	TR/TR	RazorCut PLUS	<b>161150 ●</b>
	Main sawblade	350x4.4x60	72	DP	TR/TR		<b>190708 ●</b>
	Scoring sawblade	200x4.4x45	36	HW	KON/WZ		<b>165574 ●</b>
	Scoring sawblade	200x4.3/5.1x45	30	DP	KON/FZ		<b>190572 ●</b>
<b>Homag-</b> HPP300, HPL300, HKL300	Main sawblade	380x4.8x60	54	HW	WZ		<b>163307 ●</b>
	Main sawblade	380x4.4x60	72	HW	FZ/TR		<b>163418 ●</b>
	Main sawblade	380x4.8x60	72	HW	FZ/TR		<b>163419 ●</b>
	Main sawblade	380x4.4x60	72	HW	TR/TR	RazorCut PLUS	<b>161158 ●</b>
	Main sawblade	380x4.8x60	72	HW	TR/TR	RazorCut PLUS	<b>161159 ●</b>
	Main sawblade	380x4.4x60	72	HW	TR/TR	RazorCut	<b>163384 ●</b>
	Main sawblade	380x4.8x60	72	HW	TR/TR	RazorCut	<b>163385 ●</b>
	Scoring sawblade	180x4.4x45	30	HW	KON/WZ		<b>165565 ●</b>
	Scoring sawblade	180x4.4x45	36	HW	KON/WZ		<b>165566 ●</b>
	Scoring sawblade	180x4.4x45	36	HW	KON/FZ		<b>165633 ●</b>
	Scoring sawblade	180x4.8x45	36	HW	KON/FZ		<b>165634 ●</b>
	Scoring sawblade	180x4.3/5.1x45	30	DP	KON/FZ		<b>190568 ●</b>
	Scoring sawblade	180x4.7/5.5x45	30	DP	KON/FZ		<b>190569 ●</b>
<b>Homag-</b> HPP400	Main sawblade	450x4.8x60	72	HW	FZ/TR		<b>163431 ●</b>
	Main sawblade	450x4.8x60	72	HW	TR/TR	RazorCut	<b>163390 ●</b>
	Main sawblade	450x4.8x60	72	HW	TR/TR	RazorCut PLUS	<b>161169 ●</b>
	Main sawblade	450x4.8x60	72	DP	TR/TR		<b>190712 ●</b>
	Scoring sawblade	180x4.8x45	36	HW	KON/FZ		<b>165634 ●</b>
	Scoring sawblade	180x4.7/5.5x45	30	DP	KON/FZ		<b>190569 ●</b>
<b>Mayer-</b> kappa automatic 80	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut	<b>163369 ●</b>
	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut PLUS	<b>161137 ●</b>
	Main sawblade	320x4.4x30	60	HW	FZ/TR		<b>163406 ●</b>
	Scoring sawblade	150x4.4x30	36	HW	KON/WZ		<b>165555 ●</b>
	Scoring sawblade	150x4.4x30	24	HW	KON/WZ		<b>165556 ●</b>
	Scoring sawblade	150x4.3/5.1x30	24	DP	KON/FZ		<b>190565 ●</b>
<b>Mayer-</b> kappa automatic 100	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	<b>161149 ●</b>
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	<b>163379 ●</b>
	Main sawblade	350x4.4x30	72	HW	FZ/TR		<b>163408 ●</b>
	Main sawblade	355x4.4x30	72	HW	WZ		<b>163306 ●</b>
	Scoring sawblade	150x4.4x30	36	HW	KON/WZ		<b>165555 ●</b>
	Scoring sawblade	150x4.4x30	24	HW	KON/WZ		<b>165556 ●</b>
	Scoring sawblade	150x4.3/5.1x30	24	DP	KON/FZ		<b>190565 ●</b>
	Main sawblade	350x4.4x30	72	DP	TR/TR		<b>190707 ●</b>
<b>Mayer-</b> kappa automatic 120	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut PLUS	<b>161161 ●</b>
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	<b>163387 ●</b>
	Main sawblade	400x4.4x30	72	HW	FZ/TR		<b>163421 ●</b>
	Main sawblade	400x4.4x30	60	HW	WZ		<b>163308 ●</b>
	Main sawblade	400x4.4x30	72	HW	WZ		<b>163309 ●</b>
	Scoring sawblade	150x4.4x30	36	HW	KON/WZ		<b>165555 ●</b>
	Scoring sawblade	150x4.4x30	24	HW	KON/WZ		<b>165556 ●</b>
	Scoring sawblade	150x4.3/5.1x30	24	DP	KON/FZ		<b>190565 ●</b>
	Main sawblade	400x4.4x30	72	DP	TR/TR		<b>190711 ●</b>
<b>Mayer-</b> kappa automatic 140	Main sawblade	500x5.2x30	60	HW	FZ/TR		<b>163439 ●</b>
	Main sawblade	500x5.2x30	60	HW	WZ		<b>163314 ●</b>
	Scoring sawblade	150x4.4x30	36	HW	KON/WZ		<b>165555 ●</b>
	Scoring sawblade	150x4.4x30	24	HW	KON/WZ		<b>165556 ●</b>
	Scoring sawblade	150x4.3/5.1x30	24	DP	KON/FZ		<b>190565 ●</b>



## 1. Sawing

### 1.4 Panel sizing

#### 1.4.6 Overview scoring and main sawblades

Machine-Typ	Tool Type	ABM mm	Z	QAL	ZF	System	ID
<b>Schelling-ASH</b>	Main sawblade	720x6.5x40	60	HW	FZ/TR		<b>163451 ●</b>
	Scoring sawblade	220x6.5x20	36	HW	KON/WZ		<b>165579 ●</b>
<b>Schelling-fh3</b>	Main sawblade	300x4.4x30	48	HW	WZ		<b>163300 ●</b>
	Main sawblade	300x4.4x30	60	HW	FZ/TR		<b>163400 ●</b>
	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut PLUS	<b>161137 ●</b>
	Main sawblade	300x4.4x30	60	HW	TR/TR	RazorCut	<b>163369 ●</b>
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		<b>165632 ●</b>
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		<b>190567 ●</b>
<b>Schelling-fh3 Plus package</b>	Main sawblade	350x4.4x30	54	HW	WZ		<b>163301 ●</b>
	Main sawblade	350x4.4x30	72	HW	WZ		<b>163302 ●</b>
	Main sawblade	350x4.4x30	72	HW	FZ/TR		<b>163408 ●</b>
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	<b>163379 ●</b>
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	<b>161149 ●</b>
	Main sawblade	350x4.4x30	72	DP	TR/TR		<b>190707 ●</b>
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		<b>165632 ●</b>
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		<b>190567 ●</b>
<b>Schelling-fh4 (former version)</b>	Main sawblade	350x4.4x30	54	HW	WZ		<b>163301 ●</b>
	Main sawblade	350x4.4x30	72	HW	WZ		<b>163302 ●</b>
	Main sawblade	350x4.4x30	72	HW	FZ/TR		<b>163408 ●</b>
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	<b>163379 ●</b>
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	<b>161149 ●</b>
	Main sawblade	350x4.4x30	72	DP	TR/TR		<b>190707 ●</b>
	Scoring sawblade	300x4.4x30	48	HW	KON/WZ		<b>165582 ●</b>
<b>Schelling-fh4 (new version)</b>	Main sawblade	360x4.4x30	72	HW	FZ/TR		<b>163414 ●</b>
	Main sawblade	360x4.4x30	72	HW	TR/TR	RazorCut PLUS	<b>161154 ●</b>
	Main sawblade	360x4.4x30	72	HW	TR/TR	RazorCut	<b>163382 ●</b>
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		<b>165568 ●</b>
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		<b>165569 ●</b>
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		<b>190570 ●</b>
<b>Schelling-fh5</b>	Main sawblade	400x4.4x30	60	HW	WZ		<b>163308 ●</b>
	Main sawblade	400x4.4x30	72	HW	WZ		<b>163309 ●</b>
	Main sawblade	400x4.4x30	72	HW	FZ/TR		<b>163421 ●</b>
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	<b>163387 ●</b>
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut PLUS	<b>161161 ●</b>
	Main sawblade	400x4.4x30	72	DP	TR/TR		<b>190711 ●</b>
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		<b>165568 ●</b>
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		<b>165569 ●</b>
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		<b>190570 ●</b>
<b>Schelling-fh6</b>	Main sawblade	460x4.4x30	72	HW	FZ/TR		<b>163434 ●</b>
	Main sawblade	460x4.4x30	72	HW	TR/TR	RazorCut	<b>163391 ●</b>
	Main sawblade	460x4.4x30	72	HW	TR/TR	RazorCut PLUS	<b>161170 ●</b>
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		<b>165568 ●</b>
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		<b>165569 ●</b>
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		<b>190570 ●</b>
<b>Schelling-fh8, fm8</b>	Main sawblade	520x4.4x30	72	HW	WZ		<b>163316 ●</b>
	Main sawblade	520x4.4x30	72	HW	FZ/TR		<b>163442 ●</b>
	Main sawblade	520x4.8x30	72	HW	TR/TR	RazorCut PLUS	<b>161171 ●</b>
	Scoring sawblade	200x4.4x20	24	HW	KON/WZ		<b>165568 ●</b>
	Scoring sawblade	200x4.4x20	36	HW	KON/WZ		<b>165569 ●</b>
	Scoring sawblade	200x4.8x20	36	HW	KON/WZ		<b>165573 ●</b>
	Scoring sawblade	200x4.3/5.1x20	30	DP	KON/FZ		<b>190570 ●</b>
<b>Schelling-FSM</b>	Main sawblade	720x6.5x40	60	HW	FZ/TR		<b>163451 ●</b>
<b>Schelling-FTM Option</b>	Main sawblade	680x6.2x40	60	HW	FZ/TR		<b>163449 ●</b>
	Scoring sawblade	220x6.5x20	36	HW	KON/WZ		<b>165579 ●</b>

## 1. Sawing

### 1.4 Panel sizing

#### 1.4.6 Overview scoring and main sawblades

Machine-Type	Tool Type	ABM mm	Z	QAL	ZF	System	ID
<b>Schelling-</b> s45	Main sawblade	350x4.4x30	54	HW	WZ		163301 ●
	Main sawblade	350x4.4x30	72	HW	WZ		163302 ●
	Main sawblade	350x4.4x30	72	HW	FZ/TR		163408 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	163379 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut PLUS	161149 ●
	Main sawblade	350x4.4x30	72	DP	TR/TR		190707 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●
<b>Schelling-</b> s45 Plus package	Main sawblade	400x4.4x30	60	HW	WZ		163308 ●
	Main sawblade	400x4.4x30	72	HW	WZ		163309 ●
	Main sawblade	400x4.4x30	72	HW	FZ/TR		163421 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut	163387 ●
	Main sawblade	400x4.4x30	72	HW	TR/TR	RazorCut PLUS	161161 ●
	Main sawblade	400x4.4x30	72	DP	TR/TR		190711 ●
	Scoring sawblade	180x4.4x30	30	HW	KON/FZ		165632 ●
	Scoring sawblade	180x4.3/5.1x30	30	DP	KON/FZ		190567 ●
<b>Selco-</b> EB 100	Main sawblade	360x4.4x65	72	HW	FZ/TR		163415 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
<b>Selco-</b> EB 70 (kit 80), EB 75, EB 80	Main sawblade	320x4.4x65	60	HW	TR/TR	RazorCut PLUS	161146 ●
	Main sawblade	350x4.4x30	72	HW	TR/TR	RazorCut	163379 ●
	Main sawblade	320x4.4x65	60	HW	FZ/TR		163407 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
<b>Selco-</b> EB 70 (L)	Main sawblade	300x4.4x65	60	HW	FZ/TR		163402 ●
	Main sawblade	300x4.4x65	60	HW	TR/TR	RazorCut	163372 ●
	Main sawblade	300x4.4x65	60	HW	TR/TR	RazorCut PLUS	161141 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
<b>Selco-</b> EB 90	Main sawblade	355x4.4x80	72	HW	TR/TR	RazorCut PLUS	161153 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
<b>Selco-</b> EB 95	Main sawblade	355x4.4x65	72	HW	FZ/TR		163412 ●
	Main sawblade	355x4.4x65	72	HW	TR/TR	RazorCut	163381 ●
	Main sawblade	355x4.4x65	72	HW	TR/TR	RazorCut PLUS	161152 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
<b>Selco-</b> EB 110, EB 108, EB 120, WN 125, WN 200, WN 600/132, WN 512, WN 600/145, WN 600/162	Main sawblade	400x4.4x80	72	HW	TR/TR	RazorCut PLUS	161163 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
<b>Selco-</b> EB 120, WN 125	Main sawblade	430x4.4x80	72	HW	TR/TR	RazorCut PLUS	161167 ●
	Main sawblade	430x4.4x80	72	HW	FZ/TR		163429 ●
	Scoring sawblade	200x4.4x65	36	HW	KON/WZ		165576 ●
	Scoring sawblade	200x4.3/5.1x65	30	DP	KON/FZ		190615 ●
<b>Selco-</b> WN 600/132, WN 200	Main sawblade	450x4.8x80	72	HW	FZ/TR		163433 ●
	Scoring sawblade	200x4.8x65	36	HW	KON/WZ		165577 ●
	Scoring sawblade	200x4,7/5,5x65	30	DP	KON/FZ		190574 ●
<b>Selco-</b> WN 600/145, WN 512	Main sawblade	480x4.8x80	72	HW	FZ/TR		163438 ●
	Scoring sawblade	200x4.8x65	36	HW	KON/WZ		165577 ●
	Scoring sawblade	200x4,7/5,5x65	30	DP	KON/FZ		190574 ●

## 1. Sawing

### 1.4 Panel sizing

#### 1.4.7 Circular sawblades for floor production



#### Middle cuts

##### Application:

For cutting of panels along grain for floor production.

##### Machine:

Multi blade saws.

##### Workpiece material:

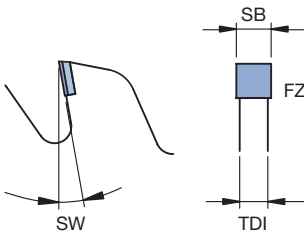
Chipboard and fibre materials paper and plastic coated, veneered.

##### Technical information:

DP tipping for long tool life. Circular sawblades BO = 115 mm for Hydro-Duo sleeve ID **030555** or BO = 110 mm for clamping flange TR 810 0. Tip height 5.5 mm. Tool body coated for higher running performance.



DP

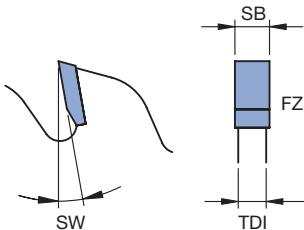


##### Circular sawblade DP tipped

WK 800 2

Machine	D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm	mm			°		
Paul	210	2.2	1.6	100	4/7/120	13/109	36	FZ	3	■ ■	<b>190676</b> □
Paul	210	2.2	1.6	115	8/7/131		36	FZ	3	■ ■	<b>190677</b> □
Homag	250	2.0	1.6	100	3/18/150		48	FZ	3	■ ■	<b>190678</b> □
Paul	250	2.0	1.6	100	4/7/140	13/109	48	FZ	3	■ ■	<b>190679</b> □
Paul	250	2.0	1.6	115	8/7/131		48	FZ	3	■ ■	<b>190680</b> □
Homag	250	2.2	1.6	100	3/18/150		36	FZ	3	■ ■	<b>190681</b> □
Paul	250	2.2	1.6	100	4/7/140	13/109	36	FZ	3	■ ■	<b>190682</b> □
Homag	250	2.2	1.6	100	3/18/150		48	FZ	3	■ ■	<b>190684</b> □
Paul	250	2.2	1.6	100	4/7/140	13/109	48	FZ	3	■ ■	<b>190685</b> □
Paul	250	2.2	1.6	115	8/7/131		36	FZ	3	■ ■	<b>190683</b> □
Paul	250	2.2	1.6	115	8/7/131		48	FZ	3	■ ■	<b>190686</b> □

HW



##### Circular sawblade TC tipped

WK 800 2

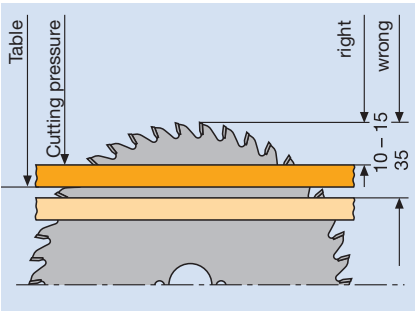
D	SB	TDI	BO	NLA	DKN	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm	mm			°		
250	3.2	2.2	100	4/7/140	13/109	48	FZ	10	■ ■	<b>061434</b> ●

# 1. Sawing

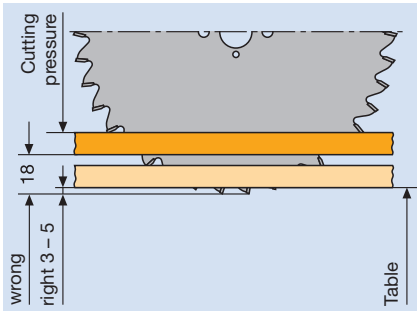
## 1.5 Cutting non-ferrous metals and plastics

<b>Working process</b>	For splitting, mitre cutting and sizing. Spray lubrication recommended when machining non-ferrous metal profiles.
<b>Workpiece materials</b>	Non-ferrous and plastic profiles, composites, insulating material and aluminium compound materials.
<b>Machines</b>	Splitting, trimming, mitre joint, double cross cutting and sizing machines.

### Application



**Positive cutting angle:**  
The positive cutting angle presses the workpiece onto the table.  
For circular sawblades with the tooth shape FZ/TR and the spindle below the workpiece for cross and mitre cutting with material thickness > 2.5 mm.



**Negative cutting angle:**  
The negative cutting angle presses the workpiece onto the table.  
For circular sawblades with the tooth shape FZ/TR and the spindle above the workpieces for cross and mitre cutting with material thickness < 2.5 mm.

### Tooth shape



**FZ/TR (square/trapezoidal teeth):**  
Tooth shape for non-ferrous metals and plastic profiles and boards.



**TR/TR (trapezoidal/trapezoidal teeth):**  
Tooth shape for better cutting quality with non-ferrous and plastic profiles.  
If altered from the standard FZ/TR shape.



## Cross and mitre cuts

### Application:

For trimming and mitre cuts - positioning of sawblade under the workpiece.

### Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

### Workpiece material:

Non-ferrous metal or plastic profiles.

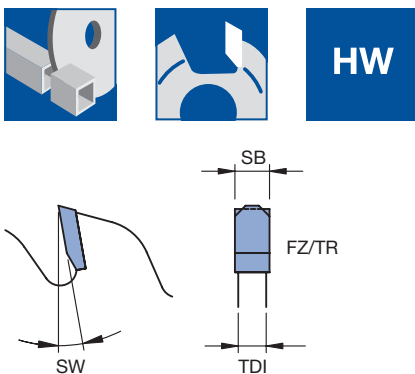
### Technical information:

Spray lubrication recommended when processing non-ferrous metal profiles.

### Circular sawblade FZ/TR cutting angle 5°

WK 452 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
Elumatec	280	3.2	2.6	32		96	FZ/TR 5		●	165725 ●
	300	3.2	2.6	30	KNL	72	FZ/TR 5		●	165726 ●
	300	3.2	2.6	30	KNL	96	FZ/TR 5		●	165727 ●
Rapid	320	3.2	2.6	30	KNL	84	FZ/TR 5		●	165728 ●
	350	3.4	2.8	30	KNL	84	FZ/TR 5		●	165729 ●
Rapid	350	3.2	2.6	30	KNL	108	FZ/TR 5		●	165730 ●
Emmegi	350	3.2	2.6	32	2/11/63	84	FZ/TR 5		●	165731 ●
					KNL					
Rapid	370	3.8	3.2	30	KNL	96	FZ/TR 5		●	165732 ●
Rapid	400	3.8	3.2	30	KNL	96	FZ/TR 5		●	165733 ●
Emmegi	400	3.8	3.2	32	2/11/63	96	FZ/TR 5		●	165734 □
Kaltenbach	400	3.8	3.2	50	4/15/80	96	FZ/TR 5		●	165735 □
Rapid, Elumatec	420	3.8	3.2	30	KNL	96	FZ/TR 5		●	165736 ●
	430	3.5	2.8	30	KNL	96	FZ/TR 5		●	165737 ●
	450	3.8	3.2	30	2/11/63	110	FZ/TR 5		●	165738 ●
					KNL					
Emmegi	450	3.8	3.2	32	2/11/63	96	FZ/TR 5		●	165739 ●
					KNL					
Rapid, Elumatec	500	4.4	3.8	30	KNL	120	FZ/TR 5		●	165740 ●
Emmegi	500	4.0	3.4	32	2/11/63	96	FZ/TR 5		●	165741 ●
Emmegi	500	4.0	3.4	32	2/11/63	120	FZ/TR 5		●	165742 ●
Elumatec	500	4.4	3.8	32	2/6/75	120	FZ/TR 5		●	165743 ●
					6/9.2-17.2/75					
Emmegi	550	4.0	3.4	32	2/11/63	96	FZ/TR 5		●	165744 ●
Emmegi	550	4.0	3.4	32	2/11/63	126	FZ/TR 5		●	165745 ●
Elumatec	550	4.4	3.8	30	KNL	120	FZ/TR 5		●	165746 ●
Stegmaier	600	4.6	4.0	30	2/11/63	140	FZ/TR 5		●	165747 ●
	600	5.0	4.4	32	2/11/63	132	FZ/TR 5		●	165748 ●
	650	5.0	4.4	30	2/11/63	144	FZ/TR 5		●	165749 ●



## 1. Sawing

### 1.5 Cutting non-ferrous metals and plastics

#### 1.5.1 Cross and mitre cut sawblades for profiles



#### Cross and mitre cuts *Excellent*

##### Application:

For trimming and mitre cuts - positioning of sawblade under the workpiece.

##### Machine:

Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

##### Workpiece material:

Non-ferrous metal or plastic profiles.

##### Technical information:

Spray lubrication is recommended when machining non-ferrous metal profiles.

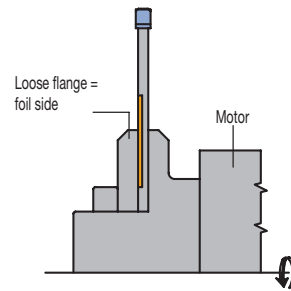
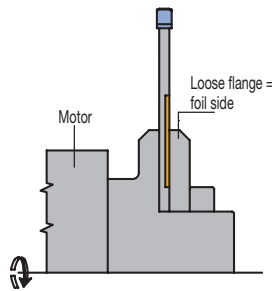
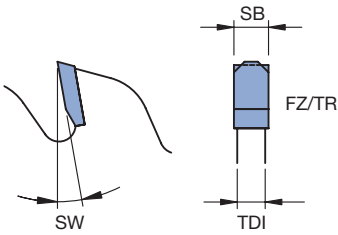
**Excellent** version. Vibration damping composite construction of the tool body by steel foil. Extreme noise reduction even with increasing dulling of the tool.



##### Circular sawblade FZ/TR cutting angle 5°

WK 472 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3.2	2.6	30	KNL	96	FZ/TR	5	left		<b>161360</b> ●
300	3.2	2.6	30	KNL	96	FZ/TR	5	right		<b>161361</b> ●
350	3.2	2.6	30	KNL	108	FZ/TR	5	left		<b>161362</b> ●
350	3.2	2.6	30	KNL	108	FZ/TR	5	right		<b>161363</b> ●







### Crossing and mitre cuts with negative cutting angle

#### Application:

For trimming and mitre cuts - positioning of workpiece under the sawblade.

#### Machine:

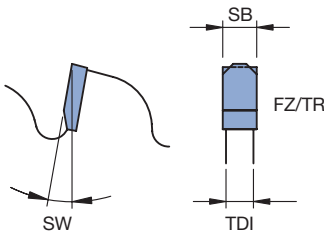
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

#### Workpiece material:

Non-ferrous metal or plastic profiles.

#### Technical information:

Spray lubrication is recommended when machining non-ferrous metal profiles. Because of the negative cutting angle, it is particularly suitable for profiles where hooking and deformation of the profiles should be avoided. Particularly suitable for cutting from above. Negative cutting angle for improved workpiece clamping.



#### Circular sawblade FZ/TR cutting angle -5°

WK 462 2

Machine	D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
	mm	mm	mm	mm	mm			°		
	300	3.2	2.6	30	KNL	72	FZ/TR	-5	■	165825 ●
Elektra Beckum, Elu, DeWalt, Fezer, Lurem, Rapid, Ulmia, Scheppach Fezer, Rapid, Ulmia	300	3.2	2.6	30	KNL	96	FZ/TR	-5	■	165826 ●
	300	3.2	2.6	30	KNL	120	FZ/TR	-5	■	165827 ●
	300	3.2	2.6	32	KNL	72	FZ/TR	-5	■	165828 □
	300	3.2	2.6	32	KNL	96	FZ/TR	-5	■	165829 □
	300	3.2	2.6	32	KNL	120	FZ/TR	-5	■	165830 □
Haffner	330	3.2	2.6	30	KNL	96	FZ/TR	-5	■	165831 ●
	330	3.2	2.6	32	KNL	96	FZ/TR	-5	■	165832 □
Haffner	350	3.4	2.8	30	KNL	84	FZ/TR	-5	■	165833 ●
	350	3.8	3.2	30	KNL	84	FZ/TR	-5	■	165834 ●
	350	3.8	3.2	32	KNL	84	FZ/TR	-5	■	165835 □
	350	3.8	3.2	40	2/10/55	84	FZ/TR	-5	■	165836 □
					2/11/63					
					KNL					
Haffner, Ulmia	350	3.2	2.6	30	KNL	108	FZ/TR	-5	■	165837 ●
Eisele, Graule	350	3.6	3.0	40	2/9/55	108	FZ/TR	-5	■	165838 ●
					4/12/64					
Elumatec	380	3.8	3.2	32		108	FZ/TR	-5	■	165839 ●
	400	3.8	3.2	30	KNL	96	FZ/TR	-5	■	165840 ●
	400	3.8	3.2	32	2/11/63	96	FZ/TR	-5	■	165841 ●
Eisele	400	3.8	3.2	40	2/12/80	96	FZ/TR	-5	■	165842 □
					4/12/64					
Kaltenbach	400	3.8	3.2	50	4/15/80	96	FZ/TR	-5	■	165843 □
Elumatec, Rapid, Haffner, Wegoma, Ulmia	420	3.8	3.2	30	KNL	108	FZ/TR	-5	■	165844 ●
Graule	420	3.8	3.2	40		108	FZ/TR	-5	■	165845 □
Rapid	450	3.8	3.2	30	KNL	108	FZ/TR	-5	■	165846 ●
Pressta Eisele	450	3.8	3.2	32	2/11/63	108	FZ/TR	-5	■	165847 ●
					KNL					
Elu, Wegoma, Rapid	500	4.4	3.8	30	2/11/63	120	FZ/TR	-5	■	165848 ●
					6/9/100					
Graule	520	4.4	3.8	50		120	FZ/TR	-5	■	165849 ●
Rapid	550	4.0	3.4	30	KNL	132	FZ/TR	-5	■	165850 ●
	550	4.0	3.4	32	2/11/63	132	FZ/TR	-5	■	165851 □
Stürtz	600	5.2	4.6	30	KNL	138	FZ/TR	-5	■	165852 ●



## 1. Sawing

### 1.5 Cutting non-ferrous metals and plastics

#### 1.5.1 Cross and mitre cut sawblades for profiles



### Crossing and mitre cuts with negative cutting angle

#### Excellent

#### Application:

For trimming and mitre cuts - positioning of workpiece under the sawblade.

#### Machine:

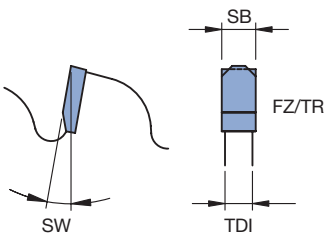
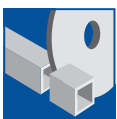
Cross, trimming, mitre and radial saws as well as double mitre cutting saws and CNC machining centres.

#### Workpiece material:

Non-ferrous metal or plastic profiles.

#### Technical information:

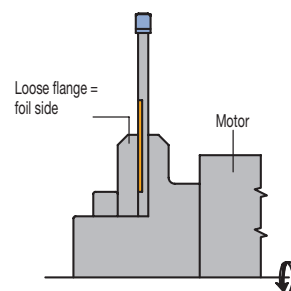
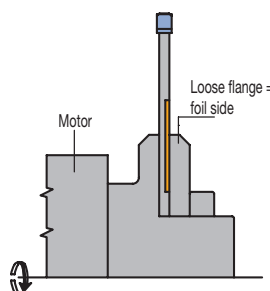
Spray lubrication is recommended when machining profiles made of non-ferrous metal. Negative cutting angle makes it particularly suitable for profiles where hooking and deformation of the profiles are to be avoided. Particularly suitable for cutting from above. Negative rake angle for improved workpiece clamping. **Excellent** version. Vibration damping composite construction of the support body by steel foil. Extreme noise reduction even with increasing dulling of the tool.



#### Circular sawblade FZ/TR cutting angle -5°

WK 482 2

D	SB	TDI	BO	NLA	Z	ZF	SW	Foil	WSS	ID
mm	mm	mm	mm	mm			°			
300	3.2	2.6	30	KNL	96	FZ/TR	-5	left		161380 ●
300	3.2	2.6	30	KNL	96	FZ/TR	-5	right		161381 ●
350	3.2	2.6	30	KNL	108	FZ/TR	-5	left		161382 ●
350	3.2	2.6	30	KNL	108	FZ/TR	-5	right		161383 ●





### Cross and mitre cuts with reduced cutting width *Premium*

#### Application:

For trimming and sizing.

#### Machine:

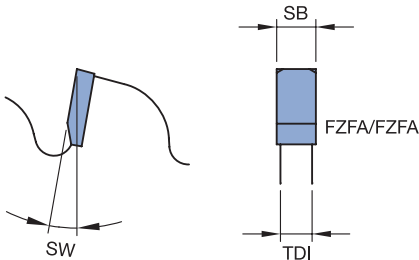
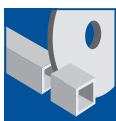
Cross, trimming, mitre and portable saws.

#### Workpiece material:

Thin walled, non-ferrous metal or plastic profiles, plastic honeycomb boards, fibre reinforced plastics (e.g. GFRP, CFRP), plastic wave boards (e.g. PVC).

#### Technical information:

Due to reduced cutting width and high number of teeth, especially suitable for thin-walled profiles (wall thickness < 2 mm) and thin panels. Negative cutting angle for smoother running. Special coating of the tool body for less adhesions.



#### Circular sawblade FZFA cutting angle -5°

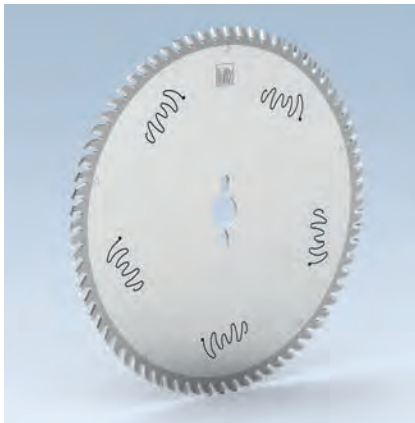
WK 467 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
190	1.8	1.4	20		72	FZFA/FZFA	-5		060278 ●
200	1.8	1.4	20	KNL	80	FZFA/FZFA	-5		060274 ●
250	2.0	1.6	30	KNL	100	FZFA/FZFA	-5		060275 ●
300	2.2	1.8	30	KNL	120	FZFA/FZFA	-5		060276 ●
350	2.4	2.0	30	KNL	140	FZFA/FZFA	-5		060279 ●

## 1. Sawing

### 1.5 Cutting non-ferrous metals and plastics

#### 1.5.1 Cross and mitre cut sawblades for profiles



#### Cross and mitre cuts in finish cut quality *Excellent* - GlossCut

##### Application:

For trimming and mitre cutting.

##### Machine:

Cross, trimming, mitre and cross cutting twin saws.

##### Workpiece material:

Non-ferrous metal or plastic profiles, coated and lacquered.

##### Technical information:

Special design of the cutting area for low-groove and low-burr cutting areas and tear-free cutting edges. **Excellent** version with filled laser ornaments for vibration damping and reduction of noise levels.

##### Circular sawblade GlossCut

WK 377 2

D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm	mm				
300	3.0	2.4	30	KNL	72	FZFA/FZFA		161005 ●
300	3.0	2.4	30	KNL	96	FZFA/FZFA		161006 ●
350	3.5	2.8	30	KNL	96	FZFA/FZFA		161007 ●

Further GlossCut dimensions suitable for portable and semi-stationary machines - see section Portable Saws and Table-Top Machines.



#### Cross and mitre cuts in finish cut quality *Excellent*

##### Application:

For trimming and mitre cutting.

##### Machine:

Cross, trimming, mitre and cross cutting twin saws.

##### Workpiece material:

Plastic profiles of windows with seals, plastic hollow wall profiles, fibre reinforced plastics.

##### Technical information:

Special tooth geometry for tear-free cutting edges on the entry and exit side as well as perfect, tear-free cutting of the rubber seal. DP tipping for long tool life even when used in fibre-reinforced profiles.

##### Circular sawblade HRFA cutting angle 5°, Diamaster PRO

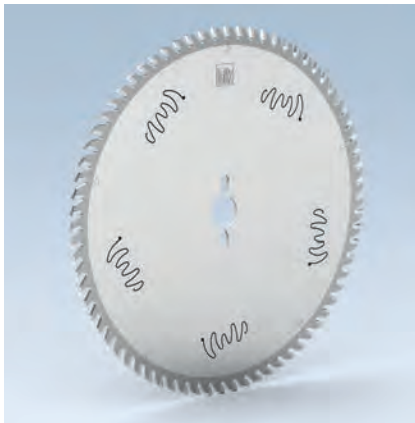
WK 808 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	4.4	3.6	30	KNL	60	HRFA	5		190666 □
350	4.4	3.6	30	KNL	70	HRFA	5		190667 □
400	4.4	3.6	30	KNL	80	HRFA	5		762339 □
450	4.4	3.6	30	KNL	90	HRFA	5		190668 □
500	4.4	3.6	30	KNL	100	HRFA	5		762341 □
550	4.4	3.6	30	KNL	110	HRFA	5		762342 □
600	4.8	4.0	30	KNL	120	HRFA	5		762343 □

## 1. Sawing

### 1.5 Cutting non-ferrous metals and plastics

#### 1.5.2 Circular sawblades für solid panels and blocks



#### Sizing in finish cut quality *Excellent* - BrillianceCut

##### Application:

For panel sizing of single boards and stacks of boards without scoring.

##### Machine:

Table and sizing saws, vertical panel sizing saws, panel sizing saws with pressure beam.

##### Workpiece material:

Transparent thermoplastics (e.g. PMMA, PC), solid surface materials (e.g. Corian).

##### Technical information:

Special tooth geometry for very smooth cutting surfaces and tear-free cutting edges. Recommended sawblade projection 5 - 10 mm. **Excellent** version with filled laser ornaments for vibration damping and reduction of noise level. Version with positive cutting angle.

##### Circular sawblade BrillianceCut

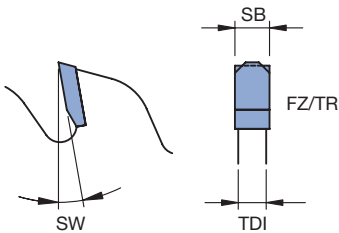
WK 371 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	WSS	ID
	303	3.5	2.5	30	KNL	60	TR/TR		<b>161028 ●</b>
Holz-Her, Mayer, Schelling	350	4.4	3.2	30	2/13/94 KNL	72	WZ/FA		<b>161029 ●</b>
Homag	350	4.4	3.2	60	2/14/100	72	WZ/FA		<b>161030 ●</b>
Homag	380	4.8	3.5	60	2/14/100 2/14/125 2/19/120	84	WZ/FA		<b>161031 ●</b>
Mayer, Schelling	400	4.4	3.2	30	2/13/94 KNL	72	WZ/FA		<b>161032 ●</b>
Mayer, Schelling	450	4.4	3.2	30	2/13/94 KNL	72	WZ/FA		<b>161033 ●</b>
Homag	450	4.8	3.5	60	2/14/125 2/19/120	72	WZ/FA		<b>161034 ●</b>

## 1. Sawing

### 1.5 Cutting non-ferrous metals and plastics

#### 1.5.2 Circular sawblades für solid panels and blocks



#### Sizing in easy melting plastics

##### Application:

For sizing and cross cutting without scoring.

##### Machine:

Table and sizing saws, vertical panel sizing saws, panel sizing saws with pressure beam.

##### Workpiece material:

Easy melting plastics (e.g. PP, PA).

##### Technical information:

Reduced number of teeth for lower heat generation as well as lower feed forces and lower power consumption even at large cutting depths. Tooth shape for cutting pitch and reduction of heat generation. Large chip spaces for optimum chip transport. Circular saw blade with suitable number of teeth must be selected depending on the material thickness. Low number of teeth for large workpiece thicknesses.

##### Circular sawblade FZ/TR, cutting angle 10°

WK 372 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
300	3.6	2.2	30	KNL	20	FZ/TR	10	■	163500 ●
300	3.6	2.2	30	KNL	42	FZ/TR	10	■	163501 ●
350	3.8	2.5	30	KNL	24	FZ/TR	10	■	163502 ●
350	3.8	2.5	30	KNL	48	FZ/TR	10	■	163503 ●
400	3.8	2.5	30	KNL	28	FZ/TR	10	■	163504 ●
400	3.8	2.5	30	KNL	54	FZ/TR	10	■	163505 ●
450	4.0	2.8	30	KNL	34	FZ/TR	10	■	163506 ●
500	4.4	3.0	30	KNL	36	FZ/TR	10	■	163507 ●



## Sizing non-ferrous solid material

### Application:

For panel sizing of single boards and stacks of boards without scoring.

### Machine:

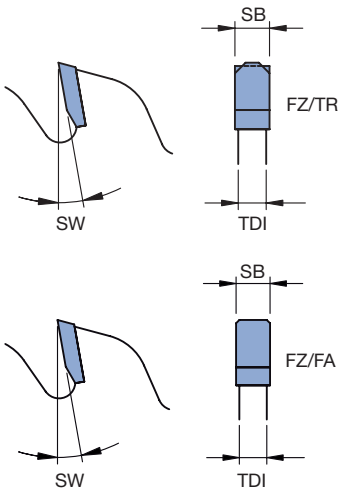
Panel sizing saws with pressure beam.

### Workpiece material:

Solid non-ferrous metals (e.g. aluminium or brass panels).

### Technical information:

Special cutting geometry for smooth cutting surfaces. Spray lubrication recommended. Reduced number of teeth and large gullet areas for higher feed speeds with the same power consumption.



### Circular sawblade FZ/TR und FZFA, cutting angle 10°

WK 452 2, WK 457 2, WK 472 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Z	ZF	SW °	WSS	ID
Schelling	350	3.8	3.0	30	KNL	48	FZFA/FZFA	10	■ ■	165925 ●
					2/13/94					
Mayer	400	4.4	3.5	30	KNL	60	FZFA/FZFA	10	■ ■	165926 ●
Mayer, Schelling	450	4.4	3.5	30	KNL	60	FZ/TR	10	■ ■	165927 ●
					2/13/94					
					2/13/114					
Schelling	460	4.4	3.5	30	2/13/94	48	FZFA/FZFA	10	■ ■	165928 ●
					2/13/114					
Schelling	520	4.4	3.5	30	2/13/94	44	FZFA/FZFA	10	■ ■	165929 ●
					2/13/114					
Schelling	530	4.4	3.5	30	2/13/94	44	FZFA/FZFA	10	■ ■	165930 ●
					2/13/114					
Mayer	570	5.0	4.0	40	2/16/80	48	FZFA/FZFA	10	■ ■	165931 ●
Schelling	620	5.5	4.5	40	2/13/140	36	FZFA/FZFA	10	■ ■	165932 ●
					2/13/114					
Schelling	620	5.5	4.5	40	2/13/140	60	FZ/TR	10	■ ■	165933 ●
					2/13/114					
Schelling	680	5.5	4.5	40	2/13/140	42	FZFA/FZFA	10	■ ■	165934 ●
					2/13/114					

## 1. Sawing

### 1.5 Cutting non-ferrous metals and plastics

#### 1.5.2 Circular sawblades für solid panels and blocks



#### Sizing *Excellent*

##### Application:

For sizing of single boards.

##### Machine:

Table, sizing and vertical panel sizing saws.

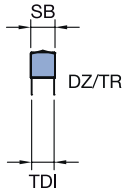
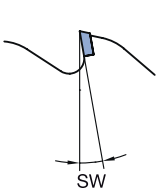
##### Workpiece material:

Gypsum and cement fibre panels, duroplastics (compact laminated boards, e.g. HPL), fibre reinforced plastics (e.g. GFRP, CFRP), alu composite panels (e.g. Alucobond®). Chipboard and fibre materials plastic coated.

##### Technical information:

DP tipping and strong tooth shape for long tool life even in highly abrasive materials.

**Excellent** design with filled laser ornaments for vibration damping and noise reduction. Tool body coated for higher running performance.



#### Circular sawblade DZ/TR, Diamaster PRO



WK 872 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
180	3.2	2.2	30		36	DZ/TR	10		<b>190747 •</b>
250	3.2	2.2	30	KNL	48	DZ/TR	10		<b>190748 •</b>
303	3.2	2.2	30	KNL	60	DZ/TR	10		<b>190673 •</b>
303	3.2	2.2	30	KNL	96	DZ/TR	10		<b>190674 •</b>
350	3.5	2.5	30	KNL	72	DZ/TR	10		<b>190749 •</b>



## 1. Sawing

### 1.6 Circular sawblades for CNC

<b>Working process</b>	For sizing, separating and trimming cut.		
<b>Workpiece materials</b>	Solid wood, wood derived materials, plastics.		
<b>Machines</b>	CNC machining centres and aggregates.		
<b>Tooth shape</b>	 	<p>WZ/WZ/FZ (alternative/square teeth): Tooth shape for solid wood, glulam and coated or veneered wood derived materials; tear-free cutting edges and high cut quality. Combinations of tooth forms (WZri, WZle, WZri, WZle, FZ).</p>	

## 1. Sawing

### 1.6 Circular sawblades for CNC 1.6.1 Trimming and sizing sawblades



#### Trimming and sizing on CNC machining centres

##### Application:

For sizing of panels on CNC machining centres.

##### Machine:

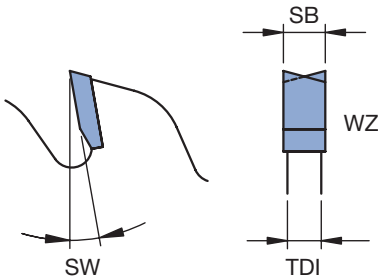
Processing units on CNC machining centres.

##### Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), solid wood panels across and along grain and for mitre joints.

##### Technical information:

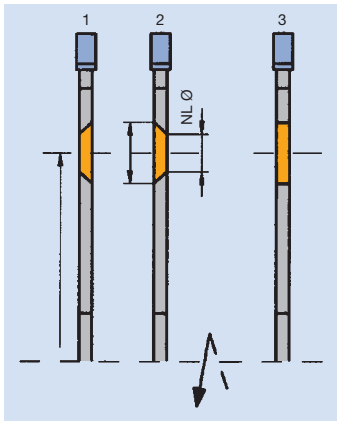
Suitable for mounting on saw flanges of machining units. Balancing quality adapted for use on CNC units. Universal dimensions, among other things, for large cutting depths and cuts.



##### Circular sawblade WZ for CNC

WK 150 2, WK 850 2

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
350	3.6	2.5	30	8/6/90	1	16	WZ	15		165975 •
				6/6.8/90						
350	3.5	2.7	30	8/6/90	1	72	WZ	15		165976 •
				6/6.8/90						



##### Type 1:

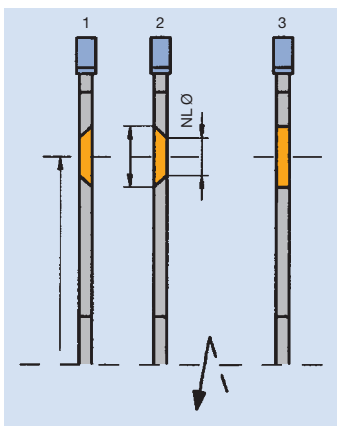
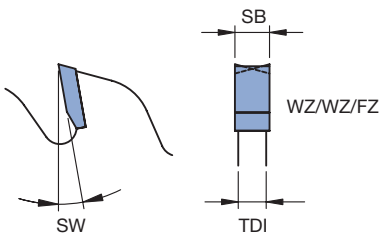
Countersink right

##### Type 2:

Countersink left

##### Type 3:

Pinhole without countersink

**Type 1:**

Countersink right

**Type 2:**

Countersink left

**Type 3:**

Pinhole without countersink

**Trimming and sizing on CNC machining centres**  
**Excellent - Katana****Application:**

For sizing of panels on CNC machining centres.

**Machine:**

Processing units on CNC machining centres.

**Workpiece material:**

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), solid wood panels across grain and for mitre joints.

**Technical information:**

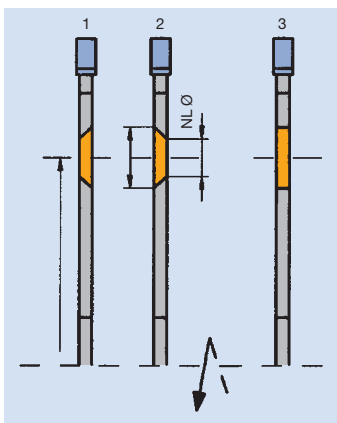
Katana tooth combination with alternating rake face bevel for highest cutting quality. High number of teeth for perfect edges and very smooth surfaces. Very well suited for mitre cuts in coated wood materials.

Recommendation for use: When sizing coated wood-derived materials, for best cutting quality, first scribe with a small infeed (1 - 2 mm) in the same direction and then cut in the opposite direction.

Suitable for mounting on saw flanges of machining units. Balancing quality adapted for use on CNC aggregates. **Excellent** design with filled laser ornaments for vibration damping and reduction of noise level.**Circular sawblade Katana for CNC**

WK 879 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Type Z	ZF	SW °	WSS	ID
	180	3.0	2.2	30			60 WZ/WZ/FZ	10	■	161267 ●
Homag, Weeke	180	3.0	2.2	30	2/7/42	3	60 WZ/WZ/FZ	10	■	161250 ●
					4/5.5/45	2				
					8/6/90	1				
Flex 5, Flex 5+	180	3.0	2.2	40	8/6.6/52	2	60 WZ/WZ/FZ	10	■	161251 ●
Homag, IMA	200	3.0	2.2	30	2/7/42	3	65 WZ/WZ/FZ	10	■	161253 ●
					4/6/52	2				
					8/6/90	1				
IMA	200	3.0	2.2	30	2/7/42	3	65 WZ/WZ/FZ	10	■	161254 ●
					4/6.6/60	2				
	220	3.0	2.2	30	8/6/90	1	70 WZ/WZ/FZ	10	■	161255 ●
					8/6/70					
Flex 5, Flex 5+, Homag, Weeke	220	3.0	2.2	40	8/6.6/52	2	70 WZ/WZ/FZ	10	■	161256 ●
	240	3.0	2.2	30			75 WZ/WZ/FZ	10	■	161268 ●
	240	3.0	2.2	30	4/6.6/52	1	75 WZ/WZ/FZ	10	■	161257 ●
					4/6.6/52	2				
					8/6/90	1				
Flex 5, Flex 5+, Weeke, Homag	240	3.0	2.2	40	8/6.6/52	2	75 WZ/WZ/FZ	10	■	161258 ●
Biesse, Holz-Her	250	3.0	2.2	30	2/7/42	3	80 WZ/WZ/FZ	10	■	161259 ●
					2/6/50	3				
					8/6/90	1				
Homag, Felder	280	3.0	2.2	30	2/7/42	3	85 WZ/WZ/FZ	10	■	161260 ●
Format-4					8/6/90	1				
Biesse	300	3.0	2.2	50	1/6/80	3	100 WZ/WZ/FZ	10	■	161266 ●
					6/5.5/80	3				
Homag	350	3.5	2.7	30	8/6/90	1	110 WZ/WZ/FZ	10	■	161263 ●



#### Type 1:

Countersink right

#### Type 2:

Countersink left

#### Type 3:

Pinhole without countersink

## Trimming and sizing on CNC machining centres

### Excellent - WhisperCut

#### Application:

For sizing of panels on CNC machining centres.

#### Machine:

Processing units on CNC machining centres.

#### Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), solid wood panels across grain and for mitre joints.

#### Technical information:

Extreme noise reduction. Specially developed group serration for perfect cutting pitch and reduction of cutting forces. High tool life due to stable tooth geometry and DP tipping. Universally applicable for a wide range of materials.

Recommendation for use: When sizing coated wood derived materials, for best cutting quality, first scribe with feed at low infeed (1 - 2 mm) and then cut in counter-rotation.

Suitable for mounting on saw flanges of machining units. Balancing quality adapted for use on CNC units. Can be resharpened 2 times. **Excellent** design with filled laser ornaments for vibration damping and reduction of noise level.

#### Circular sawblade WhisperCut for CNC

WK 879 2, WK 879 2 DP

D	SB	TDI	BO	NLA	Type	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm				°		
160	2.5	2.0	20			30	HZFA/WZFA	10		190751 ●
180	2.5	2.0	30	8/6/90	1	35	HZFA/WZFA	10		190713 ●
				2/7/42	3					
				4/6/45	2					
180	2.5	2.0	40	8/6.6/52	2	35	HZFA/WZFA	10		190714 ●
200	2.5	2.0	30	2/7/42	3	40	HZFA/WZFA	10		190715 ●
				4/6/52	2					
				8/6/90	1					
200	2.5	2.0	30	2/7/42	3	40	HZFA/WZFA	10		190716 ●
				4/6.6/60	2					
220	2.5	2.0	30	8/6/90	1	45	HZFA/WZFA	10		190717 ●
220	2.5	2.0	40	8/6.6/52	2	45	HZFA/WZFA	10		190718 ●
240	2.5	2.0	30	4/6.6/52	1	50	HZFA/WZFA	10		190719 ●
				4/6.6/52	2					
				8/6/90	1					
240	2.5	2.0	40	8/6.6/52	2	50	HZFA/WZFA	10		190720 ●
250	2.5	2.0	30	2/7/42	3	50	HZFA/WZFA	10		190721 ●
				2/6/50	3					
				8/6/90	1					
280	2.5	2.0	30	2/7/42	3	55	HZFA/WZFA	10		190722 ●
				8/6/90	1					
303	3.2	2.4	30	KNL	3	60	HZFA/WZFA	10		190728 □
				8/6/90	1					
350	3.2	2.4	30	KNL	3	70	HZFA/WZFA	10		190729 □
				8/6/90	1					

## 1. Sawing

### 1.6 Circular sawblades for CNC

#### 1.6.2 Grooving sawblades



#### Grooving on CNC machining centres

##### Application:

For grooving.

##### Machine:

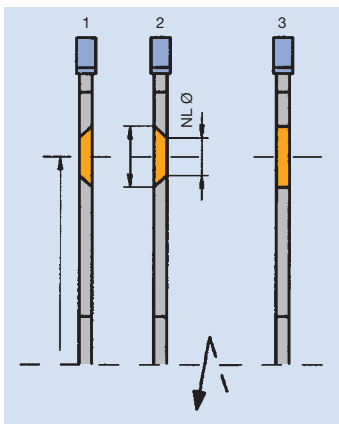
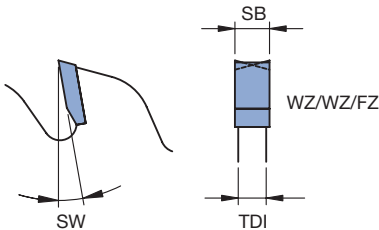
Processing units on CNC machining centres.

##### Workpiece material:

Chipboard and fibre materials paper and plastic coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood).

##### Technical information:

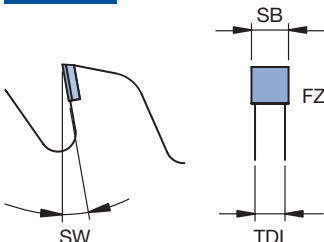
Due to special tooth combination and high number of teeth suitable for tear-free grooves in any coatings. Mounting on saw flange of machining units. Use with feed recommended for best machining quality.



**Type 1:** Countersink right

**Type 2:** Countersink left

**Type 3:** Pinhole without countersink



#### Grooving circular sawblade WZ/WZ/FZ for CNC, TC tipped

WK 859 2

Machine	D mm	SB mm	TDI mm	BO mm	NLA mm	Type Z	ZF	SW °	WSS	ID
	100	3.5	2.5	20		35	WZ/WZ/FZ	15	■	166014 ●
Homag, Weeke	100	3.5	2.5	30		35	WZ/WZ/FZ	15	■	166000 ●
	100	4.0	2.8	20		35	WZ/WZ/FZ	15	■	166015 ●
Homag, Weeke	100	4.0	2.8	30		35	WZ/WZ/FZ	15	■	166008 ●
	100	5.0	3.5	20		35	WZ/WZ/FZ	15	■	166016 ●
Homag, Weeke	100	5.0	3.5	30		35	WZ/WZ/FZ	15	■	166001 ●
	100	8.5	3.5	20		35	WZ/WZ/FZ	15	■	166013 ●
Homag	100	8.5	3.5	30	4/5,5/48 1	35	WZ/WZ/FZ	15	■	166017 ●
					4/5,5/48 2					
SCM, Morbi-	120	3.5	2.5	20	3/4,5/35 1	35	WZ/WZ/FZ	15	■	166002 ●
delli, Holz-Her					3/4,5/35 2					
Biesse, Felder	120	3.5	2.5	35	4/6,3/50 1	35	WZ/WZ/FZ	15	■	166004 ●
					4/6,3/50 2					
SCM, Morbi-	120	4.0	2.8	20	3/4,5/35 1	35	WZ/WZ/FZ	15	■	166009 ●
delli, Holz-Her					3/4,5/35 2					
Biesse, Felder	120	4.0	2.8	35	4/6,3/50 1	35	WZ/WZ/FZ	15	■	166010 ●
					4/6,3/50 2					
SCM, Morbi-	120	5.0	3.5	20	3/4,5/35 1	35	WZ/WZ/FZ	15	■	166003 ●
delli, Holz-Her					3/4,5/35 2					
Biesse, Felder	120	5.0	3.5	35	4/6,3/50 1	35	WZ/WZ/FZ	15	■	166005 ●
					4/6,3/50 2					
Homag, Weeke	125	3.5	2.5	30	4/5,5/48 1	35	WZ/WZ/FZ	15	■	166006 ●
					4/5,5/48 2					
Homag, Weeke	125	4.0	2.8	30	4/5,5/48 1	35	WZ/WZ/FZ	15	■	166011 ●
					4/5,5/48 2					
Homag, Weeke	125	5.0	3.5	30	4/5,5/48 1	35	WZ/WZ/FZ	15	■	166007 ●
					4/5,5/48 2					
Homag	200	5.0	3.5	30	4/5,5/52 1	60	WZ/WZ/FZ	15	■	166012 ●
					4/5,5/52 2					

##### Technical information:

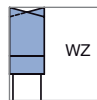
Mounting on saw flange of machining units. Use with feed recommended for tear-free grooves. DP mounting for long tool life.

#### Grooving circular sawblade FZ for CNC, DP tipped

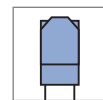
WK 800 2 DP

D mm	SB mm	TDI mm	BO mm	Z	ZF	QAL	SW °	WSS	ID
100	4.0	2.5	20	12	FZ	DP	10	■	192303 ●

<b>Working process</b>	For sizing, trimming and splitting.
<b>Workpiece materials</b>	Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), without coat-ing, with plastic coating, with veneer, glulam, plywood, duroplastics, thermo-plastics, solid surface materials (Corian, Varicor etc.), compound materials (HPL, Tres-pa etc.), non-ferrous metals (aluminium, copper etc.).
<b>Machines</b>	Portable saws, trimming, mitre-joint machines, table saws and radial arm cross cut, light sizing saws.
<b>Types of application</b>	For cutting along and across grain, trimming and mitre cut.

**Tooth shapes**

WZ (alternative top bevel teeth)



FZ/TR (square/trapezoidal teeth)

Teeth shape	Machine	Area of application
Square teeth	Portable saws	Solid wood along and across the grain, glued materials.
Alternative top bevel teeth – positive	Pull push saw, table and radial arm cross cut saws, light sizing saws.	Uncoated, plastic coated, veneered wood derived materials. Plywood, multiplex plywood. Composite/laminated materials.
Alternative top bevel teeth – negative	Trimming-, pull push saw, table saws and radial arm cross cut saws.	Solid wood across grain. Plastic hollow wall profiles. Non-ferrous metals – extruded profiles and pipes.
Flat/trapezoidal teeth – positive	Portable saws, pull push saw, table saws and radial arm cross cut saws, light sizing saws.	Uncoated wood derived materials, plastic coated, veneered. Non-ferrous metals – extruded profiles and pipes. NE-metals. Al-PU sandwich panels. Plastic hollow wall profiles. Plastic polymers (Corian, Varicor etc.).
Flat/trapezoidal teeth – negative	Portable saws, trimming-, mitre saws, table saws and radial arm cross cut saws.	Non-ferrous metals – extruded profiles/pipes. Plastic hollow wall profiles. Al-PU sandwich panels.
Alternative flat tooth with bevel	Portable saws, trimming-, mitre saws, table saws and radial arm cross cut saws, light sizing saws.	Flat and angle steel, steel plates, pipes, profiles, sandwich panels, composite materials.

**Tooth pitch/cut quality**

The saw cut quality is determined by the correct choice of the tooth shape and by the distance between the teeth. The distance between the teeth is determined by the tooth pitch.

Number of teeth	Tooth pitch	Cut quality
Low	~ 25 – 50 mm	For coarse cuts.
Medium	~ 14 – 25 mm	For good cutting quality.
High	~ 9 – 14 mm	For clean cuts to a very high quality.

## 1. Sawing

### 1.7 Portable saws and table-top machines

#### 1.7.1 Circular sawblades WZ



#### Universal sizing - AccuCut

##### Application:

For cross-cut and sizing.

##### Machine:

Accu-portable sawblades.

##### Workpiece material:

Solid wood lengthwise and crosswise as well as glued, chipboard and fibre materials raw, plastic- and paper-coated, veneered, laminated wood (e.g. plywood, multiplex).

##### Technical information:

Long battery life due to thin kerf, cutting force-reduced cutting geometry and innovative tooth pitch. Very good cutting quality due to high number of teeth.

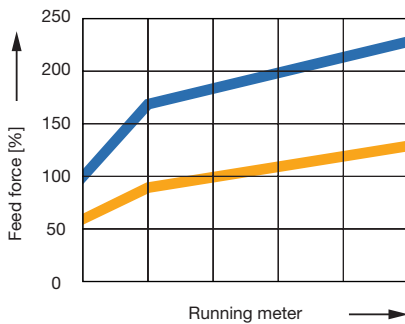


#### Circular sawblade AccuCut

WK 879 2

D	SB	TDI	BO	Z	ZF	SW	WSS	ID
mm	mm	mm	mm			°		
140	1.8	1.2	20	35	WZ/WZ/WZ/FZ	10		<b>166623</b> ●
160	1.8	1.2	20	42	WZ/WZ/WZ/FZ	10		<b>166620</b> ●
165	1.8	1.2	20	42	WZ/WZ/WZ/FZ	10		<b>166621</b> ●
190	1.8	1.2	30	42	WZ/WZ/WZ/FZ	10		<b>166622</b> ●

Comparison of feed force (MDF 38 mm)



■ Conventional circular sawblade,  
Z 48, SB 2.2 mm, WZ

■ Leitz AccuCut circular sawblade,  
Z 42, SB 1.8 mm, WZ/WZ/WZ/FZ





## Universal sizing

### Application:

For cutting along and across grain and sizing.

### Machine:

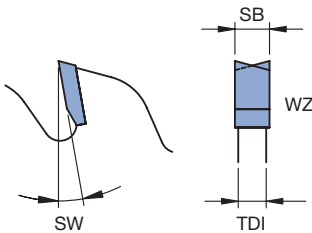
Portable and table saws.

### Workpiece material:

Solid wood along and across grain, glued. Chipboard and fibre materials, plastic and paper coated, veneered, laminated veneer lumber (e.g. plywood, multiplex plywood), duroplastics (compact laminated boards, e.g. HPL).

### Technical information:

Tooth shape for universal use.











### Circular sawblade WZ pos. cutting angle

WK 150 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
100	2.4	1.6	12		30	WZ	10		166109 ●
100	2.4	1.6	22		30	WZ	10		166110 ●
120	2.4	1.6	20		24	WZ	15		166111 ●
125	2.4	1.6	20		24	WZ	15		166112 ●
125	2.4	1.6	20		36	WZ	10		166113 ●
140	2.4	1.6	20		24	WZ	15		166114 ●
150	2.8	1.8	20		48	WZ	10		166115 ●
160	1.6	1.1	20		24	WZ	25		166100 ●
160	1.8	1.2	20		18	WZ	25		166101 ●
160	1.8	1.2	20		32	WZ	5		166102 ●
160	2.5	1.6	20		12	WZ	20		166116 ●
160	2.5	1.6	20		24	WZ	15		166117 ●
160	2.5	1.6	20		48	WZ	15		166118 ●
165	2.2	1.6	20		24	WZ	15		166119 ●
165	2.2	1.6	20		48	WZ	10		166104 ●
165	2.4	1.6	20		12	WZ	15		166103 ●
170	2.5	1.6	30		48	WZ	10		166120 ●
180	2.5	1.6	20		24	WZ	15		166121 ●
180	2.5	1.6	20		48	WZ	10		166122 ●
180	2.5	1.6	30		24	WZ	15		166123 ●
180	2.5	1.6	30		48	WZ	10		166105 ●
184	2.5	1.6	20		24	WZ	15		166124 ●
190	2.5	1.8	30		24	WZ	20		166128 ●
190	2.8	1.8	16		24	WZ	15		166125 ●
190	2.8	1.8	16		48	WZ	10		166126 ●
190	2.8	1.8	30		16	WZ	20		166127 ●
190	2.8	1.8	30		48	WZ	10		166129 ●
200	3.0	2.0	30		34	WZ	10		166130 ●
200	3.0	2.0	30		48	WZ	10		166131 ●
210	2.4	1.6	30		24	WZ	15		166133 ●
210	2.4	1.6	30		42	WZ	20		166134 ●
210	2.4	1.6	30		64	WZ	10		166135 ●
220	3.2	2.2	30		34	WZ	15		166136 ●
220	3.2	2.2	30		60	WZ	10		166107 ●
225	2.6	1.8	30		32	WZ	20		166137 ●
225	2.6	1.8	30		48	WZ	10		166138 ●
230	2.5	1.8	30		24	WZ	20		166140 ●
230	2.5	1.8	30		48	WZ	15		166108 ●
230	3.2	2.2	30		34	WZ	15		166141 ●
235	2.5	1.8	30		12	WZ	15		166158 ●
235	2.5	1.8	30		24	WZ	15		166156 ●
235	2.5	1.8	30		56	WZ	15		166157 ●
235	3.2	2.2	30		24	WZ	15		166142 ●
235	3.2	2.2	30		34	WZ	15		166143 ●
240	3.0	2.0	30		34	WZ	15		166144 ●
240	3.0	1.8	30		48	WZ	10		166145 ●
250	2.8	2.0	30	KNL	24	WZ	25		166146 ●
250	2.8	2.0	30	KNL	60	WZ	20		166147 ●



## 1.7.1 Circular sawblades WZ

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
260	3.2	2.2	30	KNL	60	WZ	10		166148 ●
280	3.2	2.2	30	KNL	48	WZ	10		166149 ●
280	3.2	2.2	30	KNL	60	WZ	10		166150 ●
315	3.0	2.0	30	KNL	48	WZ	15		166152 ●
315	3.2	2.2	30	KNL	28	WZ	20		166151 ●
315	3.2	2.2	30	KNL	72	WZ	10		166153 ●
355	3.2	2.2	30	KNL	16	WZ	20		166154 ●
355	3.2	2.2	30	KNL	32	WZ	20		166155 ●



## Circular sawblades for cutting logs

**Application:**

For sizing across grain, trimming and cross cutting.

**Machine:**

Rolling table saws and log saws.

**Workpiece material:**



Softwood and hardwood wet and dry.

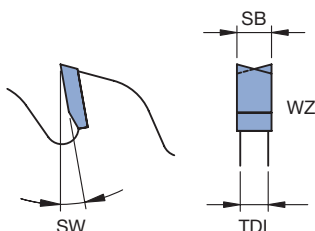
**Technical information:**

Design with chip thickness limitation. Narrow cutting width and reduced number of teeth for reduced power consumption even with thick logs.

## Circular sawblades WZ with thickness limitation

WK 150 4

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
600	3.8	2.8	30	KNL	36	WZ	20		166610 ●
700	4.2	3.2	30	KNL	42	WZ	20		166611 ●





## Trimming from the top

### Application:

For sizing across grain, trimming and cross cutting.

### Machine:

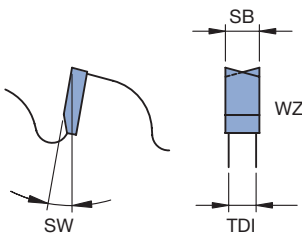
Trimming and mitre saws.

### Workpiece material:

Softwood and hardwood wet and dry, laminated veneer lumber (e.g. plywood, multiplex plywood), thin walled plastic profiles (thickness < 2 mm).

### Technical information:

Negative cutting angle especially for manually operated machines. Position of spindle above the workpiece.



### Circular sawblade WZ cutting angle -5°

WK 160 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
210	2.8	2.0	30		60	WZ	-5	■ ■	166252 ●
216	1.8	1.2	30		48	WZ	-5	■ ■	166260 ●
216	3.0	2.0	30		24	WZ	-5	■ ■	166253 ●
216	3.0	2.0	30		48	WZ	-5	■ ■	166254 ●
216	3.0	2.0	30		64	WZ	-5	■ ■	166255 ●
250	2.4	1.8	30	KNL	48	WZ	-5	■ ■	166256 ●
250	2.4	1.8	30	KNL	60	WZ	-5	■ ■	166257 ●
250	3.2	2.6	30	KNL	80	WZ	-5	■ ■	166258 ●
255	2.8	2.0	30	KNL	60	WZ	-5	■ ■	166259 ●
260	2.5	1.8	30	KNL	60	WZ	-5	■ ■	166250 ●
260	2.5	1.8	30	KNL	80	WZ	-5	■ ■	166251 ●



### Trimming cut

#### Application:

For sizing, trimming and cross cutting.

#### Machine:

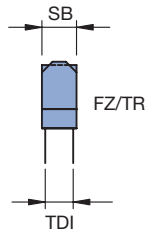
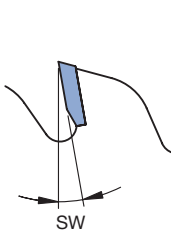
Portable and table saws.

#### Workpiece material:

Non-ferrous metal profiles, duroplastics (compact laminated boards, e.g. HPL), solid surface materials (e.g. Corian).

#### Technical information:

Solid tooth shape for universal use.



#### Circular sawblade FZ/TR cutting angle 5°

WK 452 2, WK 852 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	1.8	1.2	20		48	FZ/TR	5	■ ■	166311 ●
160	2.6	1.8	20		48	FZ/TR	5	■ ■	166300 ●
165	1.8	1.2	20		48	FZ/TR	5	■ ■	166312 ●
180	3.2	2.6	16		42	FZ/TR	5	■ ■	166301 ●
190	1.8	1.2	30		54	FZ/TR	5	■ ■	166313 ●
190	2.8	1.8	30		54	FZ/TR	5	■ ■	166302 ●
200	2.8	2.2	20		84	FZ/TR	5	■ ■	166303 ●
200	3.2	2.6	30	KNL	48	FZ/TR	5	■ ■	166304 ●
250	3.2	2.6	30	KNL	60	FZ/TR	5	■ ■	166305 ●
250	3.2	2.6	30	KNL	80	FZ/TR	5	■ ■	166306 ●
250	3.2	2.6	32	2/11/63	60	FZ/TR	5	■ ■	166307 □
250	3.2	2.6	32	2/11/63	80	FZ/TR	5	■ ■	166308 □
250	3.2	2.6	40	2/8/55	80	FZ/TR	5	■ ■	166309 □
				4/12/64					
275	3.4	2.8	40	2/9/55	72	FZ/TR	5	■ ■	166310 ●
				4/12/64					



### Trimming from the top

#### Application:

For sizing across grain, trimming and cross cutting.

#### Machine:

Trimming and mitre saws.

#### Workpiece material:

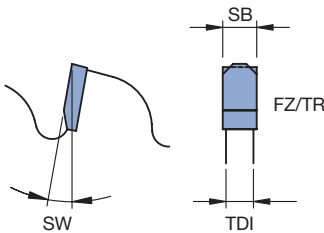
Non-ferrous metal or plastic profiles.

#### Technical information:

Negative cutting angle especially for manually operated machines. Position of spindle above the workpiece.



HW



#### Circular sawblade FZ/TR cutting angle -5°

WK 462 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	2.5	1.8	20		56	FZ/TR	-5	■	166350 ●
165	2.2	1.6	20		56	FZ/TR	-5	■	166351 ●
180	3.2	2.6	20		42	FZ/TR	-5	■	166352 ●
190	2.8	2.2	30		68	FZ/TR	-5	■	166354 ●
200	3.2	2.6	18		80	FZ/TR	-5	■	166355 ●
200	3.2	2.6	30		60	FZ/TR	-5	■	166356 ●
210	2.4	1.6	30		64	FZ/TR	-5	■	166357 ●
210	2.8	2.0	30		60	FZ/TR	-5	■	166358 ●
216	2.2	1.6	30		64	FZ/TR	-5	■	166366 ●
216	3.0	2.4	30		64	FZ/TR	-5	■	166359 ●
220	3.2	2.6	30		72	FZ/TR	-5	■	166360 ●
225	2.6	1.8	30		68	FZ/TR	-5	■	166361 ●
250	3.2	2.6	30	KNL	60	FZ/TR	-5	■	166362 ●
250	3.2	2.6	30	KNL	80	FZ/TR	-5	■	166363 ●
260	2.4	1.8	30	KNL	68	FZ/TR	-5	■	166364 ●
275	3.2	2.6	30	KNL	88	FZ/TR	-5	■	166365 ●



## Dry sawing of ferrous metals - DryCut

### Application:

For splitting, trimming and sizing.

### Machine:

Trimming and mitre saws, portable machines and table saws.

### Workpiece material:

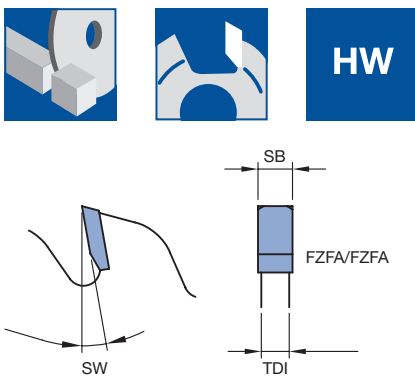
Flat and angle steel, pipes, steel plates and profiles, sandwich panels.

### Technical information:

Note: Slow feed! Reduce speed! There may be sparks in use. Pay attention to safety instructions of extraction.

### Circular sawblade DryCut

WK 977 3



D	SB	TDI	BO	Z	ZF	SW	WSS	ID
mm	mm	mm	mm			°		
160	2.0	1.6	20	48	FZFA/FZFA	0	■	163529 ●
165	2.0	1.6	20	48	FZFA/FZFA	0	■	163530 ●
190	2.0	1.6	30	54	FZFA/FZFA	0	■	163531 ●
210	2.0	1.6	30	60	FZFA/FZFA	0	■	163532 ●
225	2.2	1.8	30	64	FZFA/FZFA	0	■	163533 ●
254	2.2	1.8	30	72	FZFA/FZFA	0	■	163534 ●
300	2.2	1.8	30	80	FZFA/FZFA	0	■	163535 ●
305	2.4	2.0	25.4	80	FZFA/FZFA	0	■	163536 ●
330	2.4	2.0	30	80	FZFA/FZFA	0	■	163537 ●
355	2.4	2.0	25.4	80	FZFA/FZFA	0	■	163538 ●
400	3.0	2.4	30	84	FZFA/FZFA	0	■	163539 ●

# 1. Sawing

## 1.7 Portable saws and table-top machines

### 1.7.4 Circular sawblades for plastics and NF-metals



#### Sizing in finish cut quality *Excellent* - GlossCut

**Application:**  
For trimming and sizing.

**Machine:**  
Portable and table saws.

**Workpiece material:**  
Transparent thermoplastics (e.g. PMMA, PC), plastic wave boards (e.g. PVC), solid surface materials (e.g. Corian), alu composite panels (e.g. Alucobond®). Non-ferrous metal or plastic profiles.

**Technical information:**  
Special design of the cutting area for low-groove and low-burr cutting surfaces and tear-free cutting edges. **Excellent** design with filled laser ornaments for vibration damping and reduction of noise level (from D 210 mm).

#### Circular sawblade GlossCut WK 357 2

D	SB	TDI	BO	NLA	Z	ZF	WSS	ID
mm	mm	mm	mm	mm				
160	2.2	1.6	20		48	FZFA/FZFA		<b>161008 •</b>
165	2.2	1.6	20		48	FZFA/FZFA		<b>161009 •</b>
190	2.4	1.8	20		58	FZFA/FZFA		<b>161010 •</b>
210	2.4	1.8	30		68	FZFA/FZFA		<b>161011 •</b>
250	2.8	2.0	30	KNL	72	FZFA/FZFA		<b>161012 •</b>

Further GlossCut dimensions suitable for sizing, cross cut and mitre cut saws and twin sizing saws - see section Cutting Non-Ferrous Metals And Plastics.





#### Universal sizing

##### Application:

For universal use on building sites.

##### Machine:

Universal cutting saws.

##### Workpiece material:

Panels and timbers with small concrete and metal inclusions, wood wool (e.g. Heraklith), gypsum plasterboard and form work panel of veneer, gas aerated slabs, Styrodur slabs, roundwood and squared timbers.

##### Technical information:

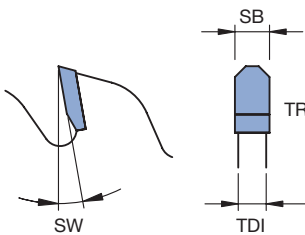
Tool body with round closed form and stable tooth shape. Special tungsten carbide grade for all requirements on construction sites. Noise reducing design.



#### Circular sawblades TR for saw benches

WK 123 2

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
350	3.5	2.5	30	KNL	24	TR	10		<b>166025 ●</b>
400	3.8	2.8	30	KNL	28	TR	10		<b>166026 ●</b>
450	4.0	3.0	30	KNL	32	TR	10		<b>166027 ●</b>
500	4.0	3.0	30	KNL	36	TR	10		<b>166028 ●</b>



## 1. Sawing

### 1.7 Portable saws and table-top machines

#### 1.7.6 Circular sawblades for fibre cement boards



#### Cutting facade panels *Excellent*

##### Application:

For trimming and sizing.

##### Machine:

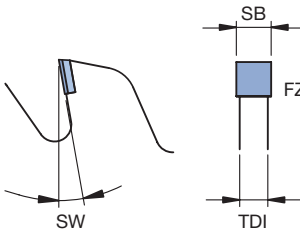
Accu-portable sawblades.

##### Workpiece material:

Gypsum and cement boards.

##### Technical information:

Thin kerf for low power requirement and long battery life. DP tipping for long tool life. Tool body with cooling holes for dust-free cutting surfaces.



##### Circular sawblade DP design

WK 100 3 DP

D	SB	TDI	BO	Z	ZF	SW	WSS	ID
mm	mm	mm	mm			°		
160	2.2	1.6	20	4	FZ	5	■	190752 ●
165	2.2	1.6	20	4	FZ	5	■	190753 ●
190	2.2	1.6	30	4	FZ	5	■	190754 ●



#### Cutting facade panels *Excellent*

##### Application:

For trimming and sizing.

##### Machine:

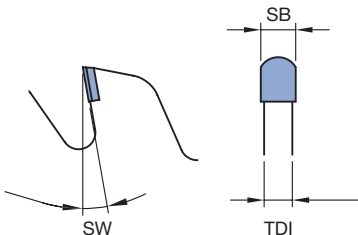
Table and sizing saws, portable and radial cross saws.

##### Workpiece material:

Gypsum and cement boards.

##### Technical information:

Robust tooth shape and DP mounting for long tool life. Special tool body design for high stability.



##### Circular sawblade DP design

WK 808 2 DP

D	SB	TDI	BO	NLA	Z	ZF	SW	WSS	ID
mm	mm	mm	mm	mm			°		
160	3.2	2.4	20		4	P	5	■	190302 ●
184	3.2	2.4	20		4	P	5	■	190696 ●
190	3.2	2.4	20		4	P	5	■	190303 ●
190	3.2	2.4	30		4	P	5	■	190745 ●
225	3.2	2.4	30		6	P	5	■	190304 ●
300	3.2	2.4	30	KNL	8	P	5	■	190305 ●

## Reducing rings

### Technical information:

For reducing the bore of circular sawblades reducing rings can be used.

Attention: When using reducing rings, pay attention to the distance to the flange.

Reducing rings in ruffle design.

### Reducing ring riffled

TB 100 0 02

D	BO	DIK	ID
mm	mm	mm	
20	16	1.0	061148 ●
20	16	1.6	061104 ●
30	20	1.4	061149 ●
30	25.4	1.8	061150 ●
32	30	1.8	061151 ●

	Possible cause	Action
<b>Sawblade wobbles</b>	– Thickness of tool is too low.	Select a sawblade with a larger kerf or a smaller diameter or increase flange diameter.
	– Insufficient tooth projection over tool body (sawblade jams in the cut, runs hot, tension lost).	Select a sawblade with a higher lateral tooth projection.
	– Resin/chips on the flanges.	Clean flanges.
	– Flange run out tolerance too high.	Check and correct flange.
	– Defective motor spindle bearing.	Replace motor spindle bearing.
	– Tooth pitch and gullet too small.	Select a sawblade with a higher tooth pitch.
	– Unbalanced sawblade.	Balance the sawblade.
	– Blunt cutting edges.	Resharpener the sawblade.
	– Wrong sawblade tensioning.	Correct sawblade tensioning.
<b>Wavy cut</b>	– Irregular tooth pitch or one sided cut.	Correct sharpening machine adjustment, resharpen the sawblade.
	– Irregular tooth thickness.	Check and correct sawblade kerf.
	– Sawblade is blunt resin build up.	Clean and resharpen the sawblade.
	– Position of fence not parallel to feed direction.	Check and adjust position.
	– One sided load from edge cutting.	Use edging sawblades (hogger).
	– Cutting speed too low.	Select a larger sawblade diameter or increase RPM.
	– Wrong sawblade tensioning.	Correct sawblade tensioning.
<b>Jamming of sawblade in cut</b>	– Slot in saw bed is too big, insufficient chip flow, causing jamming between the saw and slot.	Replace saw bed.
	– Riving knife width is too thin.	Replace riving knife.
	– Gullet too small.	Select sawblade with larger gullet.
<b>Curved cut when double edging</b>	– Sawblades sharpened one sided.	Resharpen sawblade (correct kerf of sawblade and sharpening machine adjustment).
	– Resin and glue on rollers.	Clean and, if necessary, resharpen rollers.
	– Differences in wood thickness.	Improvements necessary at customer.
	– Too high cutting forces on one side.	Optimise cutting force division.
	– Worn conveyor belt guide.	Check and adjust chain guide.
	– Short and uneven workpieces.	Comply with minimum workpiece length required by the machine manufacturer's instructions.
	– When machining short workpieces and when transporting piece by piece.	Pay attention to angular cut off work pieces.

Problem	Possible cause	Action
<b>Exceeded tolerances of horizontally cut lamellas</b>	– Sawblade tensioning not suitable for horizontal application.	Check the sawblade tensioning.
	– High resin build up on tool, tool runs very hot from friction in cut.	Clean sawblades and check if blunt.
	– Thickness and position of riving knife not adjusted to the dimensions of strips and the sawblade kerf.	Use riving knife dimension matching the sawblade kerf. Adjust riving knife spacing to correspond to the thickness of strips.
<b>Tear outs in workpieces coated on both sides when machining without scoring saw</b>	– Sawblade projection over workpiece too small or too big.	Check and adjust sawblade projection.
	– Tooth shape or number of teeth not suitable for the application.	Select a sawblade suitable for the application.
	– Concentric running tolerances of the sawblade too high.	Have the sawblade checked by Leitz service.
	– The flange used on the machine does not correspond to the guidelines for flange diameter and concentric running tolerances.	Check flanges and, if necessary, clean them. If there is a wrong ratio of sawblade diameter to flange diameter, adjust accordingly.
<b>Tear outs on the panel coating when cutting in stacks</b>	– Tool is blunt.	Resharpen main sawblade.
	– Pressure beam cannot press evenly on uneven workpieces.	Check pressing force of pressure beam.
<b>Tear outs where the tool leaves the workpiece when cutting in stacks</b>	– The kerf of the scoring sawblade is too small for the main sawblade in use.	Adjust kerf of scoring sawblade to main sawblade accordingly.

## 1. Sawing

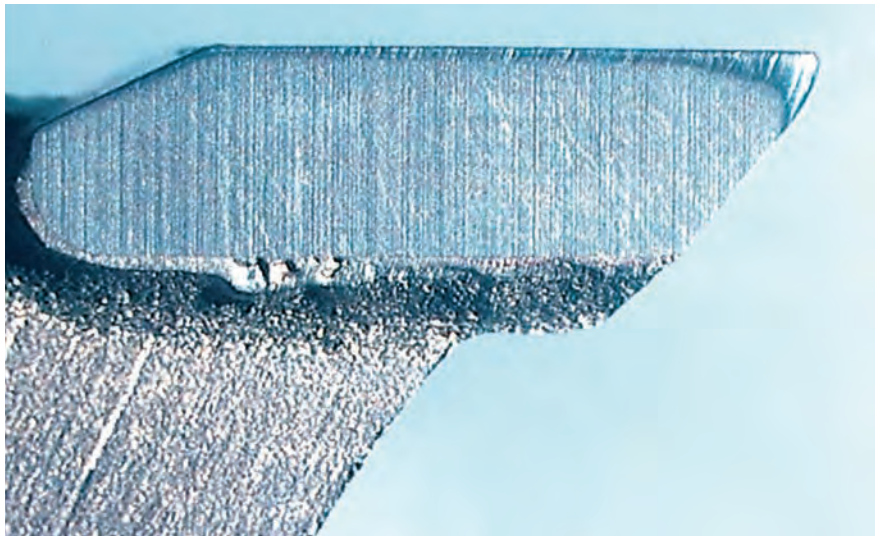
### Signs of wear of HW cutting edges and tools

#### Rounding of cutting edge

Mechanical and chemical wear cause rounding of main and minor cutting edges of a saw tooth.

In wet solid wood (e.g. green wood) chemical wear is approximately the same as mechanical wear.

When using tungsten carbide grades with special binding agents, chemical wear can be reduced. In the wood-working sector, dry wood is machined and mechanical wear dominates.



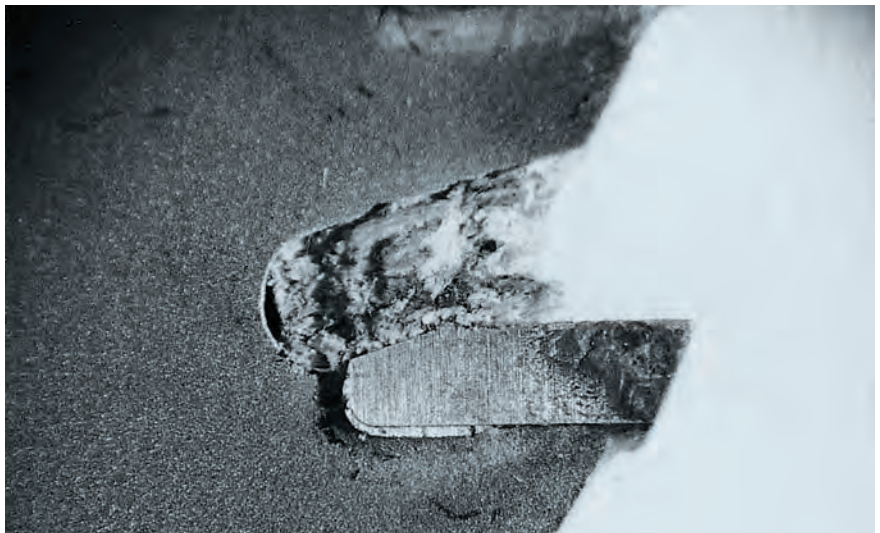
Worn HW saw tooth.

#### Cutting edge chips and cutting edge fracture

Hard foreign objects in the workpiece cause cutting edge chips and a deterioration of cut quality as well as increased shear forces. Mineral particles in wood derived materials are often the reason for cutting edge chips.

Saw teeth and pieces of the saw body can break off when, due to blunt cutting edges, the feed rate and cutting forces increase considerably.

A too high tooth feed can lead to choking of the lower part of the saw-blade gullet and the tooth breaking off the saw body.



Choked gullet.

#### Cracking of tool body

Vibrations are caused by high loads on the cutting edges and the tool body (e.g. increased bluntness, high tooth feed or one sided stress). This can cause vibration cracks in the gullet or wiper slots.

High one sided stress, e.g. when edge cutting, leads to bending, chipping or cracking of the tool body.



Fracture in the saw body.



### Cutting edge rounding of DP

Mechanical wear of uniform workpiece materials causes rounding of the main and minor cutting edges. Apart from rounding, slight chips caused by foreign objects can occur when machining certain wood derived materials.

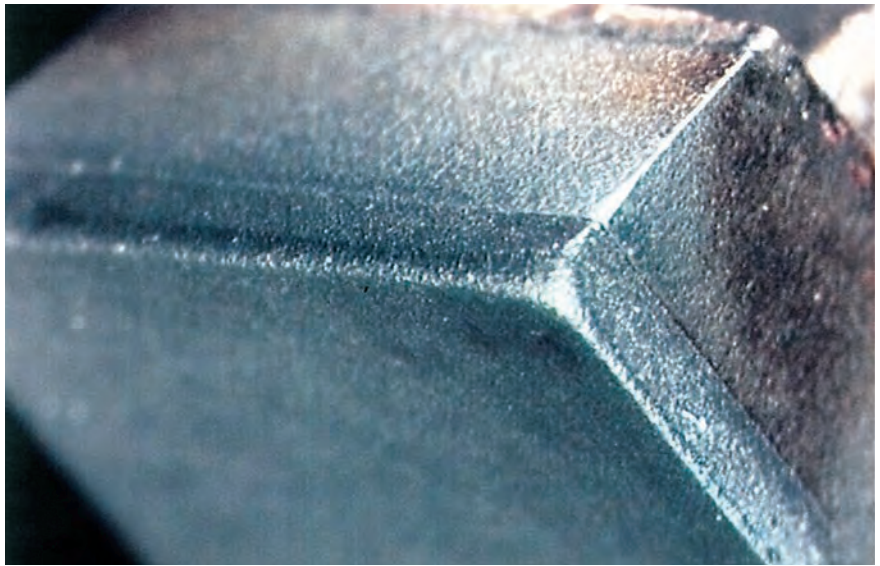
Rounding of the minor cutting edges can lead to reduced performance time and to deterioration in the cut and edge quality.

#### Action:

- Additional lateral eroding to the tooth relief angle.

#### This leads to:

- lower lateral tooth projection.
- loss of cutting width.
- higher resharpening costs.



Worn DP saw tooth.

### Cutting edge chips and cutting edge fracture

Hard mineral or metallic objects lead to cutting edge chips and to a deterioration in the cut quality.

Cutting edge chips can also be caused by inefficient dust extraction (chip flow).

Extreme bluntness and chips lead to high cutting forces and consequently cracks in the saw body material.

The condition of cutting edges and saw bodies must be checked regularly. When the performance time is up, the tools must be resharpened by experts.



Cutting edge fracture of a DP saw tooth.



## Enquiry/order form special tools – sawing



Customer details: Customer number:

(if known)

☐ Enquiry  
☐ Order

Delivery date: (not binding)   CW

Company:

Street:

Date:

Post code/place:

Enquiry/order no.:

Country:

Tool ID: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

Workpiece material: (for type, quality and machining method, see selection overview) Quality:

Machining method:

Cutting height: mm

Cutting method: ☐ single piece  
☐ in stacks  
Cutting quality: ☐ rough (rough sawn)  
☐ fine (cut to size quality)  
☐ ultra fine (finish cut quality)

Solid wood: ☐ along grain  
☐ across grain

Panel materials: ☐ sizing  
☐ square cutting

Machine

Manufacturer:

Type:

Model:

RPM: min<sup>-1</sup>

Type of feed: ☐ MAN (Hand)  
☐ MEC (Mech)

Feed rate: m min<sup>-1</sup>

Flange diameter: mm

Motor power: kW

Cutting direction: ☐ against feed (GGL)  
☐ with feed (GLL)

Tool: (must be completed)

Diameter: mm

Cutting width: mm

Bore: mm

Keyway/double keyway: mm

Pinholes:

Use: ☐ Single tool  
☐ Tool set

Cutting material: ☐ Stellite™  
☐ HW (TC)  
☐ DP (DIA)

(Complete if sawblade design is known)

Number of teeth:

Shape of teeth:

Tool body thickness: mm

Tool body shape (as per drawing): (enter number)

Additional elements of saw body (as per drawing): (enter number)

Standard design: ☐

Low noise design: ☐ with laser ornaments ☐ UT  
☐ with damping foil

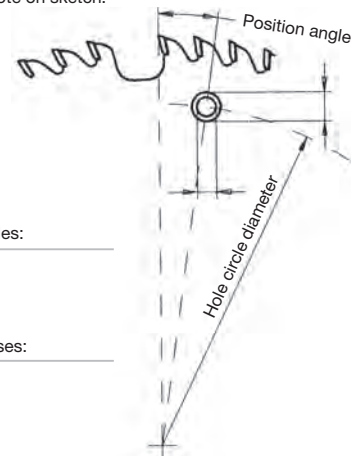
Direction of rotation ☐ left hand rotation (LL)  
(as per drawing): ☐ right hand rotation (RL)

Recessed tool body: Hub diameter: mm

Hub thickness: mm

Position of hub: ☐ Side 1  
☐ Side 2

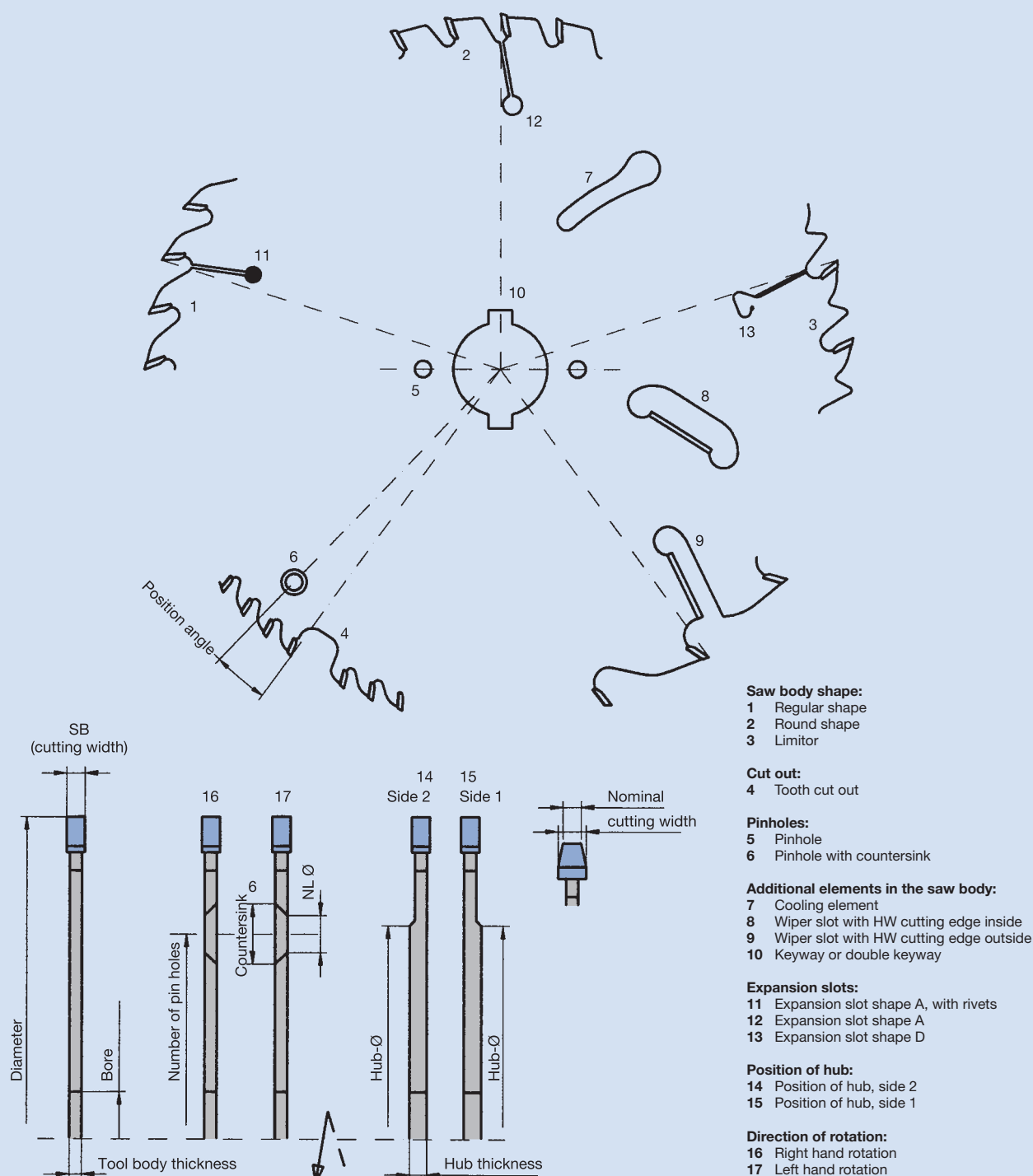
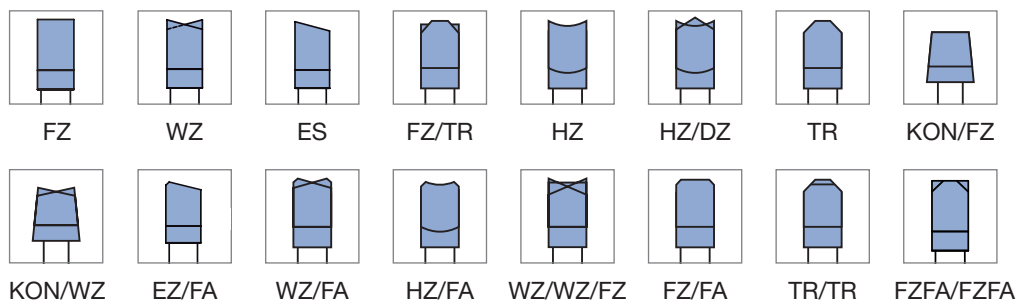
Bore – note on sketch:  
Cut out teeth – note on sketch.



Number of pinholes:

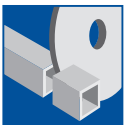
Number of recesses:

Tooth shapes





Sawing  
thin kerf



Sawing  
hollow metal



Sawing  
horizontal



Sawing  
crosscut metal



Sawing  
along grain



Scoring,  
hogging



Sawing  
across grain



Grooving,  
horizontal and vertical



Sawing  
universal



Tipped tool



Scoring,  
sawing



Low noise



Scoring and  
sawing stacks



Tungsten carbide



Sawing  
hollow sections



Polycrystalline  
diamond (PCD)



Sawing  
plastic single



Sawing  
plastic stacks



Sawing  
solid transparent plastic



# Panel processing

Leitz Lexicon Edition 7

Version 2

05/2022



## Explanation of abbreviations

A	= dimension A
$a_e$	= cutting thickness (radial)
$a_p$	= cutting depth (axial)
ABM	= dimension
APL	= panel raising length
APT	= panel raising depth
AL	= working length
AM	= number of knives
AS	= anti sound (low noise design)

b	= overhang
B	= width
BDD	= thickness of shoulder
BEM	= note
BEZ	= description
BH	= tipping height
BO	= bore diameter

CNC	= Computerized Numerical Control
-----	----------------------------------

d	= diameter
D	= cutting circle diameter
D0	= zero diameter
DA	= outside Diameter
DB	= diameter of shoulder
DFC	= Dust Flow Control (optimised chip clearance)
DGL	= number of links
DIK	= thickness
DKN	= double keyway
DP	= polycrystalline diamond
DRI	= rotation

FAB	= width of rebate
FAT	= depth of rebate
FAW	= bevel angle
FLD	= flange diameter
$f_z$	= tooth feed
$f_{z\text{ eff}}$	= effective tooth feed

GEW	= thread
GL	= total length
GS	= Plunging edge

H	= height
HC	= tungsten carbide, coated
HD	= wood thickness (thickness of workpiece)
HL	= high-alloyed tool steel
HS	= high-speed steel (HSS)
HW	= tungsten carbide (TCT)

ID	= ident number
IV	= insulation glazing

KBZ	= abbreviation
KLH	= clamping height
KM	= edge breaker
KN	= single keyway
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60

L	= length
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LH	= left hand rotation
----	----------------------

M	= metric thread
MBM	= minimum order quantity
MC	= multi-purpose steel, coated
MD	= thickness of knife
$\text{min}^{-1}$	= revolutions per minute (RPM)
MK	= morse taper
$\text{m min}^{-1}$	= metres per minute
$\text{m s}^{-1}$	= metres per second

n	= RPM
$n_{\text{max}}$	= maximum permissible RPM
NAL	= position of hub
ND	= thickness of hub
NH	= zero height
NL	= cutting length
NLA	= pinhole dimensions
NT	= grooving depth

P	= profile
POS	= cutter position
PT	= profile depth
PG	= profile group

QAL	= cutting material quality
-----	----------------------------

R	= radius
RD	= right hand twist
RH	= right hand rotation
RP	= radius of cutter

S	= shank dimension
SB	= cutting width
SET	= set
SLB	= slotting width
SLL	= slotting length
SLT	= slotting depth
SP	= tool steel
ST	= Cobalt-basis cast alloys, e.g. Stellite®
STO	= shank tolerance
SW	= cutting angle

TD	= diameter of tool body
TDI	= thickness of tool
TG	= pitch
TK	= reference diameter

UT	= cutting edges with irregular pitch
----	--------------------------------------

V	= number of spurs
$v_c$	= cutting speed
$v_f$	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
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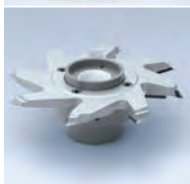
Z	= number of teeth
ZA	= number of fingers
ZF	= tooth shape (cutting edge shape)
ZL	= finger length

### Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



## 2. Panel processing



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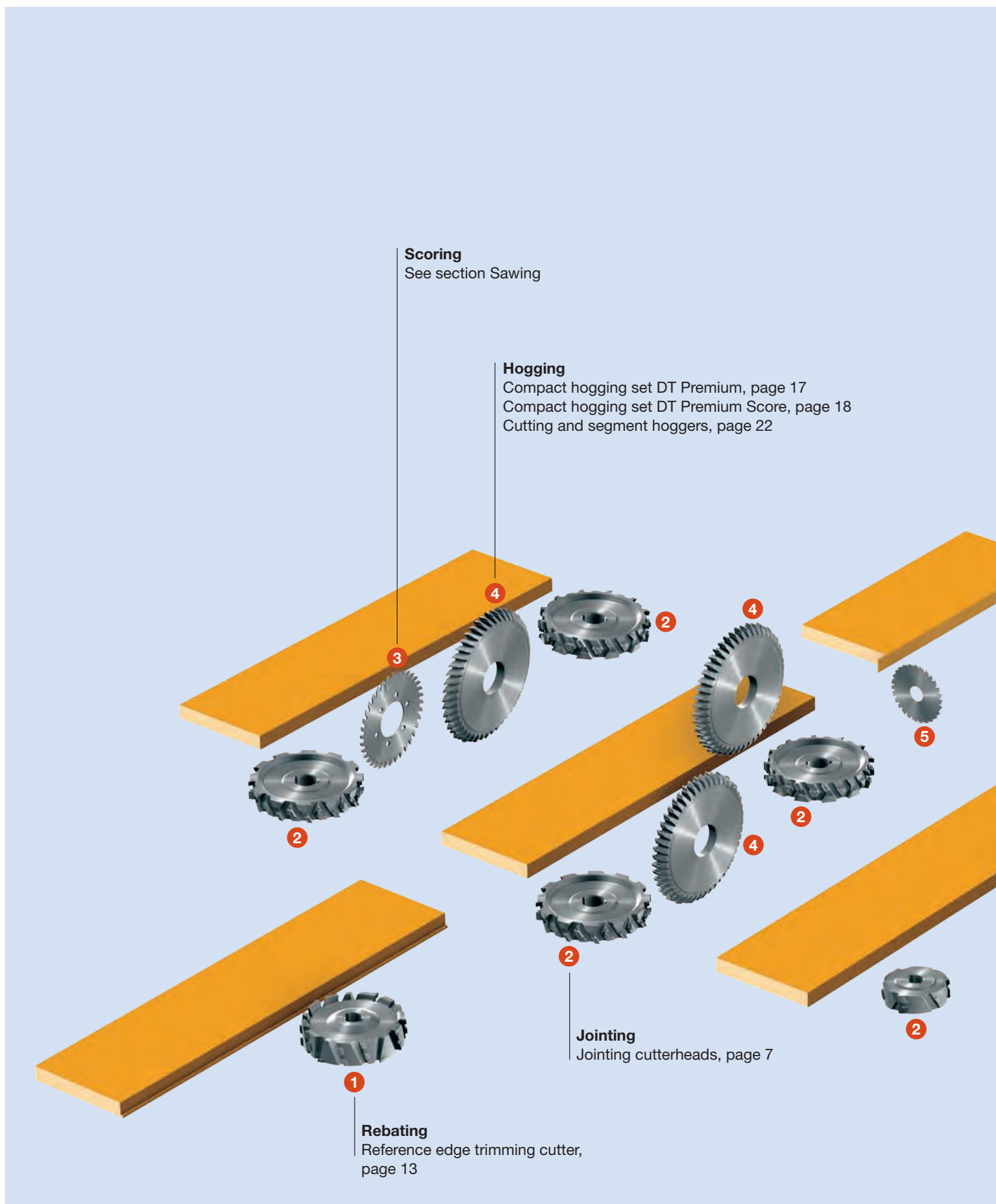
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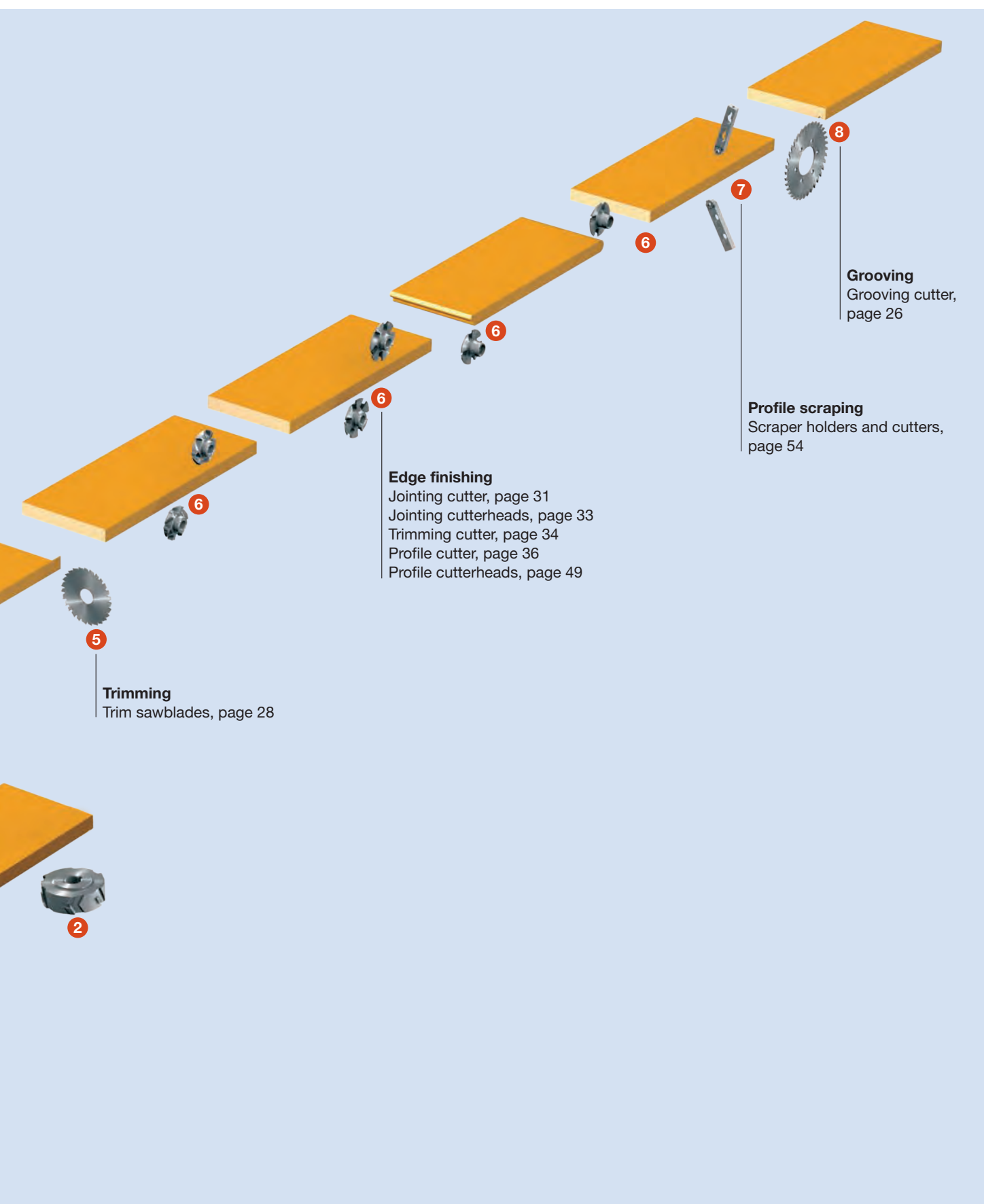
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## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters

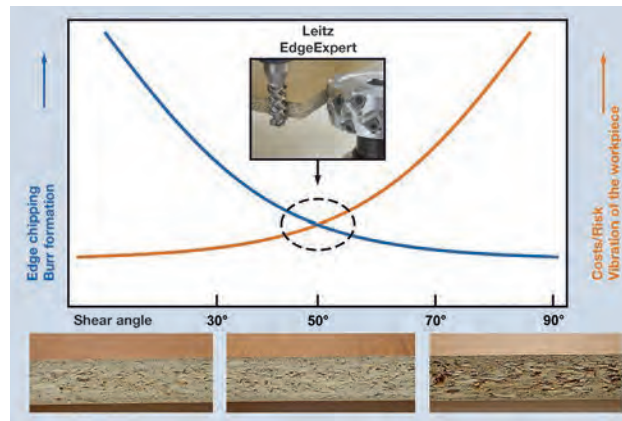
<b>Type of operation</b>	Cutting of the finished size with pre-sized, panel shaped working pieces. Therefore the jointing tools only are peripheral cutting and not with side relief!	
<b>Workpiece material</b>	Softwood and hardwood, glulam, chipboard and fibre material, uncoated and veneered, plastic and paper coated.	
<b>Machines</b>	Spindle moulders, edgebanding machines with sizing part, double end tenoners. Counter milling or jump cutting: Depending on the processing quantity and material, diamond tools or cutterheads with tungsten carbide turnblades are used.	
<b>Application</b>	<p>Jointing against feed: For all panel working materials with or without coating.</p> <p>Jointing with feed: For machining solid wood with heavily irregular course of fibres and risk of tear outs. Only allowed for machines with mechanical feed. Note: Chips are very difficult to remove.</p> <p>Jump cutting: Jointing with and against feed when cutting across, to prevent tear outs on the front and backside of the workpiece when these are already glued.</p>	
<b>Tool Designs</b>	 <p>Turnblade cutterhead with alternate shear angle: Suitable for all coated and uncoated panel shaped working materials. Turnblade tools with shear angle produce a curved surface on the workpiece. For exactly straight jointing edges we recommend ProfilCut profile cutterheads with profiled edges (special production) or diamond jointing cutters.</p> <p>Diamond jointing cutter with alternate shear angle:</p> <p>S = with symmetrical edge arrangement: Produce a slight hollow section on the milled jointing edge. This has the advantage that the edgebanding on the outside edge close tightly. The tool always must be adjusted symmetrically to the workpiece thickness. The tool can be used in RH and LH rotation.</p> <p>AS = Asymmetrical edge arrangement: One cutting edge cuts from bottom to top, the top cutting edges all are directed downward which is advantageous for frequently changing material thicknesses.</p>	 <p>2-part tools on synchronically adjustable sleeve: These tools with alternate shear angles are advantageous for high quantities and nearly constant workpiece thicknesses as with increasing tool blunting the jointing edges on the coating do not remain tear-free. The stepless and synchronic adjustment allows the use of multiple performance times and thus an increase of the tool lifetime.</p>
<b>Diamaster WhisperCut</b>	 <p>Diamaster WhisperCut – The lightweight and efficient jointing cutterhead for low noise sizing of panel material.</p> <p>Advantages at a glance:</p> <ul style="list-style-type: none"> <li>– Significant noise reduction of up to 5 dB(A) through optimized tool body shape and weight halving</li> <li>– Trouble free chip ejection and excellent chip collection through DFC technology</li> <li>– Individual use as per customer requirement: resharpenable or as changing knife system</li> </ul>	

##### Diamaster EdgeExpert



Diamaster EdgeExpert – The expert for top edge performance especially in case of demanding decors.

In interior design and furniture manufacture, the use of processed material surfaces is increasing in both use and importance. This requires new tool concepts such as the Diamaster EdgeExpert program from Leitz. Whether very thin paper decors, veneers or foil- and high-gloss coating, the Diamaster EdgeExpert enables tear-free edges and even middle layer on continuous machines and CNC machining centres. Especially suitable for zero-joint edging technology with laser, plasma or hot air.

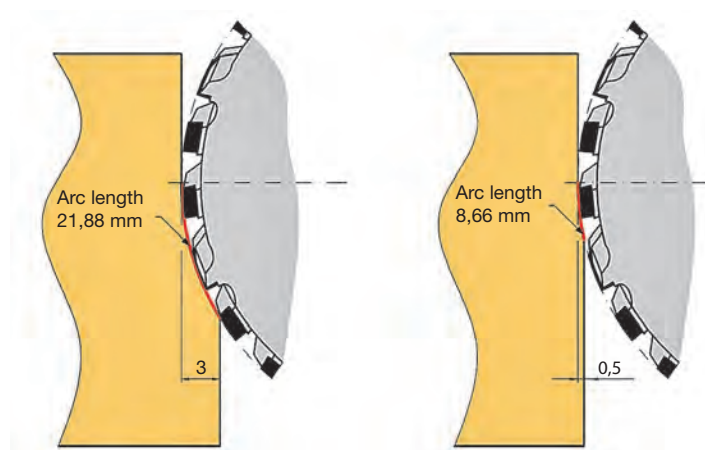


##### Dust collection

The tool characteristics of the joint cutter Diamaster PRO low noise model range have DFC gullet for delayed chip ejection and are suitable for i-system.

##### Chip removal

The chip removal has an important influence on the machining quality and on the tool life. Through a reduction of the chip removal, the arched length of the tool positioned in the interference is decreased, causing the tool to cut less material and to increase the tool life.



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters

##### Noise emission

For noise reduction, LowNoise tools Diamaster PRO with its low knife protrusion, staggered edge and shear can be used. See section Edge Processing - Jointing Cutters.

##### Service

The Diamaster WhisperCut knives either can be serviced by Leitz Service or by the user on site.

##### Resharpener Diamaster WhisperCut



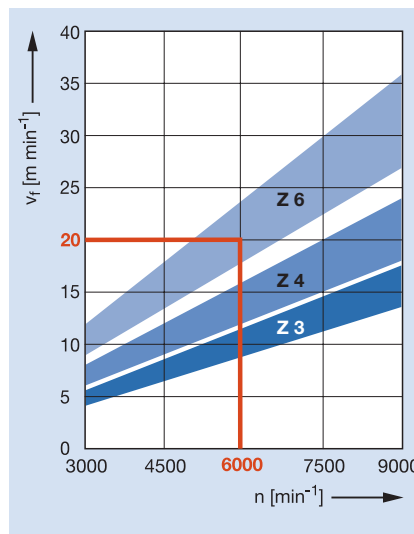
WhisperCut: Diamond knives are resharpenable in the tool body up to 3 times  
WhisperCut PLUS: Diamond knives are resharpenable in the tool body up to 10 times

##### Diamaster WhisperCut – The jointing cutterhead with exchan- geable knives

- constant diameter
- quick and easy knife change by the user on site
- no costly adjustment at the machine
- no interchangeable tool required
- optimal knife utilization with small material thicknesses

##### Feed speed related to RPM and number of teeth Z

Material: Chipboard with melamine  
resin coating





### WhisperCut jointing / milling cutter - cutterhead design

#### Application:

For tear-free and low noise jointing of workpiece edges side with and against feed (jump cutting).

#### Machine:

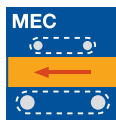
Edgebanding machines, copy shaping machines, double-end tenoners etc.

#### Workpiece material:

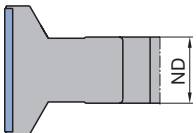
Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

#### Technical information:

DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surfaces. Tool with knife arrangement S can be used left and right and produces hollow cut for tightly closing edgebanding. Low noise design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) by DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.



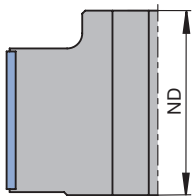
Position of boss (NAL) 1



Position of boss (NAL) 2



Position of boss (NAL) 3



Position of boss (NAL) 4

#### Diamaster WhisperCut - DFC, LowNoise, aluminium alloy tool body

WF 230 2 DP, WM 230 2 01

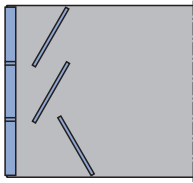
Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
Ayza Mizrak	70	54	30	20 DKN	2	2x5	10xD	AS	192320 ●	192321 ●
Ayza Mizrak	125	54	40	30 DKN	3	3x5	15xE	AS	192326 ●	192327 ●
Biesse	80	45	53	30 DKN	1	2x4	8xB	S	192127 ●	192127 ●
Biesse	80	65	53	30 DKN	2	2x6	12xB	S	192128 ●	192128 ●
Biesse	100	43	75	30 DKN	1	3x4	12xA	S	192088 ●	192088 ●
Biesse	100	65	75	30 DKN	1	3x6	18xA	S	192089 ●	192089 ●
Biesse	125	43	40	30 DKN	2	3x4	12xE	S	075627 ●	075627 ●
Biesse	125	63	40	30 DKN	2	3x6	18xE	S	075626 ●	075626 ●
Brandt	100	43.6	40.6	25 DKN	3	2x4	8xA	AS	192211 ●	192212 ●
Brandt	100	43.6	40.6	30 DKN	3	3x4	12xA	AS	090885 ●	090886 ●
Brandt	100	65.2	40.6	30 DKN	3	3x6	18xA	AS	090887 ●	090888 ●
Brandt	100	85	85	30 DKN	3	3x8	24xA	AS	090889 ●	090890 ●
Brandt	100	105	85	30 DKN	3	3x10	30xA	AS	090891 ●	090892 ●
Cehisa	100	54	25	20 DKN	2	2x5	10xA	AS	192078 ●	192079 ●
EBM	70	43	61	25 DKN	4	2x4	8xB	AS	192138 ●	192137 ●
EBM	70	43	61	25 DKN	4	2x4	8xB	AS	192237 ●	192238 ●
EBM	70	63	81	25 DKN	4	2X6	12xB	AS	192239 ●	192240 ●
EBM	100	43	61	30 DKN	4	2x4	8xA	AS	192080 ●	192081 ●
EBM	100	43	61	30 DKN	4	2x4	8xB	AS	192233 ●	192234 ●
EBM	100	63	81	30 DKN	4	2x6	12xB	AS	192235 ●	192236 ●
Felder	60	63	63.5	25 DKN	3	2x7	12xC	AS°		192278 ●
Felder	60	63	63.5	25 DKN	3	2x7	12xC	AS°	192277 ●	
Felder	80	48.5	64	25 DKN	4	3x6	12xF	AS°	192281 ●	192282 ●
Felder	80	64	64	25 DKN	3	2x7	12xF	AS°	192299 ●	
Felder	80	64	64	25 DKN	3	2x7	12xF	AS°	192279 ●	
Felder	80	64	64	25 DKN	3	3x7	18xF	AS°		192280 ●
Fravol	60	63	63.5	25 DKN	3	2x7	12xC	AS°	192247 ●	
Fravol	60	63	63.5	25 DKN	3	2x7	12xC	AS°		192248 ●
Fravol	60	84	61	25 DKN	3	2x8	14xC	AS°	192241 ●	

● available ex stock

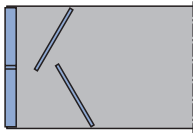
□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)

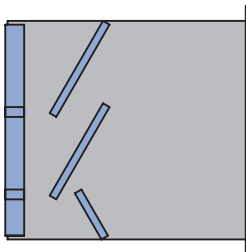




Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



Type AS° = asymmetric tip arrangement with a narrow row of teeth below

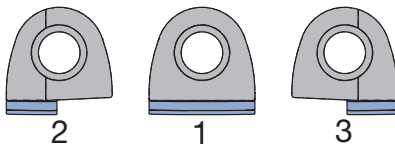
Machine	D mm	SB mm	ND mm	BO mm		NAL	Z	Knife Type	Type	ID LH	ID RH
Fraval	60	84	61	25	DKN	3	2x8	14xC	AS°		192242 ●
								2xC2			
Fraval	100	65	56.5	30	DKN	3	2x6	12xA	AS	192243 ●	192244 ●
Fraval	100	84	56.5	30	DKN	3	2x8	14xA	AS°	192285 ●	
								14xA1			
Fraval	100	84	56.5	30	DKN	3	2x8	14xA	AS°		192286 ●
								14xA2			
Fraval	100	124	96	30	DKN	2	2x11	22xA	AS	192245	192246
Hebrock	70	43	61	25	DKN	4	2x4	8xB	AS	192138 ●	192137 ●
Hebrock	70	43	61	25	DKN	4	2x4	8xB	AS	192237 ●	192238 ●
Hebrock	70	63	81	25	DKN	4	2x6	12xB	AS	192239 ●	192240 ●
Hebrock	100	43	61	30	DKN	4	2x4	8xA	AS	192080 ●	192081 ●
Hebrock	100	43	61	30	DKN	4	2x4	8xB	AS	192233 ●	192234 ●
Hebrock	100	63	81	30	DKN	4	2x6	12xB	AS	192235 ●	192236 ●
Holz-Her	70	48	41	30	DKN	2	2x5	8xD	AS°		192221 ●
								2xD2			
Holz-Her	70	48	41	30	DKN	2	2x5	8xD	AS°	192222 ●	
								2xD1			
Holz-Her	70	64	41	30	DKN	2	2x7	12xD	AS°		192223 ●
								2xD2			
Holz-Her	70	64	41	30	DKN	2	2x7	12xD	AS°	192224 ●	
								2xD1			
Holz-Her	100	63	39.5	30	DKN	2	3x6	18xB	S	192147 ●	192148 ●
								1804			
Holz-Her	100	43	25	30	DKN	2	2x4	8xA	AS	192082 ●	192083 ●
								1891			
Holz-Her	100	65	25	30	DKN	2	2x6	12xA	AS	192084 ●	192085 ●
								1891			
Holz-Her	100	63	39.5	HSK 32R	2	2	3x6	18xB	S	192307 ●	192308 ●
								FG701			
Homag	100	43.6	40.6	25	DKN	3	2x4	8xA	AS	192211 ●	192212 ●
Homag	100	43.6	40.6	30	DKN	3	3x4	12xA	AS	090885 ●	090886 ●
Homag	100	65.2	40.6	30	DKN	3	3x6	18xA	AS	090887 ●	090888 ●
Homag	100	85	85	30	DKN	3	3x8	24xA	AS	090889	090890
Homag	100	105	85	30	DKN	3	3x10	30xA	AS	090891	090892
Homag	125	42.6	54	30	DKN	3	3x4	12xA	AS	192287 ●	192288 ●
Homag	125	43	40	30	DKN	2	3x4	12xE	S	075627 ●	075627 ●
Homag	125	63	40	30	DKN	2	3x6	18xE	S	075626 ●	075626 ●
Homag	125	64.4	54	30	DKN	3	3x6	18xA	AS	192289	192290
IMA	100	32	36	30	DKN	1	3x4		AS	192090 ●	192091 ●
IMA	125	32	34	30	DKN	2	3x4	12xD	AS	192092 ●	192093 ●
IMA	125	43	42	30	DKN	2	3x5	15xD	AS	192094 ●	192095 ●
IMA	125	63	42	30	DKN	3	3x7	21xD	AS	192096 ●	192097 ●
IMA Advan- tage	125	43	57	30	DKN	4	3x5	15xD	AS	192098 ●	192099 ●
IMA Advan- tage	125	65	57	30	DKN	4	3x7	21xD	AS	192100 ●	192101 ●
Mizrak Ma- chine	70	54	30	20	DKN	2	2x5	10xD	AS	192320 ●	192321 ●
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°	192209 ●	
								3xB1			
Ott	85	48	50	30	DKN	3	3x5	12xB	AS°		192210 ●
								3xB2			
Ott	85	65	45	30	DKN	2	3x6	18xB	AS	192227 ●	192228 ●
Ott	85	85	50	30	DKN	3	3x8	24xB	AS	192229 ●	192230 ●
SCM	100	51	60	30	DKN	3	2x6	8xB	AS°	192215 ●	192216 ●
								2xB1			
								2xB2			
SCM	100	51	60	30	DKN	3	3x6	12xB	AS°	192217 ●	192218 ●
								3xB1			
								3xB2			
SCM	100	66	60	30	DKN	3	2x7	12xB	AS°	192213 ●	
								2xB1			
SCM	100	66	60	30	DKN	3	2x7	12xB	AS°		192214 ●
								2xB2			
SCM	100	66	60	30	DKN	3	3x7	18xB	AS°	192219 ●	
								3xB1			



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



Shape of WhisperCut spare knives  
SB 6.7 / 14 mm

Machine	D mm	SB mm	ND mm	BO mm	NAL	Z	Knife Type	Type	ID LH	ID RH
SCM	100	66	60	30	DKN	3	3x7 18xB	AS°		<b>192220 •</b>
Stefani	100	51	60	30	DKN	3	2x6 8xB 2xB1 2xB2	AS°	<b>192215 •</b>	<b>192216 •</b>
Stefani	100	51	60	30	DKN	3	3x6 12xB 3xB1 3xB2	AS°	<b>192217 •</b>	<b>192218 •</b>
Stefani	100	66	60	30	DKN	3	2x7 12xB 2xB1	AS°	<b>192213 •</b>	
Stefani	100	66	60	30	DKN	3	2x7 12xB 2xB2	AS°		<b>192214 •</b>
Stefani	100	66	60	30	DKN	3	3x7 18xB 3xB1	AS°	<b>192219 •</b>	
Stefani	100	66	60	30	DKN	3	3x7 18xB 3xB2	AS°		<b>192220 •</b>
Turanlar Makine	70	54	30	20	DKN	2	2x5 10xD	AS	<b>192320 •</b>	<b>192321 •</b>
Turanlar Makine	70	54	30	20	DKN	2	3x5 15xD	AS	<b>192324</b>	<b>192325</b>
Turanlar Makine	125	54	30	30	DKN	3	3x5 15xE	AS	<b>192322 •</b>	<b>192323 •</b>
Türk Makine	100	65.2	40.6	30	DKN	3	3x6 18xA	AS	<b>090887 •</b>	<b>090888 •</b>

#### Spare knives:

BEZ	ABM mm	QAL	Type	Shape	ID
WhisperCut-knife SB14	14x14.2x4.3	DP	A	1	<b>091052 •</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	A1	3	<b>091082 •</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	A2	2	<b>091081 •</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	B	1	<b>091066 •</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B1	3	<b>091067 •</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	B2	2	<b>091068 •</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	C	1	<b>091077 •</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C1	3	<b>091079 •</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	C2	2	<b>091078 •</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	D	1	<b>091071 •</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D1	3	<b>091073 •</b>
WhisperCut-knife SB6.7	6.7x14.2x4.3	DP	D2	2	<b>091072 •</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	E	1	<b>091074 •</b>
WhisperCut-knife SB14	14x14.2x4.3	DP	F	1	<b>091084 •</b>

Eroded spare knives for quick and easy knife change.

#### Spare parts:

BEZ	ABM mm	Machine	ID
Securing part set	40/30x8 M12	Holz-Her 1801/1802	<b>116011 •</b>
Spindle nut	38x28 M25x1,5	Felder, Fraval	<b>066566 •</b>
Countersink screw, Torx® 20/59°	M5x11.5		<b>007899 •</b>
Spanner wrench	50x5	Holz-Her up to YOM 2016	<b>117538 •</b>

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



#### WhisperCut jointing / milling cutter - cutterhead design

##### Application:

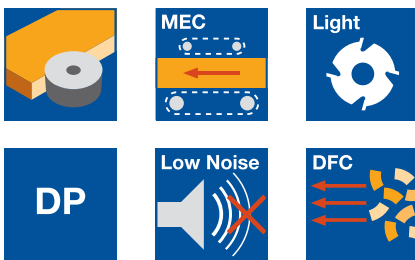
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

##### Machine:

Edgebanding machines, copy shaping machines, double-end tenoners etc.

##### Workpiece material:

Chip and fibre boards (MDF etc.) raw, veneered, painted and coated; especially for plastic, paper, HPL and anti-fingerprint coatings. Also suitable for surfaces in mat, high gloss or with relief structures.

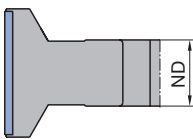


##### Technical information:

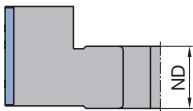
DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for tightly fitting edgebanding. Noise reduced design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) through DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.

##### Diamaster WhisperCut EdgeExpert - DFC, LowNoise, aluminium alloy tool body WM 230 2 01

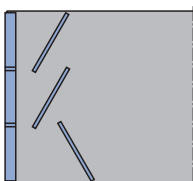
Machine	D	SB	ND	BO	NAL	$n_{\max}$	Z	Type	ID	ID
	mm	mm	mm	mm		min <sup>-1</sup>			LH	RH
Biesse	125	43	40	30 DKN	2	13700	3x6	S	192249 ●	192249 ●
Biesse	125	63	40	30 DKN	2	13700	3x8	S	192250 ●	192250 ●
Homag	125	43	40	30 DKN	2	13700	3x6	S	192249 ●	192249 ●
IMA	125	43	40	30 DKN	2	13700	3x6	AS	192251 ●	192252 ●
IMA	125	63	40	30 DKN	3	13700	3x8	AS	192301 ●	192302 ●



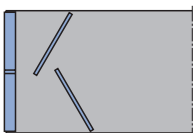
Position of boss (NAL) 2



Position of boss (NAL) 3



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



#### WhisperCut jointing / milling cutter - cutterhead design

##### Application:

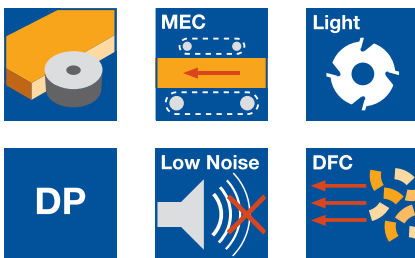
For tear-free and noise reduced jointing of workpiece cutting surfaces with and against feed (jump cutting) particularly for sensitive decorative papers, foil coatings and veneers.

##### Machine:

Edgebanding machines, copy shaping machines, double-end tenoners etc.

##### Workpiece material:

Chip and fibre boards (MDF etc.) raw, veneered, painted and coated; especially for plastic, paper, HPL and anti-fingerprint coatings. Also suitable for surfaces in mat, high gloss or with relief structures.



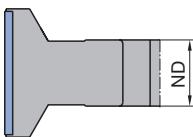
##### Technical information:

DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Tool with knife arrangement S can be used lefthand and righthand and produces a hollow cut for tightly fitting edgebanding. Noise reduced design with up to 5 dB(A) noise reduction and highly efficient chip collection (>95%) through DFC. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 3.1 mm resharpening area.

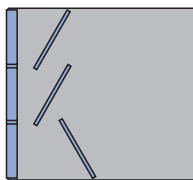
##### Diamaster WhisperCut PLUS EdgeExpert - DFC, LowNoise, aluminium alloy tool body

WM 230 2 02

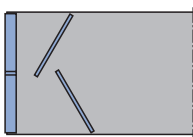
Machine	D	SB	ND	BO	NAL	$n_{\max}$	Z	Type	ID	ID
	mm	mm	mm	mm		$\text{min}^{-1}$			LH	RH
Biesse	125	43	40	30 DKN	2	13700	3x6	S	192255 ●	192255 ●
Homag	125	43	40	30 DKN	2	13700	3x6	S	192255 ●	192255 ●
IMA	125	43	40	30 DKN	2	13700	3x6	AS	192256 ●	192257 ●



Position of boss (NAL) 2



Type AS = asymmetric tip arrangement



Type S = symmetric tip arrangement



### Jointing / milling cutter on hydro sleeve

#### Application:

For tear-free and low noise jointing of workpiece edges side with and against feed (jump cutting).

#### Machine:

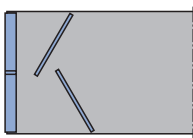
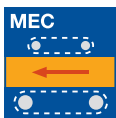
Edgebanding machines with zero joint technology.

#### Workpiece material:

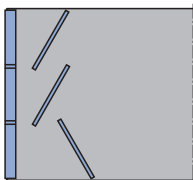
Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

#### Technical information:

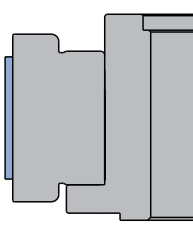
Increase of the processing quality through zero clearance hydro adaptor. Tool with alternate shear angle for tear-free jointing edge and straight cutting surface. Low noise design with noise reduction up to 5 dB(A) and highly efficient chip collection (>95%). Tool with knife arrangement S produces hollow cut for tightly closing edgebanding.



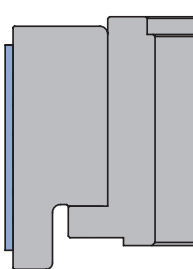
Type S = symmetric knife arrangement



Type AS = asymmetric tip arrangement



Position of boss (NAL) 1



Position of boss (NAL) 2

#### Diamaster PRO mounted on hydro sleeve

HF 230 2, HF 230 2 DP

Machine	D mm	SB mm	BO mm	$n_{\max}$ min <sup>-1</sup>	NAL	Z	Type	ID LH	ID RH
Homag	125	43	30	13,600	1	5x4	S	192133 □	192134 □
Homag	125	63	30	13,600	1	5x6	S	192135 □	192136 □
Homag	150	43	30	13,600	1	5x4	S	192205 □	192206 □
Homag	150	63	30	13,600	1	5x6	S	192207 □	192208 □

#### Diamaster WhisperCut EdgeExpert mounted on hydro sleeve

HM 230 2 01

Machine	D mm	SB mm	BO mm	$n_{\max}$ min <sup>-1</sup>	NAL	Z	Type	ID LH	ID RH
IMA	125	43	30	13,700	1	4x6	AS	192259 □	192258 □
IMA	125	63	30	13,700	1	4x8	AS	192261 □	192260 □
IMA	150	43	30	13,700	1	4x6	AS	192263 □	192262 □
IMA	150	63	30	13,700	1	4x8	AS	192265 □	192264 □

#### Diamaster PRO mounted on hydro sleeve, IMA aggregate 08.379

WM 230 2 01

Machine	D mm	SB mm	BO mm	$n_{\max}$ min <sup>-1</sup>	NAL	Z	ID LH	ID RH
IMA	125	65	30	13,700	2	4x7	192313 ●	192312 ●
IMA	125	43.5	30	13,700	2	4x5	192315 ●	192314 ●

#### Spare parts:

BEZ	ABM mm	ID
Securing part	for HF-spindle HF 30	066563 ●
Allen key	SW 5, L 150	005501 ●

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



#### Jointing / milling cutter on HSK-F 63 arbor

##### Application:

For low noise jointing of workpiece edges with and against feed (jump cutting).

##### Machine:

Edgebanding machines with zero joint technology.

##### Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

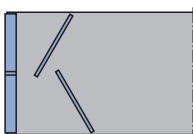
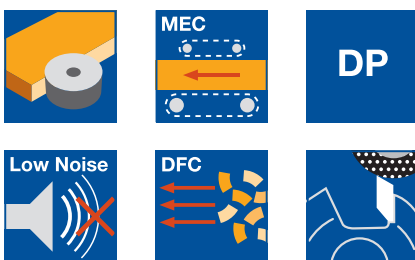
##### Technical information:

Increase of the processing quality through zero clearance HSK adaptor. Composite tool with alternate shear angle for tear-free jointing edge and straight cutting surface. Low noise design with noise reduction up to 5 dB(A) and highly efficient chip collection (>95%). Tool with knife arrangement S produces hollow cut for tightly closing edgebanding. 1.5 mm resharping area.

##### Diamaster PRO mounted on HSK-F 63 mod.

WF 230 2 DP

Machine	D mm	SB mm	BO mm	$n_{max}$ min <sup>-1</sup>	Z	Type	ID LH	ID RH
Homag	150	43	HSK-F 63 mod.	13600	5x4	S	<b>192197</b> □	<b>192198</b> □
Homag	150	63	HSK-F 63 mod.	13600	5x6	S	<b>192199</b> □	<b>192200</b> □



Type S = symmetric knife arrangement



#### Jointing / milling cutter

##### Application:

For jointing/milling rebates in panel edges.

##### Machine:

Edgebanding machines and double-end tenoners.

##### Workpiece material:

Chip and fibre boards (MDF etc.) uncoated, veneered, plastic and paper coated.

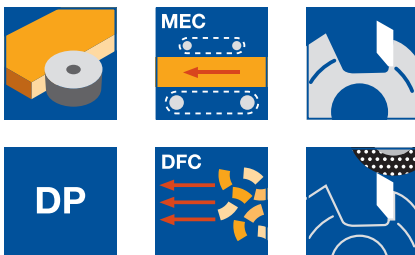
##### Technical information:

Composite tool with alternate shear angle for tear-free edges. DFC design for chip flow and efficient chip clearance (>95%). 1.5 mm resharping area.

##### Diamaster PRO - DFC

WF 230 2 DP

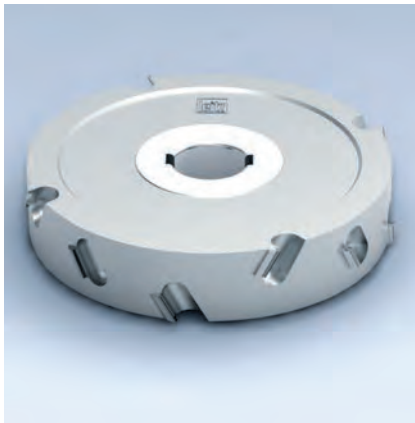
D mm	SB mm	ND mm	BO mm	$n_{max}$ min <sup>-1</sup>	Z	ID LH	ID RH
150	45	39	30 DKN	11400	4x5	<b>192266</b>	<b>192267</b>
150	64	39	30 DKN	11400	4x7	<b>192268</b>	<b>192269</b>



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.2 Jointing cutters



#### Protection milling / jump cutting

##### Application:

For tear-free jointing with and against feed (e.g. jump cutting).

##### Machine:

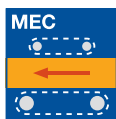
Edgebanding machines and double-end tenoners.

##### Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

##### Technical information:

Tool with alternate shear angle for tear-free edges and jointed edge. Low noise design with noise reduction of up to 5 dB(A) and efficient chip clearance (>95%). 1.5 mm resharping area.



##### Diamaster PRO - DFC, LowNoise

WF 230 2 DP

Machine	D mm	SB mm	ND mm	BO mm	NAL	$n_{max}$ min <sup>-1</sup>	Z	Type	ID LH	ID RH
Homag, IMA	180	32	42	35 DKN	1	9,500	4x3	AS	<b>090851</b>	<b>090852</b>
Homag, IMA	180	43	46	35 DKN	1	9,500	4x4	AS	<b>090841</b> ●	<b>090842</b> ●
Homag, IMA	180	63	46	35 DKN	3	9,500	4x6	AS	<b>090839</b> ●	<b>090840</b> ●



#### Protection milling / jump cutting

##### Application:

For tear-free jointing with and against feed (e.g. jump cutting).

##### Machine:

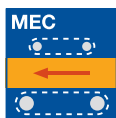
Edgebanding machines and double-end tenoners.

##### Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

##### Technical information:

Tool with large, alternate shear angle for tear-free edges and straight jointed edge. 4.0 mm resharping area.



##### Diamaster PLUS

WF 230 2

Machine	D mm	SB mm	ND mm	BO mm	NAL	$n_{max}$ min <sup>-1</sup>	Z	Type	ID LH	ID RH
Homag, IMA	180	34	34	35 DKN	2	9500	6x3	AS	<b>090847</b>	<b>090848</b>
Homag, IMA	180	43	46	35 DKN	1	9500	6x5	AS	<b>192056</b>	<b>192057</b>
Homag, IMA	180	63	46	35 DKN	3	9500	6x7	AS	<b>192058</b>	<b>192059</b>
Homag, IMA	180	34	34	35 DKN	2	9500	8x4	AS	<b>192060</b>	<b>192061</b>
Homag, IMA	180	43	46	35 DKN	1	9500	8x5	AS	<b>192062</b>	<b>192063</b>
Homag, IMA	180	63	46	35 DKN	3	9500	8x7	AS	<b>192064</b>	<b>192065</b>

##### Recommended feed rate for 6000 min<sup>-1</sup> for veneered or coated particle and fibre materials.

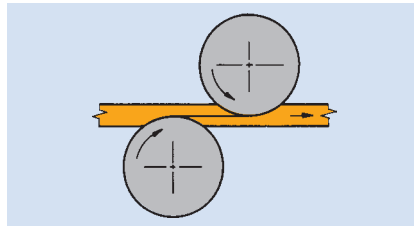
Z=4	25 m min <sup>-1</sup>
Z=6	35 m min <sup>-1</sup>
Z=8	45 m min <sup>-1</sup>
Z=10	55 m min <sup>-1</sup>
Z=12	65 m min <sup>-1</sup>
Z=14	80 m min <sup>-1</sup>



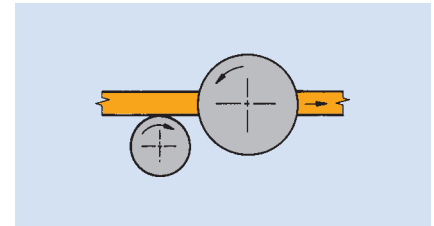
## 2. Panel processing

### 2.1 Edge processing 2.1.3 Compact hoggers - DP

<b>Process</b>	Hogging along and across the grain, sizing.
<b>Workpiece materials</b>	Chipboard and fibre materials (MDF) uncoated, with plastic or veneer coating.
<b>Machines</b>	Single sided, double-sided machines and double-end tenoners.
<b>Application</b>	Both sizing processes “double hogging” and “scoring/hogging” require two basic hogging types with different cutting geometries: <b>Diamaster DT Premium</b> – Double hogging with feed and negative rake angle and <b>Diamaster DT Premium Score</b> – Scoring/cutting with against feed with positive cutting angle.

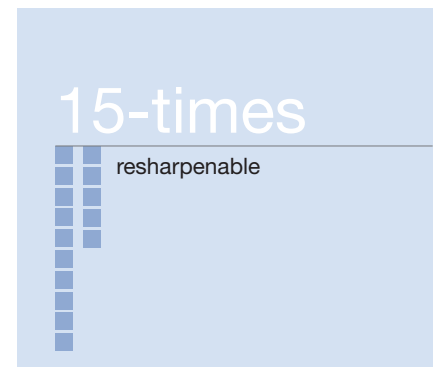
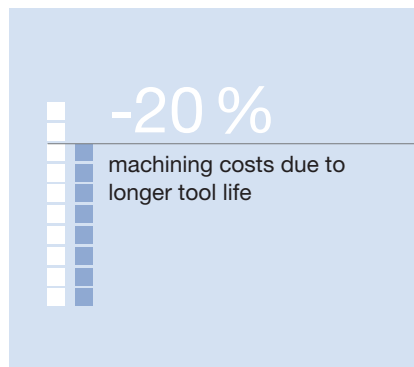


Double hogging: Both hoggers cut with feed.



Scoring/hogging: Scoring saw cuts with feed, hogger against feed.

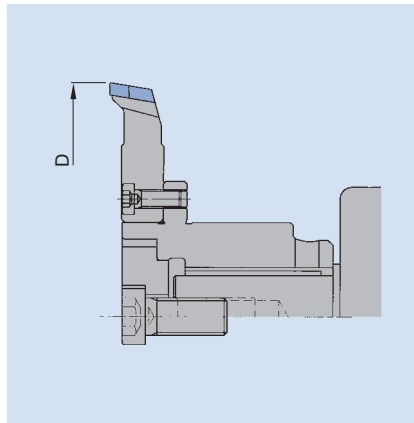
<b>Compact hogger DT Premium</b>	Manufacturers are facing major challenges due to their customers demanding changing quantities as well as requesting a wide variety of carrier and decorative materials to be used in panel production. The new DT Premium compact hogger is the solution for increasing productivity thanks to its long tool life – with perfect quality on the edge and cutting surface.
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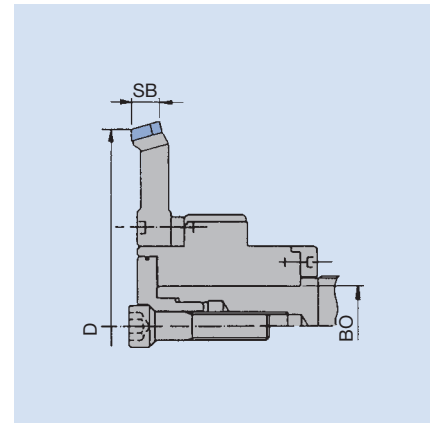
<b>Productivity &amp; efficiency</b>	<p>Maximum economic efficiency through long tool life</p> <ul style="list-style-type: none"> <li>– Long tool life even under difficult operating conditions thanks to new tooth shape</li> <li>– Reduction of set-up costs due to long tool life</li> <li>– Efficient chip removal due to innovative gullet geometry and integrated chipbreaker</li> <li>– Cost efficient processing of various materials</li> <li>– Ideal also for batch size 1 due to adapted cutting geometries</li> <li>– Resharpenable up to 15 times through larger resharpening area</li> </ul>
<b>Quality</b>	<p>Perfect edges and cutting surfaces</p> <ul style="list-style-type: none"> <li>– Excellent edge quality and smooth cutting surfaces through adapted cutting geometries</li> <li>– Clean workpiece finishes due to efficient chip removal with DFC®-Technology</li> <li>– Constant cutting width over the entire life cycle</li> </ul>
<b>Sustainability</b>	<p>Longer tool life time, less dust and noise</p> <ul style="list-style-type: none"> <li>– Reduced noise due to special tool design</li> <li>– Reduction of noise and vibration through damping elements</li> <li>– Longer tool life time through larger resharpening area</li> </ul>



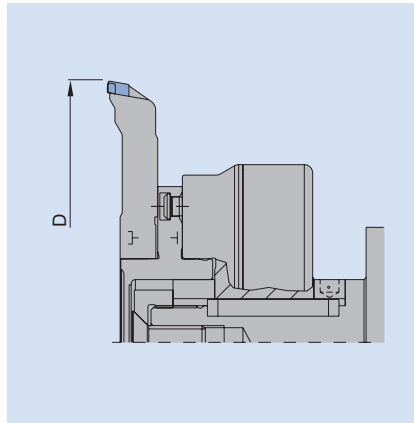
##### Designs



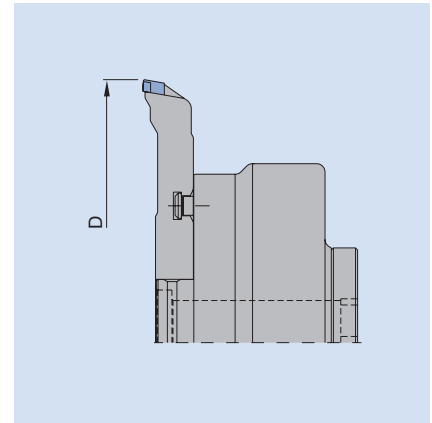
Tooth shape: top bevel decreasing.  
Hogger on standard flange.



Tooth shape: top bevel increasing.  
Hogger on HF hydro sleeve.



Tooth shape: top bevel decreasing.  
Hogger on quick change sleeve.



Tooth shape: top bevel decreasing.  
Hogger on hydro quick change sleeve.



### Diamaster DT Premium

#### Application:

For hogging along and across grain - sizing - especially for **hogging / hogging**.

#### Machine:

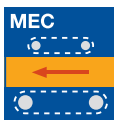
Double-end tenoners, edgebanding machines etc.

#### Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, light construction panels (honeycomb).

#### Technical information:

Maximum economic efficiency through long tool life even in different materials (batch size 1). Up to 15 times resharpenable and constant cutting width over the entire life cycle. Perfect edge quality and smooth cutting surfaces through adapted cutting geometries. Clean workpiece finishes due to efficient chip removal with DFC-technology. Hogger as standard with 4 pinholes reference diameter 100 and quick clamping system 160 (BO 60) and 192 (BO 80).



#### Diamaster DT Premium

HZ 210 2

D mm	SB mm	BO mm	ZF	Z	$v_f^*$ m min <sup>-1</sup>	ID LH	ID RH
250	10	60	1	24	30	190382 □	190383 □
250	10	60	1	30	35	190386	190387
250	10	60	1	36	40	190390 □	190391 □
250	10	60	1	42	45	190394	190395
250	10	60	1	48	50	190398 □	190399 □
250	10	60	1	54	60	190402	190403
250	10	60	1	60	80	190406	190407
250	10	60	2	24	30	190384 □	190385 □
250	10	60	2	30	35	190388	190389
250	10	60	2	36	40	190392 □	190393 □
250	10	60	2	42	45	190396	190397
250	10	60	2	48	50	190400 □	190401 □
250	10	60	2	54	60	190404	190405
250	10	60	2	60	80	190408	190409
250	10	80	1	24	30	190410 □	190411 □
250	10	80	1	30	35	190414	190415
250	10	80	1	36	40	190418 □	190419 □
250	10	80	1	42	45	190422	190423
250	10	80	1	48	50	190426 □	190427 □
250	10	80	1	54	60	190430	190431
250	10	80	1	60	80	190434	190435
250	10	80	2	24	30	190412 □	190413 □
250	10	80	2	30	35	190416	190417
250	10	80	2	36	40	190420 □	190421 □
250	10	80	2	42	45	190424	190425
250	10	80	2	48	50	190428 □	190429 □
250	10	80	2	54	60	190432	190433
250	10	80	2	60	80	190436	190437

Further dimensions on request.

Standard flanged sleeves, hydro clamping elements, quick clamping and hydro quick clamping sleeves, see section Clamping Systems.

\* Recommended feed rate.

#### Order example:

Hogging set D-250 mm, Z 36, right  
Hogging set consisting of:  
DT Premium hogger D-250 ID **190391**  
Hydro clamping sleeve ID **061702**

#### Special information:

Including assembly, machine model

#### Tooth shape 1 (ZF 1):

For processing different materials  
(batch size 1), coated wood materials  
such as HPL, melamine, high gloss.

#### Tooth shape 2 (ZF 2):

For processing veneers, paper,  
honeycomb panels.



#### Diamaster DT *Premium Score*

##### Application:

For hogging along and across grain - sizing - especially for **scoring / hogging**.

##### Machine:

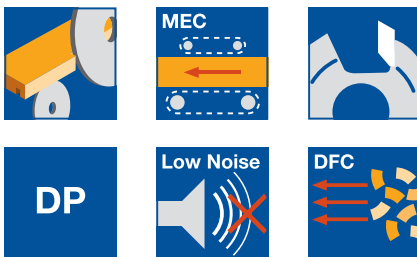
Double-end tenoners, edgebanding machines etc.

##### Workpiece material:

Chip and fibre board (MDF etc.) uncoated, veneered, plastic and paper coated, light construction panels (honeycomb).

##### Technical information:

Maximum economic efficiency through long tool life even in different materials (batch size 1). Up to 15 times resharpenable and constant cutting width over the entire life cycle. Perfect edge quality and smooth cutting surfaces through adapted cutting geometries. Clean workpiece finishes due to efficient chip removal with DFC-technology. Hogger as standard with 4 pinholes reference diameter 100 and quick clamping system 160 (BO 60) and 192 (BO 80).



##### Order example:

Hogging set D-250 mm, Z 36, right

Hogging set consisting of:

DT Premium Score hogger D-250

ID **190443**

Hydro clamping sleeve ID **061702**

##### Special information:

Including assembly, machine model

##### Tooth shape 1 (ZF 1):

For processing different materials (batch size 1), coated wood materials such as HPL, melamine, high gloss.

##### Tooth shape 2 (ZF 2):

For processing veneers, paper, honeycomb panels.

#### Diamaster DT Premium Score

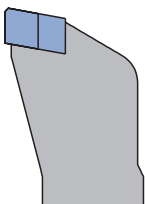
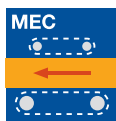
HZ 210 2

D	SB	BO	ZF	Z	$v_f^*$	ID	ID
mm	mm	mm			m min <sup>-1</sup>	LH	RH
250	10	60	1	24	18	<b>190438</b>	<b>190439</b>
250	10	60	1	36	25	<b>190442</b>	<b>190443</b>
250	10	60	1	48	30	<b>190446</b>	<b>190447</b>
250	10	60	1	60	40	<b>190450</b>	<b>190451</b>
250	10	60	2	24	18	<b>190440</b>	<b>190441</b>
250	10	60	2	36	25	<b>190444</b>	<b>190445</b>
250	10	60	2	48	30	<b>190448</b>	<b>190449</b>
250	10	60	2	60	40	<b>190452</b>	<b>190453</b>
250	10	80	1	24	18	<b>190454</b>	<b>190455</b>
250	10	80	1	36	25	<b>190458</b>	<b>190459</b>
250	10	80	1	48	30	<b>190462</b>	<b>190463</b>
250	10	80	1	60	40	<b>190466</b>	<b>190467</b>
250	10	80	2	24	18	<b>190456</b>	<b>190457</b>
250	10	80	2	36	25	<b>190460</b>	<b>190461</b>
250	10	80	2	48	30	<b>190464</b>	<b>190465</b>
250	10	80	2	60	40	<b>190468</b>	<b>190469</b>

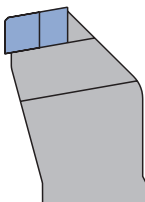
Further dimensions and version with veneer cutting edges (FUZ) on request.

Standard flanged sleeves, hydro clamping elements, quick clamping and hydro quick clamping sleeves, see section Clamping Systems.

\* Recommended feed rate.



Tooth with decreasing bevel for higher cutting performance, particularly suitable for material with a loose middle layer.



Tooth with increasing bevel for maximum stability, particularly suitable for materials with high mineral content and boards with large material overhang. At decreasing bevel and low overlap remain strips, which won't be hogged.

### Compact hogger

#### Application:

For hogging along and across grain - for sizing applications in double hogging process (**hogging / hogging**).

#### Machine:

Double-end tenoners, edgebanding machines etc.

#### Workpiece material:

Particle and fibre materials (MDF etc.) uncoated, veneered, plastic and paper coated, lightweight panels (honeycomb).

#### Technical information:

Resharpenable 10 times. **Tooth with decreasing bevel** for higher cutting performance, particularly suitable for materials with a loose middle layer. **Tooth with increasing bevel** for maximum stability, particularly suitable for materials with high mineral content and boards with a large material overhang.

#### For mounting on hydro clamping or hydro quick clamping sleeve

HZ 210 2

D mm	SB mm	BO mm	Z	ZF	$v_f^*$ m min <sup>-1</sup>	ID LH	ID RH
250	10	60	35	decreasing	35	<b>190358</b> ●	<b>190359</b> ●
250	10	60	45	decreasing	45	<b>190360</b> ●	<b>190361</b> ●
250	10	60	55	decreasing	55	<b>190362</b>	<b>190363</b>
253	10	60	35	increasing	35	<b>190364</b>	<b>190365</b>
253	10	60	45	increasing	45	<b>190366</b>	<b>190367</b>
253	10	60	55	increasing	55	<b>190368</b>	<b>190369</b>

#### For mounting on flanged sleeve or quick clamping sleeve

HZ 210 2

D mm	SB mm	BO mm	Z	ZF	$v_f^*$ m min <sup>-1</sup>	ID LH	ID RH
250	10	80	35	decreasing	35	<b>190370</b>	<b>190371</b>
250	10	80	45	decreasing	45	<b>190372</b>	<b>190373</b>
250	10	80	55	decreasing	55	<b>190374</b>	<b>190375</b>
253	10	80	35	increasing	35	<b>190376</b>	<b>190377</b>
253	10	80	45	increasing	45	<b>190378</b>	<b>190379</b>
253	10	80	55	increasing	55	<b>190380</b>	<b>190381</b>

Standard flanged sleeves, hydro clamping, quick clamping and hydro quick clamping sleeves, see Lexicon section Clamping Systems.

\* Recommended feed rate for coated chipboard materials and fibre materials.

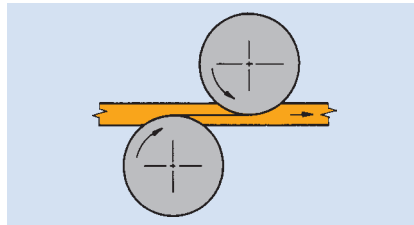
## 2. Panel processing

### 2.1 Edge processing

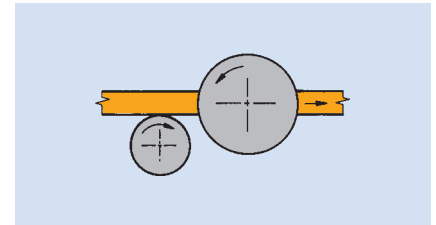
#### 2.1.4 Cutting and segment hoggers

<b>Process</b>	Hogging along and across grain with/without scoring sawblades.
<b>Workpiece materials</b>	Solid wood, wood derived materials and composite materials.
<b>Machines</b>	Multi-rip saws, double-end tenoners, window making machines, edgebanding machines.

#### Application



Double hogging:  
Both hoggers cut with feed.



Scoring/hogging:  
Scoring saw cuts with feed, hogger against feed.

#### Recommended tooth shape hogger sawblades

Workpiece material	FZ	ES	WZ
Softwood and hardwood along grain	■		□
Softwood and hardwood across grain		■	■
Laminated wood along grain	□	■	
Laminated wood across grain		■	■
Chip/fibre materials without coating	■	□	
Chip/fibre materials plastic coated	■	□	
Chip/fibre materials veneered		■	■
Chip/fibre materials paper coated		■	□
Composite material HPL-coated	■	□	
Composite material HDF, MDF veneered		■	□

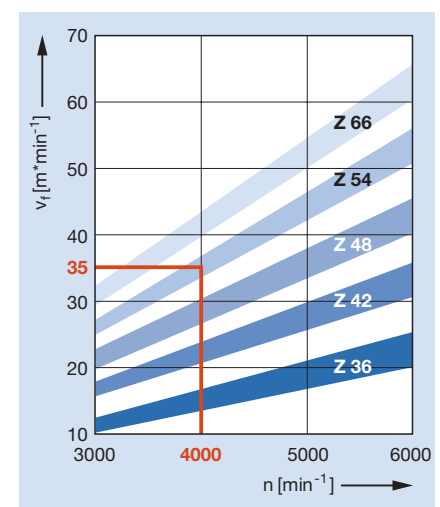
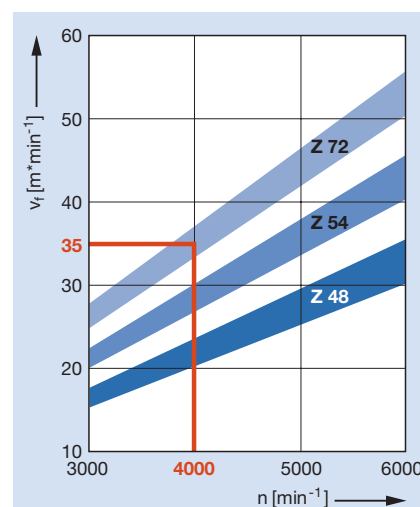
- suitable  
□ partly suitable

#### Cutting width and RPM

Tool*	D/mm	SB/mm	RPM max.
Segment hogger	250	25 – 50	7200 m/min <sup>-1</sup>
	300	30 – 60	6000 m/min <sup>-1</sup>
	350	35 – 70	5100 m/min <sup>-1</sup>

\* A larger sawblade diameter is recommended for veneered chipboard, fibre materials and laminated wood (e.g. hogger D 250 mm → recommended sawblade D 260 mm).

#### Segment hogger



Feed speed  $v_f$  in relation to the number of teeth  $Z$  and RPM  $n$ .

### 2.1 Edge processing

#### 2.1.4 Cutting and segment hoggers

##### Segment hogger

Segment hoggers are a modular design. Segment hoggers are used, depending on the diameter, for hogging widths from 25 to 70 mm. Hoggers or segment hoggers combined with different circular sawblades are suitable for cutting the following materials along and across the grain:

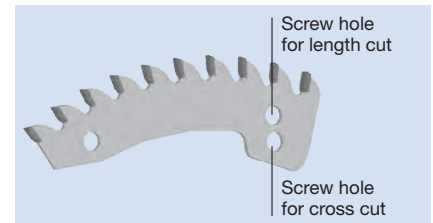
- Solid wood
- Wood derived materials without coating
- Wood derived materials with coating, with veneer, with paper etc.
- Composite materials



Cross cut



Length cut



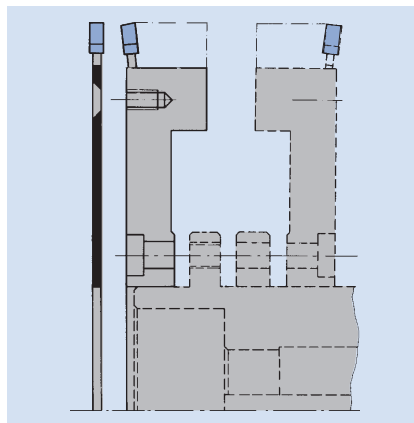
The hogging segments in segment hoggers are set either for length and or cross cut. The cross cut setting reduces the risk of breaking the corner of the workpiece when cross cutting against the feed.

Segment hoggers with up to 12 segments are used for edging and sizing on wood-derived material production lines (e.g. Siempelkamp, Kontra etc.). A special segment hogger design has been developed for the finish cut on wood derived material production lines.

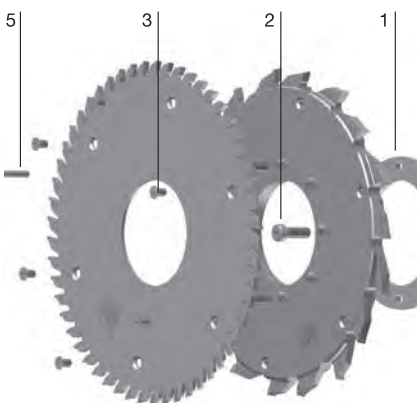
##### Saw hogger

Saw hoggers, single tools or assemblies with cutting widths of 6.35 - 12.00 mm are used for hogging along and across the grain and to size solid wood on finger jointing machines.

##### Assembly design/examples



Segment hogger with extension hogger.



### Hoggers

#### Application:

For tear-free sizing along and across grain. Machining against feed only combined with scoring sawblade. Defined trimming in front of the finger cut for adjusting the finger fit.

#### Machine:

Double-end tenoner, finger joint machine with trimming aggregate.

#### Workpiece material:

Solid wood and wood derived materials.

#### Technical information:

Steel tool body with HW circular sawblade and hogger elements mounted on flanged sleeve. Can be extended for larger hogger widths. Single sided bevel tooth shape reduces tear outs.

#### Basic hogger - steel tool body without flanged sleeve

WZ 210 2 01

BEZ	ABM mm	QAL	Z	ID LH	ID RH
Basic hogger	251x12x80	HW	18	<b>062602</b> ●	<b>062603</b> ●
Basic hogger	301x12x80	HW	24	<b>062604</b> ●	<b>062605</b> ●

#### Spare parts:

Part- no.	BEZ	ABM mm	BEM	ID
1	Spacer	115x5x80		<b>028046</b> ●
2	Cylindrical screw with ISK	M8x20		<b>005946</b> ●
3	Countersink screw, Torx® 20	M6x10	Torx® 20	<b>006083</b> ●
4	Screw with ISK	M8x17	for D = 250/350/305/355	<b>006237</b> ●
5	Allen key	SW 6		<b>005494</b> ●
6	Torx® key	Torx® 20		<b>117503</b> ●

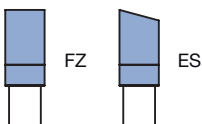
#### Additional hogger - steel tool body

WZ 210 2 02

D mm	SB mm	BO mm	Z	QAL	ID LH	ID RH
251	12	80	18	HW	<b>062652</b> ●	<b>062653</b> ●
251	12	80	24	HW	<b>062654</b> ●	<b>062655</b> ●

#### Application:

Tear-free sizing along and across the grain for working against the feed only with a scoring sawblade. Defined trimming in front of the finger cut for adjusting the finger fit.

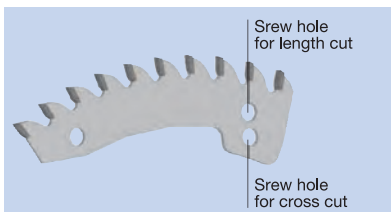
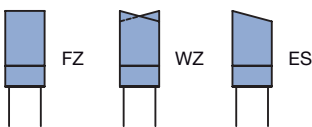
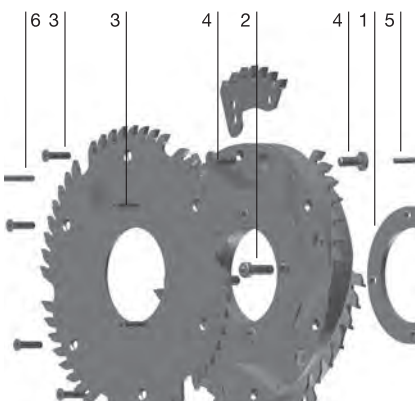
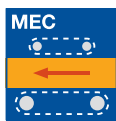


#### Circular sawblade

WK 800 2 09, WK 800 2 38, WK 801 2, WK 801 2 05

D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
250	4.4	80	54	FZ	HW	<b>061825</b> ●	<b>061826</b> ●
250	4.4	80	54	ES	HW	<b>061837</b> ●	<b>061838</b> ●
250	4.4	80	72	FZ	HW	<b>061945</b> ●	<b>061946</b> ●
260	4.4	80	72	ES	HW	<b>061860</b> ●	<b>061861</b> ●
260	4.4	80	72	FZ	HW	<b>061947</b> ●	<b>061948</b> ●
300	4.4	80	48	FZ	HW	<b>061827</b> ●	<b>061828</b> ●
300	4.4	80	48	ES	HW	<b>062028</b> ●	<b>062029</b> ●
300	4.4	80	72	FZ	HW	<b>061949</b> ●	<b>061950</b> ●





Spare segments for segment hogger

### Segment hoggers

#### Application:

For tear-free sizing along and across grain. Machining against feed only combined with scoring sawblade. Defined trimming in front of the finger cut for adjusting the finger fit.

#### Machine:

Double-end tenoners, finger joint machine with trimming aggregate, plug cutter.

#### Workpiece material:

All types of solid wood, chip and fibre boards (MDF etc.) raw, veneered, plastic and paper coated.

#### Technical information:

Steel tool body with HW circular sawblade and segment hogging elements. Staggered cut through six hogger segments. Mounted on flanged sleeve. Can be extended for larger hogging width. Single sided bevel tooth shape to improve the cutting quality and to reduce tear outs.

#### Steel basic and extension hoggers without flanged sleeve

WZ 300 2

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	26.0	80	6x7	FZ	HW	<b>064410</b> ●	<b>064411</b> ●
300	31.5	30	6x9	FZ	HW	<b>064412</b> ●	<b>064413</b> ●
350	36.5	30	6x10	FZ	HW	<b>064414</b> ●	<b>064415</b> ●

#### Spare parts:

Part- no.	BEZ	ABM mm	BEM	ID
1	Spacer	115x5x80		<b>028046</b> ●
2	Cylindrical screw with ISK	M8x20		<b>005946</b> ●
3	Countersink screw, Torx® 20	M6x10	Torx® 20	<b>006083</b> ●
4	Screw with ISK	M8x17	for D = 250/350/305/355	<b>006237</b> ●
5	Allen key	SW 6		<b>005494</b> ●
6	Torx® key	Torx® 20		<b>117503</b> ●

#### Spare circular sawblade for segment hogging set

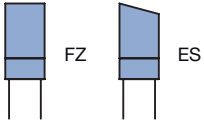
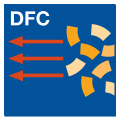
WK 800 2 45, WK 800 2 46, WK 801 2, WK 850 2 45

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	3.2	80	42	WZ	HW	<b>058219</b>	<b>058220</b>
250	4.4	80	48	FZ	HW	<b>061831</b> ●	<b>061832</b> ●
250	4.4	80	48	ES	HW	<b>061878</b> ●	<b>061879</b> ●
250	4.4	80	66	FZ	HW	<b>061953</b> ●	<b>061954</b> ●
260	4.4	80	48	ES	HW	<b>061963</b>	<b>061964</b>
260	4.4	80	66	ES	HW	<b>061965</b> ●	<b>061966</b> ●
300	4.4	30	42	FZ	HW	<b>061833</b>	<b>061834</b>
300	3.2	30	54	WZ	HW	<b>058221</b> ●	<b>058222</b> ●
300	4.4	30	66	FZ	HW	<b>061055</b> ●	<b>061056</b> ●
350	3.2	30	66	WZ	HW	<b>058223</b> ●	<b>058224</b> ●

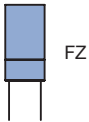
#### Spare segments for segment hogger

TM 170 0

BEZ	ABM mm	SB mm	QAL	ZF	Z	ID	ID
						LH	RH
Hogging segment	D 250	5.7	HW	FZ	7	<b>064958</b> ●	<b>064959</b> ●
Hogging segment	D 300	5.7	HW	FZ	9	<b>064960</b> ●	<b>064961</b> ●
Hogging segment	D 350	5.7	HW	FZ	10	<b>064962</b> ●	<b>064963</b> ●



DFC segment hogger available on special request.



##### Spare circular sawblade for DFC segment hogger

WK 801 2, WK 801 2 05

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	4.4	80	54	ES	HW	<b>061837 ●</b>	<b>061838 ●</b>
260	4.4	80	54	ES	HW	<b>061858</b>	<b>061859</b>
260	4.4	80	72	ES	HW	<b>061860</b>	<b>061861</b>

##### Circular sawblades:

Tooth shape **ES** is optimised to cut across grain on softwood, hardwood, wood derived materials, veneered and paper coated and veneered composite materials.

##### Segments for DFC hogger (6 pieces / hogger)

TM 170 0

D	Z	ZF	QAL	ID	ID
mm				LH	RH
246	5	FZ	HW	<b>064974 ●</b>	<b>064975 ●</b>

DFC segment hogger available on special request.

##### Circular sawblade for non-Leitz segment hoggers

WK 800 2 46

Type	D	SB	BO	Z	ZF	QAL	ID	ID
	mm	mm	mm				LH	RH
1	250	4	80	48	FZ	HW	<b>061870 ●</b>	<b>061871 ●</b>
1	250	4	100	48	FZ	HW	<b>061872 □</b>	<b>061873 □</b>

Type 1 for Leuco.

##### Segments for non-Leitz segment hogger

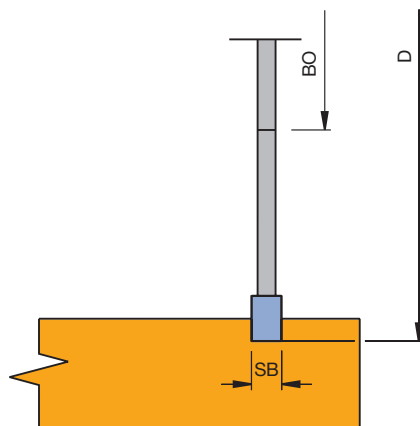
TM 170 0

Type	for D	SB	Z	ZF	QAL	ID	ID
	mm	mm				LH	RH
1	200/250	4	4	FZ	HW	<b>064976 ●</b>	<b>064977 ●</b>

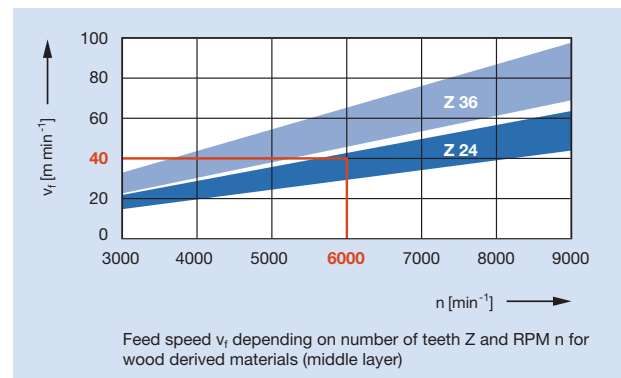
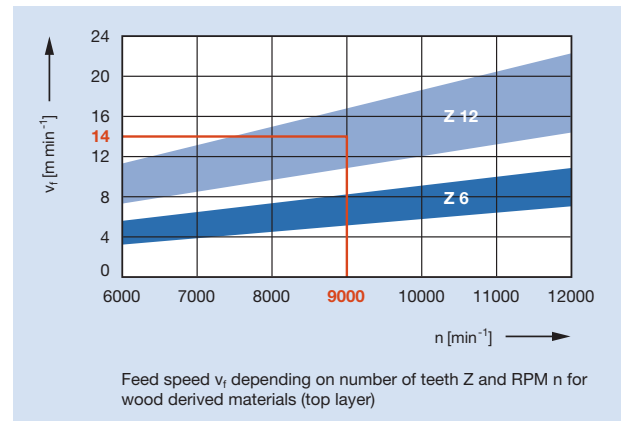
Type 1 for Leuco.

##### Grooving with feed

Straight cut composite tool for grooving with feed (MEC).



Cutting rear panel grooves

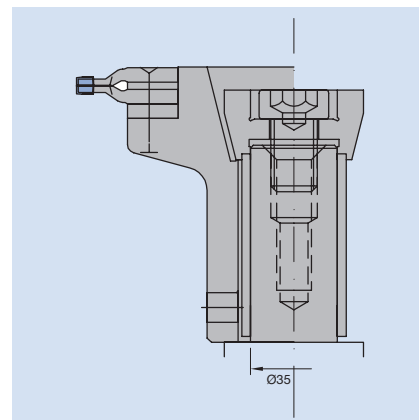


##### Grooving against feed

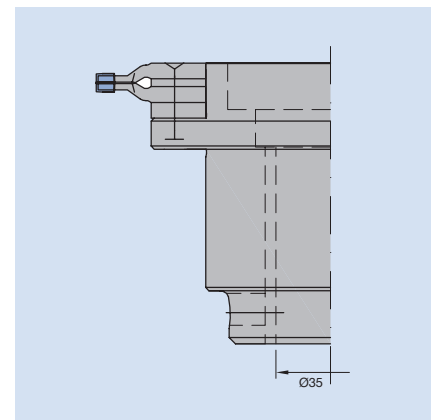
For tear-free cutting of different grooving widths on spindle moulders, moulders, edgebanding machines and double-end tenoners in uncoated and coated wood derived materials.

Adjustment of the cutting width with spacers (adjustment steps 0.1 mm). High chip collection by working against feed. Feed speed up to 40 m min<sup>-1</sup>. Constant grooving width and distances to the machine chain also after regrinding. Special cutting geometry for tear-free cuts. Suitable to mount on sleeves with bore 30, 35 and 40 mm. Tipping height 6.0 mm.

Tools for grooving against feed available on request.



Assembly example:  
Spindle 30 KN or DKN



Assembly example:  
Spindle 35 KN or DKN



### Grooving cutter for mechanical feed

#### Application:

Grooving with feed (climb cut).

#### Machine:

Moulders and double-end tenoners.

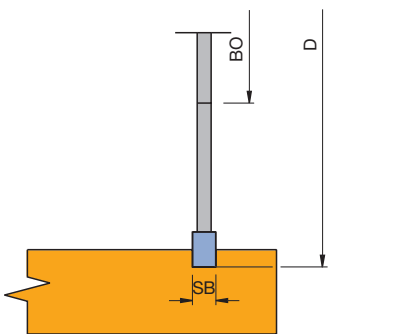
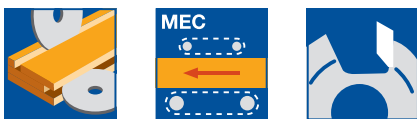
#### Workpiece material:

Solid wood, uncoated, coated and veneered wood derived materials.

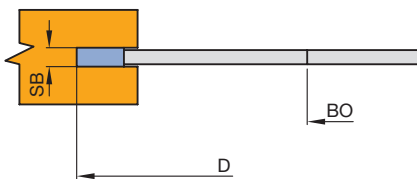
#### Z 12

WF 100 2 02

D mm	SB mm	TDI mm	BO mm	BO <sub>max</sub> mm	Z	n <sub>max</sub> min <sup>-1</sup>	ID
125	1.5	0.8	30	50	12	13700	020145 ●
125	2.0	1.2	30	50	12	13700	020147 ●
125	2.5	1.4	30	50	12	13700	020149 ●
125	3.0	2.0	30	50	12	13700	020150 ●
125	3.5	2.2	30	50	12	13700	020151 ●
125	4.0	2.5	30	50	12	13700	020152 ●
125	4.5	3.0	30	50	12	13700	020153 ●
125	5.0	3.5	30	50	12	13700	020191 ●
125	6.0	4.5	30	50	12	13700	020192 ●
125	7.0	5.0	30	50	12	13700	020193 ●
125	8.0	6.0	30	50	12	13700	020194 ●
125	10.0	7.0	30	50	12	13700	020196 ●
150	3.0	2.0	30	60	12	11400	020154 ●
150	3.5	2.2	30	60	12	11400	020155 ●
150	4.0	2.5	30	60	12	11400	020156 ●
150	4.5	3.0	30	60	12	11400	020157 ●
150	5.0	3.5	30	60	12	11400	020158 ●
150	6.0	4.5	30	60	12	11400	020159 ●
150	7.0	5.0	30	60	12	11400	020160 ●
150	8.0	6.0	30	60	12	11400	020161 ●
150	10.0	7.0	30	60	12	11400	020163 ●



Cutting the rear panel groove



Grooving the narrow side



### Grooving cutter for mechanical feed

#### Application:

Grooving with feed (climb cut).

#### Machine:

Moulders and double-end tenoners.

#### Workpiece material:

Solid wood, uncoated, coated and veneered wood derived materials.

#### Z 18, HW tipped

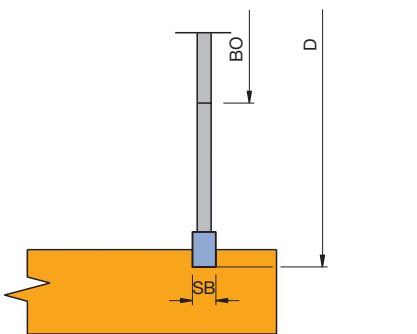
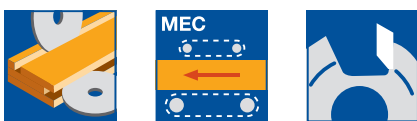
WF 100 2 03

D	SB	TDI	BO	BO <sub>max</sub>	DKN	Z	QAL	n <sub>max</sub>	ID
mm	mm	mm	mm	mm	mm			min <sup>-1</sup>	
150	1.5	0.8	30	60		18	HW	11400	020164 ●
150	2.0	1.2	30	60		18	HW	11400	020166 ●
150	2.5	1.4	30	60		18	HW	11400	020168 ●
150	3.0	2.0	30	60		18	HW	11400	020169 ●
150	4.0	2.5	30	60		18	HW	11400	020170 ●
150	5.0	3.5	30	60		18	HW	11400	020171 ●
150	6.0	4.5	30	60		18	HW	11400	020172 ●
150	8.0	6.0	30	60		18	HW	11400	020173 ●
150	8.5	6.0	30	60		18	HW	11400	020319 ●
150	10.0	7.0	30	60		18	HW	11400	020174 ●
180	2.0	1.2	30	70		18	HW	9500	020202 ●
180	2.5	1.4	30	70		18	HW	9500	020203 ●
180	3.0	2.0	30	70		18	HW	9500	020204 ●
180	3.5	2.2	30	70		18	HW	9500	020205 ●
180	4.0	2.5	30	60		18	HW	9500	020197 ●
180	5.0	3.5	30	60		18	HW	9500	020198 ●
180	6.0	4.5	30	60		18	HW	9500	020199 ●
180	8.0	6.0	30	60		18	HW	9500	020200 ●
180	8.5	6.0	30	60		18	HW	9500	020320 ●
180	10.0	7.0	30	60		18	HW	9500	020201 ●
200	2.0	1.2	35	80	10x45	18	HW	8500	020299 ●
200	2.5	1.4	35	80	10x45	18	HW	8500	020301 ●
200	3.0	2.0	35	80	10x45	18	HW	8500	020302 ●
200	4.0	2.5	35	80	10x45	18	HW	8500	020303 ●
200	5.0	3.5	35	80	10x45	18	HW	8500	020304 ●
200	6.0	4.5	35	80	10x45	18	HW	8500	020305 ●
200	8.0	6.0	35	80	10x45	18	HW	8500	020306 ●
200	8.5	6.0	30	80	10x45	18	HW	8500	020321 ●
200	10.0	7.0	35	80	10x45	18	HW	8500	020307 ●

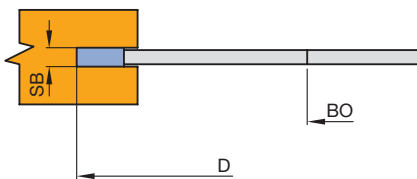
#### Z 18, DP tipped

WF 100 2 DP

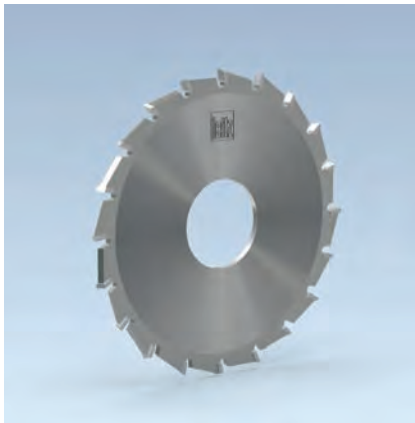
D	SB	TDI	BO	BO <sub>max</sub>	DKN	Z	QAL	n <sub>max</sub>	ID
mm	mm	mm	mm	mm	mm			min <sup>-1</sup>	
150	4.0	2.5	30	60		18	DP	11400	192304 ●
180	4.0	2.5	30	60		24	DP	9500	192305 ●
200	4.0	2.5	30	80	10x45	24	DP	8500	192306 ●



Cutting the rear panel groove



Grooving the narrow side



### Circular sawblade for end trim on edgebanding machines

#### Application:

For low noise edgebanding trim cuts.

#### Machine:

Single or double-sided edgebanding machines and double-end tenoners.

#### Workpiece material:

Veneered, melamine and plastic edging.

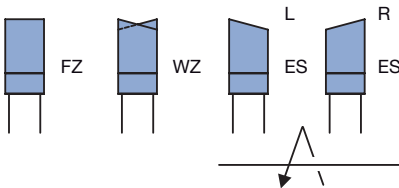
#### Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

#### Veneered and plastic edging:

Edging thickness  $\geq 2.0$  mm - crosscut saw ES pos.

Edging thickness  $< 2.0$  mm - crosscut saw ES neg.



#### Circular sawblade - LowNoise

SK 499 2, WK 101 2, WK 300 2, WK 301 2, WK 311 2, WK 321 2, WK 331 2, WK 372 2

Machine	D	SB	BO	NLA	Z	ZF	ID	ID
	mm	mm	mm	mm			LH	RH
Biesse	115	3.2	52	3/7,1/64	30	ES pos.	<b>166420</b>	<b>166421</b>
Biesse	115	3.2	56	3/7,1/68	30	ES pos.	<b>166422</b>	<b>166423</b>
Biesse	130	3.6	30	4/7,4/46	24	ES pos.	<b>166424</b> ●	<b>166425</b> ●
Biesse	140	3.2	30		36	ES pos.	<b>166427</b> ●	<b>166426</b> ●
Brandt	100	2.6	32		30	ES neg.	<b>166400</b> ●	<b>166401</b> ●
Brandt	100	2.6	32		30	ES pos.	<b>166429</b> ●	<b>166430</b> ●
Brandt	110	2.4	32		40	ES pos.	<b>166432</b>	<b>166433</b>
Brandt	125	2.6	32		30	ES neg.	<b>166403</b> ●	<b>166404</b> ●
Brandt	150	2.8	20		36	ES pos.	<b>166434</b> ●	<b>166435</b> ●
Cehisa	100	3.0	32		30	ES pos.	<b>166436</b> ●	<b>166437</b> ●
Fravol	100	3.2	22		24	ES pos.	<b>166407</b> ●	<b>166406</b> ●
Fravol	100	2.6	30		30	ES pos.	<b>166476</b> ●	<b>166477</b> ●
Fravol	125	3.2	22		30	ES pos.	<b>166411</b> ●	<b>166410</b> ●
Holz-Her	110	3.6	22		16	ES pos.	<b>166439</b> ●	<b>166440</b> ●
Homag	80	3.2	34	8/4,2/44	30	ES pos.	<b>166443</b> ●	<b>166444</b> ●
Homag	92	3.0	32	2/3/52	20	ES pos.	<b>166471</b> ●	<b>166470</b> ●
* Homag	100	3.0	32		20	ES pos.	<b>166445</b> ●	<b>166446</b> ●
Homag	100	3.0	32	2/3,8/52	20	ES pos.	<b>166447</b> ●	<b>166448</b> ●
Homag	100	3.2	32		20	ES neg.	<b>166449</b> ●	<b>166450</b> ●
Homag	100	2.6	32		30	ES neg.	<b>166400</b> ●	<b>166401</b> ●
Homag	100	2.6	32		30	ES pos.	<b>166429</b> ●	<b>166430</b> ●
Homag	110	2.4	32		40	ES pos.	<b>166432</b>	<b>166433</b>
Homag	110	1.7	40	4/5,5/52	30	FZ/TR pos.	<b>166453</b> ●	<b>166453</b> ●
* Homag	120	3.2	40		30	ES pos.	<b>166454</b> ●	<b>166455</b> ●
Homag	125	2.6	32		30	ES neg.	<b>166403</b> ●	<b>166404</b> ●
Homag	150	2.8	20		36	ES pos.	<b>166434</b> ●	<b>166435</b> ●
Homag	150	3.5	30	4/5,6/52	40	ES pos.	<b>166458</b>	<b>166459</b>
IDM	90	3.0	30		20	FZ pos.	<b>166461</b>	<b>166461</b>
SCM	150	3.8	35	4/6,5/50	30	ES pos.	<b>166468</b> ●	<b>166469</b> ●
Türk Makine	140	3.2	30		36	ES pos.	<b>166417</b>	<b>166418</b>
Wilmsmeyer	100	3.2	32		20	ES neg.	<b>166449</b> ●	<b>166450</b> ●

\* = For 2 part set SK 499 2 use mounting flange ID **066750**.

#### Workpiece material:

Softwood, hardwood edging.

#### Technical information:

Tooth geometries and pitch designed for optimum cutting quality.

#### Solid wood edging and multi-purpose application:

Edging thickness  $\geq 2.0$  mm - crosscut saw WZ pos.

Edging thickness  $< 2.0$  mm - crosscut saw WZ neg.

#### Circular sawblade - LowNoise, WZ

WK 250 2, WK 350 2, WK 360 2, WK 370 2, WK 380 2, WK 850 2


Machine	D	SB	BO	NLA	Z	ZF	ID	ID
	mm	mm	mm	mm			LH	RH
Biesse	100	3.2	30		20	WZ pos.	166478 ●	166478 ●
Biesse	160	3.2	20		48	WZ pos.	166428 ●	166428 ●
Brandt	100	2.6	32		30	WZ pos.	166431 ●	166431 ●
Brandt	125	2.4	32		24	WZ pos.	166402 ●	166402 ●
EBM	100	2.4	22	2/4/30	20	WZ neg.	166405 ●	166405 ●
Felder	100	3.2	22		20	WZ pos.	166438 ●	166438 ●
Felder	110	3.2	30		20	WZ pos.	166475 ●	166475 ●
Hebrock	100	2.4	22	2/4/30	20	WZ neg.	166405 ●	166405 ●
Holz-Her	110	3.6	22		20	WZ pos.	065663 ●	065663 ●
Holz-Her	120	3.2	22		20	WZ pos.	166474 ●	166474 ●
Holz-Her	140	3.2	22		36	WZ pos.	166441 ●	166441 ●
Holz-Her	160	3.2	20		48	WZ pos.	166428 ●	166428 ●
Holz-Her	160	3.2	30		24	WZ pos.	065664 ●	065664 ●
Homag	100	3.6	32		20	WZ pos.	166451 ●	166451 ●
Homag	100	2.6	32		30	WZ pos.	166431 ●	166431 ●
Homag	110	3.6	32		20	WZ pos.	166452 ●	166452 ●
Homag	120	3.6	40	8/5,6/52	24	WZ pos.	166419 ●	166419 ●
Homag	120	3.2	40	8/5,6/52	36	WZ pos.	166456 ●	166456 ●
Homag	120	3.6	40	8/5,6/52	36	WZ pos.	166457 ●	166457 ●
Homag	125	2.4	30	8/6,5/48	36	WZ pos.	058234 ●	058234 ●
Homag	125	2.4	32		24	WZ pos.	166402 ●	166402 ●
Homag	170	3.2	30	8/5,6/52	36	WZ pos.	166412 ●	166412 ●
Homag	180	3.2	30	4/5,6/52	54	WZ pos.	166460 ●	166460 ●
IMA	160	3.5	22		36	WZ neg.	166462 ●	166462 ●
IMA	160	3.2	22		48	WZ neg.	166414 ●	166414 ●
IMA	180	3.2	22		48	WZ pos.	166463 ●	166463 ●
IMA	180	3.2	22		48	WZ neg.	166464 ●	166464 ●
IMA	200	3.2	22		64	WZ pos.	166479 ●	166479 ●
IMA 08.415	180	3.5	22		42	WZ neg.	166415 ●	166415 ●
IMA 08.492	160	3,0	22		36	WZ pos.	166413 ●	166413 ●
Ott	140	3.2	16		36	WZ pos.	166466 ●	166466 ●
Raimann	100	3.6	32		20	WZ pos.	166451 ●	166451 ●
Raimann	120	3.2	32		20	WZ neg.	166467 ●	166467 ●
SCM	115	3.2	30		30	WZ pos.	166416 ●	166416 ●



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools

<b>Working processes</b>	<p>Finishing plastic, veneered and solid wood edges of wood material boards.</p> <ul style="list-style-type: none"> <li>– Pre-cutting to remove asymmetric edge protrusions on top and bottom edges and edge trimming solid wood edges.</li> <li>– Profiling a bevel or round edge on top and bottom edges.</li> <li>– Profiling a bevel and round edges on top and bottom edges and front and back.</li> <li>– Profile scrapers to remove knife marks.</li> <li>– Flat scrapers for excellent alignment of edge and workpiece.</li> </ul>
<b>Workpiece material</b>	Thick plastic edgebanding made from PVC, PP, ABS, thin plastic edgebanding made from melamine resin, veneer edgebanding, solid wood banding and edgebanding.
<b>Machines</b>	Single or double-sided edgebanding machines, double-end tenoners.
<b>Application</b>	Against feed for plastic edgebanding, preferably with feed for solid wood edge lippings.
<b>Technical features</b>	Tool and touch roller positions are coordinated, requiring constant tool dimensions. It is recommended not to resharpen edge processing tools.
<b>Chip disposal</b>	Tools marked with the symbol  are optimised for these machines, and guide the chips from the tool cutting edge into the extraction. Even at low extraction air speeds more than 97% of the chips are collected. This improves not only process efficiency and productivity, but also the working environment. New machines require less extraction.



### Pre / finishing edge trimming cutter

#### Application:

To trim edgebandings on horizontal spindles or for bevelling with inclined spindles.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

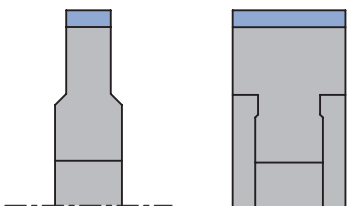
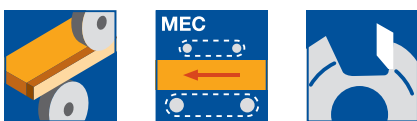
#### Technical information:

HW/DP tipped tools with cylindrical bore.

#### Joining cutter

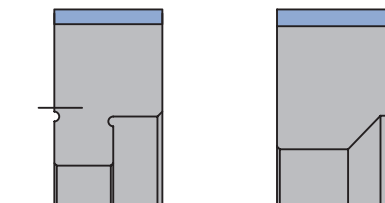
WF 200 2, WF 200 2 DP, WF 210 2 DP

Machine	D mm	SB mm	ND mm	BO mm	Type	Z	QAL	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
Biesse	70	10	12	16	DKN 1	6	DP	18000	090899 ●	090899 ●
Biesse	70	20	12	16	DKN 2	6	DP	18000	090893	090893
Biesse	80	22	12	16	DKN 3	6	DP	18000	192103 ●	192102 ●
Brandt	70	10	12	16	DKN 1	6	DP	18000	090899 ●	090899 ●
Brandt	70	20	12	16	DKN 2	6	DP	18000	090893	090893
Brandt	70	25	25	16	DKN 3	4	HW	18000	065588 ●	065589 ●
Fravol	80	30	27.5	20	DKN 3	4	DP	18000	192270 ●	192271 ●
Holz-Her 1828	70	19.5	19.5	20	DKN 4	4	HW	18000	065592	065593
Ott	70	16.5	10	16	DKN 3	4	DP	18000	192283 ●	192284 ●
Stefani	80	20	11	16	DKN 2	4	DP	18000	192110 ●	192111 ●



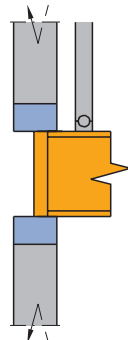
Type 1

Type 2

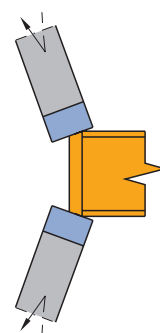


Type 3

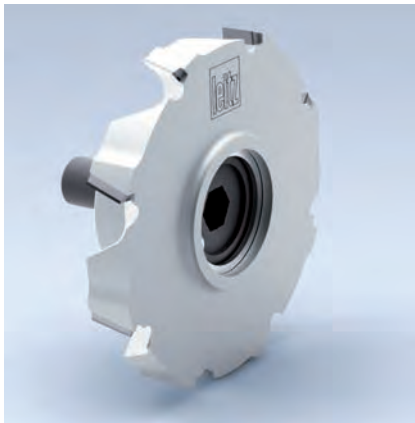
Type 4



Trimming of edges on horizontal spindle  
- top motor tracing.



Bevelling of edges with inclined spindle.



### Pre / finishing edge trimming cutter *iQsystem*

#### Application:

To trim edgebandings on horizontal spindles or for bevelling with inclined spindles.

#### Machine:

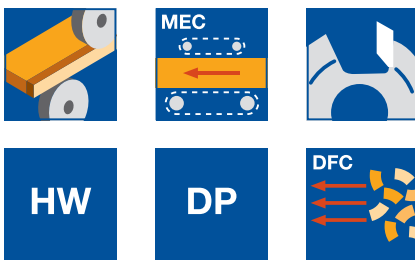
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

HW/DP tipped tools with HSK 25 R adaptor and a special extraction hood i-System for efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity.



#### Joining cutter *iQsystem* - HSK 25 R

WF 200 2 DP, WF 210 2

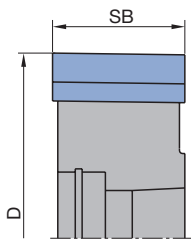
Machine	D mm	SB mm	BO mm	Z	QAL	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Homag, IMA	70	25	HSK 25 R	4	HW	18000	<b>073092 ●</b>	<b>073093 ●</b>
Homag, IMA	70	8	HSK 25 R	4	DP	18000	<b>198472 ●</b>	<b>198473 ●</b>
Homag, IMA	70	8	HSK 25 R	6	DP	18000	<b>198474 ●</b>	<b>198475 ●</b>
Homag, IMA	70	8	HSK 25 R	8	DP	18000	<b>198404 ●</b>	<b>198405 ●</b>
Homag, IMA	70	15	HSK 25 R	4	DP	18000	<b>198406 ●</b>	<b>198407 ●</b>
Homag, IMA	70	15	HSK 25 R	6	DP	18000	<b>198468 ●</b>	<b>198469 ●</b>

#### Recommended number of teeth:

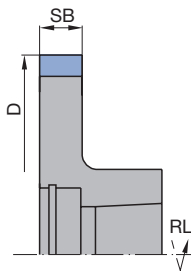
Feed rates of up to 35 m min<sup>-1</sup> Z 4

Feed rates of up to 60 m min<sup>-1</sup> Z 6

Feed rates of up to 100 m min<sup>-1</sup> Z 8 (thin edge)



HW jointing cutter with HSK 25 R adaptor, SB-25 mm



DP jointing cutter with HSK 25 R adaptor



### Pre / finishing edge trimming cutter cutterhead design

#### Application:

To trim edgebandings on horizontal spindles or for bevelling with inclined spindles.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Cutterhead with turnblade knives, cylindrical bore or HSK 25 R adaptor.

#### Joining cutterhead

WW 200 2, WW 200 2 06, WW 200 2 25

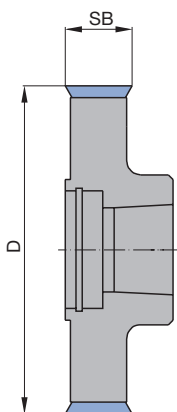
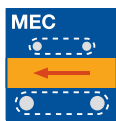
Machine	Type	D mm	SB mm	BO mm	Z	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
Brandt	1	70	14.3	16 DKN	4	18000	<b>025130 ●</b>	<b>025130 ●</b>
Homag	1	70	14.3	HSK 25 R	4	12000	<b>073599 ●</b>	<b>073600 ●</b>
Homag	2	70	20	16 DKN	4	18000	<b>025079 ●</b>	<b>025079 ●</b>
Ott, Holz-Her	2	70	20	16	4	18000	<b>025078</b>	<b>025078</b>
Holz-Her 1962	2	80	40	30 KN	4	18000	<b>024415</b>	<b>024415</b>

#### Spare knives:

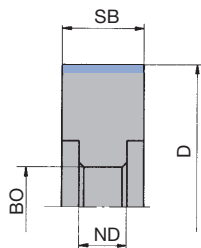
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	20x12x1.5	HW-05F	10	<b>005083 ●</b>
1	Turnblade knife	40x12x1.5	HW-05F	10	<b>005085 ●</b>
5	Turnblade knife	14.3x14.3x2.5	HW	10	<b>005426 ●</b>

#### Spare parts:

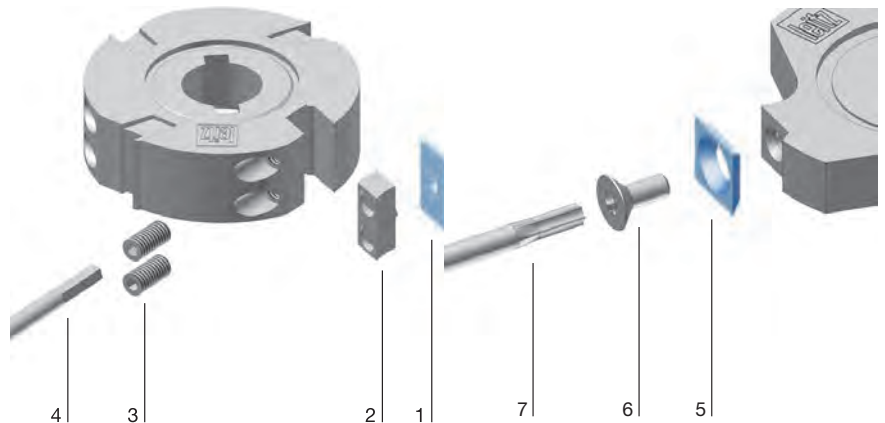
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge with pin	18x11.5x7	<b>005272 ●</b>
3	Allen screw	M6x12	<b>006035 ●</b>
4	Allen key	SW 3	<b>005444 ●</b>
6	Countersink screw, Torx® 20	M5x12	<b>006247 ●</b>
7	Torx® key	Torx® 20	<b>006091 ●</b>

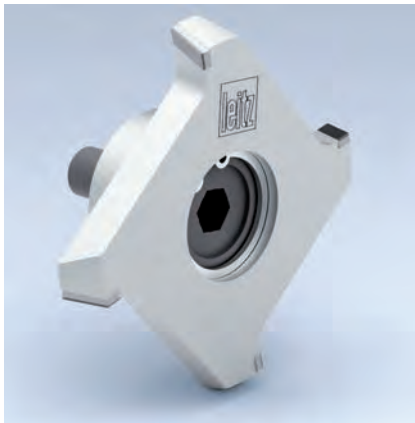


Type 1: WW 200 2 25



Type 2: WW 200 2 06





### Bevel cutter

#### Application:

To bevel edgebandings.

#### Machine:

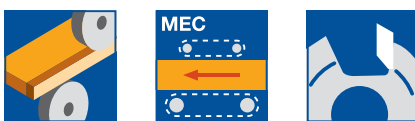
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

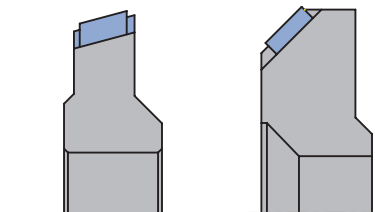
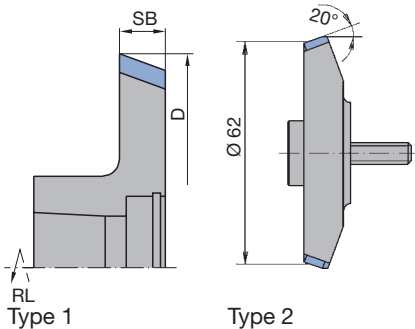
DP tipped tools with cylindrical bore, HSK 25 R or HSK 32 adaptor for FK aggregates.



#### Various bevel angles - DP tipped

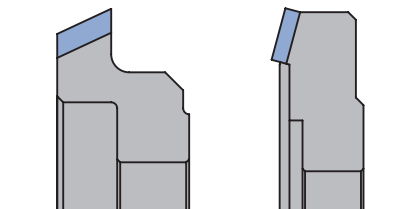
WF 300 2 DP, WF 350 2 DP

Machine	D mm	SB mm	BO mm	Type	Z	QAL	FAW °	ID LH	ID RH
Biesse	67.2	9	16 DKN	5	6	DP	25°	091976	091975
Biesse	67.2	9	20 DKN	5	6	DP	25°	091970	091969
Biesse	68	9	16 DKN	5	6	DP	45°	091978	091977
Biesse	68	9	20 DKN	5	6	DP	45°	091972	091971
Biesse	80	10.5	16 DKN	6	4	DP	15°	091974	091973
Holz-Her 1825	52	6	16 DKN	3	2	DP	15°	091982	091981
Holz-Her 1832	53	8	16 DKN	3	3	DP	15°	091986	091985
Holz-Her 1832	56	5	16 DKN	3	3	DP	45°	091988	091987
Holz-Her 1833	72.5	8	20 DKN	4	4	DP	45°	091984	091983
Homag	62	5	HSK 32	2	4	DP	20°	091518	091519
Homag	62	5	HSK 32	2	6	DP	20°	091658	091659
Homag	62	5	HSK 32	2	6	DP	30°	091690	091691
Homag	62	5	HSK 32	2	6	DP	45°	091692	091693
Homag	75	8	HSK 25 R	1	4	DP	20°	091790	091791
IMA	75	8	HSK 25 R	1	4	DP	20°	091790	091791
Stefani	70	5	12 DKN	3	4	DP	20°	091980	091979



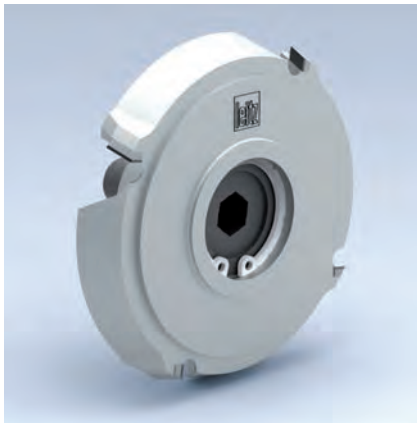
Type 3

Type 4



Type 5

Type 6



### Bevel cutter *iQsystem*

#### Application:

To bevel edgebandings.

#### Machine:

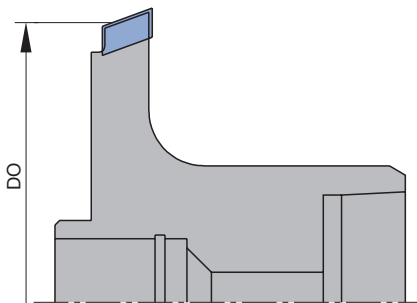
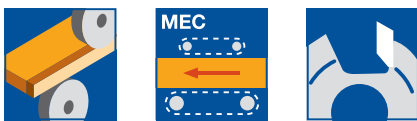
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

DP tipped tools with HSK 25 R or HSK 32 adaptor for FK aggregates combined with special extraction hoods i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. High concentricity. Constant reference diameter.

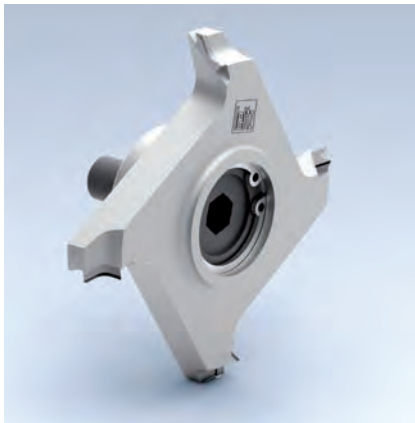


#### Various bevel angles *iQsystem* - Diamaster PRO

WF 350 2 DP

Machine	D <sub>0</sub> mm	SB mm	BO mm	Z	QAL	FAW °	NH mm	ID LH	ID RH
Homag	62	5	HSK 32	4	DP	20°	31.5	198200 ●	198201 ●
Homag	62	5	HSK 32	4	DP	45°	31.5	198240 ●	198241 ●
Homag	62	5	HSK 32	6	DP	20°	31.5	198202 ●	198203 ●
Homag	62	5	HSK 32	6	DP	45°	31.5	198242 ●	198243 ●
Homag	70	8	HSK 25 R	4	DP	20°	19.5	198408 ●	198409 ●
Homag	70	8	HSK 25 R	4	DP	45°	19.5	198464 ●	198465 ●
Homag	70	8	HSK 25 R	6	DP	20°	19.5	198410 ●	198411 ●
Homag	70	8	HSK 25 R	6	DP	45°	19.5	198466 ●	198467 ●
IMA	70	8	HSK 25 R	4	DP	20°	19.5	198408 ●	198409 ●
IMA	70	8	HSK 25 R	4	DP	45°	19.5	198464 ●	198465 ●
IMA	70	8	HSK 25 R	6	DP	20°	19.5	198410 ●	198411 ●
IMA	70	8	HSK 25 R	6	DP	45°	19.5	198466 ●	198467 ●

Bevel cutter with HSK 32 adaptor for FK aggregates



### Profile cutter

#### Application:

To round edgebandings.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

DP tipped tools with cylindrical bore or HSK 25 R adaptor.

$D_0$  = constant reference diameter.

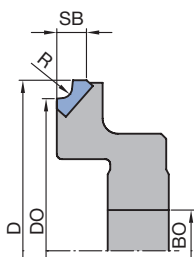
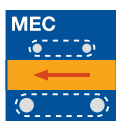
#### Various radii

WF 501 2, WF 501 2 DP, WF 502 2 DP, WF 599 2

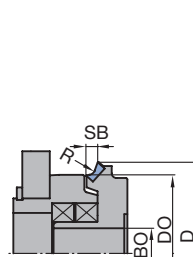
Machine	D	$D_0$	BO	Z	QAL	R	Type	$n_{\max}$	ID	ID
	mm	mm	mm			mm		min <sup>-1</sup>	LH	RH
Biesse	67	60	16 DKN	6	DP	1,0	1	18,000	091960 ●	091961 ●
Biesse	68	60	16 DKN	6	DP	2,0	1	18,000	091962 ●	091963 ●
Biesse	70	60	16 DKN	6	DP	3,0	1	18,000	091964 ●	091965 ●
Biesse	72	70	16 KN	6	DP	1,0	5	18,000	192518 ●	192519 ●
Biesse	73	70	16 KN	6	DP	2,0	5	18,000	192520 ●	192521 ●
Biesse	75	70	16 KN	6	DP	3,0	5	18,000	192522 ●	192523 ●
* Brandt	58	50	16 DKN	4	DP	1,0	2	12,000		091999 □
** Brandt	58	50	16 DKN	4	DP	1,5	2	18,000		192602 ●
* Brandt	58	50	16 DKN	4	DP	2,0	2	12,000		091966 ●
** Brandt	58	50	16 DKN	4	DP	2,0	2	18,000		192603 ●
Brandt	70	62	HSK 25 R 4	4	DP	1,0	7	18,000	192588 ●	192589 ●
Brandt	70	62	HSK 25 R 4	4	DP	1,3	7	18,000	192590 ●	192591 ●
Brandt	70	62	HSK 25 R 4	4	DP	1,5	7	18,000	192592 ●	192593 ●
Brandt	70	62	HSK 25 R 4	4	DP	2,0	7	18,000	192594 ●	192595 ●
Brandt	70	62	HSK 25 R 4	4	DP	3,0	7	18,000	192596 ●	192597 ●
EBM	32	24	14 DKN	2	DP	2,0	3	18,000	074526 ●	
EBM	56	49.7	16 DKN	2	DP	2,0	6	18,000	192669 ●	192670 ●
EBM	56	49.7	16 DKN	2	DP	2,5	6	18,000	192641 ●	192642 ●
Fravol	50	39.91	15 KN	4	DP	1-3	11	18,000		192665 ●
Fravol	50	40.1	15 KN	4	DP	1-3	10	18,000	192663 ●	192664 ●
Fravol	50	39.91	15 KN	6	HW	1-3	11	18,000		065594 ●
Fravol	73	71.15	20 DKN	4	DP	1-3	8	18,000	192645 ●	192646 ●
Fravol	76.8	74.71	20 DKN	4	DP	1-3	9	18,000	192647 ●	192648 ●
Hebrock	32	24	14 DKN	2	DP	2,0	3	18,000	074526 ●	
Hebrock	56	49.7	16 DKN	2	DP	2,0	6	18,000	192669 ●	192670 ●
Hebrock	56	49.7	16 DKN	2	DP	2,5	6	18,000	192641 ●	192642 ●
Holz-Her 1825	57	50	16 DKN	2	DP	2,0	3	24,000	192536 ●	192537 ●
Holz-Her 1825	57	50	16 DKN	2	DP	2,5	3	24,000	192538 ●	192539 ●
Holz-Her 1825	57	50	16 DKN	2	DP	3,0	3	24,000	192540 ●	192541 ●
Holz-Her 1827	56	50	20 DKN	2	DP	2,0	4	24,000	192506 ●	192507 ●
Holz-Her 1827	56	50	20 DKN	2	DP	2,5	4	24,000	192508 ●	192509 ●
Holz-Her 1827	57	50	20 DKN	2	DP	3,0	4	24,000	192510 ●	192511 ●

\* For Brandt edge trimming cutter with keyed and torque support.

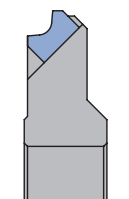
\*\* = For Brandt edge trimming cutter with keyed (without torque support).



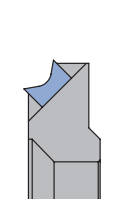
Type 1



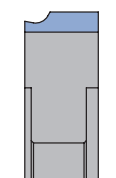
Type 2



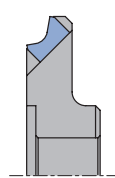
Type 3



Type 4



Type 5

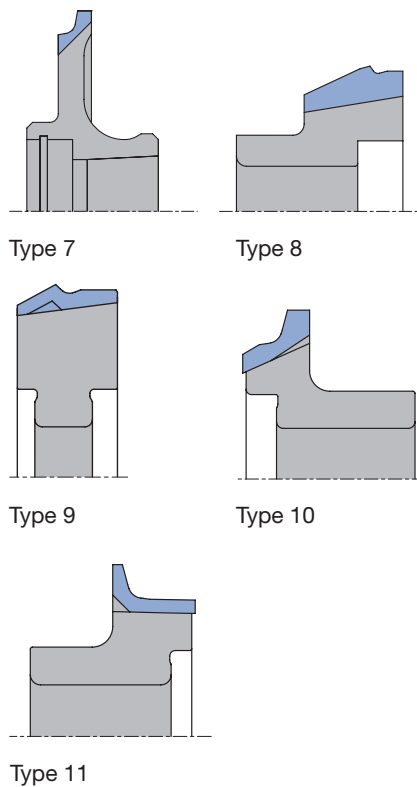


Type 6



## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



Machine	D mm	D <sub>0</sub> mm	BO mm	Z	QAL	R mm	Type	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
Holz-Her 1832	58.7	50	16 DKN	3	DP	2,0	3	24,000	192512 ●	192513 ●
Holz-Her 1832	58.7	50	16 DKN	3	DP	2.5	3	24,000	192514 ●	192515 ●
Holz-Her 1832	58.7	50	16 DKN	3	DP	3,0	3	24,000	192516 ●	192517 ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	2,0	4	18,000	192500 ●	192501 ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	2.5	4	18,000	192502 ●	192503 ●
Holz-Her 1833	72.5	61	20 DKN	4	DP	3,0	4	18,000	192504 ●	192505 ●
* Homag	58	50	16 DKN	4	DP	1,0	2	12,000		091999 □
** Homag	58	50	16 DKN	4	DP	1.5	2	18,000		192602 ●
* Homag	58	50	16 DKN	4	DP	2,0	2	12,000		091966 ●
** Homag	58	50	16 DKN	4	DP	2,0	2	18,000		192603 ●
Homag	70	62	HSK 25 R 4	DP	1,0	7	18,000	192588 ●	192589 ●	
Homag	70	62	HSK 25 R 4	DP	1.3	7	18,000	192590 ●	192591 ●	
Homag	70	62	HSK 25 R 4	DP	1.5	7	18,000	192592 ●	192593 ●	
Homag	70	62	HSK 25 R 4	DP	2,0	7	18,000	192594 ●	192595 ●	
Homag	70	62	HSK 25 R 4	DP	3,0	7	18,000	192596 ●	192597 ●	
Ott	69	61	16 DKN	3	DP	2,0	1	18,000	192649 ●	192650 ●
Ott	69	61	16 DKN	4	DP	2,0	1	18,000	192651 ●	192652 ●
Stefani	51.5	49.71	16 DKN	4	HW	1,0	8	18,000	192657 ●	192658 ●
Stefani	51.5	49.71	16 DKN	4	HW	1.5	8	18,000	192659 ●	192660 ●
Stefani	51.5	49.71	16 DKN	4	HW	2,0	8	18,000	192661 ●	192662 ●
Stefani	70	60	16 DKN	4	DP	1,0	6	18,000	192524 ●	192525 ●
Stefani	70	60	16 DKN	4	DP	2,0	6	18,000	192526 ●	192527 ●
Stefani	70	60	16 DKN	4	DP	3,0	6	18,000	192528 ●	192529 ●
Türk Makine	46	39	16	4	DP	2,0	3	18,000	192643 ●	192644 ●

\* For Brandt edge trimming cutter with keyed and torque support.

\*\* = For Brandt edge trimming cutter with keyed (without torque support).

## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



#### Profile cutter

##### Application:

To round (profile) edgebandings on FK aggregate.

##### Machine:

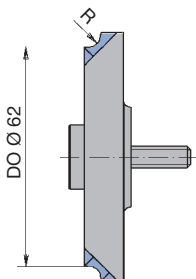
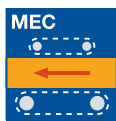
Single or double-sided edgebanding machines.

##### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

##### Technical information:

DP tipped tools with HSK 32 adaptor for FK-aggregates. High concentricity.  
D<sub>0</sub> = constant reference diameter.

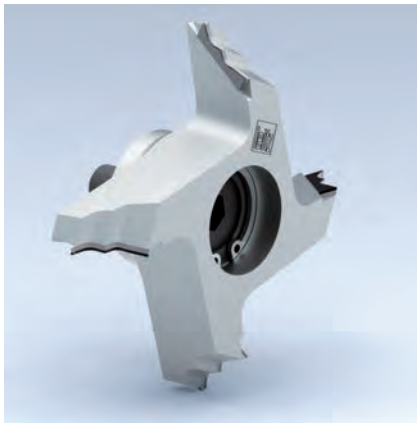


Type 1

#### Various radii - Diamaster PRO, FK aggregate, HSK 32

WF 501 2 DP

Machine	D <sub>0</sub> mm	BO mm	Z	QAL	R mm	Type	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
Homag	62	HSK 32	4	DP	1.0	1	18000	091500	091501
Homag	62	HSK 32	4	DP	1.5	1	18000	091502	091503
Homag	62	HSK 32	4	DP	2.0	1	18000	091504	091505
Homag	62	HSK 32	4	DP	2.5	1	18000	091506	091507
Homag	62	HSK 32	4	DP	3.0	1	18000	091508	091509
Homag	62	HSK 32	6	DP	1.0	1	18000	091672	091673
Homag	62	HSK 32	6	DP	1.5	1	18000	091674	091675
Homag	62	HSK 32	6	DP	2.0	1	18000	091650	091651
Homag	62	HSK 32	6	DP	2.5	1	18000	091676	091677
Homag	62	HSK 32	6	DP	3.0	1	18000	091652	091653



#### Profile cutter

##### Application:

For a choice of radii or bevels on edgebandings.

##### Machine:

Single or double-sided edgebanding machines.

##### Workpiece material:

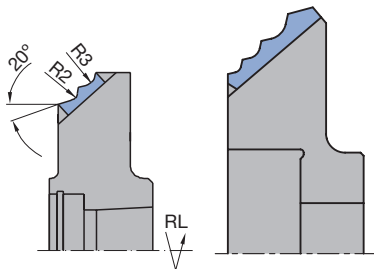
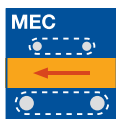
Plastic, softwood, hardwood and veneer edgebander.

##### Technical information:

DP tipped tools with cylindrical bore or HSK 25 R adaptor.

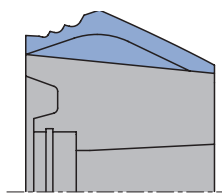
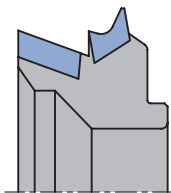
Profiling with e.g. radii 2.0 and 3.0 mm and bevel 20°.

D<sub>0</sub> = constant reference diameter.



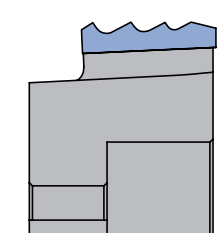
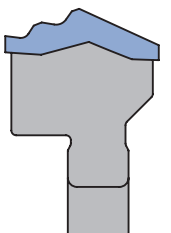
Type 1

Type 2



Type 3

Type 4



Type 5

Type 6

#### Multi-profile cutter - Diamaster PRO

WF 501 2, WF 501 2 DP, WF 501 2 DP, WF 502 2 DP, WF 502 2 DP

Machine	D mm	D <sub>0</sub> mm	BO mm	Type	Z	R mm	FAW °	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
Biesse	75.4	60	16 DKN	2	6	1/2/3	25°	18000	091996 ●	091995 ●
Brandt	78	57.3	16 DKN	2	4	1.2/2/3	15°	18000	091967 ●	091968 ●
Holz-Her	58	50	20 DKN	3	2	2		18000	192530 ●	192531 ●
1826										
Holz-Her	58	50	20 DKN	3	2	2.5		18000	192532 ●	192533 ●
1826										
Holz-Her	58	50	20 DKN	3	2	3		18000	192534 ●	192535 ●
1826										
Holz-Her	71	68	16 DKN	6	4	3/2/1.3	45°	18000	192673 ●	192674 ●
FR 701										
Holz-Her	71	68	16 DKN	6	4	2/2/1.3	45°	18000	192675 ●	192676 ●
FR 701										
Holz-Her	71	68	16 DKN	6	4	2/1.3/1.3	45°	18000	192677 ●	192678 ●
FR 701										
Holz-Her	71	68	16 DKN	6	4	3/2/1.3	10°	18000	192679 ●	192680 ●
FR 701										
Holz-Her	71	68	16 DKN	6	4	1.3/1/0.8	45°	18000	192681 ●	192682 ●
FR 701										
Homag	74.33	65.7	HSK 25 R 4	4	1/2			18000	198506 ●	198507 ●
Homag	74.67	65.7	HSK 25 R 4	4	1.3/2			18000	198508 ●	198509 ●
Homag	85	65.2	HSK 25 R 1	4	2/3		20°	18000	091798 ●	091799 ●
Homag	74.33	62.99	16 DKN	5	4	1/2		18000	192683 ●	192684 ●
Homag	74.66	65.69	16 DKN	5	4	1.3/2		18000	192685 ●	192686 ●
IMA	85	65.2	HSK 25 R 1	4	2/3		20°	18000	091798 ●	091799 ●
Stefani	74.5	63.88	HSK 25 R 4	4	1/1.5/2		20°	18000	192655 ●	192656 ●
Stefani	74.5	63.88	HSK 25 R 1	4	1/1.5/2		20°	18000	192653 ●	192654 ●

Alternative multi-profile trimming heads with different dimensions can be supplied at short notice on request.



### Profile cutter *iQsystem*

#### Application:

To round edgebandings.

#### Machine:

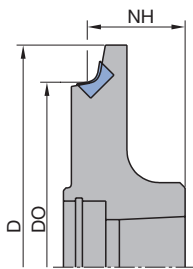
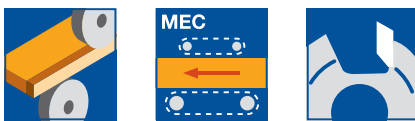
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

#### Workpiece material:

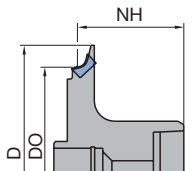
Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

DP tipped tools with HSK 25 R adaptor and special extraction hoods i-System for efficient chip clearance (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Maximum concentricity. Constant reference diameter.



Radius cutter with HSK 25 R adaptor



Radius cutter with HSK 32 R adaptor for FK aggregates

#### Various radii *iQsystem* - Diamaster PRO, HSK 25 R

WF 501 2 DP

Machine	D	D <sub>0</sub>	NH	BO	Z	QAL	R	n <sub>max</sub>	ID	ID
	mm	mm	mm	mm			mm	min <sup>-1</sup>	LH	RH
Homag, IMA 76	70	17.5	HSK 25 R	4	DP	1.0	18000	<b>198494</b> ●	<b>198484</b> ●	
Homag, IMA 76	70	17.5	HSK 25 R	4	DP	1.5	18000	<b>198495</b> ●	<b>198485</b> ●	
Homag, IMA 76	70	18.5	HSK 25 R	4	DP	2.0	18000	<b>198496</b> ●	<b>198486</b> ●	
Homag, IMA 78	70	19	HSK 25 R	4	DP	2.5	18000	<b>198497</b> ●	<b>198487</b> ●	
Homag, IMA 78	70	19.5	HSK 25 R	4	DP	3.0	18000	<b>198498</b> ●	<b>198488</b> ●	
Homag, IMA 76	70	17.5	HSK 25 R	6	DP	1.0	18000	<b>198499</b> ●	<b>198489</b> ●	
Homag, IMA 76	70	17.5	HSK 25 R	6	DP	1.5	18000	<b>198500</b> ●	<b>198490</b> ●	
Homag, IMA 76	70	18.5	HSK 25 R	6	DP	2.0	18000	<b>198501</b> ●	<b>198491</b> ●	
Homag, IMA 78	70	19	HSK 25 R	6	DP	2.5	18000	<b>198502</b> ●	<b>198492</b> ●	
Homag, IMA 78	70	19.5	HSK 25 R	6	DP	3.0	18000	<b>198503</b> ●	<b>198493</b> ●	

#### Application:

To round (profile) edgebandings on FK aggregate.

#### Technical information:

DP tipped tools with HSK 32 adaptor for FK aggregates with special extraction hoods i-System for highly efficient chip clearance (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Maximum concentricity. Constant reference diameter.

#### Various radii *iQsystem* - Diamaster PRO, FK aggregate, HSK 32

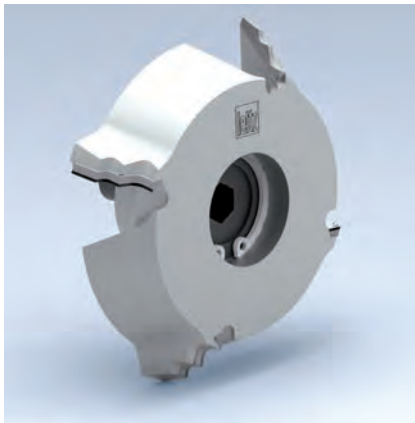
WF 501 2 DP

Machine	D	D <sub>0</sub>	NH	BO	Z	QAL	R	n <sub>max</sub>	ID	ID
	mm	mm	mm	mm			mm	min <sup>-1</sup>	LH	RH
Homag	75	62	31.5	HSK 32	4	DP	1.0	18000	<b>198212</b> ●	<b>198213</b> ●
Homag	75	62	31.5	HSK 32	4	DP	1.5	18000	<b>198214</b> ●	<b>198215</b> ●
Homag	75	62	31.5	HSK 32	4	DP	2.0	18000	<b>198216</b> ●	<b>198217</b> ●
Homag	75	62	31.5	HSK 32	4	DP	2.5	18000	<b>198220</b> ●	<b>198221</b> ●
Homag	75	62	31.5	HSK 32	4	DP	3.0	18000	<b>198222</b> ●	<b>198223</b> ●
Homag	75	62	31.5	HSK 32	6	DP	1.0	18000	<b>198246</b> ●	<b>198247</b> ●
Homag	75	62	31.5	HSK 32	6	DP	1.5	18000	<b>198244</b> ●	<b>198245</b> ●
Homag	75	62	31.5	HSK 32	6	DP	2.0	18000	<b>198218</b> ●	<b>198219</b> ●
Homag	75	62	31.5	HSK 32	6	DP	2.5	18000	<b>198238</b> ●	<b>198239</b> ●
Homag	75	62	31.5	HSK 32	6	DP	3.0	18000	<b>198224</b> ●	<b>198225</b> ●

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools



#### Profile cutter *iQsystem*

##### Application:

For a choice of radii or bevels on edgebandings.

##### Machine:

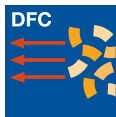
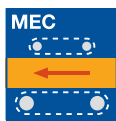
Single or double-sided edgebanding machines. Machines combined with special extraction hood i-System for efficient chip clearance.

##### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

##### Technical information:

DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for efficient chip clearance (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Profile combination of routing with e.g. radii of 2.0 and 3.0 mm and bevel 20°. High concentricity.

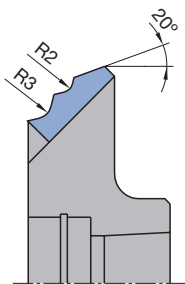


#### Multi-profile cutter *iQsystem* - Diamaster PRO, HSK 25 R

WF 501 2 DP

Machine	D mm	D <sub>0</sub> mm	BO mm	Z	QAL	R mm	FAW °	ID LH	ID RH
Homag, IMA	85	62	HSK 25 R	4	DP	2/3	20°	198444 ●	198445 ●
Homag, IMA	85	62	HSK 25 R	4	DP	1.5/2	20°	198504 ●	198505 ●
Homag, IMA	85	62	HSK 25 R	6	DP	2/3	20°	198456 ●	198457 ●

Alternative multi-profile trimming heads with different dimensions can be supplied at short notice on request.

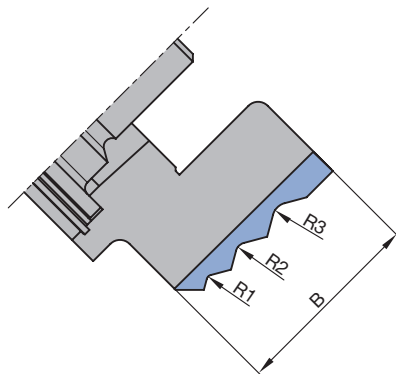
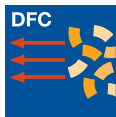
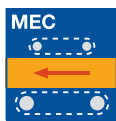


Multi-profile cutter i-System

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools



#### Profile cutter *iQsystem*

##### Application:

For a choice of radii and bevels on edgebandings. Corner rounding on leading and trailing edges and radius/bevel on top/bottom edges.

##### Machine:

IMA edgebanding machine with KFA aggregates.

##### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

##### Technical information:

DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Constant diameters. Low noise.

#### Multi-profile cutter *iQsystem* - Diamaster PRO, HSK 25 R, KFA aggregate WF 502 2 DP

Machine	D	B	BO	Z	R	FAW	ID	ID
	mm	mm	mm		mm	°	LH	RH
IMA Multiprofiler	75	30	HSK 25 R	6	1/2/3	15°	091916 ●	091917 ●
IMA Multiprofiler	75	30	HSK 25 R	6	1/1.5/2	20°	091922 ●	091923 ●
IMA Multiprofiler KFA	75	28	HSK 25 R	6	1/2/3	15°	091912 ●	091913 ●
IMA Multiprofiler KFA	75	28	HSK 25 R	6	1/1.5/2	20°	091924 ●	091925 ●
IMA Multiprofiler KFA	75	28	HSK 25 R	6	1/2/3	45°	091926 ●	091927 ●

Alternative multi-profile trimming heads with different dimensions can be supplied at short notice on request.

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools



#### Profile cutter *iQsystem*

##### Application:

For a choice of radii and bevels on edgebandings. Corner rounding on leading and trailing edges and radius/bevel on top/bottom edges.

##### Machine:

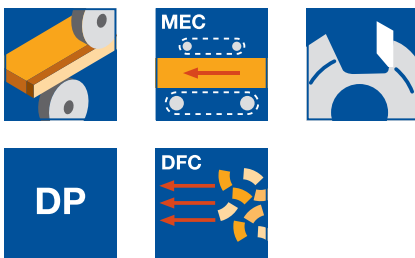
IMA edgebanding machines with MFA aggregates.

##### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

##### Technical information:

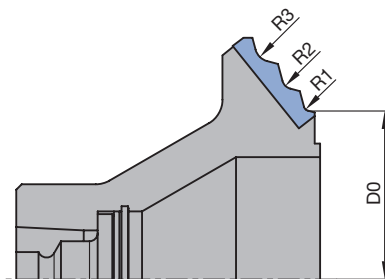
DP tipped tools with HSK 25 R adaptor and special extraction hood i-System for highly efficient chip collection (approx. 97%) with reduced extraction energy consumption. Clean workpieces, no interference with scanning aggregates and less rework. Constant diameters. Low noise.



#### Multi-profile cutter *iQsystem* - Diamaster PRO, HSK 25 R, MFA aggregates WF 502 2 DP

Machine	D mm	D <sub>0</sub> mm	BO mm	Z	R mm	FAW °	ID LH	ID RH
IMA	89	62	HSK 25 R	6	1/2	15°	091918 ●	091919 ●
IMA	89	57	HSK 25 R	6	1/2/3	15°	091920 ●	091921 ●

Alternative multi-profile trimming heads with different dimensions can be supplied at short notice on request.







### Profile cutter *IQ-system*

#### Application:

To round (profile trim) edgebandings on FK31 aggregates.

#### Machine:

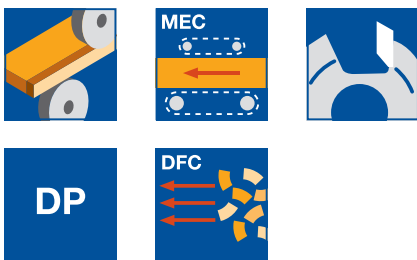
Homag edgebanding machines with profile FK31 trimming aggregate.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

DP tipped tools with bore for mounting as set on the tool adaptor. DFC design for highly efficient chip clearance of more than 97%.  $D_0$  = constant reference diameter. Low noise DP tool. Maximum concentricity. Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service.



#### Diamaster PRO, FK31 aggregate - Tool 1 fixed

WF 501 2 DP

Machine	Tool no.	D mm	$D_0$ mm	BO mm	Z	QAL	R mm	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Homag	1	88	80.1	46	4	DP	1.5	18000	<b>192558</b> ●	<b>192559</b> ●
Homag	1	88	80.1	46	4	DP	2.0	18000	<b>192556</b> ●	<b>192557</b> ●
Homag	1	88	80.1	46	4	DP	2.2	18000	<b>192580</b> ●	<b>192581</b> ●
Homag	1	88	80.1	46	4	DP	2.5	18000	<b>192554</b> ●	<b>192555</b> ●
Homag	1	88	80.1	46	4	DP	3.0	18000	<b>192552</b> ●	<b>192553</b> ●

#### Diamaster PRO, FK31 aggregate - Tool 2 moveable

WF 501 2 DP

Machine	Tool no.	D mm	$D_0$ mm	BO mm	Z	QAL	R mm	FAW °	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Homag	2	87	80.1	55	4	DP	1.0		18,000	<b>192568</b> ●	<b>192569</b> ●
Homag	2	87	80.1	55	4	DP	1.5		18,000	<b>192566</b> ●	<b>192567</b> ●
Homag	2	87	80.1	55	4	DP	1.7		18,000	<b>192582</b> ●	<b>192583</b> ●
Homag	2	87	80.1	55	4	DP	2.0		18,000	<b>192564</b> ●	<b>192565</b> ●
Homag	2	87	80.1	55	4	DP	2.5		18,000	<b>192562</b> ●	<b>192563</b> ●
Homag	2	87	80.1	55	4	DP	3.0		18,000	<b>192560</b> ●	<b>192561</b> ●
Homag	2	87	80.1	55	4	DP		45°	18,000	<b>192112</b> ●	<b>192113</b> ●
Homag	2	87	80.1	55	4	DP		30°	18,000	<b>192123</b> ●	<b>192124</b> ●
Homag	2	87	80.1	55	4	DP		20°	18,000	<b>192114</b> ●	<b>192115</b> ●

#### Diamaster PRO, FK31 aggregate - Tool 3 moveable

WF 300 2 DP, WF 501 2 DP

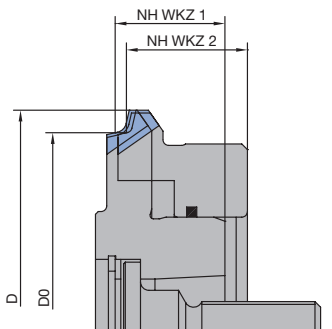
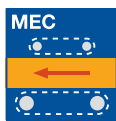
Machine	Tool no.	D mm	$D_0$ mm	BO mm	Z	QAL	R mm	FAW °	$n_{max}$ min <sup>-1</sup>	ID LH	ID RH
Homag	3	92	80.1	73	4	DP	1.0		18000	<b>192574</b> ●	<b>192575</b> ●
Homag	3	92	80.1	73	4	DP	1.5		18000	<b>192572</b> ●	<b>192573</b> ●
Homag	3	92	80.1	73	4	DP	1.7		18000	<b>192584</b> ●	<b>192585</b> ●
Homag	3	92	80.1	73	4	DP	2.0		18000	<b>192570</b> ●	<b>192571</b> ●
Homag	3	92	80.1	73	4	DP		15°	18000	<b>091520</b> ●	<b>091521</b> ●
FK 31 PowerTrim											
Homag	3	92	80.1	73	4	DP		20°	18000	<b>192118</b> ●	<b>192119</b> ●
Homag	3	92	80.1	73	4	DP		30°	18000	<b>192125</b> ●	<b>192126</b> ●
Homag	3	92	80.1	73	4	DP		45°	18000	<b>192116</b> ●	<b>192117</b> ●

Differing radii available at short notice from a tool bank. Tool 1 radius must be greater than tool 2 and 3. The larger radius defines the maximal bevel size of the moveable bevel tools 2 and 3.

#### Spare parts:

Part-no.	BEZ	ABM mm	ID
4	Cylindrical screw with ISK	M5x12	<b>114046</b> ●
5	Cylindrical screw with ISK	M5x30	<b>114045</b> ●
	Allen key	SW 3	<b>005444</b> ●

Tools supplied with mounting screws.



### Profile cutter flexTrim

#### Application:

For multi-profile cutting with radii and bevelling of edges. Combination of two profiles for automatic profile resetting in the workpiece gap.

#### Machine:

Homag edgebanding machines for cutting units types FK11, FK20, FK21, FF12, FF32, PF21 with flexTrim cutting head.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

2 part DP composite tool for setwise application. DFC design for efficient chip collection. Maximum processing quality through high running accuracy and smooth running.  $D_0$  = constant reference diameter, RPM  $n_{max} = 18000 \text{ min}^{-1}$ . It is recommended to have individual tools changed by the Leitz tool service.

#### Multi-profile cutterset flexTrim - Diamaster PRO

SF 542 2 15

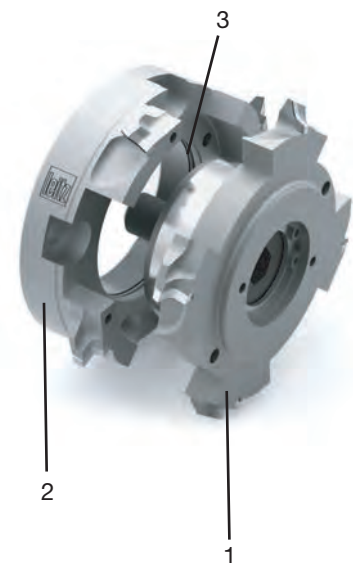
Machine	D	D <sub>0</sub>	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	78	70	19.5	HSK 25 R	4	DP	1.5/1.0		194300 ●	194301 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0/1.0		194302 ●	194303 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0/1.5		194304 ●	194305 ●
Homag	78	70	19.5	HSK 25 R	4	DP	3.0/2.0		194306 ●	194307 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0	20°	194308 ●	194309 ●
Homag	78	70	19.5	HSK 25 R	4	DP	2.0	45°	194310 ●	194311 ●

Tool 1 fix + tool 2 flexible

All tools and further profile variants available in various dimensions from blank at short notice. Further combinations possible on request.

#### Spare parts:

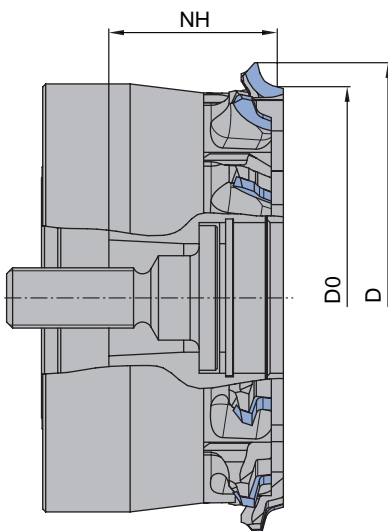
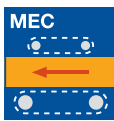
Part-no.	Tool no.	BEZ	ABM	ID
			mm	
3	2	O-Ring	40x1.78 NBR70	118300 ●



1 = Tool 1  
2 = Tool 2  
3 = O-Ring

## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



#### Profile cutter flexTrim3

##### Application:

For multi-profile cutting with radii on edges. Combination of three profiles for automatic profile resetting.

##### Machine:

Homag edgebanding machines for cutting units type FF32 with flexTrim cutting head.

##### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

##### Technical information:

DP composite tool for setwise application.

Maximum processing quality through high running accuracy and quiet running.

$D_0$  = constant reference diameter, RPM  $n_{max} = 12.000 \text{ min}^{-1}$ .

Replacement of tool components only by qualified personnel of the tool or machine manufacturer.

#### Multi-profile cutterset flexTrim3 - Diamaster PRO

SF 541 2 17

Machine	D	$D_0$	NH	BO	Z	QAL	R	FAW	ID	ID
	mm	mm	mm	mm			mm	°	LH	RH
Homag	78	70	28	HSK 25 R	4	DP	2/1.5/1		<b>194500 ●</b>	<b>194501 ●</b>
Homag	78	70	28	HSK 25 R	4	DP	2/1.3/1		<b>194502 ●</b>	<b>194503 ●</b>
Homag	78	70	28	HSK 25 R	4	DP	2/1	45	<b>194514 ●</b>	<b>194515 ●</b>
Homag	78	70	28	HSK 25 R	4	DP	2/1.3	45	<b>194518 ●</b>	<b>194519 ●</b>

Further profile variants and combinations possible on request. Single tools available on request.



### Profile cutter QuattroForm

#### Application:

For multi-profile cutting with radii and bevelling of edges.

#### Machine:

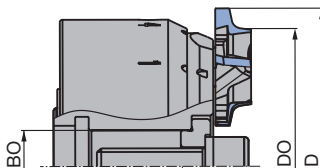
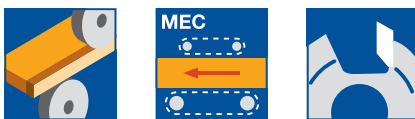
Holz-Her model Lumina and Accura 2015 and newer models. Application on revolver cutting unit Quattro Form (FF 701 Multi).

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

DP composite tool with 4 profiles and mounting screw. Profiles automatically adjustable by the machine control. Patented system.  $D_0$  = constant reference diameter,  $RPM\ n = 18000\ min^{-1}$ . It is recommended to have individual tools changed by the Leitz tool service.



### Multi-profile cutter QuattroForm - Diamaster PRO

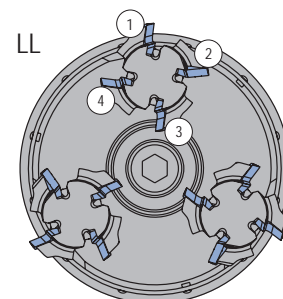
SF 540 2 10

Machine	D mm	D <sub>0</sub> mm	BO mm	Z	R mm	FAW °	ID LH	ID RH
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/2	45	194101 ●	194100 ●
Holz-Her FF 701 Multi	70	61	16	3	3/1.3/2	45	194103 ●	194102 ●
Holz-Her FF 701 Multi	70	61	16	3	3/1.3/2	10	194105 ●	194104 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/1.3	45	194107 ●	194106 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.5/1	45	194109 ●	194108 ●
Holz-Her FF 701 Multi	70	61	16	3	0.8/1/1.3	45	194111 ●	194110 ●
Holz-Her FF 701 Multi	70	61	16	3	3/2/2	45	194113 ●	194112 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.3	45	194115 ●	194114 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/2/1.3	45	194117 ●	194116 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1/2	45	194119 ●	194118 ●
Holz-Her FF 701 Multi	70	61	16	3	2/1.3/1.3/1.3	45	194121 ●	194120 ●
Holz-Her FF 701 Multi	70	61	16	3	2/3/2/3	45	194123 ●	194122 ●

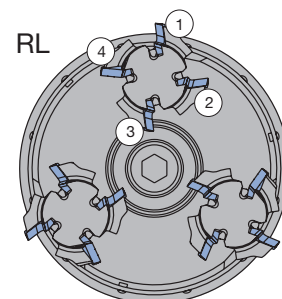
All tools and further profile variants are available in various dimensions from blanks at short notice. Profile radius maximum 3 mm.

#### Spare parts:

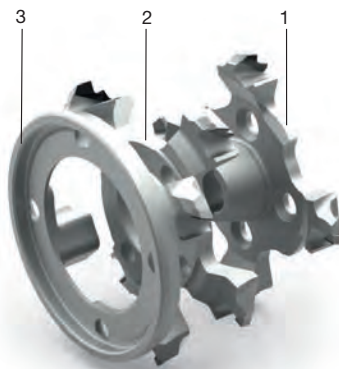
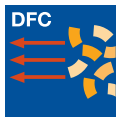
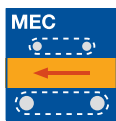
BEZ	ID
Maintenance set Quattro Form	008383 ●



①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	194101	5059124
R3	R1.3	R2	F45°	194103	5059126
R3	R1.3	R2	F10°	194105	5059128
R2	R1.3	R1.3	F45°	194107	5059130
R2	R1.5	R1	F45°	194109	5059351
R0.8	R1	R1.3	F45°	194111	5059132
R3	R2	R2	F45°	194113	5059134
R2	R1.3	F45°	F45°	194115	5058922
R2	R1.3	R2	R1.3	194117	5061838
R2	R1	R2	F45°	194119	5062650
R2	R1.3	R1.3	R1.3	194121	
R2	R3	R2	R3	194123	5065378



①	②	③	④	Leitz-Id.	Holzher
R2	R1.3	R2	F45°	194100	5059123
R3	R1.3	R2	F45°	194102	5059125
R3	R1.3	R2	F10°	194104	5059127
R2	R1.3	R1.3	F45°	194106	5059129
R2	R1.5	R1	F45°	194108	5059350
R0.8	R1	R1.3	F45°	194110	5059131
R3	R2	R2	F45°	194112	5059133
R2	R1.3	F45°	F45°	194114	5058919
R2	R1.3	R2	R1.3	194116	5061834
R2	R1	R2	F45°	194118	5062652
R2	R1.3	R1.3	R1.3	194120	
R2	R3	R2	R3	194122	5065379



- 1 = Tool 1  
2 = Tool 2  
3 = Tool 3

### Profile cutter Multi-Edge

#### Application:

For multi-profile cutting with radii and bevelling of edges.

#### Machine:

Stefani.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

DP composite tool with bore holes for setwise assembling on machine side adaptor. DFC design for efficient chip collection. Maximum processing quality through high running accuracy and smooth running.  $D_0$  = constant reference diameter, RPM  $n_{\max} = 18000 \text{ min}^{-1}$ . Tool change while the spindle is running. It is recommended to have individual tools changed by the Leitz tool service.

#### Diamaster PRO - Tool 1 fixed

WF 501 2 16

Machine	D	$D_0$	BO	Z	QAL	R	$n_{\max}$	ID	ID
	mm	mm	mm			mm	$\text{min}^{-1}$	LH	RH
Stefani	68	61.7	10 DKN	4	DP	1.0	18000	<b>192606</b> ●	<b>192605</b> ●
Stefani	68	61.7	10 DKN	4	DP	1.3	18000	<b>192608</b> ●	<b>192607</b> ●
Stefani	68	61.7	10 DKN	4	DP	1.5	18000	<b>192610</b> ●	<b>192609</b> ●
Stefani	68	61.7	10 DKN	4	DP	2.0	18000	<b>192612</b> ●	<b>192611</b> ●
Stefani	68	61.7	10 DKN	4	DP	2.5	18000	<b>192614</b> ●	<b>192613</b> ●
Stefani	68	61.7	10 DKN	4	DP	3.0	18000	<b>192616</b> ●	<b>192615</b> ●

#### Diamaster PRO - Tool 2 movable

WF 501 2 16

Machine	D	$D_0$	BO	Z	QAL	R	$n_{\max}$	ID	ID
	mm	mm	mm			mm	$\text{min}^{-1}$	LH	RH
Stefani	68	61.7	23	4	DP	1.0	18000	<b>192618</b> ●	<b>192617</b> ●
Stefani	68	61.7	23	4	DP	1.3	18000	<b>192620</b> ●	<b>192619</b> ●
Stefani	68	61.7	23	4	DP	1.5	18000	<b>192622</b> ●	<b>192621</b> ●
Stefani	68	61.7	23	4	DP	2.0	18000	<b>192624</b> ●	<b>192623</b> ●
Stefani	68	61.7	23	4	DP	2.5	18000	<b>192626</b> ●	<b>192625</b> ●
Stefani	68	61.7	23	4	DP	3.0	18000	<b>192628</b> ●	<b>192627</b> ●

#### Diamaster PRO - Tool 3 movable

WF 501 2 16

Machine	D	$D_0$	BO	Z	QAL	R	$n_{\max}$	ID	ID
	mm	mm	mm			mm	$\text{min}^{-1}$	LH	RH
Stefani	68	61.7	38	4	DP	1.0	18000	<b>192672</b> ●	<b>192671</b> ●
Stefani	68	61.7	38	4	DP	1.3	18000	<b>192632</b> ●	<b>192631</b> ●
Stefani	68	61.7	38	4	DP	1.5	18000	<b>192634</b> ●	<b>192633</b> ●
Stefani	68	61.7	38	4	DP	2.0	18000	<b>192636</b> ●	<b>192635</b> ●
Stefani	68	61.7	38	4	DP	2.5	18000	<b>192638</b> ●	<b>192637</b> ●
Stefani	68	61.7	38	4	DP	3.0	18000	<b>192640</b> ●	<b>192639</b> ●

Further profile variants in various dimensions available on request at short notice.





### Profile cutterhead / bevel cutterhead

#### Application:

To round edgebandings.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Cutterheads with HW knives and cylindrical bore with DKN. The same cutterhead tool body for R 1.5 to 3.0 mm.  $D_0$  = constant reference diameter.

#### Various radii - Brandt

WE 500 2

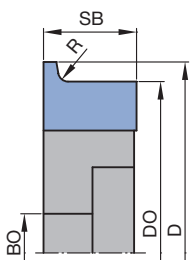
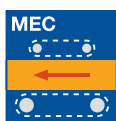
Machine	D	$D_0$	SB	BO	Z	R	Type	$n_{max}$	ID	ID
	mm	mm	mm	mm		mm		min <sup>-1</sup>	LH	RH
Brandt	56	50	16	16 DKN	4	2	1	18000	075006	075005
Brandt	58	50	12	16 DKN	4	3	2	18000	075004	075004
Brandt	78	70	19	16 DKN	4	3	1	18000	075003	075002
Brandt	82	70	16	16 DKN	4	2	2	18000	075009	075009

#### Spare knives:

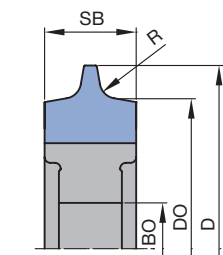
Part- no.	Type	BEZ	ABM	QAL	R	VE	ID	ID
			mm		mm	PCS	LH	RH
1	1	Exchange knife	16x13.4x2	HW	1.5	10	075325 ●	075324 ●
1	1	Exchange knife	16x13.4x2	HW	2.0	10	075327 ●	075326 ●
1	1	Exchange knife	16x13.4x2	HW	3.0	10	075329 ●	075328 ●
1	1	Exchange knife	19.6x15.2x2	HW	1.5	10	075334 ●	075333 ●
1	1	Exchange knife	19.6x15.2x2	HW	2.0	10	075336 ●	075335 ●
1	1	Exchange knife	19.6x15.2x2	HW	2.5	10	075338 ●	075337 ●
1	1	Exchange knife	19.6x15.2x2	HW	3.0	10	075303 ●	075302 ●
1	2	Exchange knife	12x13x2	HW	1.5	10	075339 ●	075339 ●
1	2	Exchange knife	12x13x2	HW	2.0	10	075330 ●	075330 ●
1	2	Exchange knife	12x13x2	HW	3.0	10	075304 ●	075304 ●
1	2	Exchange knife	16x17.5x2	HW	1.5	10	009539 ●	009539 ●
1	2	Exchange knife	16x17.5x2	HW	2.0	10	005132 ●	005132 ●
1	2	Exchange knife	16x17.5x2	HW	3.0	10	005133 ●	005133 ●

#### Spare parts:

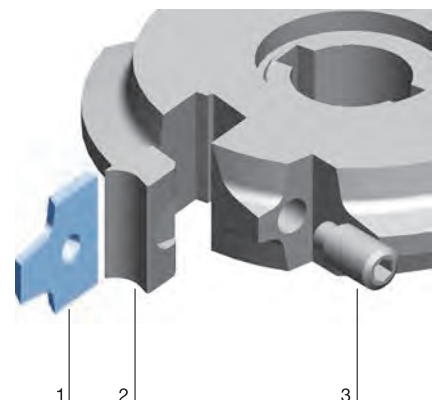
Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge	10x11.5x7	075400 ●
2	Clamping wedge	10x10.9x7	075403 ●
2	Clamping wedge	13.5x11x7	075404 ●
2	Clamping wedge	19	075401 ●
2	Clamping wedge	19	075402 ●
3	Allen screw	M6x12	006035 ●
	Allen key	SW 3	005444 ●
	Setting gauge for knives	1.0	005350 ●

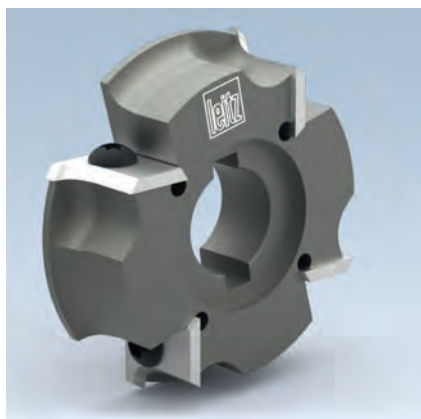


Type 1



Type 2





### Profile cutterhead / bevel cutterhead

#### Application:

To round edgebandings.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Cutterheads with HW knives and cylindrical bore with DKN. One cutterhead basic body for R 1.5 to 3.0 mm.  $D_0$  = constant reference diameter.

#### Various radii - Hebrock/EBM

WE 500 2

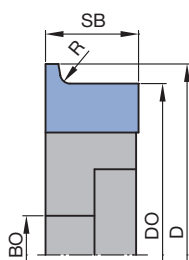
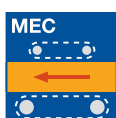
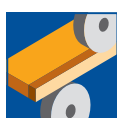
Machine	D	$D_0$	SB	BO	Z	R	Type	$n_{\max}$	ID	ID
	mm	mm	mm	mm		mm		min <sup>-1</sup>	LH	RH
Hebrock/EBM	56	49.7	14.5	16 DKN	4	2.0	1	18000	<b>074559</b>	<b>074560</b>
Hebrock/EBM	56	49.7	14.5	16 DKN	4	2.5	1	18000	<b>074557</b>	<b>074558</b>

#### Spare knives:

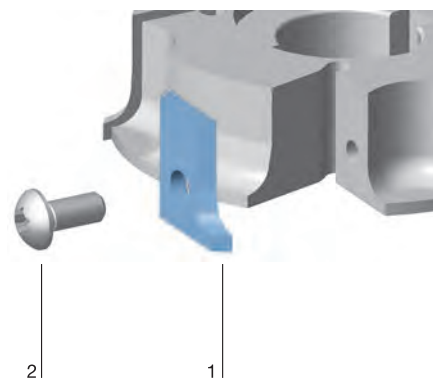
Part-	Type	BEZ	ABM	QAL	R	VE	ID	ID
no.			mm			PCS	LH	RH
1	1	Combi exchange knife	14.5x14.5x2	HW	2.0	10	<b>074632</b> ●	<b>074633</b> ●
1	1	Combi exchange knife	14.5x14.5x2	HW	2.5	10	<b>074630</b> ●	<b>074631</b> ●

#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Screw	M3.5x8	<b>005723</b> ●



Type 1







### Profile cutterhead / bevel cutterhead

#### Application:

To round and bevel edgebandings.

#### Machine:

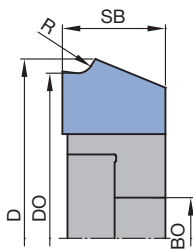
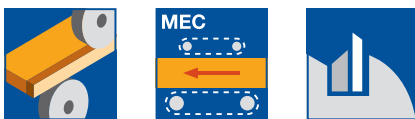
Single or double-sided edgebanding machines. Machines must be equipped with DFC system.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Cutterheads with HW knives and cylindrical bore with DKN.  $D_0$  = constant reference diameter. DFC design for highly efficient chip clearance of more than 97%.



#### Various profiles - DFC, Brandt

WE 500 2

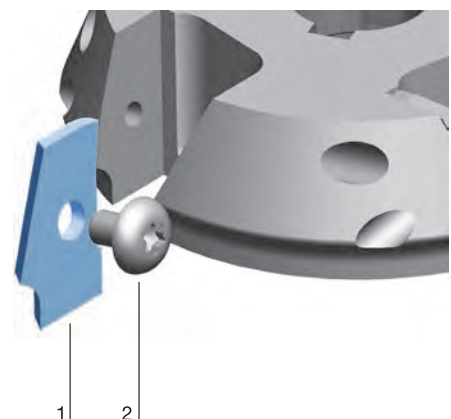
Machine	D	SB	BO	Z	R	FAW	Type	$n_{\max}$	ID	ID
	mm	mm	mm		mm	°		min <sup>-1</sup>	LH	RH
Brandt	70.23	20.28	16 DKN	4		15°	1	12000	075012 □	075013 □
Brandt	70.23	20.28	16 DKN	4		30°	1	12000	075014 □	075015 □
Brandt	69.98	20.28	16 DKN	4		45°	1	12000	075016 □	075017 □
Brandt	70.57	20.28	16 DKN	4	1.0		1	12000	075018 □	075019 □
Brandt	70.57	20.28	16 DKN	4	1.2		1	12000	075020 □	075021 □
Brandt	70.57	20.28	16 DKN	4	1.3		1	12000	075072 □	075073 □
Brandt	70.57	20.28	16 DKN	4	1.5		1	12000	075022 □	075023 □
Brandt	70.57	20.28	16 DKN	4	2.0		1	12000	075024 ●	075025 ●
Brandt	70.57	20.28	16 DKN	4	2.5		1	12000	075026 □	075027 □
Brandt	70.57	20.28	16 DKN	4	3.0		1	12000	075028 ●	075029 ●

#### Spare knives:

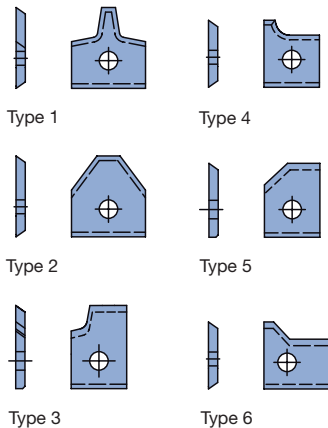
Part- no.	Type	BEZ	ABM	QAL	R	FAW	VE	ID	ID
			mm		mm	°	PCS	LH	RH
1	1	Exchange knife	22.3x14x2	HW	1.0		10	075315 ●	075314 ●
1	1	Exchange knife	22.3x14x2	HW	1.2		10	075317 □	075316 □
1	1	Exchange knife	22.3x14x2	HW	1.3		10	075272 ●	075271 ●
1	1	Exchange knife	22.3x14x2	HW	1.5		10	075319 ●	075318 ●
1	1	Exchange knife	22.3x14x2	HW	2.0		10	075307 ●	075306 ●
1	1	Exchange knife	22.3x14x2	HW	2.5		10	075321 □	075320 □
1	1	Exchange knife	22.3x14x2	HW	3.0		10	075309 ●	075308 ●
1	1	Exchange knife	22.3x14x2	HW	15°		10	075311 ●	075310 ●
1	1	Exchange knife	22.3x14x2	HW	30°		10	075331 ●	075332 □
1	1	Exchange knife	22.3x14x2	HW	45°		10	075313 ●	075312 ●

#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Oval head screw Torx® 15	M4x6	006225 ●
	Torx® key	Torx® 15	005466 ●



### Profile cutterhead / bevel cutterhead



#### Profile knives for edge finishing

TM 135 0

SB mm	H mm	DIK mm	QAL	Knife	R mm	FAW °	ID LH	ID RH
16	17.5	2	HW	1	2.0		005132 ●	005132 ●
16	17.5	2	HW	1	3.0		005133 ●	005133 ●
16	17.5	2	HW	1	4.0		005134 ●	005134 ●
16	17.5	2	HW	1	5.0		005135 ●	005135 ●
16	17.5	2	HW	2		45°	009525 ●	
12	17	2	HW	3	2.0		073554 ●	073555 ●
12	18	2	HW	3	2.0		074033 ●	074034 ●
12	17	2	HW	3	3.0		073558 ●	073559 ●
12	18	2	HW	3	3.0		074035 ●	074036 ●
13	15	2	HW	3	2.0		073505 ●	073504 ●
13	15	2	HW	3	3.0		073509 ●	073508 ●
12	14.5	2	HW	4	2.0		075342 ●	075341 ●
14.5	14.5	2	HW	4	2.5		073543 ●	073544 ●
12	14.5	2	HW	4	3.0		075301 ●	075300 ●
12	16	2	HW	5		45°	073541 ●	073540 ●
14.5	14.5	2	HW	6		45°		073545 □

#### Profile knives for system Biesse

TM 135 0

Type	BEZ	ABM mm	QAL	R mm	VE PCS	ID LH	ID RH
1	Exchange knife	16x17x2	HW	1.0	10	074600 □	074600 □
1	Exchange knife	16x17x2	HW	1.5	10	074601 □	074601 □
1	Exchange knife	16x17x2	HW	2.0	10	074602 ●	074602 ●
1	Exchange knife	16x17x2	HW	2.5	10	074603 □	074603 □
1	Exchange knife	16x17x2	HW	3.0	10	074604 □	074604 □
2	Exchange knife	40x17x2	HW	1.0	10	074610 □	074611 □
2	Exchange knife	40x17x2	HW	1.5	10	074612 □	074613 □
2	Exchange knife	40x17x2	HW	2.0	10	074614 □	074615 □
2	Exchange knife	40x17x2	HW	2.5	10	074616 □	074617 □
2	Exchange knife	40x17x2	HW	3.0	10	074618 □	074619 □
3	Exchange knife	20x16x2	HW	1.0	10	074620 □	074620 □
3	Exchange knife	20x16x2	HW	1.5	10	074621 □	074621 □
3	Exchange knife	20x16x2	HW	2.0	10	074622 ●	074622 ●
3	Exchange knife	20x16x2	HW	2.5	10	074623 □	074623 □
3	Exchange knife	20x16x2	HW	3.0	10	074624 □	074624 □

#### Profile knives for system Holz-Her

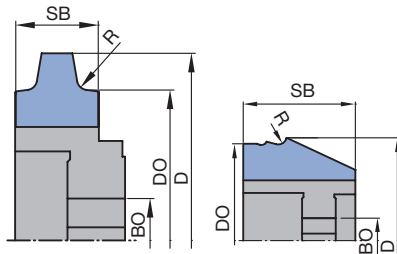
TM 435 0

BEZ	ABM mm	QAL	VE PCS	DRI	ID
Turnblade knife	30x12x1.5.PT1.3	HW	10	RH	005088 ●
Turnblade knife	30x12x1.5.PT1.3	HW	10	LH	005089 ●

#### Profile knives for system Ott

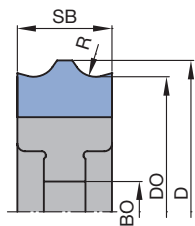
TM 135 0

Type	BEZ	ABM mm	QAL	R mm	VE PCS	ID LH	ID RH
1	Exchange knife	16x16.5x2	HW	1.0	10	074540 □	074540 □
2	Exchange knife	16x17.5x2	HW	1.5	10	009539 ●	009539 ●
1	Exchange knife	16x17.5x2	HW	2.0	10	005132 ●	005132 ●
1	Exchange knife	16x18.5x2	HW	2.5	10	074543 □	074543 □
2	Exchange knife	16x17.5x2	HW	3.0	10	005133 ●	005133 ●
1	Exchange knife	16x19.5x2	HW	3.5	10	074545 □	074545 □
2	Exchange knife	25x15x2	HW	1.0	10	619194 □	619194 □
2	Exchange knife	25x15x2	HW	1.5	10	619195 □	619195 □
2	Exchange knife	25x15x2	HW	2.0	10	619196 ●	619196 ●
2	Exchange knife	25x15x2	HW	2.5	10	619197 □	619197 □
2	Exchange knife	25x15x2	HW	3.0	10	619198 □	619198 □
2	Exchange knife	25x15x2	HW	3.5	10	619202 □	619202 □

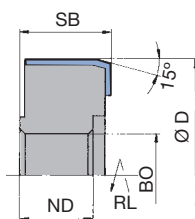


Type 1

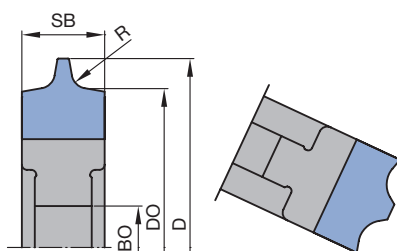
Type 2



Type 3

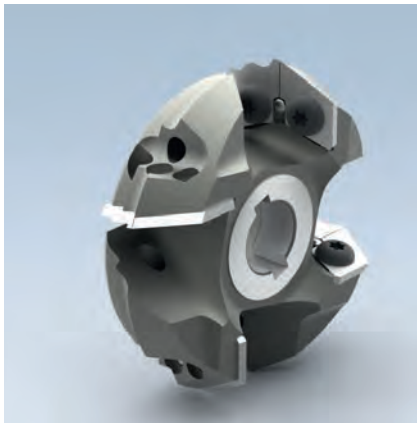


Type 4: WW 500 2 03



Type 1

Type 2



### Multi-profile cutterhead / bevel cutterhead

#### Application:

For a choice of radii or bevels on edgebandings.

#### Machine:

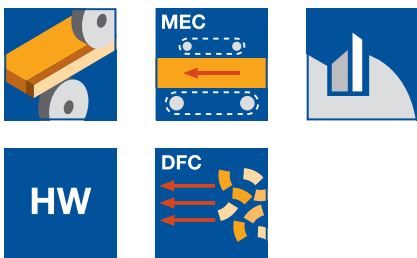
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

#### Technical information:

Cutterheads with HW knives and cylindrical bore with DKN.  $D_0$  = constant reference diameter. DFC design for highly efficient chip clearance of more than 97%. Various radii bevel combinations available.



#### Various profiles - DFC, Brandt

WE 500 2

Machine	D	SB	BO	Z	R	FAW	Type	$n_{max}$	ID	ID
	mm	mm	mm		mm	°		min <sup>-1</sup>	LH	RH
Brandt	74.24	25.28	16 DKN	4+4	1/1.5	1	1	12000	075040 □	075041 □
Brandt	74.24	25.28	16 DKN	4+4	1/2	1	1	12000	075032 ●	075033 ●
Brandt	74.24	25.28	16 DKN	4+4	1/3	1	1	12000	075036 ●	075037 ●
Brandt	74.24	25.28	16 DKN	4+4	1.3/2	1	1	12000	075034 ●	075035 ●
Brandt	74.24	25.28	16 DKN	4+4	1.3/3	1	1	12000	075048 ●	075049 ●
Brandt	74.24	25.28	16 DKN	4+4	1.5/2	1	1	12000	075042 ●	075043 ●
Brandt	74.24	25.28	16 DKN	4+4	1.5/3	1	1	12000	075044 ●	075045 ●
Brandt	74.24	25.28	16 DKN	4+4	2/3	1	1	12000	075038 ●	075039 ●
Brandt	74.24	25.28	16 DKN	4+4	1	15°	1	12000	075046 □	075047 □
Brandt	74.24	25.28	16 DKN	4+4	2	30°	1	12000	075050 □	075051 □

Further radii combinations available at short notice.

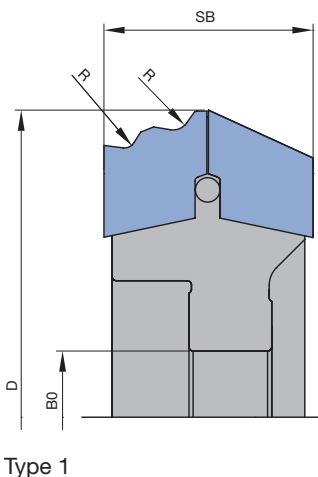
#### Spare knives:

Part- no.	Type	BEZ	ABM	QAL	R	FAW	VE	ID	ID
			mm		mm	°	PCS	LH	RH
1	1	Exchange knife	17.9x14.2x2	HW	1/1.5	10	10	075365 □	075366 □
1	1	Exchange knife	17.9x14.2x2	HW	1/2	10	10	075347 ●	075348 ●
1	1	Exchange knife	17.9x14.2x2	HW	1/3	10	10	075351 ●	075352 ●
1	1	Exchange knife	17.9x14.2x2	HW	1.3/2	10	10	075349 ●	075350 ●
1	1	Exchange knife	17.9x14.2x2	HW	1.3/3	10	10	075373 ●	075374 ●
1	1	Exchange knife	17.9x14.2x2	HW	1.5/2	10	10	075367 ●	075368 ●
1	1	Exchange knife	17.9x14.2x2	HW	1.5/3	10	10	075369 ●	075370 ●
1	1	Exchange knife	17.9x14.2x2	HW	2/3	10	10	075353 ●	075354 ●
1	1	Exchange knife	17.9x14.2x2	HW	1	15°	10	075371 ●	075372 ●
1	1	Exchange knife	17.9x14.2x2	HW	2	30°	10	075201 ●	075202 ●
2	1	Exchange knife	18.1x13.5x2	HW		10	10	075355 ●	075356 ●

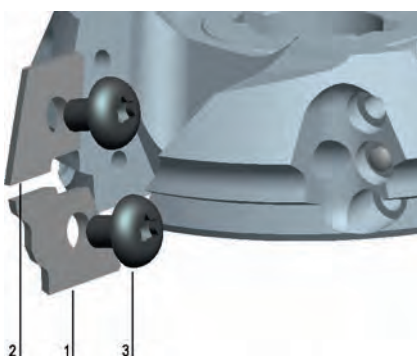
Further radii combinations available at short notice.

#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
3	Oval head screw Torx® 15	M4x6	006225 ●
	Torx® key	Torx® 15	005466 ●



Type 1





### Profile scrapers

#### Application:

For scraping edgebandings with radii or bevels.

#### Machine:

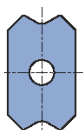
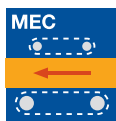
Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic edgebandings.

#### Technical information:

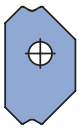
Bevel and radius scraper for scraper holder.



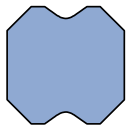
Type 1



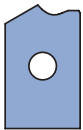
Type 6



Type 2



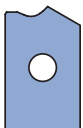
Type 7



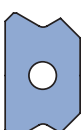
Type 3



Type 8



Type 4



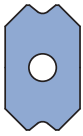
Type 5

#### Scrapers

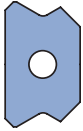
TM 435 0

Machine	R mm	FAW °	ABM mm	Type	QAL	BEM	VE PCS	ID
Biesse, Stefani		25°	12.7x12.7x3.18	7	HW		10	074552 ●
Biesse, Stefani	1.0		12.7x12.7x3.18	7	HW	Profile relief 10°	10	074548 ●
Biesse, Stefani	1.5		12.7x12.7x3.18	7	HW	Profile relief 10°	10	074549 ●
Biesse, Stefani	2.0		12.7x12.7x3.18	7	HW	Profile relief 10°	10	074550 ●
Biesse, Stefani	3.0		12.7x12.7x3.18	7	HW	Profile relief 10°	10	074551 ●
Fravol	1-3		12x20x2	4	HW		10	074639 ●
Fravol	1-3		12x20x2	3	HW		10	074640 ●
Holz-Her, Homag	1.0		12x20x2	1	HW	Profile relief 6°	10	074039 ●
Holz-Her, Homag	1.5		12x20x2	1	HW	Profile relief 6°	10	074074 ●
Holz-Her, Homag	2.0		12x20x2	1	HW	Profile relief 6°	10	074040 ●
Holz-Her, Homag	2.5		12x20x2	1	HW	Profile relief 6°	10	074075 ●
Holz-Her, Homag	3.0		12x20x2	1	HW	Profile relief 6°	10	074041 ●
Holz-Her, Homag, IMA	45°		12x20x2	1	HW		10	074037 ●
Homag	45°		12x20x2	2	HW	Profile relief 15°	10	073724 ●
Homag	1.0		12x20x2	2	HW	Profile relief 15°	10	073725 ●
Homag	1.5		12x20x2	2	HW	Profile relief 15°	10	073726 ●
Homag	2.0		12x20x2	2	HW	Profile relief 15°	10	073727 ●
Homag	2.5		12x20x2	2	HW	Profile relief 15°	10	073728 ●
Homag	3.0		12x20x2	2	HW	Profile relief 15°	10	073729 ●
Homag, Homag - BAZ	3°		20x11.5x2	6	HW		10	073717 ●
Homag, Homag - BAZ	1.0		20x11.5x2	6	HW	Profile relief 6°	10	073713 ●
Homag, Homag - BAZ	1.5		20x11.5x2	6	HW	Profile relief 6°	10	073714 ●
Homag, Homag - BAZ	2.0		20x11.5x2	6	HW	Profile relief 6°	10	073715 ●
Homag, Homag - BAZ	3.0		20x11.5x2	6	HW	Profile relief 6°	10	073716 ●
IMA	1.0		12x20x2	5	HW	Profile relief 15°	10	074044 ●
IMA	1.5		12x20x2	5	HW	Profile relief 15°	10	074076 ●
IMA	2.0		12x20x2	5	HW	Profile relief 15°	10	074021 ●
IMA	2.5		12x20x2	5	HW	Profile relief 15°	10	074077 ●
IMA	3.0		12x20x2	5	HW	Profile relief 15°	10	074022 ●
Ott	1.0		12.29x13.49x3.3	8	HW		10	074643 ●
Ott	2.0		12.29x13.49x3.3	8	HW		10	074644 ●

Additional scrapers available on request at short notice.



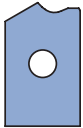
Type 1



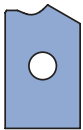
Type 2



Type 3



Type 4



Type 5

#### Technical information:

Prevention of stress-whitening and rework through special cutting geometry and quality. Scraper turnblades with different radii for adaption in scraper holder.

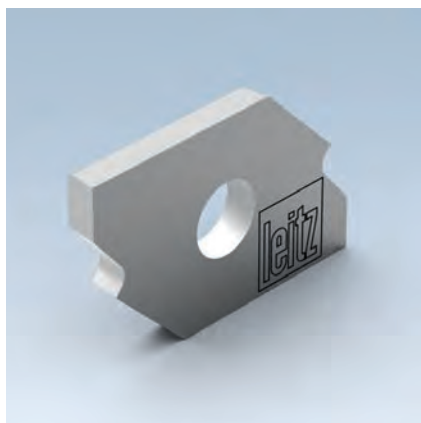
#### Radii scrapers with anti-stress-whitening bevel

TM 435 0

Machine	R mm	FAW °	ABM mm	QAL	BEM	Type	ID
Brandt, Hebrock/EBM, Holz-Her, Homag, IMA		45°	12x20x2	HW		1	<b>074103 ●</b>
Brandt, Hebrock/EBM, 1.0 Holz-Her, Homag	1.0		12x20x2	HW	Profile relief 6°	1	<b>074095 ●</b>
Brandt, Hebrock/EBM, 1.3 Holz-Her, Homag	1.3		12x20x2	HW	Profile relief 6°	1	<b>074096 ●</b>
Brandt, Hebrock/EBM, 1.5 Holz-Her, Homag	1.5		12x20x2	HW	Profile relief 6°	1	<b>074097 ●</b>
Brandt, Hebrock/EBM, 2.0 Holz-Her, Homag	2.0		12x20x2	HW	Profile relief 6°	1	<b>074098 ●</b>
Brandt, Hebrock/EBM, 2.5 Holz-Her, Homag	2.5		12x20x2	HW	Profile relief 6°	1	<b>074099 □</b>
Brandt, Hebrock/EBM, 3.0 Holz-Her, Homag	3.0		12x20x2	HW	Profile relief 6°	1	<b>074100 ●</b>
IMA	1.0		12x20x2	HW	Profile relief 15°	2	<b>074090 ●</b>
IMA	1.3		12x20x2	HW	Profile relief 15°	2	<b>074101 □</b>
IMA	1.5		12x20x2	HW	Profile relief 15°	2	<b>074091 ●</b>
IMA	2.0		12x20x2	HW	Profile relief 15°	2	<b>074092 ●</b>
IMA	2.5		12x20x2	HW	Profile relief 15°	2	<b>074093 □</b>
IMA	3.0		12x20x2	HW	Profile relief 15°	2	<b>074094 ●</b>
Homag, Homag - BAZ	1.0		20x11.5x2	HW	Profile relief 6°	3	<b>073719 ●</b>
Homag, Homag - BAZ	1.5		20x11.5x2	HW	Profile relief 6°	3	<b>073720 ●</b>
Homag, Homag - BAZ	2.0		20x11.5x2	HW	Profile relief 6°	3	<b>073721 ●</b>
Homag, Homag - BAZ	3.0		20x11.5x2	HW	Profile relief 6°	3	<b>073723 ●</b>
Fravol	1-3		15.44x20x2	HW		5	<b>074641 ●</b>
Fravol	1-3		15.44x20x2	HW		4	<b>074642 ●</b>

#### Spare parts:

BEZ	ABM mm	ID
Torx® key	Torx® 15	<b>005466 ●</b>
Oval head screw Torx® 15	M4x6	<b>006225 ●</b>



### Profile scrapers

#### Application:

For scraping edgebandings with radii or bevels.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

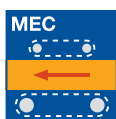
Plastic edgebandings.

#### Technical information:

Various bevel and radii scraper turnblades for mounting in scraper holders.

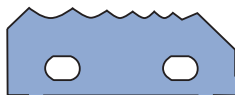
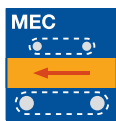
#### Profile scrapers - Holz-Her, aggregate ZK701

TM 435 0



Machine	R mm	FAW °	ABM mm	QAL	VE PCS	ID bottom	ID top
Holz-Her	1.0		12x19x2	HW	10	074561 ●	074562 ●
Holz-Her	1.3		12x19x2	HW	10	074563 ●	074564 ●
Holz-Her	1.5		12x19x2	HW	10	074565 ●	074566 ●
Holz-Her	2.0		12x19x2	HW	10	074567 ●	074568 ●
Holz-Her	2.5		12x19x2	HW	10	074569 ●	074570 ●
Holz-Her	3.0		12x19x2	HW	10	074571 ●	074572 ●
Holz-Her		45°	12x19x2	HW	10	074573 ●	074574 ●
Holz-Her		10°	12x19x2	HW	10	074575 ●	074576 ●

Additional scrapers available on request at short notice.



Multi-profile scraper

### Profile scrapers

#### Application:

For scraping edgebandings with radii or bevels.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic edgebandings.

#### Technical information:

Multi-profile scraper with a choice of bevels and radii.

#### Multi-profile scrapers

TM 135 0

Machine	BEM	QAL	ID LH	ID RH
Homag	R 1/1,5/2/3/5/grain 20°	HW	<b>074049 •</b>	
Homag	R 0.45/1/1.5/2/3/5	HW		<b>074050 •</b>
IMA	R 1,5/2/3	HW	<b>074079 •</b>	
IMA	R 1/2/3	HW		<b>074078 •</b>
Stefani	R 1/2/3/Bevel	HW	<b>074081 •</b>	<b>074080 •</b>
Biesse	R 1/2/3/Bevel	HW	<b>074082 •</b>	<b>074082 •</b>

#### Spare parts:

BEZ	ABM mm	ID
Torx® key	Torx® 15	<b>005466 •</b>
Oval head screw Torx® 15	M4x6	<b>006225 •</b>

#### Technical information:

Prevention of stress-whitening and rework through special bevel. Multi-profile scraper with different bevels and radii.

#### Multi-profile scraper with anti-stress-whitening bevel

TM 135 0

Machine	BEM	QAL	ID LH	ID RH
Homag	R 1/1,5/2/2,5/3/20°	HW	<b>073104 •</b>	<b>073105 •</b>

Further radii combinations with anti-stress-whitening bevel available at short time.

#### Spare parts:

BEZ	ABM mm	ID
Torx® key	Torx® 15	<b>005466 •</b>
Oval head screw Torx® 15	M4x6	<b>006225 •</b>



## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools



#### Profile scrapers

##### Application:

For scraping edgebandings with radii or bevels.

##### Machine:

Single or double-sided edgebanding machines.

##### Workpiece material:

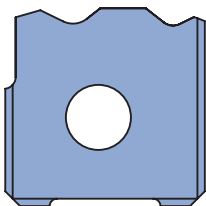
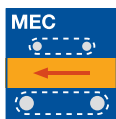
Plastic edgebandings.

##### Technical information:

Various bevels and radii. Scraper turnblade knives to carry in scraper holder.

##### Multi-profile scraper - Brandt

TM 135 0



Machine	ABM mm	QAL	R mm	FAW °	VE PCS	ID bottom	ID top
Brandt	13.5x13.38x2	HW	1/1.5		2	<b>075375 ●</b>	<b>075376 ●</b>
Brandt	13.5x13.38x2	HW	1/2		2	<b>075357 ●</b>	<b>075358 ●</b>
Brandt	13.5x13.38x2	HW	1/3		2	<b>075361 ●</b>	<b>075362 ●</b>
Brandt	13.5x13.38x2	HW	1.3/2		2	<b>075359 ●</b>	<b>075360 ●</b>
Brandt	13.5x13.38x2	HW	1.3/3		2	<b>075379 ●</b>	<b>075380 ●</b>
Brandt	13.5x13.38x2	HW	1.5/2		2	<b>075377 ●</b>	<b>075378 ●</b>
Brandt	13.5x13.38x2	HW	2/3		2	<b>075363 ●</b>	<b>075364 ●</b>
Brandt	13.5x13.38x2	HW	2	30°	2	<b>075397</b>	<b>075398</b>

Further radii combinations and anti-stress-whitening knives available at short notice.

##### Spare parts:

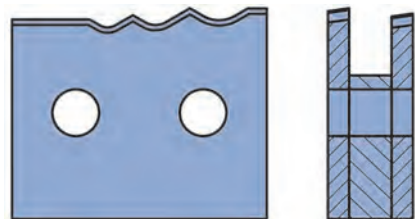
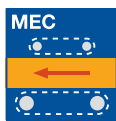
BEZ	ABM mm	ID
Torx® key	Torx® 15	<b>005466 ●</b>
Oval head screw Torx® 15	M4x6	<b>006225 ●</b>

Multi-profile scraper

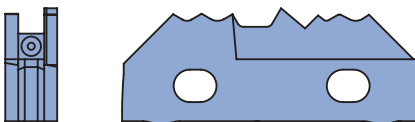
## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools



Duo multi-profile scraper Type 1  
(all profiles in Duo design)



Duo multi-profile scraper Type 2  
(2 profiles in Duo design)

### Profile scrapers

#### Application:

For scraping edgebandings with radii or bevels. Especially for colour fastness and anti-stress whitening for dark edges and high gloss PMMA edges.

#### Machine:

Single or double-sided edgebanding machines or double-end tenoners.

#### Workpiece material:

Plastic edgebandings as PP, ABS, PMMA, etc.

#### Technical information:

Duo multi-profile scraper with different radii and bevels for 4 profiles in total. Staggered cut on two consecutively arranged scrapers with special micro geometry for high edge quality, colour fastness, high gloss level and without stress-whitening. Especially in conjunction with jointless edgebanding.

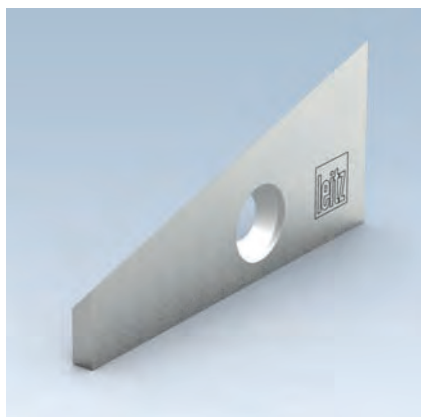
**Attention:** Only applicable on standard scraper aggregates with special profile scraper holders.

#### Duo multi-profile scraper

TM 135 0, TM 435 0

Machine	BEM	Type	QAL	ID LH	ID RH
Homag	R 1.3/2.0 (Duo) R 0.6/1.5/5°	2	HW	<b>073730</b>	<b>073731</b>
IMA	R 1.3/1.5/2/45°	1	HW	<b>074084 ●</b>	<b>074085 ●</b>
IMA	R 1/2/3/45°	1	HW	<b>074088 ●</b>	<b>074089 ●</b>

Further radii combinations available at short notice.



### Flat scrapers

#### Application:

For scraping edgebandings and glue.

#### Machine:

Single or double-sided edgebanding machines.

#### Workpiece material:

Plastic edgebandings.

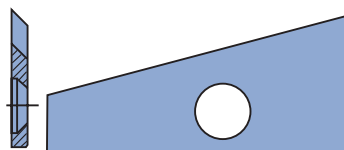
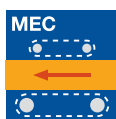
#### Technical information:

Different profile flat scrapers.

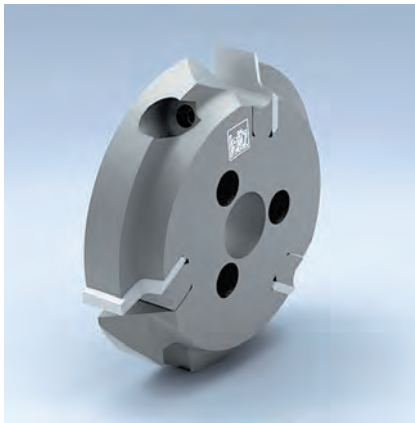
#### Flat scraper knives

TC 105 0, TM 135 0, TM 440 0

Machine	ABM mm	QAL	FAW °	ID LH	ID RH
Biesse	16x16x4,7	HW			074556 ●
Biesse	22,9x22,9x2,5	HW			074555 ●
Brandt, Homag, Ott	15x14,3x2,5	HW	6°	074500 ●	074501 ●
Fravol	20x12x1,5	HW			074638 ●
Hebrock, EBM	36x30x3	HW		074634	074635
Holz-Her	HW:14x14x2	HW			009546 ●
Homag	32x55x4,5	HW	15°	074047 ●	074048 ●
IMA	14,3x14,3x2,5	HW			074305 ●
IMA	55x25x3	HW	15°	074023 ●	074024 ●
IMA BAZ	11x14,3x2,5	HW			074306 ●



Flat scraper



### Profile cutterhead / bevel cutterhead for stationary machines

#### Application:

To round/bevel edgebandings.

#### Machine:

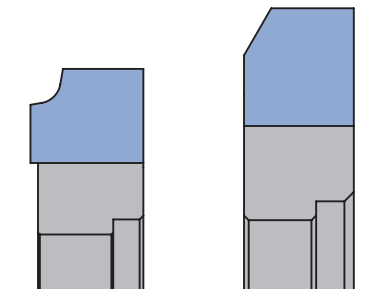
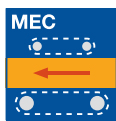
Homag BAZ.

#### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

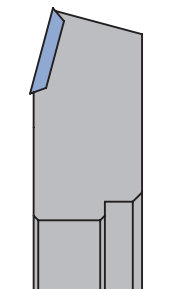
#### Technical information:

Cutterheads with HW knives for edge trimming cutter aggregate. The same cutterhead tool body suitable for R 1.0 to 3.0 mm.  $D_0$  = constant reference diameter.



Type 1

Type 2



Type 3

#### Various radii / bevels - Homag

WE 500 2

D	$D_0$	BO	NLA	Z	QAL	R	FAW	Type	$n_{max}$	ID	ID
mm	mm	mm	mm			mm	°		min <sup>-1</sup>	LH	RH
59	50	15	3/4.2/25	3	HW	1.0		1	18000	073001	073000
59	50	15	3/4.2/25	3	HW	1.5		1	18000	073003	073002
59	50	15	3/4.2/25	3	HW	2.0		1	18000	073005	073004
59	50	15	3/4.2/25	3	HW	3.0		1	18000	073009	073008
60	50	15	3/4.2/25	3	HW		15°	2	18000	073037	073036
60	50	15	3/4.2/25	3	HW		30°	2	18000	073039	073038
60	50	15	3/4.2/25	3	HW		45°	2	18000	073041	073040
62	50	15	3/4.2/25	3	HW		15°	3	18000	073101	073100

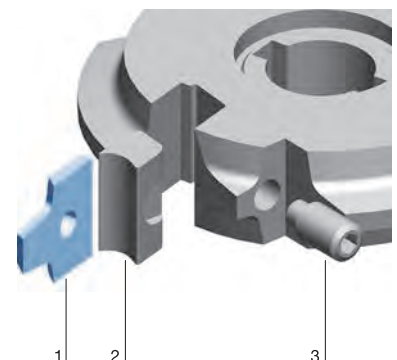
Type 3 for special thin edgebandings.

#### Spare knives:

Part-no.	SB	H	DIK	QAL	R	FAW	Type	ID	ID
	mm	mm	mm		mm	°		LH	RH
1	13	15	2	HW	1.0		1	073501	073500
1	13	15	2	HW	1.5		1	073503	073502
1	13	15	2	HW	2.0		1	073505	073504
1	13	15	2	HW	3.0		1	073509	073508
1	12	16	2	HW		15°	2	073537	073536
1	12	16	2	HW		30°	2	073539	073538
1	12	16	2	HW		45°	2	073541	073540
1	14	14	2	HW-F			3	005099	005099

#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge RH	11.5x14.4x7	073400
2	Clamping wedge LH	11.5x14.4x7	073401
3	Allen screw	M6x12	006035
3	Countersink screw, Torx® 20	M6x0.5x4.9	006243
	Allen key	SW 3	005444
	Torx® key	Torx® 20	006091
	Setting gauge for knives	1.0	005350



## 2. Panel processing

### 2.1 Edge processing 2.1.7 Edge finishing tools



#### Profile cutter / bevel cutter for stationary machines.

##### Application:

To round/bevel edgebandings.

##### Machine:

Homag BAZ.

##### Workpiece material:

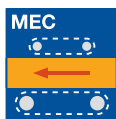
Plastic, softwood, hardwood and veneer edgebander.

##### Technical information:

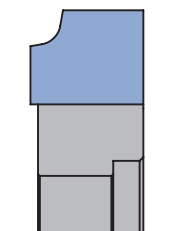
DP tipped tool with cylindrical bore.  $D_0$  = constant reference diameter.

##### Radii cutter DP - Homag

WF 501 2 DP



D	D <sub>0</sub>	BO	NLA	Z	QAL	R	Type	n <sub>max</sub>	ID	ID
mm	mm	mm	mm			mm		min <sup>-1</sup>	LH	RH
57	50	15	3/4.2/25	3	DP	2.0	1	18000	073103 ●	073102 ●
57	50	15	3/4.2/25	3	DP	3.0	1	18000	091522 ●	091523 ●



Type 1

## 2. Panel processing

### 2.1 Edge processing

#### 2.1.7 Edge finishing tools



#### Profile cutter / bevel cutter for stationary machines.

##### Application:

To round/bevel edgebandings.

##### Machine:

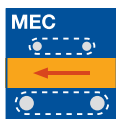
IMA (BIMA).

##### Workpiece material:

Plastic, softwood, hardwood and veneer edgebander.

##### Technical information:

HW tipped profile/bevel cutter, 1 or 2 part design. DP tipped tools available at short notice.

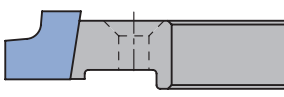
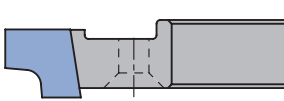
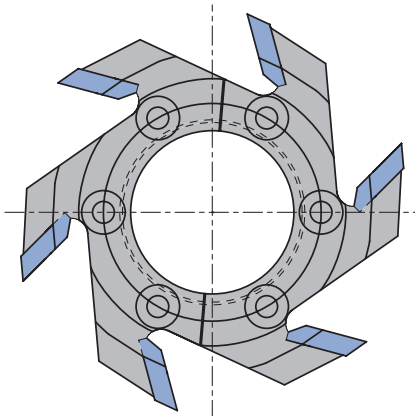


##### Various radii / bevels - IMA

WF 501 2

D	D <sub>0</sub>	SB	BO	NLA	Z	QAL	R	FAW	Type	n <sub>max</sub>	ID	ID
mm	mm	mm	mm	mm			mm	°		min <sup>-1</sup>	LH	RH
64.4	55	10.2	30	6/5/40	6	HW	1.5		1	18000	074062	074063
64.4	55	10.2	30	6/5/40	6	HW	2.0		1	18000	074064	074065
64.4	55	10.2	30	6/5/40	6	HW	3.0		1	18000	074066	074067
70	60	9	30	6/5/40	6	HW	1.5		1	18000	074056	074057
70	60	9	30	6/5/40	6	HW	2.0		1	18000	074058	074059
70	60	9	30	6/5/40	6	HW	3.0		1	18000	074060	074061
70	60	9	30	6/5/40	6	HW		15°	1	18000	074068	074069
70	60	9	30	6/5/40	6	HW		30°	1	18000	074070	074071
70	60	9	30	6/5/40	6	HW		45°	1	18000	074072	074073

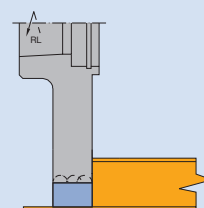
All cutters are available at short notice in 2 part design.



#### Rebating

Rebating cutter, page 67

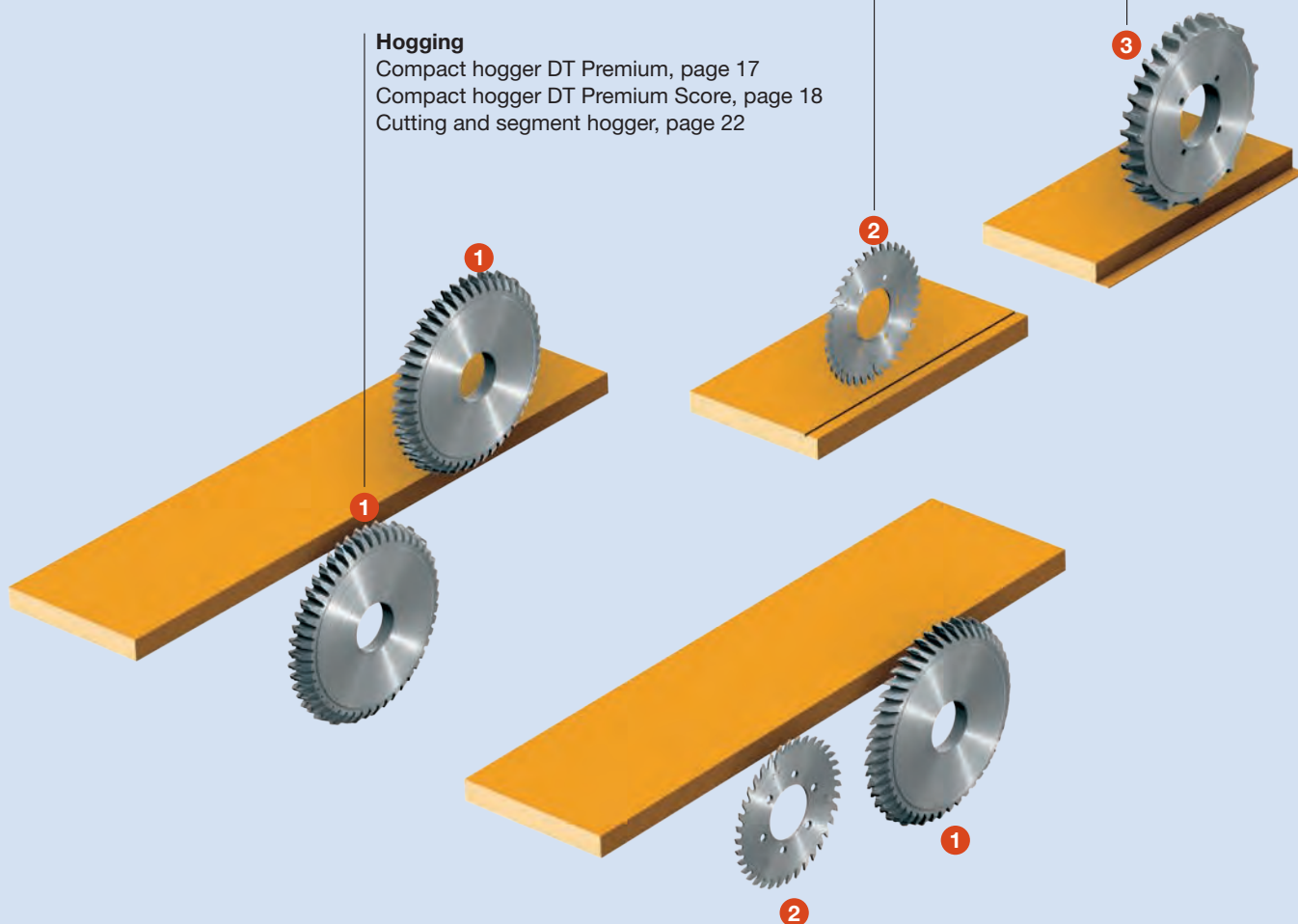
Milling off the wooden composite board to uncover the cover layer, application mostly with feed.



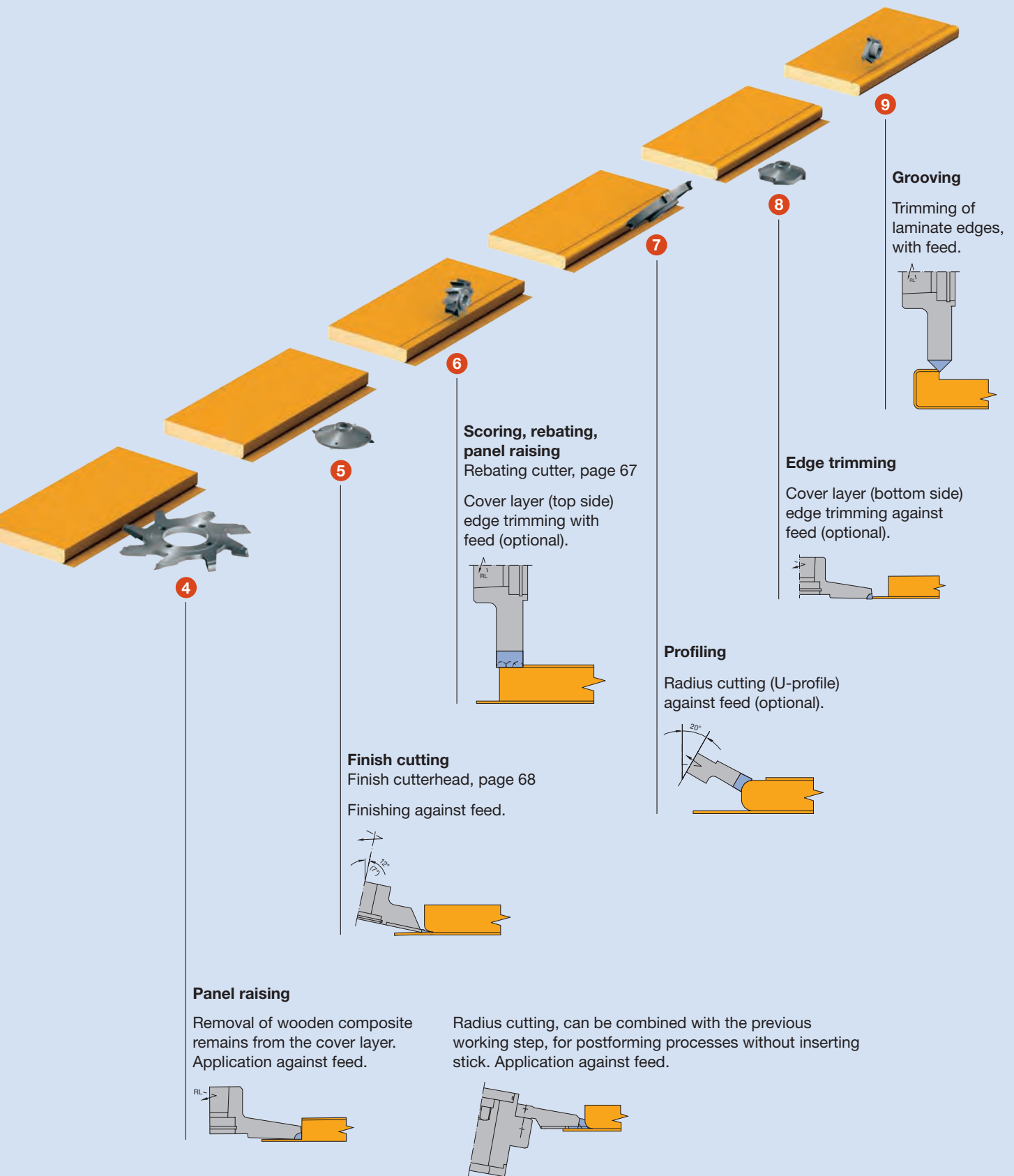
#### Scoring

#### Hogging

Compact hogger DT Premium, page 17  
Compact hogger DT Premium Score, page 18  
Cutting and segment hogger, page 22







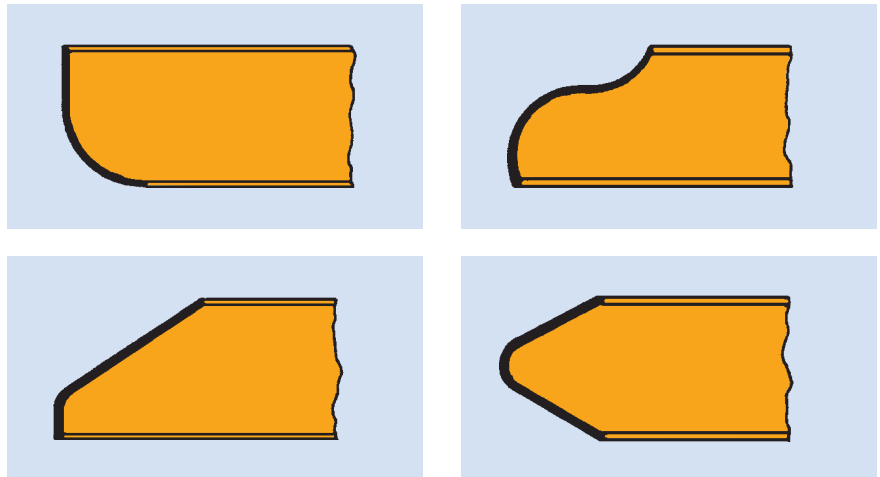
## 2. Panel processing

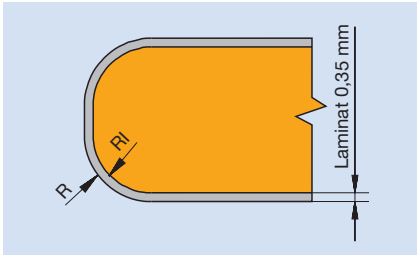
### 2.2 Postforming processing

#### 2.2.2 Postforming tools

<b>Working processes</b>	Production of workpieces with narrow edges for profiling and coating with edging material.
<b>Workpiece material</b>	Chipboard and fibre materials (e.g. MDF boards).
<b>Machines</b>	Single or double-sided soft forming machines.
<b>Procedure</b>	<p>Sizing panel by scoring hogging or double hogging, protection milling, if required.</p> <p>Scoring and removing the coating on the workpiece surface by horizontal spindle.</p> <p>Profiling the narrow edge with vertical, horizontal or inclined spindles.</p> <p>Cutting the edgebanding on the sized side to a precise dimension with the tracing spindle.</p> <p>Edge trimming of the banding on the side banded first with tracing spindle.</p> <p>Scraping, if required.</p>
<b>Important order data</b>	<ul style="list-style-type: none"> <li>– Profile</li> <li>– Coating thickness</li> <li>– Coating material</li> <li>– Machine side</li> <li>– Number of sides to be coated</li> <li>– Expected profile production volume</li> </ul> <p>Given the diversity of products, standard tools and special tools are used in soft forming according to requirements.</p>

#### Profile examples

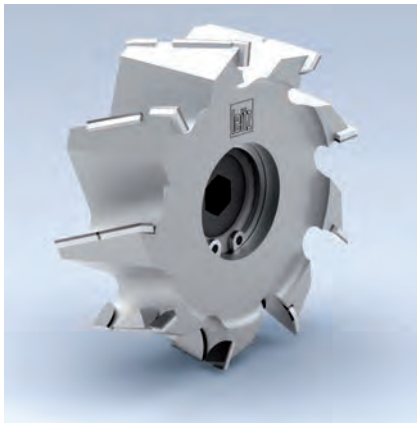


<b>Working process</b>	Production of workpieces with profiled narrow edges with jointless HPL, CPL or veneer surface coating material wrapped around the narrow face.
<b>Workpiece material</b>	Chipboard and fibre materials (e.g. MDF).
<b>Machines</b>	Single or double-sided post forming machines.
<b>Important ordering information</b>	<div style="display: flex; align-items: flex-start;">  <div style="margin-left: 20px;"> <ul style="list-style-type: none"> <li>– Radius and internal radius</li> <li>– Coating thickness</li> <li>– Material thickness</li> <li>– Type of coating</li> <li>– Post forming with or without inlay rod</li> <li>– Machine side</li> </ul> <p>R = External radius, e.g. R9 RI = Internal radius, e.g. R8,65</p> </div> </div>

## 2. Panel processing

## 2.2 Postforming processing

### 2.2.2 Postforming tools



#### Rebating cutter

##### Application:

To rebate the core to uncover and trim the edge of the top layer.

##### Machine:

Postforming machines.

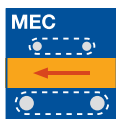
##### Workpiece material:

HPL, CPL or veneer coated chip and fibre boards (particle board, MDF etc.).

##### Technical information:

DP tipped tools with HSK 25 R adaptor. High number of teeth removes the need for pre-scoring.

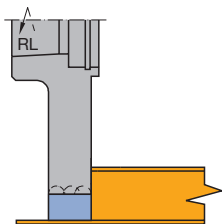
DP tools - 2.0 mm resharping area.



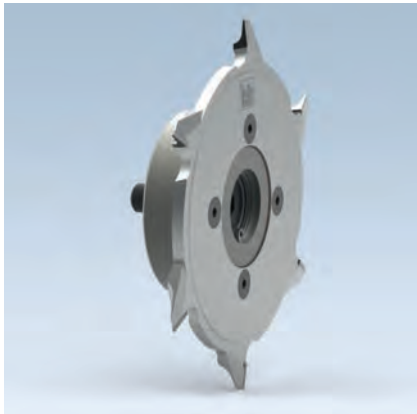
#### Diamaster PRO

WF 499 2

Machine	D mm	SB mm	BO mm	Z	$n_{\max}$ $\text{min}^{-1}$	ID LH	ID RH
Homag, IMA	70	25	HSK 25 R	9+3	18000	<b>091796</b>	<b>091797</b>



Rebating cutter with HSK 25 R bore:  
Machining the laminate layer with  
horizontal motor



### Finishing cutterhead

#### Application:

For finish cutting of radii on postforming profiles.

#### Machine:

Postforming units.

#### Workpiece material:

HPL, CPL or veneer coated chip and fibre boards (chipboard, MDF etc.).

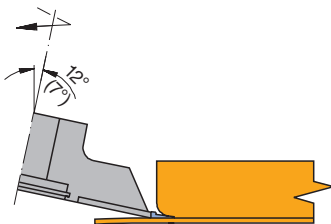
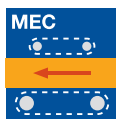
#### Technical information:

Cutterhead with DP tipped profile knives and HSK 25 R adaptor. Suitable for finish cutting of all radii up to R 14 mm.

#### 7° inclined spindle

WF 556 2

Machine	D mm	SB mm	BO mm	Z	QAL	$n_{\max}$ min <sup>-1</sup>	Spindle angle °	ID LH	ID RH
Homag, IMA	125	5.1	HSK 25 R	6	DP	12000	7	<b>192666</b>	<b>192667</b>



Finish cutting of all radii up to R 14 mm with spindle angle 7°

#### Technical information:

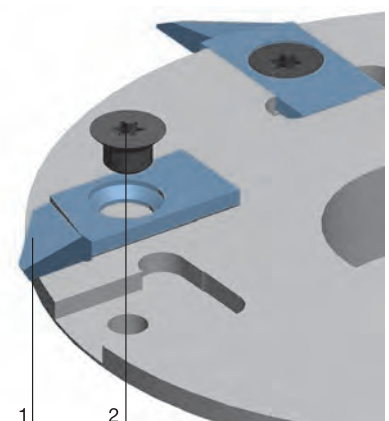
Spare knives for cutterhead with DP profile knives and cylindrical bore or HSK 25 R adaptor. Suitable for finish cutting radii up to R 14. Non-resharpenable knives 0.5 mm optimised for sensitive coatings, veneer postforming and maximum contour accuracy.

#### Spare knives for finishing cutterheads

TM 160 0

BEZ	ABM mm	QAL	ID LH	ID RH
Knife	12x31x2.5x0.5. SB2.5	DP	<b>008208 ●</b>	<b>008204 ●</b>

Spare knives for 7° and 12° inclined spindles.



## 2. Panel processing

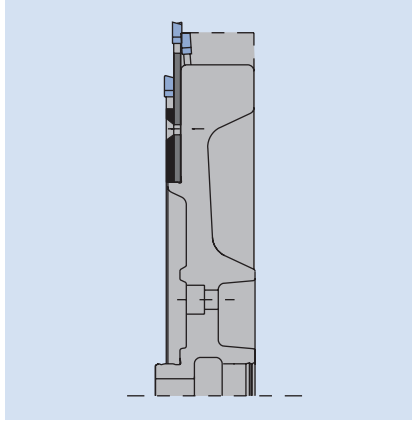
### 2.3 Panel processing

#### 2.3.1 Segment hoggers for sizing

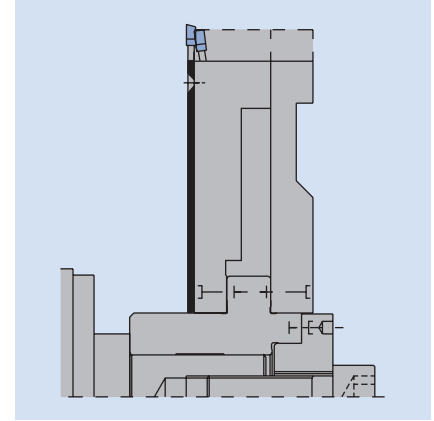
##### Segment hogger

The cut edge quality of the sizing and finish cuts depends on the circular sawblades. Tool body in steel or aluminium. Staggered cut with tungsten carbide segments. Assembly on flanged sleeve or direct assembly on the motor spindle without flanged sleeve depends on the design.

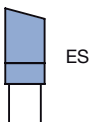
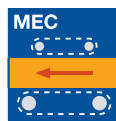
##### Designs



Toolset for finish-production unit with sizing and finish cut



Toolset for sizing unit mounted on flanged sleeve



### Segment hogger for sizing unit

#### Application:

For hogging along and across grain with/without scoring sawblade.

#### Machine:

Sizing station in production lines.

#### Workpiece material:

Chip and fibre boards (MDF etc.) uncoated, veneered, plastic coated.

#### Technical information:

The cut edge quality depends on the circular sawblade. Tool body D 305 mm in steel or D 355 mm in aluminium. Staggered cut with six tungsten carbide segments. Build up option with extension hogger unit. For D 305 mm the hogger is mounted directly on the spindle without flanged sleeve.

#### Hogger for sizing unit

SZ 300 2, SZ 301 2

Machine	D	SB	BO	Z/ZF <sub>Sawblade</sub>	QAL	ID	ID
	mm	mm	mm			LH	RH
Siempelkamp	305	60.1	30	60/ES	HW	064700 □	064701 □
Siempelkamp	355	60.5	40 DKN	72/ES	HW	064702	064703

#### Spare parts:

Part- no.	BEZ	ABM mm	BEM	ID
1	Countersink screw, Torx® 20	M6x12	Torx® 20	006084 ●
2	Screw with ISK	M8x17	for D = 250/350/305/355	006237 ●
3	Cylindrical screw with ISK	M8x60	for D = 305	005878 ●
3	Cylindrical screw with ISK	M8x35	for D = 305/350	005874 ●
3	Cylindrical screw with ISK	M8x25	for D = 355	005947 ●

#### Hogging sawblade

WK 801 2

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
305	4.4	120	60	ES	HW	061844 ●	061845 ●
355	4.4	80	72	ES	HW	061846 ●	061847 ●

#### Technical information:

Steel (D 300 mm) and aluminium (D 350 mm) with segments.

#### Basic hogger

WZ 300 2

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
300	28	30	6x7	FZ	HW	064440	064441
350	36.5	80	6x10	FZ	HW	064442	064443

#### Extension hogger

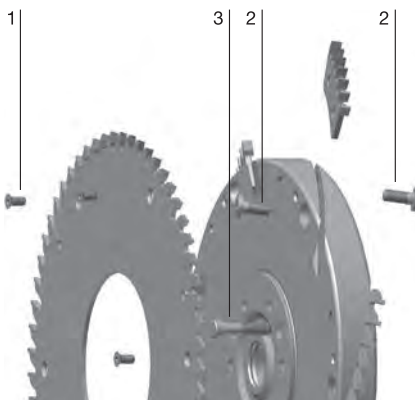
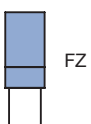
WZ 300 2

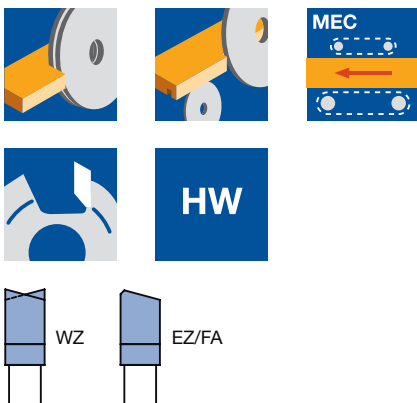
D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
300	28	30	6x7	FZ	HW	064444	064445
350	20.2	80	6x10	FZ	HW	064446	064447

#### Segments (6 per hogger)

TM 170 0

ABM mm	Z	ZF	QAL	ID	ID
				LH	RH
D 300/340	7	FZ	HW	064970 ●	064971 ●
D 350	10	FZ	HW	064962 ●	064963 ●





### Segment hogger for splitting unit

#### Application:

For hogging along and across grain with/without scoring sawblade.

#### Machine:

Sizing station in production lines.

#### Workpiece material:

Chip and fibre boards (MDF etc.) uncoated, veneered, plastic coated.

#### Technical information:

Cut edge quality of the trim and finish cuts is defined by the sawblades. Set assembled with finish cut, trim sawblade and twelve tungsten carbide tipped segments. Staggered cut by twelve hogging segment. The hogger is mounted directly on the motor spindle without flanged sleeve.

#### Hogger for splitting unit

SZ 300 2

Machine	D mm	SB mm	BO mm	Z/ZF Sawblade	QAL	ID LH	ID RH
Siempel- kamp	350	42.1	30	60 ES/FA 72 WZ	HW	<b>064704</b>	<b>064705</b>

#### Spare parts:

Part-no.	BEZ	ABM mm	BEM	ID
1	Countersink screw, Torx® 20	M6x16	Torx® 20	<b>006086 •</b>
2	Cylindrical screw with ISK	M8x35	for D = 305/350	<b>005874 •</b>

#### Technical information:

D 300 mm finish cut and D 350 mm trimming sawblade.

#### Hogging sawblade

WK 802 2, WK 850 2

D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
300	4.4	200	60	ES/FA	HW	<b>061848 •</b>	<b>061849 •</b>
350	4.4	200	72	WZ	HW	<b>061850 •</b>	<b>061850 •</b>

#### Basic hogger with segments

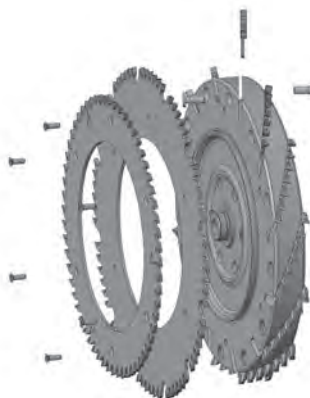
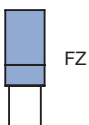
WZ 300 2

D mm	SB mm	BO mm	Z	ZF	QAL	ID LH	ID RH
340	34.5	30	12x7	FZ	HW	<b>064448</b>	<b>064449</b>

#### Segments (12 per hogger)

TM 170 0

ABM mm	Z	ZF	QAL	ID LH	ID RH
D 300/340	7	FZ	HW	<b>064970 •</b>	<b>064971 •</b>



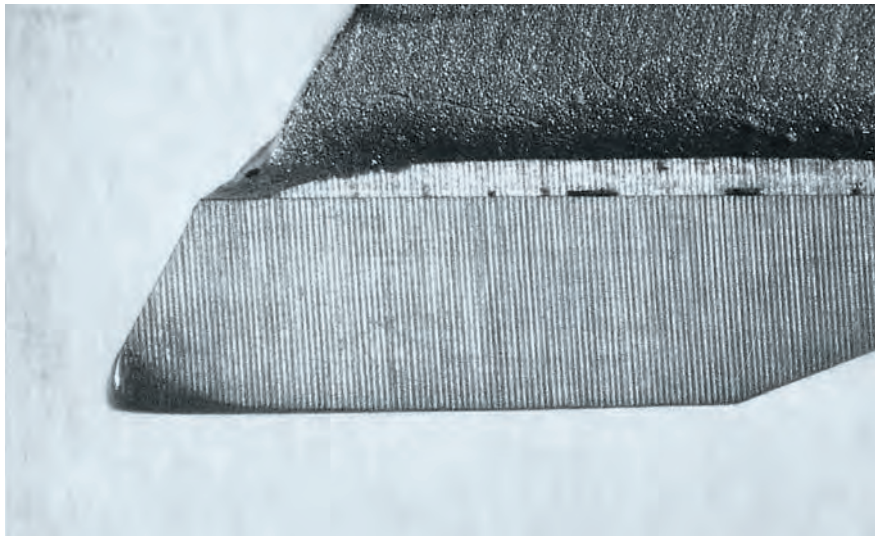


Problem	Possible cause	Action
<b>Break outs at the edge of the workpiece top edge</b>	- Incorrect height adjustment of hogging motor and tilt in feed direction	Correct setting Check position of tools in feed direction, adjust standard value of 0.1 mm to the panel edge
	- Too much axial play in spindle bearing or damaged bearing	Check motor bearings and tolerances
	- Track vibrates due to low chain tension and damaged guides	Check the chain tension, replace damaged parts
	- Incorrect top pressure adjustment	Check top pressure
	- Run out tolerance too high, possible tool imbalance	Measure tool, correct and check for imbalance
	- Insufficient number of teeth, feed rate too high	Increase number of teeth or adjust feed speed
<b>Break outs at the edge of the workpiece bottom edge</b>	- Workpiece projection too large or thin workpieces	Provide additional support in the tool area
	- Incorrect adjustment in feed direction of scoring or hogging tool	Produce trial sample and adjust motors
	- Scoring sawblade not adjusted to the accuracy required in feed direction or hogging tool tilted too far	Check angles of scoring sawblade and hogging tool in feed direction
<b>Tooth pattern at workpiece edge wavy surface</b>	- Tool position setting angle is too high	Correct the tool setting angle
	- Transport of workpiece not consistent during through feed	Check chain and drive
	- Inconstant workpiece feed rate	Increase number of teeth or adjust feed speed
	- Run out tolerance too high, possible imbalanced tool	Measure tool, correct and check for imbalance
<b>Surface of middle layer rough, uneven (with steps)</b>	- Tool worn, blunt	Repair and service the tool
	- Insufficient number of teeth, feed speed too high	Increase number of teeth, adjust feed speed
	- Adjustment of top and bottom tools (scoring/hogging tool) not level with feed direction	Produce trial sample and adjust motors
	- Adjustment of hogging tool not at correct angle to the track	Check angle with dial gauge on the horizontal moving spindle
	- Incorrect tooth shape of tool and angle geometry	Check and correct
	- Insufficient middle layer quality of the workpiece	Improve by removing resin and sharpening more frequently
<b>Break outs at edge of workpiece end grain, front</b>	- Adjustment of jump head to the hogging tool not level with feed direction	Produce trial sample and adjust motors
<b>Break outs at edge of workpiece end grain, back</b>	- Adjustment of the controlled scoring motor not level with the hogging unit in feed direction	Check movement of the jump scoring motor and correct adjustment to the hogging unit
	- Poor quality of middle layer of workpiece material (large chip flow, poor pressing)	Improve by removing resin and sharpening tools more often
	- Insufficient number of teeth, feed speed too high	Increase number of teeth or adjust feed speed
	- Incorrect tooth shape and angle geometry	Check and adjust through resharpener

### Rounding of the cutting edge

When hogging solid wood and wood-derived materials with or without coating, the teeth of the hogging sawblade and hogger parts are subject to mechanical and chemical wear.

The surface quality determines the size of the cutting edge abrasion. An extremely worn sawblade tooth requires additional sharpening and reduces the number of possible resharpenings.



Typical cutting edge wear when machining solid wood.

### Cutting edge destruction through improper use

If the relationship between the number of teeth and feed speed is incorrect, the cutting forces will be too high when hogging solid wood, especially with a high moisture content. This leads to choking the gullet and consequently destruction of the saw tooth.

#### Action:

Reduce the number of teeth to increase the gullet area; adjust feed speed so the cutting quality is still adequate.



Cutting edge destruction through improper use.

### Cutting edge destruction through overstress

If the material to be removed is wider than the cutting width of the hogger, the outside teeth of the raised hogger segments are destroyed by overstress.

The hogging width must always be smaller than the cutting width of the hogging tool.



Destruction of saw tooth through overstress.

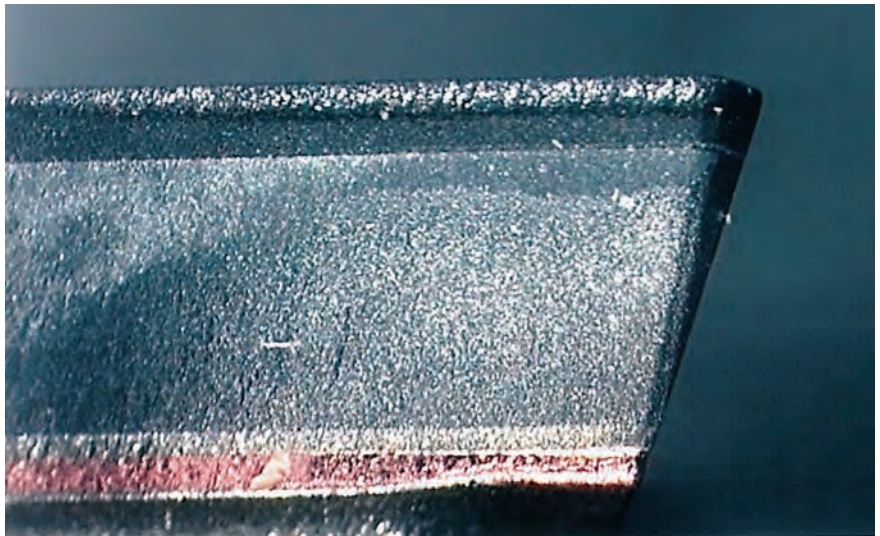


### Rounding of cutting edges

The illustration opposite shows a typical blunt cutting edge, resulting from mechanical abrasion when machining uniform materials.

Removing the resin from the sides of the teeth between resharpening intervals leads to a considerably longer performance time, as it prevents the loss of side relief.

The area of wear should be approx. 0.2 to max. 0.3 mm.

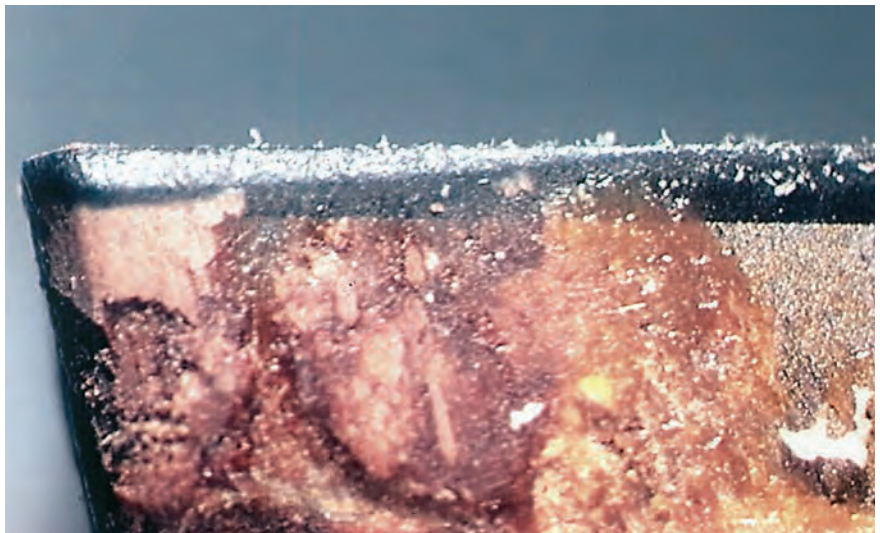


Wear to cutting edges after machining MDF.

### Cutting edge rounding and resin build up

Apart from cutting edge wear, a build-up also forms at the side of the teeth from adhesive dust and chip particles (resin build-up) when the workpiece material has a high resin content or the tool has been run for a long time.

This leads to higher cutting forces and power consumption, low surface and middle layer quality and a considerably reduced tool life.

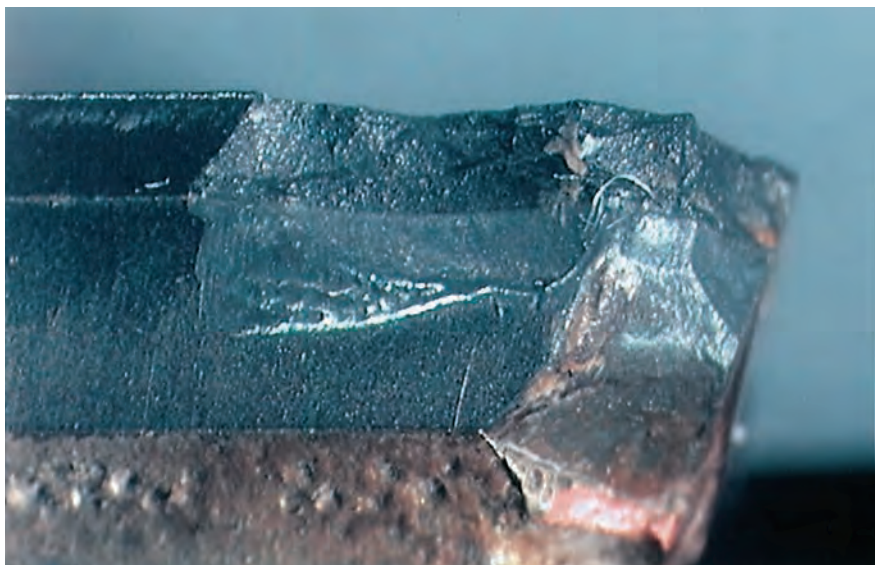


Wear to cutting edges and resin build-up after machining chipboard.

### Cutting edge destruction

The cutting edges can be destroyed when machining workpiece materials with a high sand content, a grain size up to 2 - 3 mm diameter (I) or containing metallic particles.

Using DP (DIA) tools when machining such workpiece materials is problematic and use is not recommended for efficient machining.



Cutting edge destruction from metallic particles.

## Enquiry/order form special tools – panel processing



**Customer details:** Customer number:          
(if known)

☐ Enquiry  
☐ Order

Delivery date: (not binding)   CW

Company:

Street:

Date:

Post code/place:

Enquiry/order no.:

Country:

Tool ID: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

### Workpiece material:

Type:

Moisture content (of solid wood) %

Direction of machining

☐ along grain ☐ across grain

Cutting quality:

☐ Pre-hogging

Coating:

☐ Yes

☐ No

Type (of wood derived material):

Hogging width: mm

Material thickness: mm

☐ Finish hogging

### Machine:

Manufacturer:

Type:

Model:

Power: kW (HP) motor spindle (see drawing):

RPM: min<sup>-1</sup>

Feed: m min<sup>-1</sup>

Hogging motor:

☐ Against feed

☐ With feed

☐ Application scoring/hogging

☐ Application hogging/hogging

### Tool:

Tool type (see selection):

☐ Hogging set in cutter design

☐ Hogging set with segments

☐ Compact hogging set

☐ Other

Dimensions:

Diameter mm

Cutting width mm

Bore mm

Adaptor:

☐ Mechanical

☐ Quick change

☐ Hydraulic

No. of teeth:

Hogging sawblade

Hogger

Cutting material:

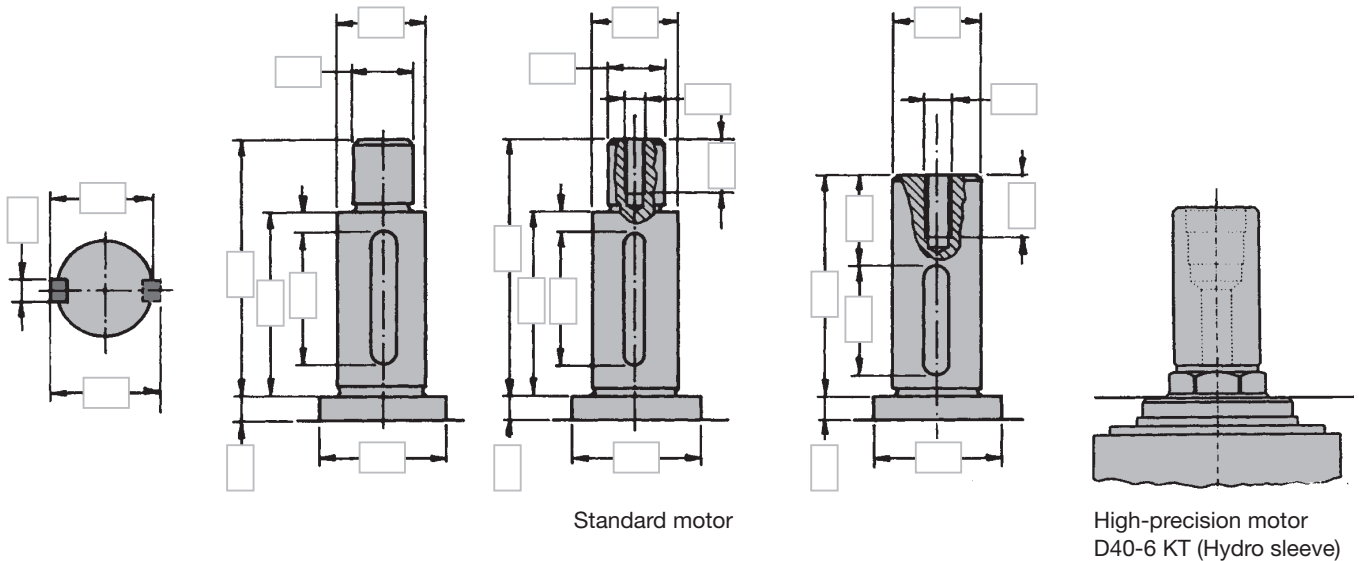
☐ HW (TC)

☐ DP (DIA)

Please state existing data on tool, machine and workpiece material.

**Hogging motor/spindle details:**

(Enter dimensions on drawing or state in space for sketches)



**Sketch for application plan, motor spindle etc.**



Scoring  
hogging



Tipped tool



Hogging



Light  
Light alloy  
body



Double  
hogging



Interchangeable  
knives



End  
trimming



Mechanical  
knife clamping,  
reversible



Edge  
trimming



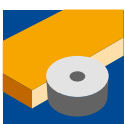
Resharpenable  
cutting face



Grooving,  
horizontal  
and vertical



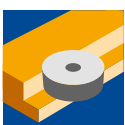
Resharpenable  
clearance face



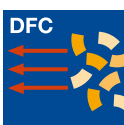
Jointing



Low Noise  
Low noise



Rebating



DFC  
Optimised  
chip flow



Profiling



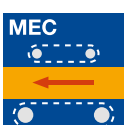
HW  
Tungsten  
carbide



Profiling  
joints



DP  
Polycrystalline  
diamond (PCD)



MEC  
Mechanical  
feed





# Planing and profiling

Leitz Lexicon Edition 7

Version 2

03/2022



## Explanation of abbreviations

A	= dimension A
$a_e$	= cutting thickness (radial)
$a_p$	= cutting depth (axial)
ABM	= dimension
APL	= panel raising length
APT	= panel raising depth
AL	= working length
AM	= number of knives
AS	= anti sound (low noise design)

b	= overhang
B	= width
BDD	= thickness of shoulder
BEM	= note
BEZ	= description
BH	= tipping height
BO	= bore diameter

CNC	= Computerized Numerical Control
-----	----------------------------------

d	= diameter
D	= cutting circle diameter
D0	= zero diameter
DA	= outside Diameter
DB	= diameter of shoulder
DFC	= Dust Flow Control (optimised chip clearance)
DGL	= number of links
DIK	= thickness
DKN	= double keyway
DP	= polycrystalline diamond
DRI	= rotation

FAB	= width of rebate
FAT	= depth of rebate
FAW	= bevel angle
FLD	= flange diameter
$f_z$	= tooth feed
$f_{z\text{ eff}}$	= effective tooth feed

GEW	= thread
GL	= total length
GS	= Plunging edge

H	= height
HC	= tungsten carbide, coated
HD	= wood thickness (thickness of workpiece)
HL	= high-alloyed tool steel
HS	= high-speed steel (HSS)
HW	= tungsten carbide (TCT)

ID	= ident number
IV	= insulation glazing

KBZ	= abbreviation
KLH	= clamping height
KM	= edge breaker
KN	= single keyway
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60

L	= length
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LH	= left hand rotation
----	----------------------

M	= metric thread
MBM	= minimum order quantity
MC	= multi-purpose steel, coated
MD	= thickness of knife
$\text{min}^{-1}$	= revolutions per minute (RPM)
MK	= morse taper
$\text{m min}^{-1}$	= metres per minute
$\text{m s}^{-1}$	= metres per second

n	= RPM
$n_{\text{max}}$	= maximum permissible RPM
NAL	= position of hub
ND	= thickness of hub
NH	= zero height
NL	= cutting length
NLA	= pinhole dimensions
NT	= grooving depth

P	= profile
POS	= cutter position
PT	= profile depth
PG	= profile group

QAL	= cutting material quality
-----	----------------------------

R	= radius
RD	= right hand twist
RH	= right hand rotation
RP	= radius of cutter

S	= shank dimension
SB	= cutting width
SET	= set
SLB	= slotting width
SLL	= slotting length
SLT	= slotting depth
SP	= tool steel
ST	= Cobalt-basis cast alloys, e.g. Stellite™
STO	= shank tolerance
SW	= cutting angle

TD	= diameter of tool body
TDI	= thickness of tool
TG	= pitch
TK	= reference diameter

UT	= cutting edges with irregular pitch
----	--------------------------------------

V	= number of spurs
$v_c$	= cutting speed
$v_f$	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
-----	----------------------

Z	= number of teeth
ZA	= number of fingers
ZF	= tooth shape (cutting edge shape)
ZL	= finger length

### Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



### 3. Planing and profiling



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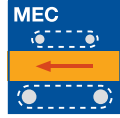
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### 3. Planing and profiling

#### 3.1 Surface planing – thicknessing

##### Application



Surface-cutting, thicknessing and width planing of workpieces of any length on surface planing machines and planing machines. The workpieces are first planed to get a reference surface. In the second operation they are planed to thickness (dimension) and possibly jointed to get a right angle as second reference surface.

##### Workpiece material

Softwood and hardwood, dry and wet, chip and fibreboards (e.g. chipboard, MDF), insulating materials, plastics.

##### Machines

Surface planing and thicknessing machines.

##### Mounting of long planerheads

Long planerheads have integrated ball bearings and drive pulleys.

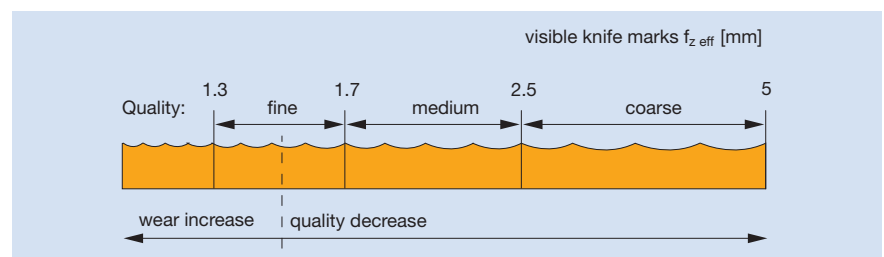
##### Recommended cutting materials

	HS	Marathon (MC)	HW
Softwood dry	◆	◆	◆
Softwood wet	◇	◆	
Hardwood dry	◇	◆	◆
Hardwood wet	◇	◆	
Plywood		◇	◆
Chipboard			◆
MDF			◇
WPC (Wood-Plastic-Composite)	◇	◆	◆

◆ suitable

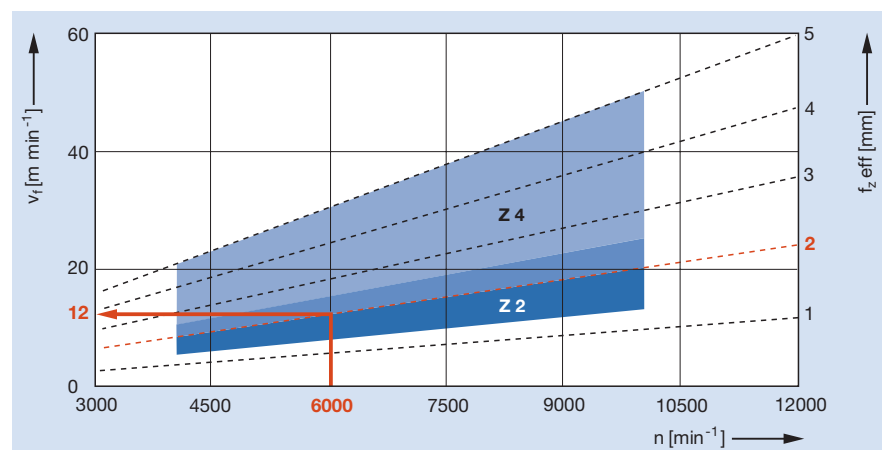
◇ partly suitable

##### Feed speed



The feed speed is determined by the required surface quality.  
Relation between the surface quality and length of knife marks  $f_{z\text{ eff}}$ .

##### Diagram to determine the feed speed $v_f$ depending on RPM $n$ and knife marks $f_{z\text{ eff}}$ for different number of teeth $Z^*$



\* Even on tools with several wings, only the marks of one knife show on the workpiece surface (one-knife finish).  
Z 2 and Z 4 tools produce the same surface quality under identical machining conditions. (see technical information and charts in section User Manual).

#### Long planerheads, construction type



#### Technical information

Centrofix Plus - long planerhead made of steel.  
Turnblade system with formfitting centrifugal clamping. Turnblades with integrated chipbreaker for clean finish also in difficult wood types. Fast, precise knife changes with no adjustment.

#### Cutting material

HW, HS, MC.

#### Application

For planing softwood, hardwood, insulating materials, plastics.



#### Technical information

VariPlan - long planerhead made of steel.  
Resharpenable and constant diameter turnblade system. Self-positioning and centrifugal force supporting knife clamping for easy handling.

#### Cutting material

HW, HS.

#### Application

For planing of softwood, hardwood, insulating material, plastics.



#### Technical information

HeliPlan/HeliCut - long planerhead made of steel.  
Turnblades can be turned four times.  
Low noise and energy efficient through spiral and segmented knife arrangement.

#### Cutting material

HW.

#### Application

For planing of softwood and hardwood, insulating material, plastics.

## Enquiry/order form special tools – surface planing – thicknessing



**Customer details:** Customer number:  
(if known)

--	--	--	--	--	--	--	--

☐ Enquiry  
☐ Order

Delivery date: (not binding)

--	--

CW

Company:

Street:

Date:

Post code/place:

Enquiry/order no.:

Country:

Tool ID: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

### Workpiece material:

Type:

☐ Solid wood:

Type:

Moisture content:

%

☐ Wood derived material:

Type:

Density:

g/cm<sup>3</sup>

☐ Others

Type:

Additional information:

### Machine:

Manufacturer:

Type:

Model:

Spindle sequence (in feeding direction) e.g. 1 bottom, 2 right hand, 3 left hand, 4 top, 5 multi-purpose.

Motor:

Power:

RPM:

Spindle dimensions:

Add. information:

1		kW (HP)	min <sup>-1</sup>	mm	
2		kW (HP)	min <sup>-1</sup>	mm	
3		kW (HP)	min <sup>-1</sup>	mm	
4		kW (HP)	min <sup>-1</sup>	mm	
5		kW (HP)	min <sup>-1</sup>	mm	

### Tool:

Tool type (see selection):

Dimension:

Diameter:

mm

Cutting width:

mm

Bore:

mm

No. of teeth:

Cutting material:

☐ HL (HLS)

☐ HS (HSS)

☐ HW (HM)

☐ ST

Direction of rotation:

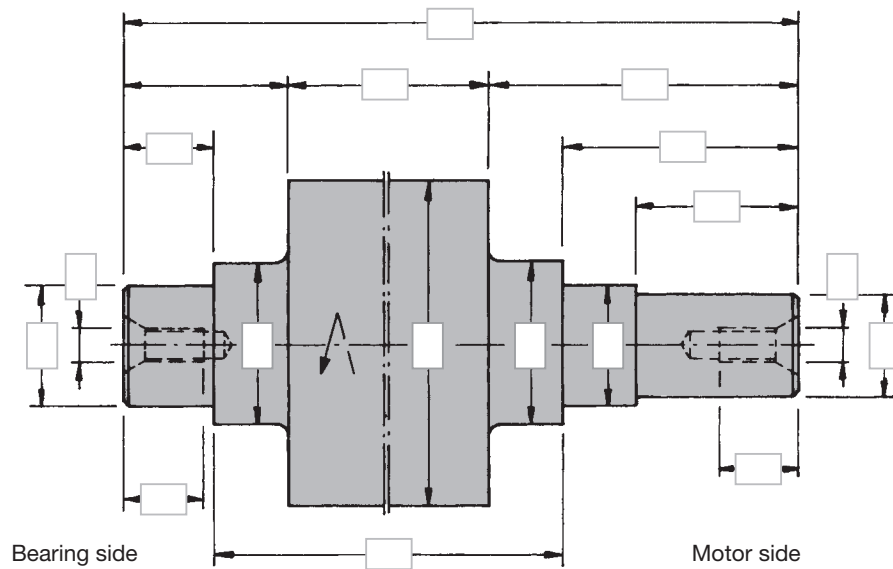
☐ left hand

☐ right hand

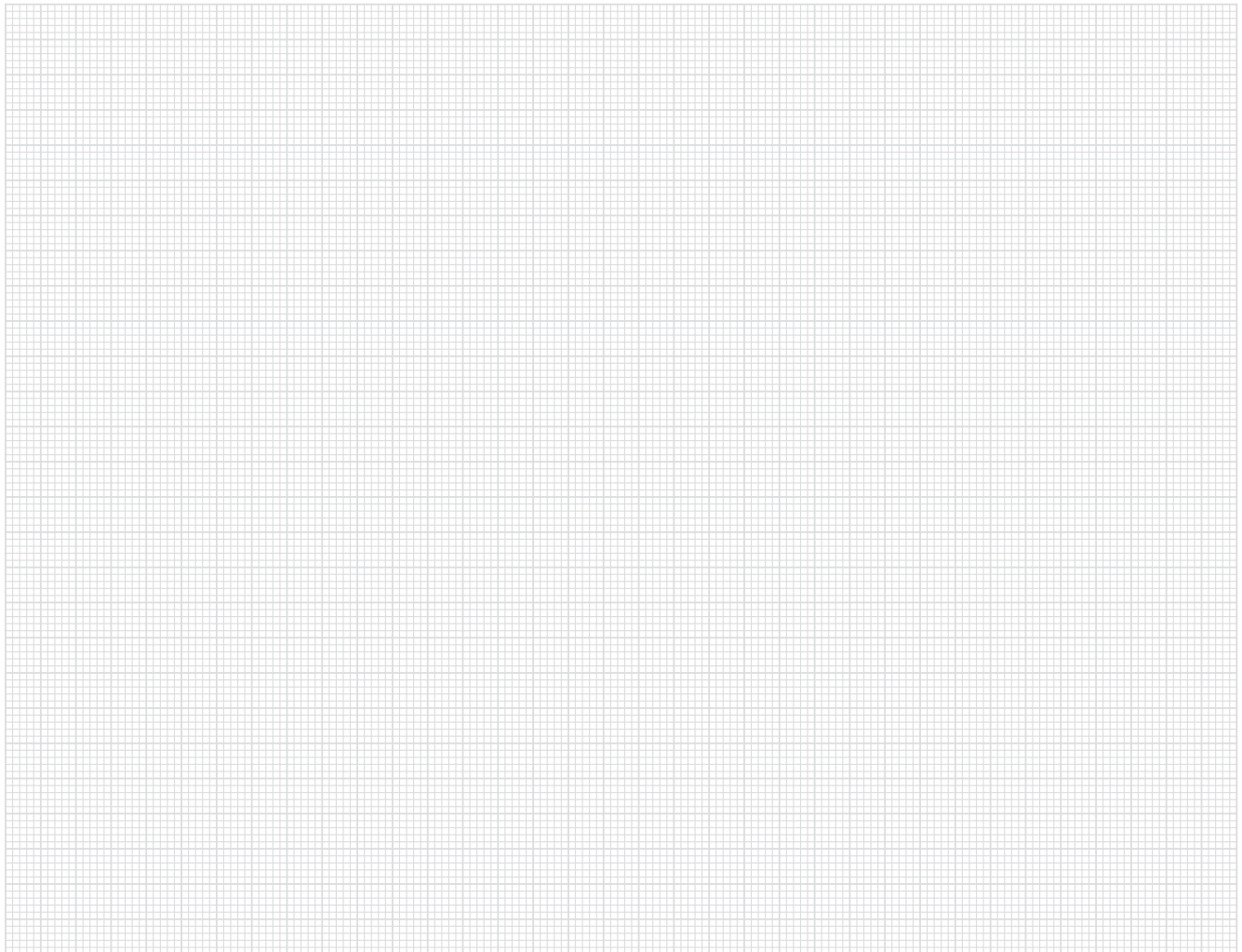
Please state existing data on tool, machine and workpiece material.

### Dimensions for long planerheads

(Enter dimensions on drawing or graph)



Sketch for application, special motor spindle etc., side of table to workpiece and fence.

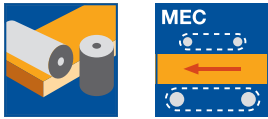




### 3. Planing and profiling

#### 3.2 Planing 3.2.1 Cutterheads for pre-planing

##### Working process



Planing is the first step after cutting the workpiece to size. It prepares workpiece surfaces and machines a datum surface for accurate workpiece processing. Pre-planing is recommended prior to profiling on four-sided moulders and multi spindle moulding machines. Pre-planing and reference heads can be combined on the same spindle to guide the timber through the machine.

##### Workpiece materials

Softwood and hardwood, dry or wet  
Chipboard and wood fibre materials (MDF etc.).

##### Machines

Four-sided moulders and multi spindle moulding machines.

##### Tool clamping

Mounted directly on the machine spindle, retained by spindle nut.

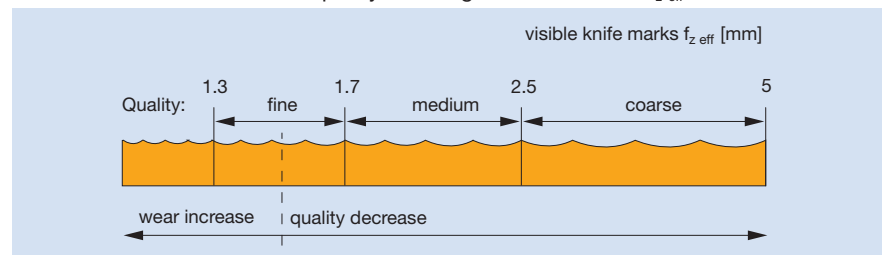
##### Recommended cutting material

	HS	Marathon (MC)	HW
Softwood dry	◆	◆	◆
Softwood wet	◇	◆	
Hardwood dry	◇	◆	◆
Hardwood wet	◇	◆	
Plywood		◇	◆
Chipboard			◆
MDF			◇
WPC (Wood-Plastic-Composite)	◇	◆	◆

◆ suitable      ◇ partly suitable

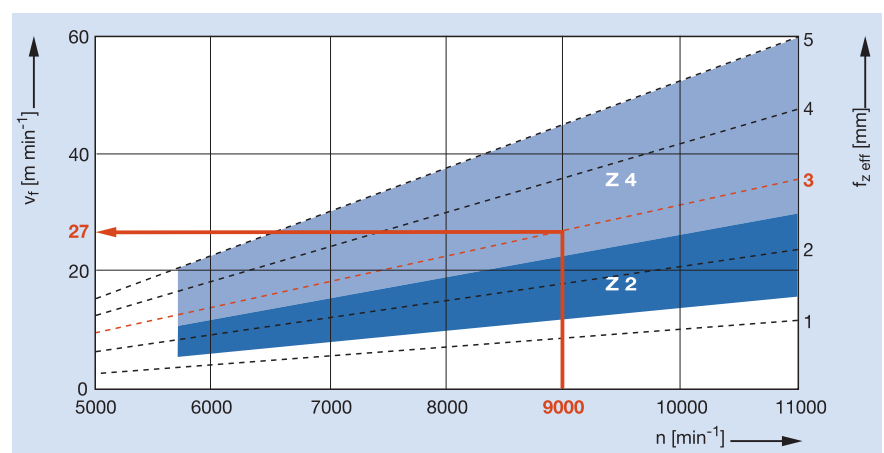
##### Feed speed

The feed speed is determined by the required surface quality.  
Relation between the surface quality and length of knife marks  $f_{z \text{ eff}}$ .



The feed speed is determined according to the quality requirements which can be measured by the produced cuttermarks.  
The diagram shows the relation between surface quality and length of knife marks  $f_{z \text{ eff}}$ .

##### Planerhead Z 2 and Z 4



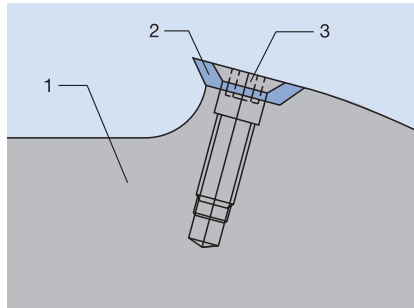
Even on tools with several wings, only the marks of one knife show on the workpiece surface (one-knife finish).  
Z 2 and Z 4 tools produce the same surface quality under identical machining conditions (see technical information and charts in section User Manual).



#### Planerhead HeliPlan



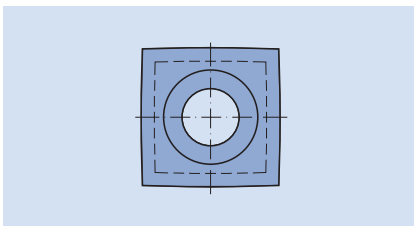
<b>Application</b>	Planing, pre-planing.
<b>Machines</b>	Four-sided moulders and profiling machines or machines with HSK 85 WS interface.
<b>Workpiece material</b>	Softwood and hardwood.
<b>No. of teeth/tool life</b>	2/2 staggered, each HW turnblade knife has 4 lives.
<b>Cutting material</b>	HW.
<b>Chip removal</b>	Softwood: up to 15.0 mm. Hardwood: up to 10.0 mm.
<b>Tool design</b>	Aluminium or steel tool body with spiral, staggered single cutting edges, mounted on the tool body periphery.
<b>Technical features</b>	HW turnblade knives with 4 curved cutting edges.



- 1) Tool body of steel or aluminium
- 2) Knives
- 3) Clamping screw

<b>Special advantages</b>	<ul style="list-style-type: none"> <li>– Minimum breakout.</li> <li>– Noise reduction (up to 10 dB(A)).</li> <li>– The staggered cut reduces both the cutting force and feed pressure.</li> <li>– Turnblade knives have four cutting edges (four lives).</li> </ul>
---------------------------	---

#### Note



HW turnblade knife with 4 cutting edges.

- Barely visible marks in the overlap area; minimal waviness.
- As HeliPlan has a staggered cut of individual cutting edges, the tool has limited suitability for producing finished surfaces. Finish planing or profiling may be necessary depending on the quality requirement.
- Tool body surface hardening advisable for abrasive workpiece materials.
- Use in combination with reference cutterhead WW 410 2 (see page 11) on the first bottom spindle of moulding machines.



#### Planerhead HeliPlan with 4 edge HW turnblade knives

##### Application:

Pre-planing, surfacing and jointing all types of wood with large chip removal. Also suitable for finish planing if quality demands are less important or in combination with subsequent sanding.

##### Machine:

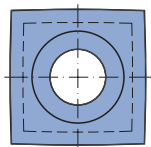
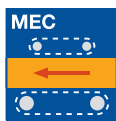
Four-sided moulders.

##### Workpiece material:

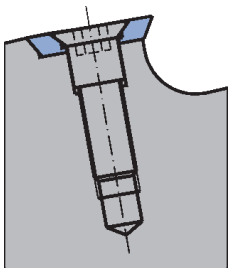
Softwood and hardwood.

##### Technical information:

Pre-planing cutterhead with 4 edge HW turnblade knives. Low noise and energy efficient due to spiral, segmented edge arrangement. Smooth finish by radiused cutting edges. Aluminium tool body. Optional with steel reference cutterhead for machines with fence.



HW turnblade knife



Knives mounted on periphery

##### Aluminium tool body, with bore

WW 220 2 01

D	SB	ND	BO	Z	AM	$n_{\max}$	ID
mm	mm	mm	mm		PCS	min <sup>-1</sup>	
125	130	136	40	2/2	22	12000	030423 ●
125	166	172	40	2/2	28	12000	030467 ●
125	210	216	40	2/2	36	12000	030452
125	236	242	40	2/2	40	12000	030466 ●
125	256	262	40	2/2	44	12000	030470 ●
140	166	172	50	2/2	28	12000	030468
140	236	242	50	2/2	40	12000	030469

Design with HW cutting edges.

Further dimensions and inch dimensions available on request.

Suitable reference cutterheads on page 11.

##### Spare knives:

BEZ	ABM	QAL	VE	ID
	mm		PCS	
Turnblade knife	15x15x2.5	HW	10	009535 ●
Turnblade knife	15x15x2.5	TDC		602901 ●

##### Spare parts:

BEZ	ABM	ID
	mm	
Countersink screw, Torx® 20	M5x14.2-8.8	007394 ●
Torx® key	Torx® 20	006091 ●



#### Planerhead HeliPlan with 4 edge HW turnblade knives

##### Application:

Pre-planing, surfacing and jointing all types of wood with large chip removal. Also suitable for finish planing if quality demands are less important or in combination with subsequent sanding.

##### Machine:

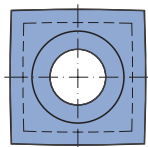
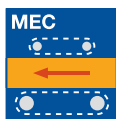
Four-sided moulders with HSK 85 WS interfaces.

##### Workpiece material:

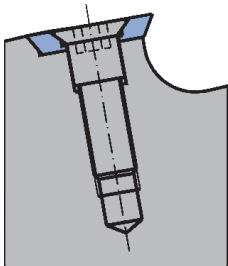
Softwood and hardwood.

##### Technical information:

Pre-planing cutterhead with 4 edge HW turnblade knives. Low noise and energy efficient due to spiral, segmented edge arrangement. Smooth finish through radiused cutting edges. Aluminium tool body. Tool and HSK are shrink-fit together. Optional steel reference cutterhead for machines with fence.



HW turnblade knife



Knives mounted on periphery

##### Aluminium tool body, with HSK 85 WS

WL 210 2 02

D	SB	A	Z	AM	$n_{\max}$	ID	ID
mm	mm	mm		PCS	min <sup>-1</sup>	bottom	top
125	130	26	2/2	22	12000	<b>132000</b> □	<b>132001</b> □
125	166	26	2/2	28	12000	<b>132022</b> □	<b>132023</b> □
125	210	26	2/2	36	12000	<b>132008</b>	<b>132009</b>
125	236	26	2/2	40	12000	<b>132024</b> □	<b>132025</b> □
125	270	26	2/2	46	8000	<b>132012</b>	<b>132013</b>
125	310	26	2/2	54	8000	<b>132014</b> ●	<b>132015</b> ●

##### Aluminium tool body, HSK 85 WS with reference cutterhead

WL 403 2 02

D	SB	A	Z	V	AM	$n_{\max}$	DRI	ID
mm	mm	mm			PCS	min <sup>-1</sup>		
125	236	26	2/2	2	40	12000	bottom	<b>132066</b> □
125	310	26	2/2	2	54	8000	bottom	<b>132065</b> □

Design with HW cutting edges.

Further dimensions and inch dimensions available on request.

##### Spare knives:

BEZ	ABM	QAL	VE	ID
	mm		PCS	
Turnblade knife	15x15x2.5	HW	10	<b>009535</b> ●
Turnblade knife	15x15x2.5	TDC		<b>602901</b> ●

##### Spare parts:

BEZ	ABM	ID
	mm	
Countersink screw, Torx® 20	M5x14.2-8.8	<b>007394</b> ●
Torx® key	Torx® 20	<b>006091</b> ●



### Hydro Planerhead HeliPlan

#### Application:

Pre-planing, surface cutting of all types of wood with large chip removal. Finish cutting of glueable surfaces and workpieces with secondary quality demands.

#### Machine:

Four-sided moulders and profiling machines.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Pre-planing cutterhead with 4-time HW turnblades. Low noise and energy efficient through spiral, segmented edge arrangement. Plane surfaces through radiused cutting edges. Tool bodies of lightweight aluminium with integrated hydro clamping system. Activated by a grease gun.

#### Aluminium tool body

HW 230-2

D mm	SB mm	BO mm	Z	$n_{\max}$ min <sup>-1</sup>	ID
160	150	50	4/4	11000	132200
160	180	50	4/4	11000	132201
160	200	50	4/4	11000	132202
160	230	50	4/4	11000	132203
160	310	50	4/4	11000	132204
200	150	50	6/6	8000	132205
200	180	50	6/6	8000	132206
200	200	50	6/6	8000	132207
200	230	50	6/6	8000	132208
200	310	50	6/6	8000	132209
250	150	50	8/8	6900	132210
250	180	50	8/8	6900	132211
250	200	50	8/8	6900	132212
250	230	50	8/8	6900	132213
250	310	50	8/8	6900	132214

Design in steel/lightweight aluminium on request. This version combines the advantages of a light weight tool and a wear resistant knife seating and gullet area.

#### Spare knives:

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	009535 ●
Turnblade knife	15x15x2.5	TDC		602901 ●

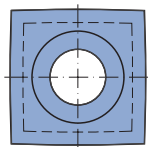
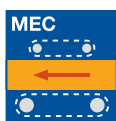
#### Spare parts:

BEZ	ABM mm	ID
Countersink screw, Torx® 20	M5x14.2-8.8	007394 ●
Torx® key	Torx® 20	006091 ●

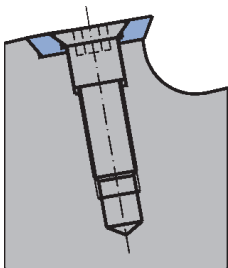
#### Clamping collars without thread

TD 870 0

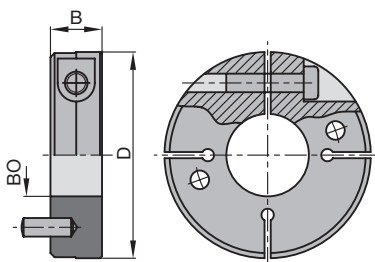
D mm	B mm	BO mm	ID
100	25	40	030700 ●
100	25	50	030702 ●



HW turnblade knife



Knives mounted on periphery



Clamping collar without thread



#### Reference cutterhead

##### Application:

For cutting a side reference rebate when surface planing on the first bottom spindle in combination with a planer cutterhead.

##### Machine:

Four-sided moulders with fence.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Steel tool body with HW turnblade knives, can be combined with pre-planing and finish planing cutterheads on the first bottom spindle.

D 145 for planerheads D 125.

D 160 for planerheads D 140.



##### For wedge-type system, build-up system, CentroStar

WW 410 2

D	SB	BO	Z	V	QAL	$n_{\max}$ min <sup>-1</sup>	ID
mm	mm	mm					
145	15	40	2	2	HW	12000	<b>132077 ●</b>
160	15	50	2	2	HW	11000	<b>132078 ●</b>

##### For HeliPlan, VariPlan Plus

WW 410 2

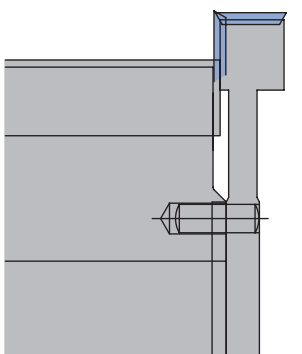
D	SB	BO	Z	V	QAL	$n_{\max}$ min <sup>-1</sup>	ID
mm	mm	mm					
145	15	40	2	2	HW	12000	<b>132075 ●</b>
160	15	50	2	2	HW	11000	<b>132076 ●</b>

##### Spare knives:

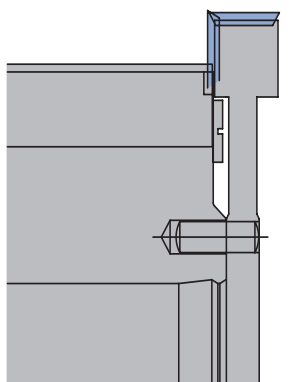
BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	<b>009535 ●</b>

##### Spare parts:

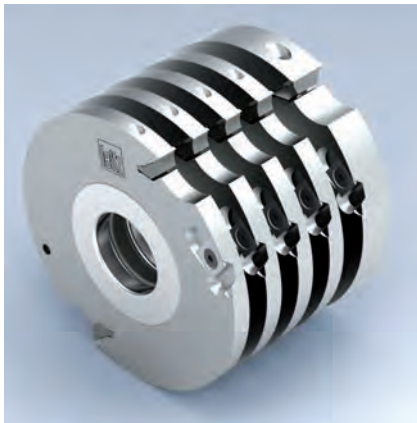
BEZ	ABM mm	ID
Spacer	70x3x40, DTK58	<b>028617 ●</b>
Countersink screw, Torx® 20	M5x14.2-8.8	<b>007394 ●</b>
Pin	6x20	<b>008617 ●</b>



Combination with wedge-type system, build up system and CentroStar. For planerheads without boss, mounted with spacers.



Combination with HeliPlan and VariPlan Plus cutterhead. Mounting without spacer.



#### Cutterhead for groove bed guide

##### Application:

For guide grooves on the first bottom spindle for precise feeding of short parts or curved workpieces.

##### Machine:

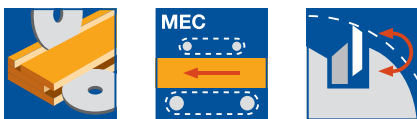
Four-sided moulders with groove beds.

##### Workpiece material:

Softwood and hardwood, along grain.

##### Technical information:

Build up turnblade knife tool system, diameter and cutting width constant. The closed, round design of the tool body reduces the noise level.



##### HW turnblade design

WW 101 2, WW 102 2

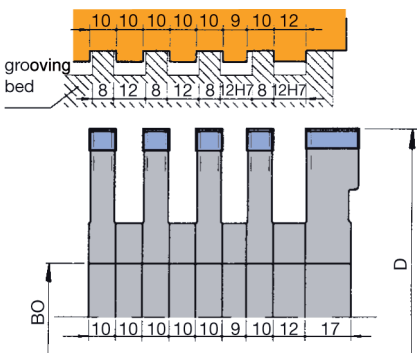
D	SB	BO	BO <sub>max</sub>	Z	V	n <sub>max</sub>	ID
mm	mm	mm	mm			min <sup>-1</sup>	
125	20	40	50	2	2	12000	020389 ●
125	10	40	50	2	2	12000	020390 ●
140	20	40	50	2	2	10900	020386 ●
140	10	40	50	2	2	10900	020388 ●

##### Spare knives:

BEZ	ABM	QAL	VE	ID
	mm		PCS	
Turnblade knife	19.7x8x1.5	HW-30F	10	005071 ●
Turnblade knife	9.7x8x1.5	HW-30F	10	005197 ●
Turnblade spur VS1	14x14x2	HW-F	10	005099 ●

##### Spare parts:

BEZ	ABM	ID
	mm	
Spacer	60x0.1x40	027941 ●
Spacer	60x0.3x40	027942 ●
Spacer	60x9x40	028449 ●
Spacer	60x10x40	027951 ●
Clamping wedge	18x18.75x8.27	009671 ●
Clamping wedge	9x18.75x8.27	009764 ●
Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
Allen screw with shank, Torx® 15	M5x20	007380 ●
Countersink screw, Torx® 20	M6x0.5x4.9	006243 ●
Torx® key	Torx® 15	117507 ●
Torx® key	Torx® 20	117503 ●
Setting gauge for knives	0.3/0.8	005374 ●



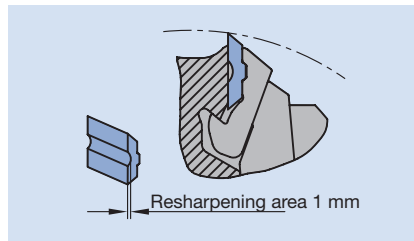
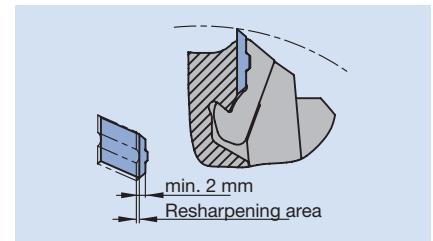
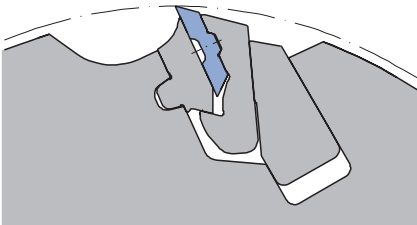
##### Number of tools for different widths

SB	working width mm				
mm	80	100	120	140	170
SB 20	1	1	1	1	1
SB 10	3	4	5	6	8



#### Planing cutterhead VariPlan Plus



<b>Application</b>	Pre and finish planing of all types of wood.
<b>Machines</b>	Four-sided and multi spindle moulders, also with HSK 85 WS interface.
<b>Workpiece material</b>	Softwood and hardwood, plastics (limited suitable).
<b>Number of knives</b>	Z 2 to Z 12 depending on the feed speed and the tool diameter.
<b>Resharpener area</b>	 
<b>Cutting material</b>	HS for softwood. HW for hardwood, mixed use of softwood and hardwood or laminated wood with glued joint.
<b>Chip removal</b>	Pre-planing: Softwood up to 10 mm, hardwood up to 8 mm. Finish planing up to 1.0 mm.
<b>Tool design</b>	Resharpenable and constant diameter tool system with turnblade planer knives. Aluminium body, wear resistant steel chip breaker. Centrifugal force assisted, self-centering knife clamping system.
<b>Technical characteristics</b>	 <p>Operational safety through full form knife clamping. Fast knife change through self-positioning knife clamping. Knife clamping in the dust-protected area.</p> <p>One sharpening operation, therefore 2 extra tool lives by turnblade knife. VariPlan Plus basic body for 3 knife variants: Microfinish, RipTec and Integral turnblade knives.</p> <p>VariPlan Plus Planerheads for machines with HSK 85 WS interface are mounted on HSK 85 WS arbor. Combination with pre surfacing/rebating cutterhead possible.</p>

Aluminium tool body with steel chip breaker.



#### Planerhead VariPlan Plus Integral

##### Application:

Versatile application as planing tool:  
For roughing and finishing on a processing spindle.

##### Machine:

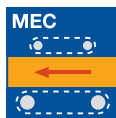
Four-side moulders and multi-spindle planing machines.

##### Workpiece material:

Softwood and hardwood with knots and fibre structure difficult to machine.

##### Technical information:

Tool with 2 VariPlan ripple knives and 2 straight VariPlan planer knives (constant diameter and resharpenable). Unequally pitched cutting arrangement for optimum chip formation. Light metal tool body. For chip removal > 1 mm.



##### Planerhead with bore

WW 240 2 09

D	SB	ND	BO	BO <sub>max</sub>	QAL	n <sub>max</sub>	Z	ID
mm	mm	mm	mm	mm		min <sup>-1</sup>		
125	130	136	40		HW	12000	2+2	<b>131712</b> ●
125	166	172	40		HW	12000	2+2	<b>131713</b> ●
125	236	242	40		HW	12000	2+2	<b>131714</b> ●
140	130	136	40	50	HW	10500	2+2	<b>131715</b> ●
140	166	172	40	50	HW	10500	2+2	<b>131716</b> ●
140	236	242	40	50	HW	10500	2+2	<b>131717</b> ●

##### Planerhead with HSK 85 WS

WP 240 2 09

D	SB	QAL	n <sub>max</sub>	Z	ID	ID
mm	mm		min <sup>-1</sup>		LH	RH
125	130	HW	12000	2+2	<b>131806</b> □	<b>131807</b> □
125	166	HW	12000	2+2	<b>131808</b> □	<b>131809</b> □
125	236	HW	12000	2+2	<b>131810</b> □	<b>131811</b> □

Special production tools with deviating cutting widths are not possible!

##### Spare knives:

BEZ	SB	H	DIK	SET	QAL	ID
	mm	mm	mm	PCS		
Turnblade knife set - VariPlan (ripple)	130	16	3.7	2	HW-MF	<b>617506</b> ●
Turnblade knife set - VariPlan (ripple)	166	16	3.7	2	HW-MF	<b>617571</b> ●
Turnblade knife set - VariPlan (ripple)	236	16	3.7	2	HW-MF	<b>617569</b> ●
Turnblade knife set - VariPlan	130	16	3.7	2	HW-MF	<b>617106</b> ●
Turnblade knife set - VariPlan	166	16	3.7	2	HW-MF	<b>617171</b> ●
Turnblade knife set - VariPlan	236	16	3.7	2	HW-MF	<b>617169</b> ●



#### Planerhead VariPlan Plus

##### Application:

Multi-purpose planing tool:  
For pre-planing with RipTec turnblades.  
For finish planing with microfinish turnblades.

##### Machine:

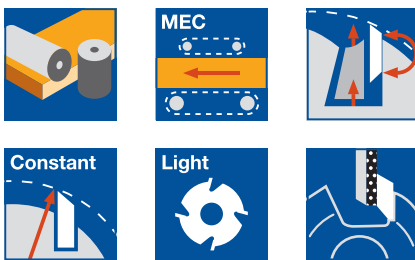
Four-sided moulders and multi spindle planing machines.

##### Workpiece material:

Softwood and hardwood, thermoplastics (partly suitable).

##### Technical information:

Resharpenable and constant diameter planerhead system.  
Self-positioning and centrifugal force supported knife clamping. Lightweight aluminium tool body. Resharpener the knives on the cutting face means one sharpening operation gives two additional lives.



##### Lightweight aluminium tool body

WW 240 2 05

D	SB	ND	BO	$n_{\max}$	Z	ID	ID
mm	mm	mm	mm	min <sup>-1</sup>		HS	HW-MF
125	130	136	40	12000	2	134250 □	134200 ●
125	150	156	40	12000	2	134251	134201
125	166	172	40	12000	2	134252 □	134202 ●
125	180	186	40	12000	2	134253	134203
125	210	216	40	12000	2	134254	134204
125	236	242	40	12000	2	134255 □	134205 ●
125	256	262	40	12000	2	134258	134208
125	270	276	40	10500	2	134256	134206
125	130	136	40	12000	4	134450 □	134400 ●
125	150	156	40	12000	4	134451	134401
125	166	172	40	12000	4	134452 □	134402 ●
125	180	186	40	12000	4	134453	134403
125	210	216	40	12000	4	134454	134404
125	236	242	40	12000	4	134455 □	134405 ●
125	256	262	40	12000	4	134458	134408 ●
125	270	276	40	10500	4	134456	134406

Further dimensions and inch dimensions on request.

Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

##### Spare knives:

SB	H	DIK	SET	ID	ID
mm	mm	mm	PCS	HS	HW-MF
130	16	3.7	2	610506 ●	617106 ●
150	16	3.7	2	610509 ●	617109 ●
166	16	3.7	2	610571 □	617171 ●
180	16	3.7	2	610512 ●	617112 ●
210	16	3.7	2	610515 ●	617115 ●
236	16	3.7	2	610569 □	617169 ●
256	16	3.7	2	610572 □	617172 ●
270	16	3.7	2		617165 ●



#### Planerhead VariPlan Plus

##### Application:

Multi-purpose planing tool:  
For pre-planing with RipTec turnblades.  
For finish planing with microfinish turnblades.

##### Machine:

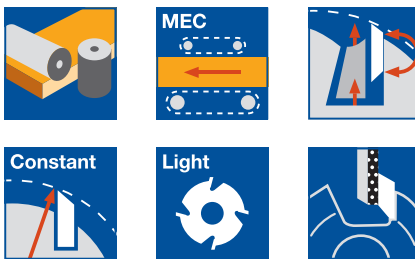
Four-sided moulders and multi spindle moulders with HSK 85 WS interfaces.

##### Workpiece material:

Softwood and hardwood, thermoplastics (partly suitable).

##### Technical information:

Resharpenable and constant diameter planerhead system. Self-positioning and centrifugal force supported knife clamping. Lightweight aluminium tool body. Resharpener the knives on the cutting face means one sharpening operation gives two additional lives. Tool body and HSK arbor are shrunk fit together.



##### Lightweight aluminium tool body on HSK 85 WS

WP 240 2 05

D mm	SB mm	A mm	$n_{max}$ min <sup>-1</sup>	Z	QAL	ID LH / bottom	ID RH / top
125	130	26	12000	2	HW-MF	134500 □	134501 □
125	150	26	12000	2	HW-MF	134502	134503
125	166	26	12000	2	HW-MF	134504 □	134505 □
125	180	26	12000	2	HW-MF	134506	134507
125	210	26	12000	2	HW-MF	134508	134509
125	236	26	12000	2	HW-MF	134510 □	134511 □
125	270	26	8000	2	HW-MF	134512	134513
125	310	26	8000	2	HW-MF	134514	134515
125	130	26	12000	4	HW-MF	134600 □	134601 □
125	150	26	12000	4	HW-MF	134602	134603
125	166	26	12000	4	HW-MF	134604 □	134605 □
125	180	26	12000	4	HW-MF	134606	134607
125	210	26	12000	4	HW-MF	134608	134609
125	236	26	12000	4	HW-MF	134610 □	134611 □
125	270	26	8000	4	HW-MF	134612	134613
125	310	26	8000	4	HW-MF	134614	134615

Further dimensions and inch dimensions on request.

Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

##### Spare knives:

SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW-MF
130	16	3.7	2	610506 ●	617106 ●
150	16	3.7	2	610509 ●	617109 ●
166	16	3.7	2	610571 □	617171 ●
180	16	3.7	2	610512 ●	617112 ●
210	16	3.7	2	610515 ●	617115 ●
236	16	3.7	2	610569 □	617169 ●
270	16	3.7	2		617165 ●
310	16	3.7	2	610522 ●	617122 ●

### 3. Planing and profiling

#### 3.2 Planing

##### 3.2.2 Cutterheads for pre and finish planing



#### Planerhead VariPlan Plus

##### Application:

Multi-purpose planing tool:  
For pre-planing with RipTec turnblades.  
For finish planing with microfinish turnblades.

##### Machine:

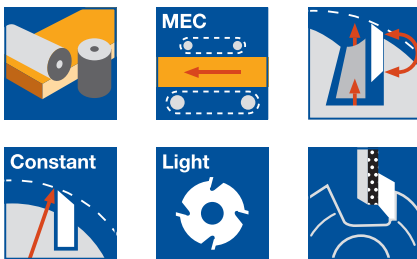
Four-sided moulders and multi spindle moulders with HSK 85 WS interfaces.

##### Workpiece material:

Softwood and hardwood, thermoplastics (partly suitable).

##### Technical information:

Resharpenable and constant diameter planerhead system. Self-positioning and centrifugal force supported knife clamping. Lightweight aluminium tool body. Resharpener the knives on the cutting face means one sharpening operation gives two additional lives. Tool body and HSK arbor are shrunk fit together.



##### Lightweight aluminium tool body on HSK 85 WS with reference cutterhead Z2 / V2

WP 240 2 08

D	SB	A	n <sub>max</sub>	Z	QAL	DRI	ID
mm	mm	mm	min <sup>-1</sup>				
125	236	26	12000	2	HW-MF	LH / bottom	<b>134581</b> □
125	236	26	12000	4	HW-MF	LH / bottom	<b>134681</b> □

Further dimensions and inch dimensions on request.

Spare knives (HS/HW-MF/HW-RipTec) see section Knives and Spare Parts.

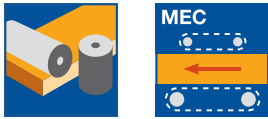
##### Spare knives:

SB	H	DIK	SET	ID	ID
mm	mm	mm	PCS	HS	HW-MF
130	16	3.7	2	<b>610506</b> ●	<b>617106</b> ●
150	16	3.7	2	<b>610509</b> ●	<b>617109</b> ●
166	16	3.7	2	<b>610571</b> □	<b>617171</b> ●
180	16	3.7	2	<b>610512</b> ●	<b>617112</b> ●
210	16	3.7	2	<b>610515</b> ●	<b>617115</b> ●
236	16	3.7	2	<b>610569</b> □	<b>617169</b> ●
270	16	3.7	2		<b>617165</b> ●
310	16	3.7	2	<b>610522</b> ●	<b>617122</b> ●

### 3. Planing and profiling

#### 3.2 Planing 3.2.3 Cutterheads for finish planing

##### Application



Finish planing is the last production step on four-sided moulders. The recommended finish planing cutting depth is 0.5-0.8 mm. For good results, a tear-out free pre-planed surface is required.

##### Workpiece material

Softwood and hardwood.  
Chipboard and fibre materials (MDF etc.).

##### Machines

Four-sided moulders with or without jointing.

##### Tool clamping

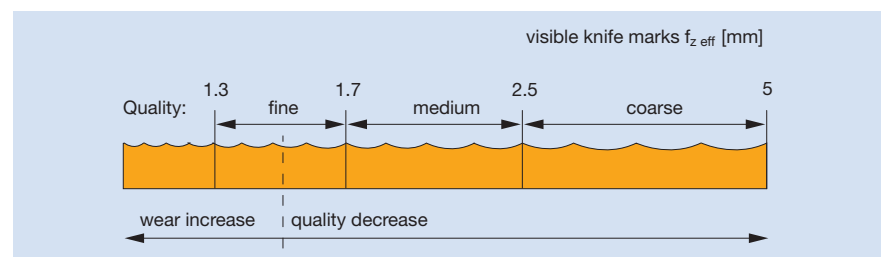
Direct on the machine spindle with spindle clamping nut, with hydro clamping element or with HSK interface.

##### Recommended cutting

	HS	Marathon (MC)	HW
Softwood dry	◆	◆	◇
Softwood wet		◆	◆
Plywood		◇	◆
Chipboard			◆
MDF			◆
WPC (Wood-Plastic-Composite)	◇	◆	◆

◆ suitable      ◇ partly suitable

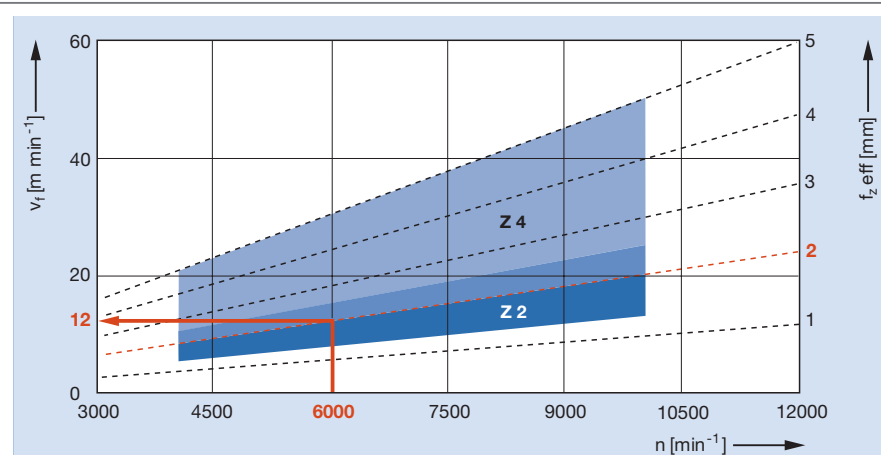
##### Feed speed



The selection of the feed speed is determined by the required surface quality. See diagram for the relationship between surface quality and length of knife marks  $f_{z \text{ eff}}$ .

**Diagram to determine feed speed  $v_f$  depending on RPM  $n$  and length of knife marks  $f_{z \text{ eff}}$  for different number of wings.**

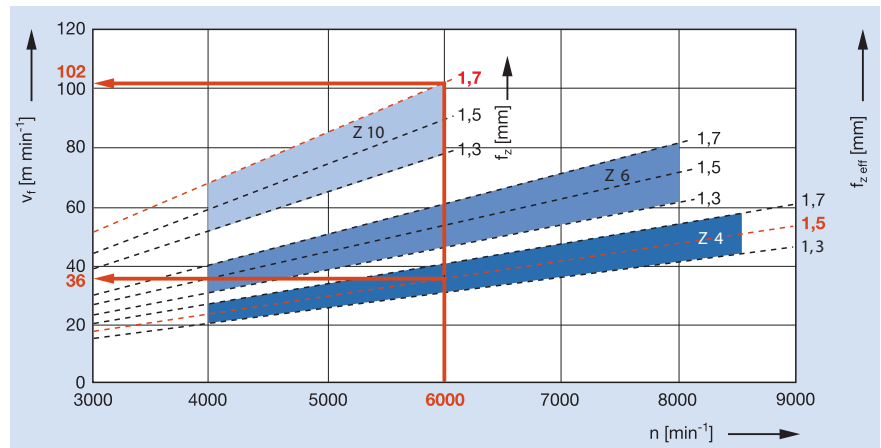
Diagram:  
Planing cutterhead  
Z 2 and Z 4



Even on tools with several wings, only the marks of one knife show on the workpiece surface (one-knife finish).  
Z 2 and Z 4 tools produce the same surface quality under identical machining conditions (see technical information and charts in section User Manual).

#### Length of cutter marks for jointed hydro planing cutterheads

Diagram:  
Hydro planerhead  
Z 4  
Z 6  
Z 10



The marks of all knives show on the workpiece in regular pitches on jointed hydro tools. More wings means high feed speeds maintaining the same surface quality (see technical information and charts in section User Manual).

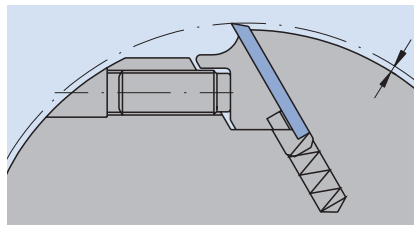


#### Wedge type system



<b>Application</b>	Planing, pre-planing and finish planing.
<b>Machines</b>	Four-sided moulders.
<b>Workpiece material</b>	Softwood and hardwood.
<b>Features of knives</b>	Knife thickness: 3 mm, knife height: 30 mm. Resharpener area: 10 mm.
<b>Cutting material</b>	HS, HW and Marathon (MC).
<b>Chip removal</b>	Softwood: up to 15.0 mm. Hardwood: up to 10.0 mm.
<b>Tool design</b>	Aluminium alloy cutterhead with resharpenable planer knives (SB x 30 x 3 mm). Used on four-sided moulders for pre-planing and finish planing.
<b>Technical information</b>	Cutterhead with compression spring for knife positioning with setting gauge.

#### Note



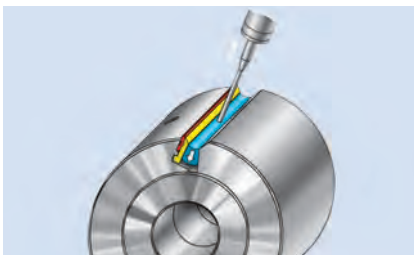
Correct knife projection:  
maximum 2 mm.

- Knives resharpened in the cutterhead for improved run out accuracy and better planing quality.
- After resharpening, check the minimum knife clamping height marked on the tool body.
- Always tighten the screws from the middle to the outside; setting torque 17 Nm
- Check the knife projection (see picture above). Position the planing knife with key and setting gauge.
- Mounting the reference head requires two additional holes D 7 mm on a pitch circle diameter of 58 mm and a spacer 3 mm (ID **028617**).

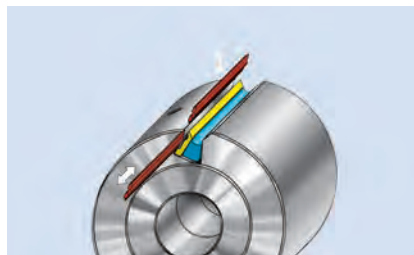
#### CentroStar planerhead



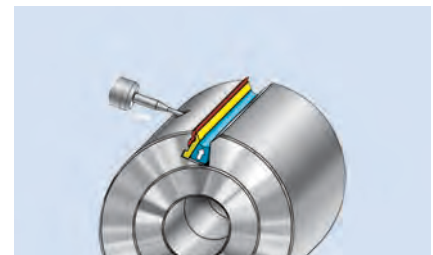
<b>Application</b>	Jointing, pre-planing and finish planing with low chip removal.
<b>Machines</b>	Four-sided moulders.
<b>Workpiece material</b>	Softwood and hardwood.
<b>Number of wings</b>	Z 2 to Z 4; Reversible knife with 2 lives per knife.
<b>Cutting material</b>	HS, HW and Marathon (MC).
<b>Chip removal</b>	Softwood: up to 7.0 mm. Hardwood: up to 5.0 mm.
<b>Tool design</b>	Aluminium cutterhead with turnblade knives, constant diameter and form fitting centrifugal clamping system.
<b>Technical information</b>	<ul style="list-style-type: none"> <li>– Centrifugal clamping system.</li> <li>– Turnblade knives with chip breaker for clean surfaces in difficult zones.</li> <li>– Lightweight aluminium tool body.</li> <li>– Hardened steel replaceable wear parts.</li> </ul>
<b>Note</b>	<ul style="list-style-type: none"> <li>– CentroStar quick clamping system with snap mechanism (no clamping screws) for quick and easy knife replacement.</li> <li>– Lower noise level compared to existing cutterheads from optimised gullet and closed tool body.</li> <li>– Can be used with Reference cutterhead WW 410 2 on four-sided moulding machines.</li> </ul>



Loosen knife clamping.



Radial and axial knife change possible.



Activate knife clamping. Secured by form fitting centrifugal clamping system.

#### Serrated back planerhead with HSK 85 WS interface



<b>Application</b>	Pre and finish planing.
<b>Machines</b>	Planing machines with HSK 85 WS interface.
<b>Workpiece material</b>	Softwood and hardwood, dry and wet.
<b>Number of wings</b>	Z 2, Z 4, Z 6
<b>Cutting material</b>	Marathon (MC), tungsten carbide HW.
<b>Chip removal</b>	Softwood: up to 12 mm. Hardwood: up to 10 mm.
<b>Feed type</b>	Mechanical feed.
<b>Tool design</b>	<p>Monobloc steel tool body. High concentricity and balance quality. Seating for 60° serrated back planer knives H = 40 mm x 5.0 mm thickness with standard tooth pitch 1.6 mm.</p>
<b>Resharpener area</b>	9 mm.
<b>Advantages</b>	Pre and finish planing with Marathon planer knives resharpened to one cutting circle. For finish planing with $n = 12000 \text{ min}^{-1}$ and a feed rate $> 18 \text{ m min}^{-1}$ , the planer knives require jointing on the machine. After jointing, all knives will have the same cutting circle.
<b>Note</b>	<p>Cutting angle 20° for softwood. Cutting angle 12° for hardwood and wood fibre materials. Jointing with <math>n = 10000 \text{ min}^{-1}</math>.</p>

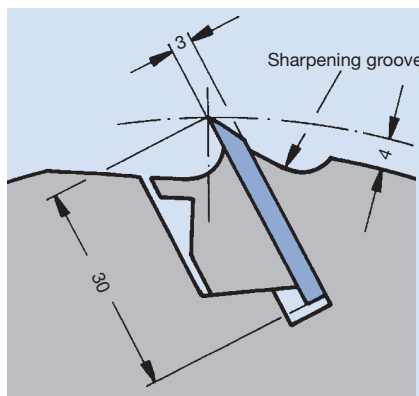
#### Hydro planerhead



<b>Application</b>	Surfacing, pre-planing and finish planing for feeds from 24 to 120 m min <sup>-1</sup> .
<b>Machines</b>	Multi spindle moulders, with jointing if required.
<b>Workpiece material</b>	Softwood and hardwood.
<b>Number of wings</b>	Z 4 to Z 12 depending on the diameter.
<b>Cutting material</b>	HS, HW and Marathon (MC 33).
<b>Chip removal</b>	Pre-planing: up to 5.0 mm. Finish planing: up to 0.8 mm.
<b>Tool design</b>	Steel cutterhead with hydraulic clamping, open hydro clamping system with resharpenable planer knives resharpened in the cutterhead for concentricity < 0.005 mm.
<b>Technical features</b>	Jointed knives for excellent surfaces at high feed speeds. Maximum joint bevel width: for softwood 0.5 mm, for hardwood 0.7 mm. High running accuracy and low vibration from hydro clamping. High feed speeds depend on the number of wings and RPM (see page 24, Diagram to determine feed speed).

#### Note

- Hydro clamp only on spindle.
- Clamp to spindle with clamping collar.
- For knives 30 x 3 mm (35 x 3 from diam. 203 on) HS, HW and MC.



Sharpening groove on the body behind knife for easy knife resharpening in the cutterhead on sharpening machines.

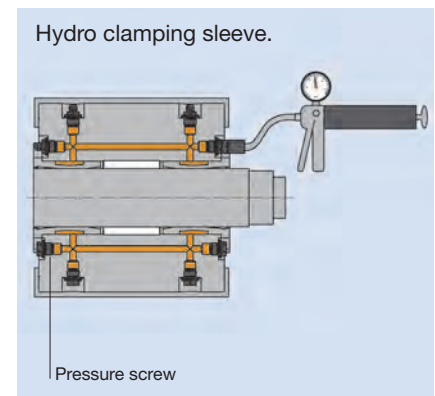


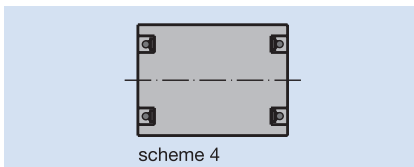
Illustration of hydro clamping system.

#### TurboPlan Plus hydro planerhead



<b>Application</b>	Pre-planing and precision finish planing feed from between 160 to 360 m min <sup>-1</sup> .
<b>Machines</b>	High performance moulders with precision spindles and counter bearing.
<b>Workpiece material</b>	Softwood and hardwood.
<b>Diameter/ Number of wings</b>	D 200 to D 360. Z 4 to Z 32.
<b>Cutting material</b>	Marathon (MC 33).
<b>Chip removal</b>	Pre-planing: 5.0 mm. Finish planing: 0.8 mm.
<b>Resharpener area</b>	10.0 mm.
<b>Tool design</b>	Hydro planerhead with steel body. Open hydro clamping system. Integrated balancing segments, attached to body. Form fitting knife clamping: Resharpenable knives with serrated back in Leitz Marathon design. Central knife clamping by open hydro system.
<b>Technical features</b>	For Leitz serrated back Marathon knives HS 30 x 5.0 mm. High concentricity and low vibration from hydro clamping system. Knives resharpened in automatic resharpening machines have a concentricity < 0.005 mm.
<b>Tool clamping</b>	Hydro clamping system.
<b>Knife clamping</b>	Form fitting design, hydro clamping.

#### Note



Jointed knives give an excellent finish at high feed speeds. Do not pressurise the hydro clamping system without mounting the tool on the spindle.  
Working pressure 350-450 bar – check daily. Spindle safety – use locking collars to reduce the risk of the tool spinning and cold welding on the spindle.  
For Leitz serrated back knives Marathon (MC) 30 x 5 mm.

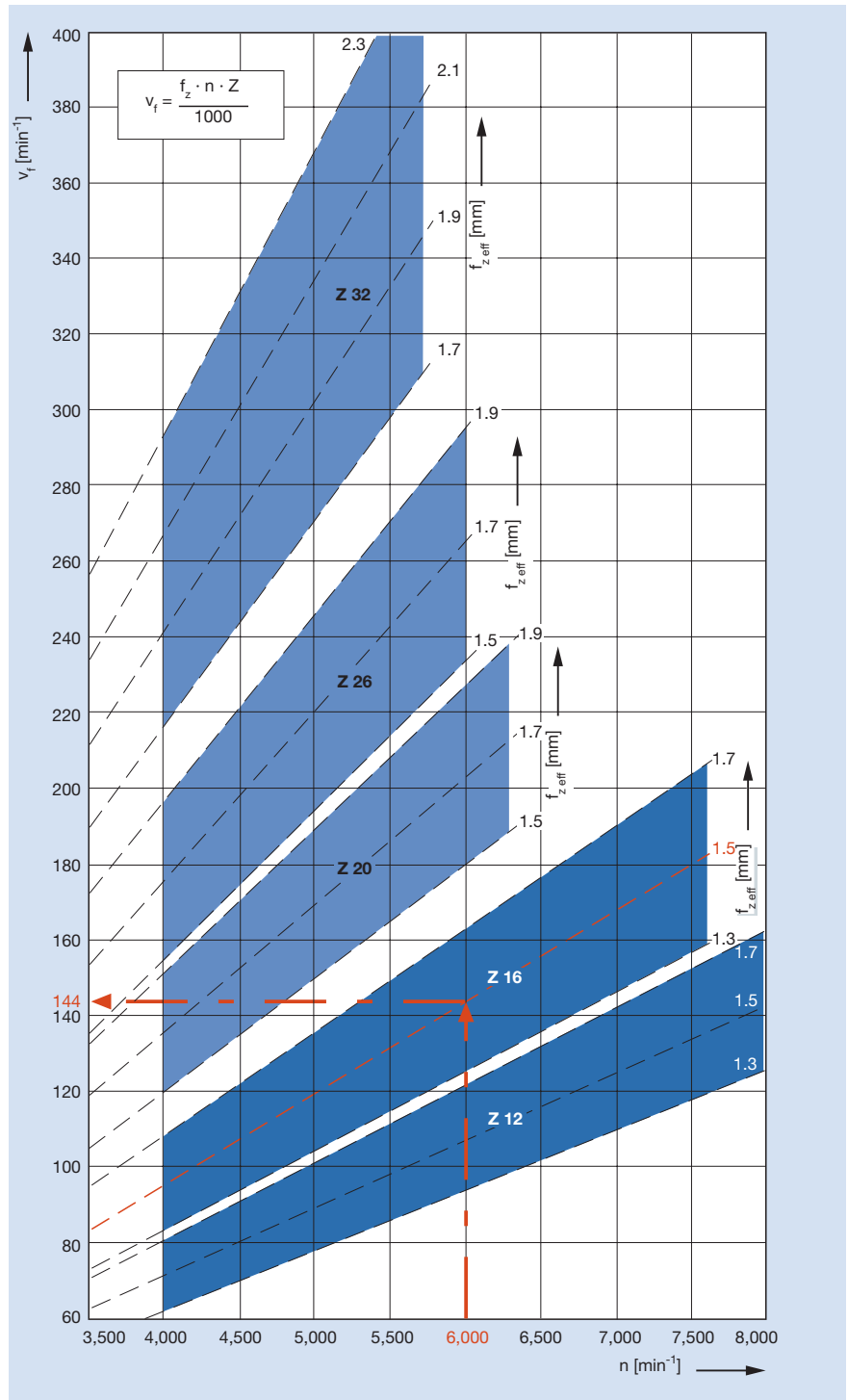
**Diagram to determine feed speed  $v_f$  of jointed hydro planerheads depending on RPM  $n$  and knife marks  $f_{z\text{eff}}$  different number of wings  $Z^*$**

Diagram:  
Hydro planerhead  
RotaPlan and TurboPlan

Z 12  
Z 16  
Z 20  
Z 26  
Z 32

### Hydro planerheads – TurboPlan Plus

The feed speed is determined by the required surface quality (length of knife marks  $f_{z\text{eff}}$ ) and depends on the RPM and the number of wings in the cutterhead. The relation can be found in the diagram below.



With jointed hydro tools the marks of all knives are shown on the workpiece in regular pitches. More wings mean higher feed speeds maintaining the same surface quality.



#### Planerhead wedge-type system

##### Application:

Multi-purpose suitable for pre-planing with large chip removal and for finish planing.

##### Machine:

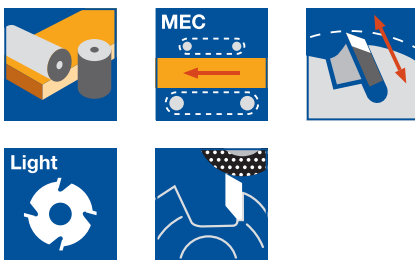
Four-sided moulders and profile machines.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Cutterhead with resharpenable planer knives SB x 30 x 3.0 mm. Pressure springs position the knives by a setting gauge on the defined cutting edge circle. Cutting material quality HS, Marathon (MC33) and HW available.



##### Aluminium tool body, coated

WM 200 2 07

D	SB	BO	n <sub>max</sub>	Z	ID	ID
mm	mm	mm	min <sup>-1</sup>		HS	HW
125	100	40	10500	4	140408 ●	140458 □
125	130	40	10500	4	140409 ●	140459 □
125	150	40	10500	4	140410 ●	140460
125	170	40	10500	4	140411 ●	140461 □
125	180	40	10500	4	140412 ●	140462
125	210	40	10500	4	140413 ●	140463
125	230	40	10500	4	140414 ●	140464
125	240	40	10500	4	140415 ●	140465 □

Suitable reference cutterhead on page 11.

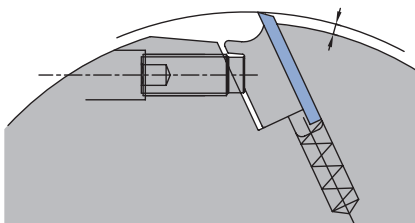
##### Spare knives:

Part-no.	SB	H	DIK	ID	ID	ID	ID
	mm	mm	mm	HS Classic	HS Premium	HW	MC33
1	100	30	3	605002 ●	027103 ●	027279 ●	606702 ●
1	130	30	3	605005 ●	027106 ●	027282 ●	606705 ●
1	150	30	3	605006 ●	027107 ●	027283 ●	606706 ●
1	170	30	3	605007 ●	027108 ●	027284 ●	606707 ●
1	180	30	3	605008 ●	027109 ●	027285 ●	606708 ●
1	210	30	3	605010 ●	027110 ●	027286 ●	606710 ●
1	230	30	3	605011 ●	027111 ●	027287 ●	606711 ●
1	240	30	3	605012 ●	027134 ●	027323 ●	606712 ●

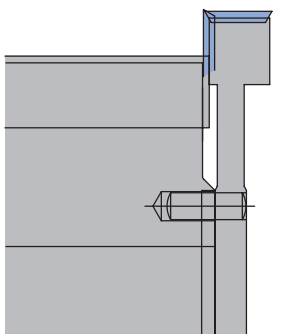
Spare knives in further dimensions and qualities see section Knives and Spare Parts.

##### Spare parts:

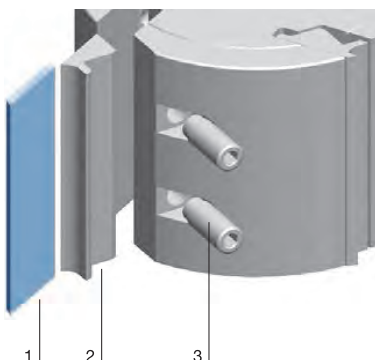
Part-no.	BEZ	ABM	for SB	ID
		mm	mm	
2	Clamping wedge		100	620900 ●
2	Clamping wedge		130	620901 ●
2	Clamping wedge		150	620902 ●
2	Clamping wedge		170	620903 ●
2	Clamping wedge		180	620904 ●
2	Clamping wedge		210	620905 ●
2	Clamping wedge		230	620906 ●
2	Clamping wedge		240	620907 ●
3	Allen screw	M10x1x25		007395 ●
	Allen key	SW 5		117509 ●
	Pressure spring	27x6x0.75		008076 ●
	Setting gauge	D125/140		005361 ●



Correct protrusion: max. 2 mm



Combined with reference cutterhead







#### Planerhead CentroStar

##### Application:

Especially suitable for finish planing. Can also be used for pre-planing with chip removal up to 6 mm.

##### Machine:

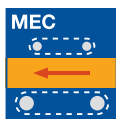
Four-sided moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Form fit knife clamping system supported by centrifugal force. Axial or radial knife removal. HS or HW turnblade planer knife SB x 12 x 2.7 mm. Integrated chip breaker to prevent pre-splitting. Aluminium tool body.



##### Aluminium tool body

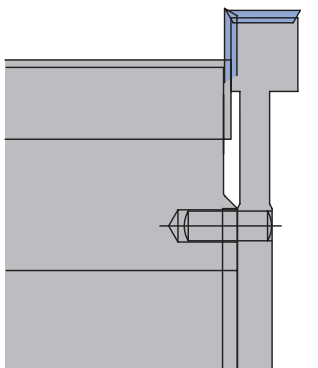
WW 240 2 20

D	SB	ND	BO	BO <sub>max</sub>	Z	n <sub>max</sub>	ID	ID
mm	mm	mm	mm	mm		min <sup>-1</sup>	HS	HW
125	100	106	40	50	4	12000	130442 ●	130443 □
125	130	136	40	50	4	12000	130446 ●	130447 □
125	166	172	40	50	4	12000	130492 ●	130493 □
125	180	186	40	50	4	12000	130454 ●	130455 □
125	210	216	40	50	4	12000	130458 ●	130459 □
125	236	242	40	50	4	12000	130494 ●	130495 □
125	256	262	40	50	4	12000	130496 ●	130497 □

Further dimensions and inch dimensions available on request.

Suitable reference cutterheads on page 11.

Spare parts service only by the manufacturer.



Combined with reference cutterhead

##### Spare knives:

SB	H	DIK	QAL	SET	ID
mm	mm	mm		PCS	
100	12	2.7	HS	4	610203 ●
130	12	2.7	HS	4	610205 ●
166	12	2.7	HS	4	610286 ●
180	12	2.7	HS	4	610211 ●
210	12	2.7	HS	4	610213 ●
236	12	2.7	HS	4	610287 ●
256	12	2.7	HS	4	610288 ●
100	12	2.7	HW-F	2	610606 ●
130	12	2.7	HW-F	2	610612 ●
166	12	2.7	HW-F	2	610680 ●
180	12	2.7	HW-F	2	610621 ●
210	12	2.7	HW-F	2	610627 ●
236	12	2.7	HW-F	2	610679 ●
256	12	2.7	HW-F	2	610681 ●



### Planerhead with HSK 85 WS and serrated back HS Marathon planer knives

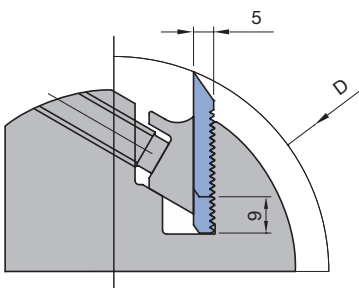
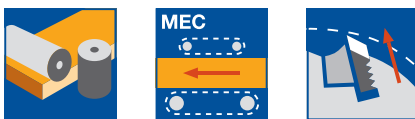
**Application:**  
Finish planing.

**Machine:**  
Four-sided moulders with HSK 85 WS interface.

**Workpiece material:**  
Cutting angle 20° for softwood and hardwood in general.  
Cutting angle 12° for materials likely to splinter such as oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

**Technical information:**

Finish planing cutterhead in mono block design DTK 90 mm with serrated back planer knives SB x 40 x 5 mm ground to cutting circle. Jointable by specific jointing stone. Steel tool body. High balance quality by assembly with parts of the same weight.



**Cutting angle 20°**

WP 210 2 01

D	SB	A	QAL	Z	$n_{\max}$	ID	ID
mm	mm	mm			min <sup>-1</sup>	LH / bottom	RH / top
106	130	26	MC33	2	12000	140322 ●	140323 ●
106	170	26	MC33	2	12000	140324 ●	140325 ●
106	240	26	MC33	2	12000	140326 ●	140327 ●
106	80	26	MC33	4	12000	140330 ●	140331 ●
106	130	26	MC33	4	12000	140332 ●	140333 ●
106	170	26	MC33	4	12000	140334 ●	140335 ●
106	240	26	MC33	4	12000	140336 ●	140337 ●
128	80	26	MC33	6	10000	140346 ●	140347 ●
128	130	26	MC33	6	10000	140348 ●	140349 ●
128	170	26	MC33	6	10000	140350 ●	140351 ●
128	240	26	MC33	6	8000	140352 ●	140353 ●

**Cutting angle 12°**

WP 210 2 01

D	SB	A	QAL	Z	$n_{\max}$	ID	ID
mm	mm	mm			min <sup>-1</sup>	LH / bottom	RH / top
106	130	26	MC33	2	12000	140302 ●	140303 ●
106	170	26	MC33	2	12000	140304 ●	140305 ●
106	240	26	MC33	2	12000	140306 ●	140307 ●
106	130	26	MC33	4	12000	140312 ●	140313 ●
106	170	26	MC33	4	12000	140314 ●	140315 ●
128	80	26	MC33	6	10000	140340 ●	140341 ●
128	130	26	MC33	6	10000	140342 ●	140343 ●
128	170	26	MC33	6	10000	140344 ●	140345 ●

**Spare knives:**

SB	H	DIK	QAL	VE	ID
mm	mm	mm		PCS	
80	40	5	MC33	2	697302 ●
130	40	5	MC33	2	697304 ●
170	40	5	MC33	2	697306 ●
240	40	5	MC33	2	697311 ●

**Spare parts:**

BEZ	ABM	for SB	ID
	mm	mm	
Clamping wedge	78x25.3x10.8	80	620702 ●
Clamping wedge	128x25.3x10.8	130	620705 ●
Clamping wedge	168x25.3x10.8	170	620707 □
Clamping wedge	238x25.3x10.8	240	620710 □
Allen screw	M10x1x20		007396 ●
Allen key	SW 5		117509 ●



### Hydro planerhead

#### Application:

Pre and finish planing with high feed speeds.

#### Machine:

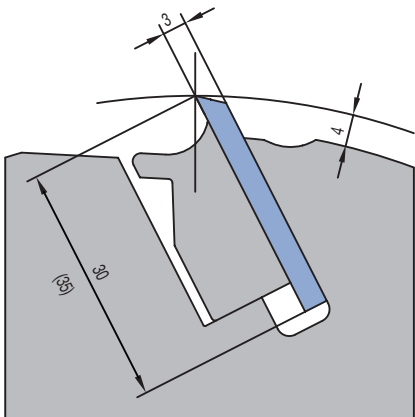
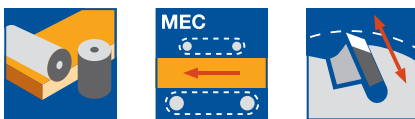
Four-sided moulders and profile machines with jointing equipment.

#### Workpiece material:

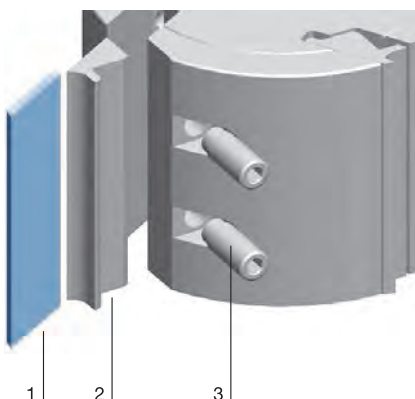
Softwood and hardwood.

#### Technical information:

Steel tool body with corrosion resistant surface protection. Integrated hydro clamping system with exchangeable clamping sleeves. Activated by a grease gun. Inclusive resharpenable HS planer knives (SB x 30 x 3 mm). From diameter 203 mm, knives with 35 mm height also can be used. Hydro planerheads can only be used in combination with a clamping collar.



Mounted knife



#### Steel tool body

HM 200 2 07

D mm	SB mm	BO mm	Z	QAL	n <sub>max</sub> min <sup>-1</sup>	ID
163	130	50	4	HS	8100	142050
163	160	50	4	HS	8100	142051
163	230	50	4	HS	8100	142052
163	60	50	6	HS	8100	142053 ●
163	100	50	6	HS	8100	142054 ●
163	130	50	6	HS	8100	142055 ●
163	160	50	6	HS	8100	142056 ●
163	230	50	6	HS	8100	142057 ●
163	60	50	8	HS	8100	142058
163	100	50	8	HS	8100	142059
163	130	50	8	HS	8100	142060
163	160	50	8	HS	8100	142061
163	180	50	8	HS	8100	142062
163	230	50	8	HS	8100	142063
203	100	50	12	HS	6600	142064
203	130	50	12	HS	6600	142065
203	160	50	12	HS	6600	142066
203	180	50	12	HS	6600	142067
203	230	50	12	HS	6600	142068

Lightweight aluminium version on request.

#### Spare knives:

Part-no.	SB mm	H mm	DIK mm	ID HS Classic	ID HS Premium	ID HW	ID MC33
1	60	30	3	605000	027101 ●	027277 ●	606700 ●
1	100	30	3	605002 ●	027103 ●	027279 ●	606702 ●
1	130	30	3	605005 ●	027106 ●	027282 ●	606705 ●
1	160	30	3	605045 ●	027163 ●		606745 ●
1	180	30	3	605008 ●	027109 ●	027285 ●	606708 ●
1	230	30	3	605011 ●	027111 ●	027287 ●	606711 ●

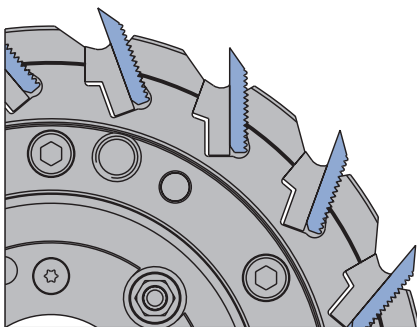
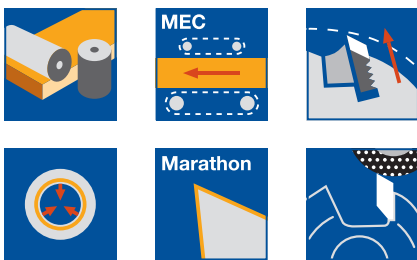
#### Spare parts:

Part-no.	BEZ	ABM mm	for SB mm	ID
2	Clamping wedge		60	620950 ●
2	Clamping wedge		100	620951 ●
2	Clamping wedge		130	620952 ●
2	Clamping wedge		160	620953 ●
2	Clamping wedge		180	620954 ●
2	Clamping wedge		230	620955 ●
3	Allen screw	M10x1x25		007395 ●
3	Allen screw	M10x1x20		007396 ●
3	Allen screw	M10x1x16		007397 ●
	Grease nipple	M10x1		007935 ●
	Relief plug	M10x1		007983 ●
	Allen key	SW 5		117509 ●
	Grease gun			008239 ●

● available ex stock

□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)



TurboPlan PLUS knife clamping

### Hydro planerhead TurboPlan PLUS

#### Application:

Pre and finish planing with high feed speeds.

#### Machine:

High performance planing machines with precision spindles and counter bearing as well as a jointing unit.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Tool body in weight optimized design with two independent hydro systems for the tool and knife clamping. Activated by a grease gun. Marathon coated planer knives with back serration (SB x 30 x 5 mm). Hydro planerheads can only be used in combination with a clamping collar.

#### Weight optimised design

HM 200 2 08

D	SB	BO	Z	$n_{\max}$ $\text{min}^{-1}$	ID
mm	mm	mm			
200	150	50	14	8000	<b>142230</b>
200	230	50	14	8000	<b>142231</b>
200	330	50	14	8000	<b>142232</b>
225	150	50	18	7200	<b>142233</b>
225	230	50	18	7200	<b>142234</b>
225	330	50	18	7200	<b>142235</b>
260	150	50	22	6200	<b>142236</b>
260	230	50	22	6200	<b>142237</b>
260	330	50	22	6200	<b>142238</b>

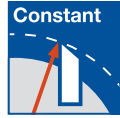
#### Spare knives:

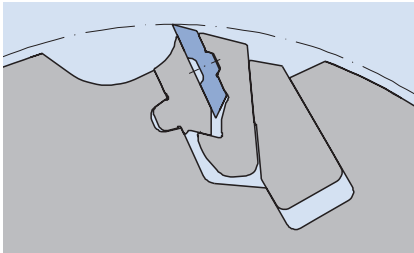
SB	H	DIK	QAL	ID
mm	mm	mm		
150	30	5	MC33	<b>697359</b> □
230	30	5	MC33	<b>697360</b> □
330	30	5	MC33	<b>697363</b> □






#### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Knife setting device	for TurboPlan		<b>142290</b>
Setting gauge for Hydro planerhead	Knife protrusion 3.8 mm		<b>142291</b>
Grease gun			<b>008239</b> ●
Grease cartridge	for Hydro sleeve		<b>007934</b> ●
Jointing stone (round)	12x32	Colour: grey	<b>008237</b> ●
Jointing stone (angular)	20x15x60	Colour: brown	<b>008238</b> ●

#### Planerhead VariPlan Plus/ProFix F



<b>Application</b>	Four-sided moulders for planing, grooving or profiling in one process step. The combination of planing knives and profiling knives allows the planerhead to be used as a multi-purpose planing and profiling tool.
<b>Machines</b>	Four-sided moulders.
<b>Workpiece material</b>	Softwood and hardwood.
<b>Cutting material</b>	Planing knives HS / HW. Profile knives HW.
<b>Number of wings</b>	Z 2+2 seatings for radius, bevel, grooving or profile knives.
<b>Resharpener area</b>	Planer knife 1.0 mm, profile knife 4.5 mm
<b>Chip removal</b>	Softwood: up to 10.0 mm. Hardwood: up to 7.0 mm.
<b>Tool design</b>	Lightweight aluminium cutterhead with resharpenable turnblade planing knives. Clamping system with constant profile and constant diameter (see introduction VariPlan Plus and ProFix cutterhead).
<b>Technical features</b>	 <p>Axially adjustable profile knives can be adjusted to the corresponding wood width/height. Profile depths up to 25 mm and working widths up to 120 mm possible.</p> <p>Cutterhead with lightweight aluminium tool body and steel chip breaker.</p>

<b>Accessories</b>	Bevel, grooving, fluting knives; two left and two right knives per set.
	<div> <div> bevel: 22 mm x 45°  </div> <div> rounding: R = 3 – 22,5 mm  </div> <div> flute: R = 3 – 25 mm  </div> <div> flute: R = 3 – 22,5 mm  </div> <div> Nut: 8 x 10 mm, 12 – 25 mm  </div> </div>

<b>Note</b>	<ul style="list-style-type: none"> <li>– Quick change of VariPlan Plus knives in radial direction.</li> <li>– Quick change and adjustment of ProFix profile knives in axial direction.</li> <li>– Special profile knives on request.</li> </ul>
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#### Planerhead VariPlan Plus/ProFix F system PF 25

##### Application:

For planing and profiling (chamfering) e.g. grooving, bevelling, rounding or profiling in common.

##### Machine:

Four-sided moulders.

##### Workpiece material:

Softwood and hardwood.

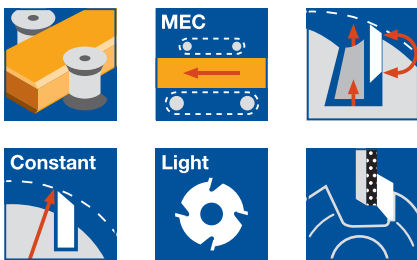
##### Technical information:

Resharpenable cutterhead system with constant diameter and constant profile.

VariPlan Plus planerhead with knife seatings for ProFix F profile knives (PF 25) and

HW microfinish turnblade knives. Profile knives:  $PT_{max}$  25 mm,  $SB_{max}$  100 mm.

Lightweight aluminium tool body.



##### Bore 40 mm

WW 240 2 07

D	SB	ND	BO	QAL	$n_{max}$	Z	ID
mm	mm	mm	mm		$min^{-1}$		
125	130	136	40	HW	10200	2+2	<b>131060 ●</b>
125	166	172	40	HW	10200	2+2	<b>131058 ●</b>
125	236	242	40	HW	10200	2+2	<b>131059 ●</b>

Further knife types, dimensions and inch dimensions on request. Servicing with spare parts only by the manufacturer. VariPlan Plus spare knives in section Knives and Spare Parts.

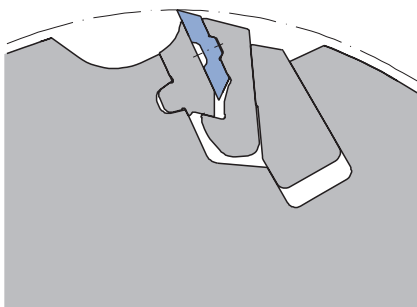
##### Spare knives:

BEZ	SB	ABM	QAL	ID	ID
	mm	mm		LH	RH
ProFix F knife PF 25 R=3	25	R=3	HW	<b>011041 ●</b>	<b>011042 ●</b>
ProFix F knife PF 25 R=5	25	R=5	HW	<b>011043 ●</b>	<b>011044 ●</b>
ProFix F knife PF 25 R=10	25	R=10	HW	<b>011047 ●</b>	<b>011048 ●</b>
ProFix F knife PF 25 Bevel 45°	25	Bevel 45°	HW	<b>011051 ●</b>	<b>011052 ●</b>

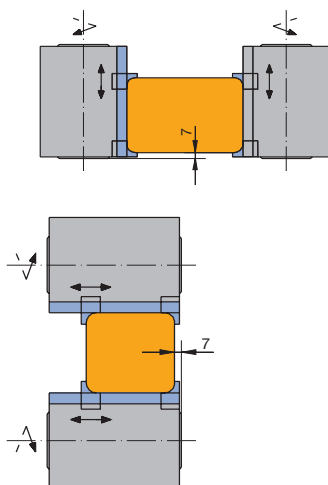
Further profile knives on request.

##### Spare parts:

BEZ	ABM	ID	ID
	mm	LH	RH
Knife holder for edge knives	D=125, SW=20°	<b>011301 ●</b>	<b>011300 ●</b>
Knife holder for grooving knives	D=125, SW=20°, NT=6	<b>011303 ●</b>	<b>011302 ●</b>
Allen key	SW 4		<b>005445 ●</b>
Allen key	SW 5		<b>005452 ●</b>

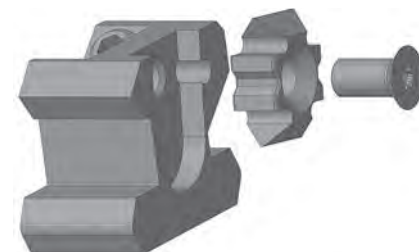


Lightweight aluminium tool body with steel chip breaker

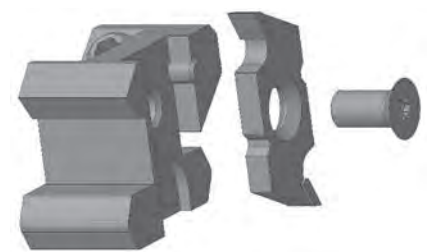


Use on vertical or horizontal spindles

$HD = SB - 40 \text{ mm}$



Knife holder to adapt edge knives.



Knife holder to adapt grooving knives.





#### Planerhead VariPlan Plus/ProFix F system PF 25

##### Application:

For planing and profiling (chamfering) e.g. grooving, bevelling, rounding or profiling in common.

##### Machine:

Four-sided moulders with HSK 85 WS interface.

##### Workpiece material:

Softwood and hardwood.

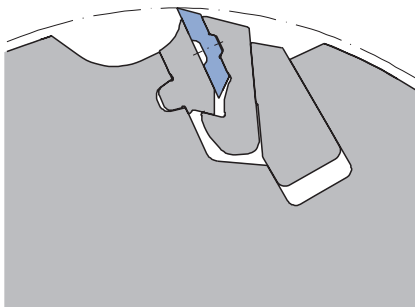
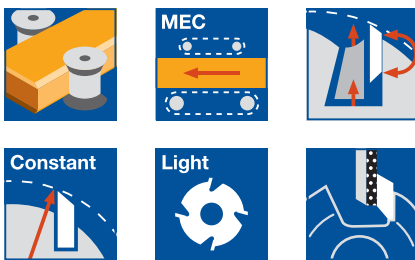
##### Technical information:

Resharpenable cutterhead system with constant diameter and constant profile.

VariPlan Plus planerhead with knife seatings for ProFix F profile knives (PF 25) and

HW microfinish turnblade knives. Profile knives:  $PT_{max}$  25 mm,  $SB_{max}$  100 mm.

Lightweight aluminium tool body.



Lightweight aluminium tool body with steel chip breaker

##### HSK 85 WS

WP 240 2 01

D	SB	A	Z	$n_{max}$	DRI	BEM	ID
mm	mm	mm		$min^{-1}$			
125	130	26	2+2	10200	LH	left/on bottom	<b>131120</b> □
125	130	26	2+2	10200	RH	right/on top	<b>131121</b> □
125	166	26	2+2	10200	LH	left/on bottom	<b>131116</b> □
125	166	26	2+2	10200	RH	right/on top	<b>131117</b> □
125	236	26	2+2	10200	LH	on bottom	<b>131118</b> □
125	236	26	2+2	10200	RH	on top	<b>131119</b> □

Further knife types, dimensions and inch dimensions on request. Servicing with spare parts only by the manufacturer. VariPlan Plus spare knives in section Knives and Spare Parts.

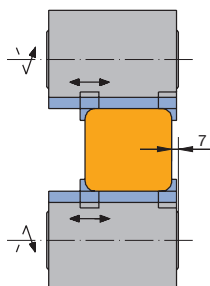
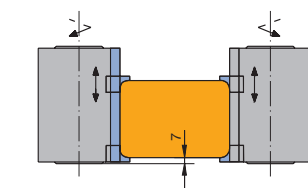
##### Spare knives:

BEZ	SB	ABM	QAL	ID	ID
	mm	mm		LH	RH
ProFix F knife PF 25 R=3	25	R=3	HW	<b>011041</b> ●	<b>011042</b> ●
ProFix F knife PF 25 R=5	25	R=5	HW	<b>011043</b> ●	<b>011044</b> ●
ProFix F knife PF 25 R=10	25	R=10	HW	<b>011047</b> ●	<b>011048</b> ●
ProFix F knife PF 25 Bevel 45°	25	Bevel 45°	HW	<b>011051</b> ●	<b>011052</b> ●

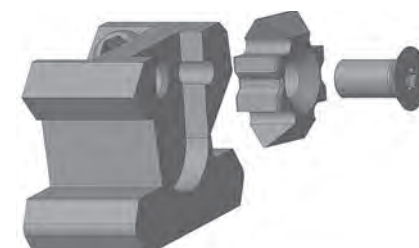
Further profile knives on request.

##### Spare parts:

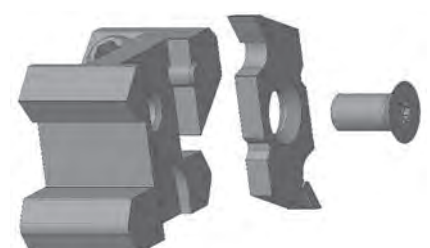
BEZ	ABM	ID	ID
	mm	LH	RH
Knife holder for edge knives	D=125, SW=20°	<b>011301</b> ●	<b>011300</b> ●
Knife holder for grooving knives	D=125, SW=20°, NT=6	<b>011303</b> ●	<b>011302</b> ●
Allen key	SW 4		<b>005445</b> ●
Allen key	SW 5		<b>005452</b> ●



Use on vertical or horizontal spindles  
 $HD = SB - 40 \text{ mm}$



Knife holder to adapt edge knives.



Knife holder to adapt grooving knives.



### 3. Planing and profiling

### 3.3 Profiling

#### 3.3.1 Tools for tongue and groove joints

<b>Profile variations</b>	<p>Tongue and groove profiles are used on wall, ceiling and floor panels. The profiles are standardised and different in each country. The tools for machining solid wood panels presented on the following product pages are the most common designs in Europe. The majority of tools for wall and ceiling panel machining are produced to customer specifications.</p>
<b>Workpiece materials</b>	Softwood and medium hardwood.
<b>Machines</b>	<p>Four-sided moulders with feed speeds up to 80 m min<sup>-1</sup>. Machines with high precision spindles and jointing units for feed speeds up to 300 m min<sup>-1</sup>.</p>
<b>Application</b>	<p>Machining against feed, panel face down. Groove right, tongue left. Groove machined either as a part of the groove profile or separately on a horizontal spindle.</p>
<b>Tool design</b>	<p><b>HL solid cutter:</b> HL solid cutters are form ground with a large resharping area. Suitable for softwood such as spruce or fir. The main application is high speed moulders for producing standardised tongue and groove boards in high quantities and with high quality requirements.</p> <p><b>HW/HS-tipped tools:</b> HW/HS-tipped tools have a smaller resharping area of approx. 5 mm depending on the tipping thickness. HW/HS-tipped tools are suitable for softwood and hardwood. They are mainly used on small volume moulding machines with frequent profile changes.</p>

#### Design of grooving and tongue cutter sets

Tongue and groove cuttersets are of 2 part, adjustable.



Tongue cutter:  
Always wing on wing.



Grooving cutter:  
two designs –  
wing on wing or  
wing on gullet

#### Wing-on-wing design:

With the wing-on-wing design, the two parts of the cutter set are positioned with the cutting edges on top of each other and the gullets in line so the two parts can be resharpened simultaneously.

Advantage: Resharping simpler and greater resharping area.

Disadvantage: Only every other groove wing is cutting the groove flank.

For a Z 6 groove cutter, only three groove wings are cutting each side of the groove.

Tear-outs can occur at high feed speeds.

### 3. Planing and profiling

#### 3.3 Profiling

##### 3.3.1 Tools for tongue and groove joints



Wing-on-gullet design:

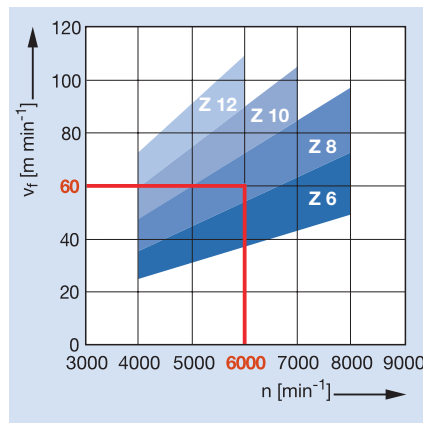
Unless indicated otherwise, Leitz delivers wing-on-gullet design as a standard.

With this design, the two cutter parts are adjusted so that the wings of one part lie in the gullets of the other part.

Advantage: All the wings are constantly working on the groove side.

This design is preferable for high feed speeds.

#### Relation between feed rate, RPM and number of wings



For tools without hydro clamping, only the marks of one knife show on the surface (one-knife finish).

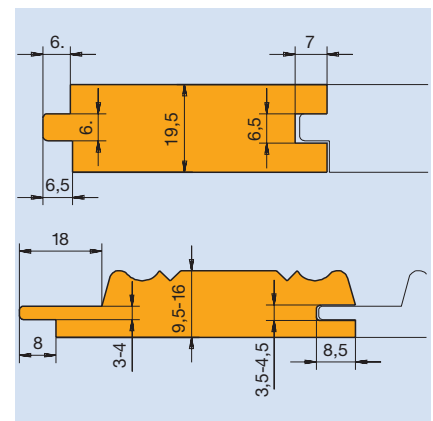
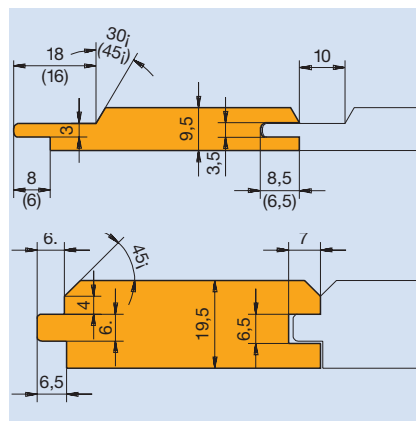
When calculating the maximum feed speed, only one cutting edge can be taken into account.

If the tool is clamped with a hydro clamping system and the profiling is resharpened to a concentricity of at least 0.01 mm, all cutting edges are equally involved in the cutting process and can be taken into account when calculating the maximum feed speed.

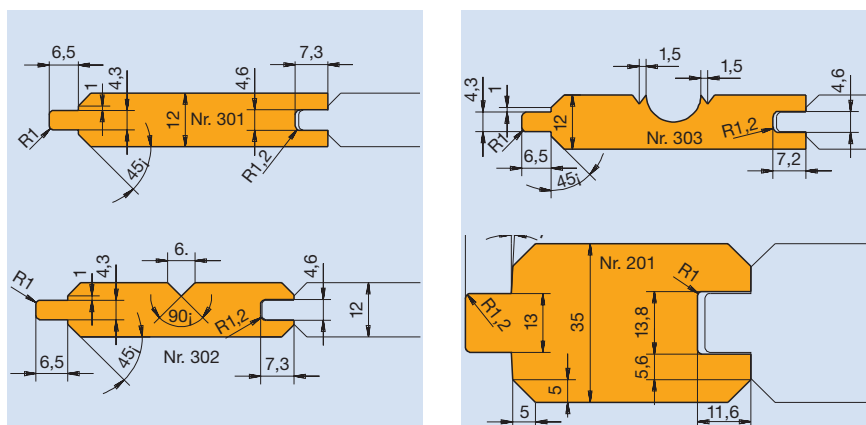
$f_z$  0.8 - 1.5 mm

#### Profile samples for groove and tongue panels

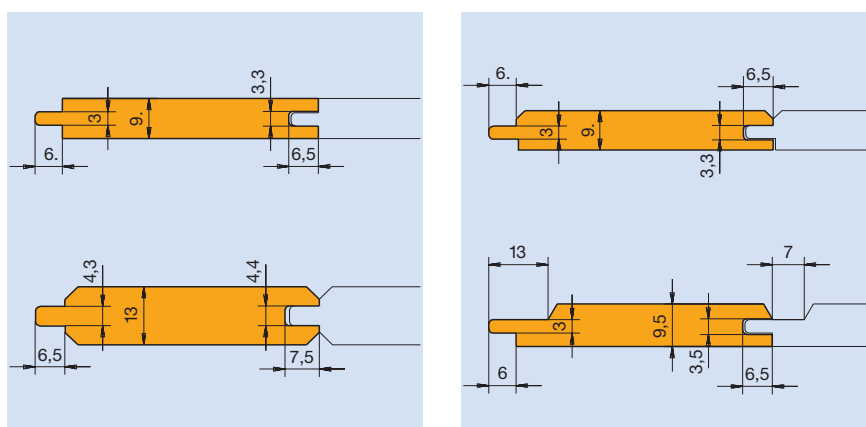
German standard profiles



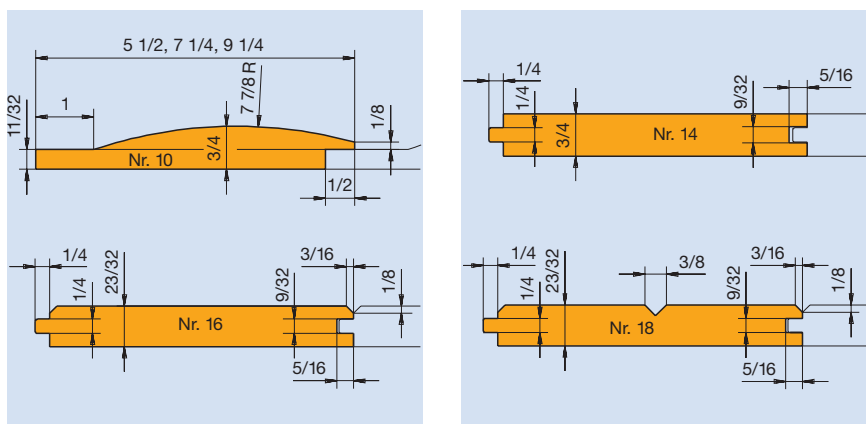
Australian standard profiles



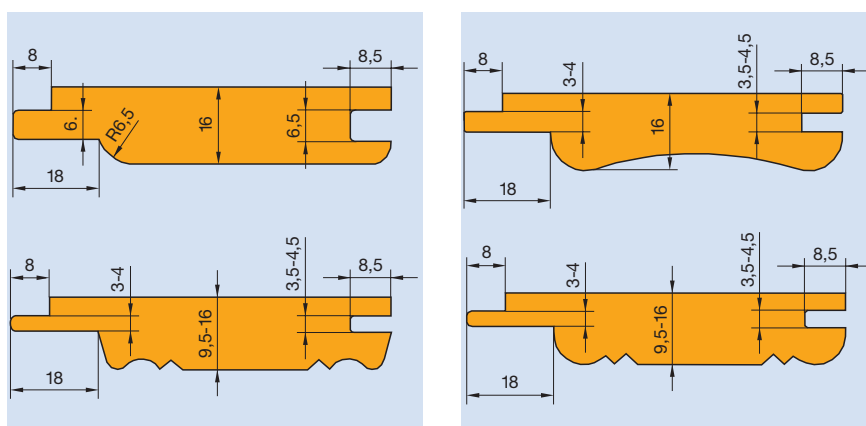
Scandinavian standard profiles



Canadian standard profiles



European country-house profiles





#### Tongue and groove cutter, HL solid / HS tipped

##### Application:

For tongue and groove profiles on wall and ceiling panels.

##### Machine:

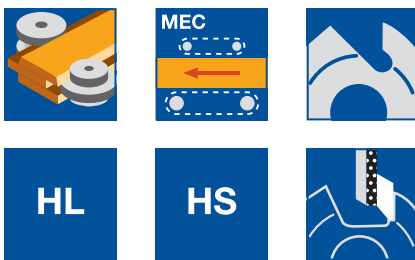
Four-sided moulders.

##### Workpiece material:

Softwood, along grain.

##### Technical information:

Tongue and groove cutterset with spacers for adjustment to different wood thicknesses and tongue and groove widths. BO 60 for use on hydro sleeve for high feed speeds and machining qualities. HL profile cutter with form ground clearance and large reshaping area; HS tipped design with straight clearance.



##### Straight with closed joint (P3), as viewed from finished face

AF 200 2

P	D	BO	HD	Z	NT	FL	$n_{\max}$	QAL	ID
	mm	mm	mm		mm	mm	$\text{min}^{-1}$		
3	180	60	15 - 27	6	8.5	8	9000	HL	021876
3	160	40	15 - 27	6	8.5	8	9000	HS	022016

##### Bevel profile with closed joint (P5), as viewed from finished face

AF 210 2

P	D	BO	HD	Z	NT	FL	$n_{\max}$	QAL	ID
	mm	mm	mm		mm	mm	$\text{min}^{-1}$		
5	160	40	12.5 - 16	6	7	6	9000	HS	021913

##### Bevel profile (P1, P4)

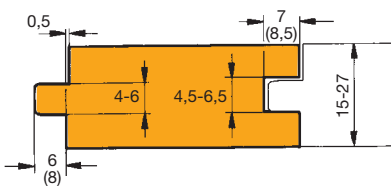
AF 240 2

P	D	BO	HD	NT	FL	Z	$n_{\max}$	QAL	ID
	mm	mm	mm	mm	mm		$\text{min}^{-1}$		
1	180	60	12 - 27	7	6	6	9000	HL	021964
4	180	60	12 - 27	8	8.5	6	9000	HL	021969

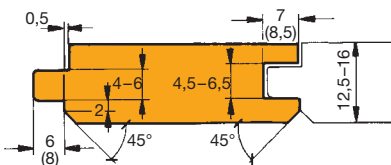
##### Radius profile R5 (P6)

AF 221 2

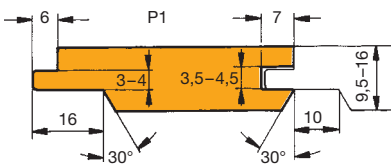
P	D	BO	HD	NT	FL	Z	$n_{\max}$	QAL	ID
	mm	mm	mm	mm	mm		$\text{min}^{-1}$		
6	180	60	14 - 19	10	10.5	6	9000	HL	021883



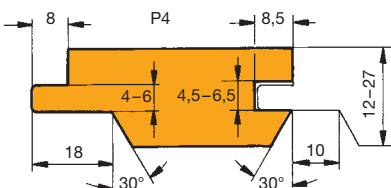
Profile 3: AF 200 2



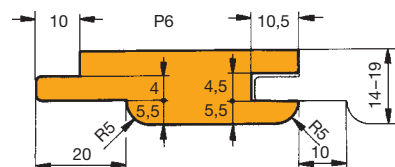
Profile 5: AF 210 2



Profile 1: AF 240 2



Profile 4: AF 240 2



Profile 6: AF 221 2



### Profile cutterhead set ProfilCut Q - bevelling / rounding

#### Application:

Multi-purpose tool set for bevelling, rounding and jointing the workpiece edges at the same time.

#### Machine:

Spindle moulders, copy shaping and moulders, double-end tenoner.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

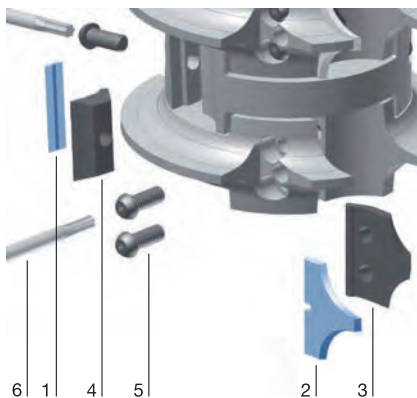
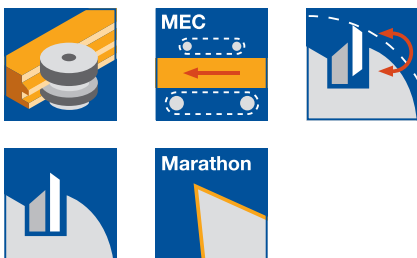
With a combination of jointing and bevelling/rounding cutterheads, different profiles and wood thicknesses can be machined. Profile knives with different radii/bevels can be mounted in one cutterhead.

#### Mechanical feed

SE 541 2 53

Tool Type	D <sub>0</sub> mm	AW PCS	n <sub>max</sub> min <sup>-1</sup>	Z	ID
Jointing-rounding	125	2	8000	2	<b>126063</b> □
Rounding-jointing-rounding	125	3	8000	2	<b>126064</b> □
Rounding-rounding	125	2	8000	2	<b>126065</b> □

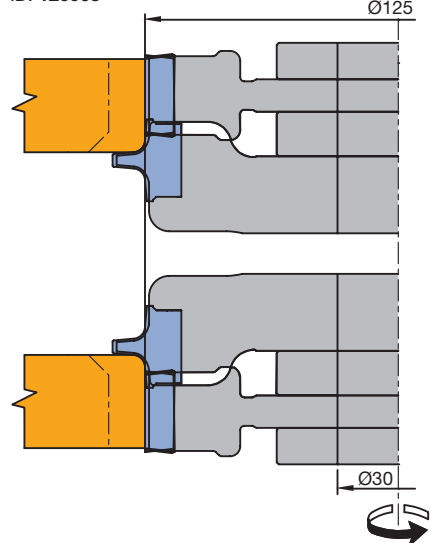
Further radii are available at short notice.



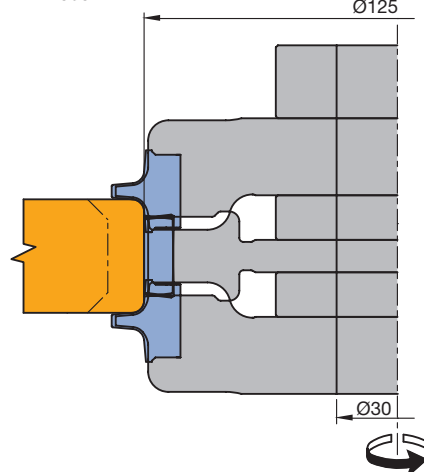
#### Spare parts:

Part-no.	BEZ	ABM mm	Tool no.	ID
3	Clamping wedge	18x22x8.27	1/2	<b>629231</b>
3	Clamping wedge	33x28x8.27	3/4	<b>629232</b>
3	Clamping wedge	38x29.71x8.27	5	<b>629233</b>
3	Clamping wedge	38x29.71x8.27	6	<b>629234</b>
3	Clamping wedge	48x31.73x8.27	7	<b>629235</b>
3	Clamping wedge	48x31.73x8.27	8	<b>629236</b>
4	Clamping wedge	18x18.75x8.27	20	<b>009671</b> ●
4	Clamping wedge	33x18.75x8.27	35	<b>009674</b> ●
4	Clamping wedge	48x18.75x8.27	50	<b>009677</b> ●
5	Clamping screw w. disc, Torx® 25	M6x18.5		<b>007442</b> ●
6	Torx® key	Torx® 25		<b>117504</b> ●

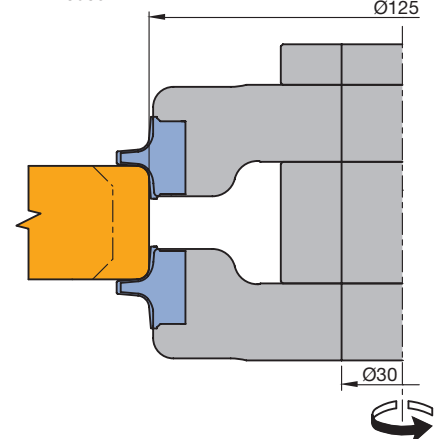
ID. 126063



ID. 126064

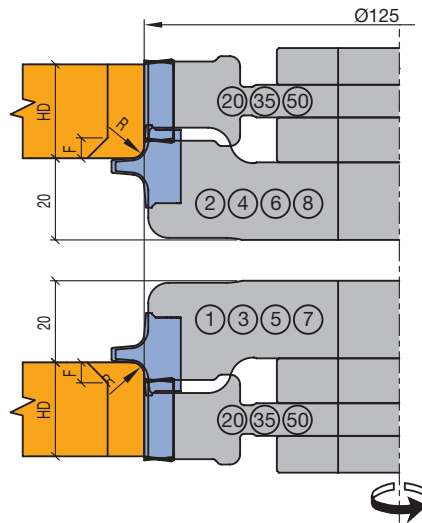


ID. 126065



#### ID. 126063

Order example:  
 -Combination ID 126063  
 -Profile description top down RL  
 jointingSB35/R5 or R5/jointingSB35  
 -Bore diameter 30



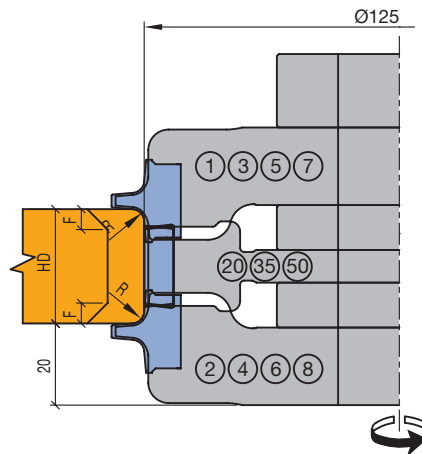
Wood thickness (HD):

Jointing tool	(20)	(35)	(50)
max. HD	18+R (F)	33+R (F)	48+R (F)

F (bevel) max. = 5 or 9x45°

#### ID. 126064

Order example:  
 -Combination ID 126064  
 -Profile description top down RL  
 R5/jointingSB35/R5  
 -Bore diameter 30

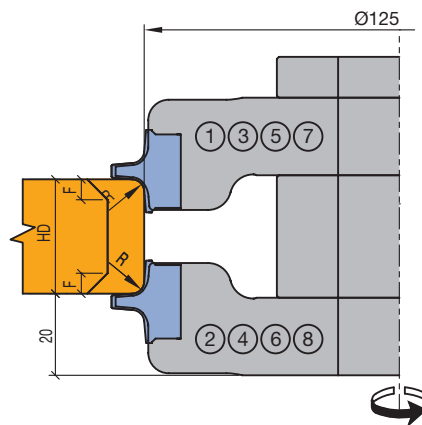


Radii tools	Jointing tool			Minimum wood thickness
	(20)	(35)	(50)	
No.1+2	6	12	24	
No.1+4	13	19	31	
No.1+6	18	24	36	
No.1+8	28	34	46	
No.3+2	13	19	31	
No.3+4	20	26	38	
No.3+6	25	31	43	
No.3+8	35	41	53	
No.5+2	18	24	36	
No.5+4	25	31	43	
No.5+6	30	36	48	
No.5+8	40	46	58	
No.7+2	28	34	46	
No.7+4	35	41	53	
No.7+6	40	46	58	
No.7+8	50	56	68	
max. HD	18+R+R (F+F)	33+R+R (F+F)	48+R+R (F+F)	

F (bevel) max. = 3, 5, 7x45° or 8x40°  
 Wood thicknesses are calculated with max. bevel

#### ID. 126065

Order example:  
 -Combination ID 126065  
 -Profile description top down RL  
 R5/R5  
 -Bore diameter 30

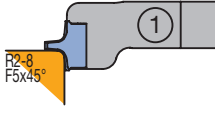


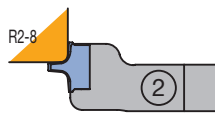
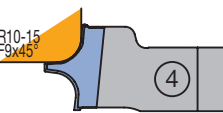

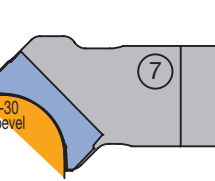
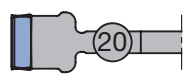
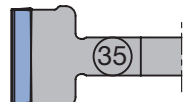
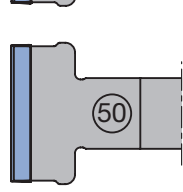
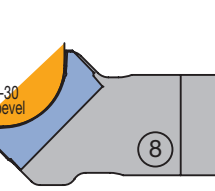
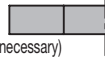


Radii tools		Minimum wood thickness
No.1+2	-2	
No.1+4	5	
No.1+6	10	
No.1+8	20	
No.3+2	5	
No.3+4	12	
No.3+6	17	
No.3+8	27	
No.5+2	10	
No.5+4	17	
No.5+6	22	
No.5+8	32	
No.7+2	20	
No.7+4	27	
No.7+6	32	
No.7+8	42	

### 3. Planing and profiling

### 3.3 Profiling

#### 3.3.2 Radius profile cutterheads

<p>Spare part: clamping wedge 629231</p> 	<table border="1"> <tr><td>WZ 125306</td><td>R4</td></tr> <tr><td>ME 619247</td><td></td></tr> <tr><td>WZ 125307</td><td>R5</td></tr> <tr><td>ME 619248</td><td></td></tr> <tr><td>WZ 125308</td><td>R6</td></tr> <tr><td>ME 619249</td><td></td></tr> <tr><td>WZ 125309</td><td>R7</td></tr> <tr><td>ME 619250</td><td></td></tr> <tr><td>WZ 125310</td><td>R8</td></tr> <tr><td>ME 619251</td><td></td></tr> <tr><td>WZ 125311</td><td>F5x45°</td></tr> <tr><td>ME 619253</td><td></td></tr> </table>	WZ 125306	R4	ME 619247		WZ 125307	R5	ME 619248		WZ 125308	R6	ME 619249		WZ 125309	R7	ME 619250		WZ 125310	R8	ME 619251		WZ 125311	F5x45°	ME 619253		<p>Spare part: clamping wedge 629232</p> 	<table border="1"> <tr><td>WZ 125321</td><td>R11</td></tr> <tr><td>ME 619255</td><td></td></tr> <tr><td>WZ 125322</td><td>R12</td></tr> <tr><td>ME 619256</td><td></td></tr> <tr><td>WZ 125323</td><td>R13</td></tr> <tr><td>ME 619257</td><td></td></tr> <tr><td>WZ 125324</td><td>R14</td></tr> <tr><td>ME 619258</td><td></td></tr> <tr><td>WZ 125325</td><td>R15</td></tr> <tr><td>ME 619259</td><td></td></tr> <tr><td>WZ 125326</td><td>F9x45°</td></tr> <tr><td>ME 619260</td><td></td></tr> </table>	WZ 125321	R11	ME 619255		WZ 125322	R12	ME 619256		WZ 125323	R13	ME 619257		WZ 125324	R14	ME 619258		WZ 125325	R15	ME 619259		WZ 125326	F9x45°	ME 619260		<p>Spare part: clamping wedge 629233</p> 	<table border="1"> <tr><td>WZ 125334</td><td>R16</td></tr> <tr><td>ME 619263</td><td></td></tr> <tr><td>WZ 125335</td><td>R17</td></tr> <tr><td>ME 619264</td><td></td></tr> <tr><td>WZ 125336</td><td>R18</td></tr> <tr><td>ME 619265</td><td></td></tr> <tr><td>WZ 125337</td><td>R19</td></tr> <tr><td>ME 619266</td><td></td></tr> <tr><td>WZ 125338</td><td>R20</td></tr> <tr><td>ME 619267</td><td></td></tr> <tr><td>WZ 125339</td><td>F9x40°</td></tr> <tr><td>ME 619269</td><td></td></tr> </table>	WZ 125334	R16	ME 619263		WZ 125335	R17	ME 619264		WZ 125336	R18	ME 619265		WZ 125337	R19	ME 619266		WZ 125338	R20	ME 619267		WZ 125339	F9x40°	ME 619269	
WZ 125306	R4																																																																												
ME 619247																																																																													
WZ 125307	R5																																																																												
ME 619248																																																																													
WZ 125308	R6																																																																												
ME 619249																																																																													
WZ 125309	R7																																																																												
ME 619250																																																																													
WZ 125310	R8																																																																												
ME 619251																																																																													
WZ 125311	F5x45°																																																																												
ME 619253																																																																													
WZ 125321	R11																																																																												
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WZ 125325	R15																																																																												
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### 3. Planing and profiling

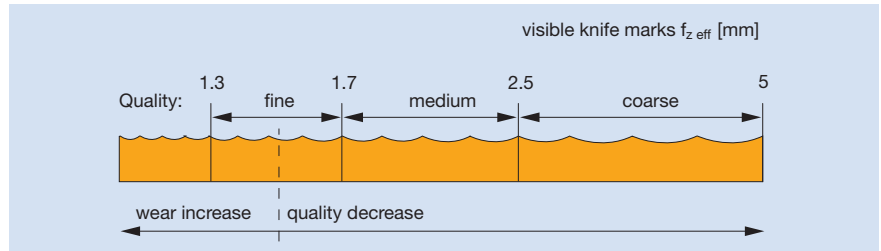
### 3.3 Profiling

#### 3.3.3 Cutterheads for multi-purpose profiling

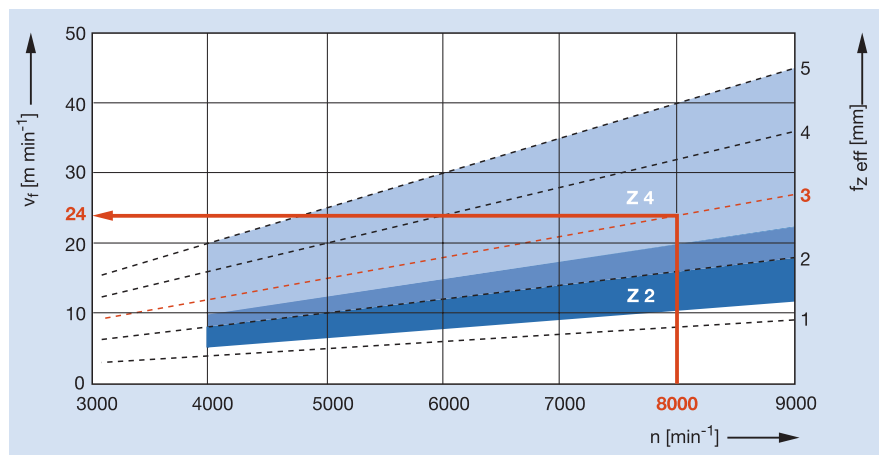
##### Process steps

The cutterheads presented in the following section are suitable for a variety of profiles in the craft and industrial sectors. Due to the different application possibilities, the use of the tool and wood types to be machined are detailed on the respective product pages.

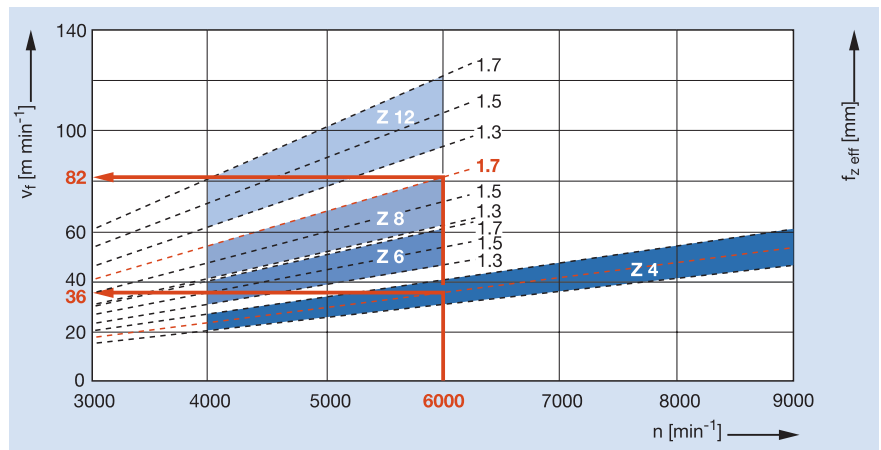
##### Relation between surface quality and length of knife marks $f_{z \text{ eff}}$



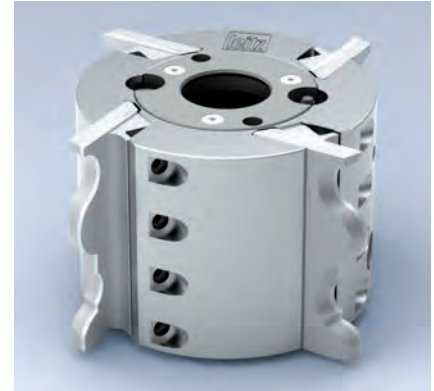
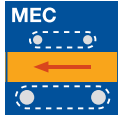
##### Cutterhead without hydro clamping: Feed speeds depending on RPM, length of knife marks and number of wings



##### Cutterhead with hydro clamping: Feed speeds depending on RPM, length of knife marks and number of wings



#### Profile cutterheads for serrated back blank knives



<b>Application</b>	Multi-purpose profiling, machining along grain.
<b>Machines</b>	Four-sided moulders and profiling machines.
<b>Workpiece materials</b>	Softwood and hardwood.
<b>Number of teeth</b>	Z 2, Z 4.
<b>Cutting material</b>	Marathon (MC), HW.
<b>Resharpener area</b>	10.8 mm (9 + 1.8 mm) Marathon (MC) and HW blank knife with backing plate.
<b>Feed</b>	Four-sided profiling.
<b>Tool design</b>	Steel tool body. High concentricity and balance. Knife seat for serrated back knives in HS and MC 33, thickness 8 mm, and HW and HW PowerKnifeSystem (MicroSystem blank knives), total thickness 10 mm (HW blank knife and backing plate). Standard pitch 1.6 mm.
<b>Advantages</b>	Optimal cutting speed with $n = 12,000 \text{ min}^{-1}$ and thus improved finish quality. For optimal finish quantity we recommend to grind in the profile blanks in the cutterhead and joint them additionally on the machine.
<b>Note</b>	Cutting angle $20^\circ$ for softwood. Cutting angle $12^\circ$ for hardwood and wood fibre materials. PowerKnifeSystem (HW MicroSystem) blank knives with a knife height of 70 mm can only be used for cutting widths up to 150 mm. For jointing: resharpened concentricity of $< 0.005 \text{ mm}$ .

### 3. Planing and profiling

### 3.3 Profiling

#### 3.3.3 Cutterheads for multi-purpose profiling



#### Profile cutterhead ProFix F

##### Application:

Flexible profiling of different profiles, suitable for panel production.

##### Machine:

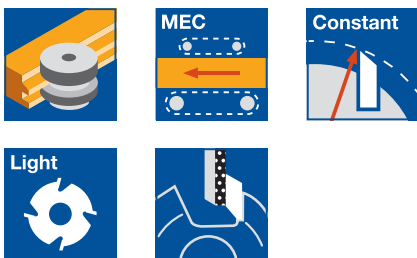
Four-sided moulder and profiling machine.

##### Workpiece material:

Softwood and hardwood, with grain.

##### Technical information:

Resharpenable, diameter and profile constant tooling system. Easy profile adjustment through knife change. No tool measurement required. To adapt ProFix F knives with 4.5 mm resharpening area and a profile depth of 25 mm max. Lightweight aluminium tool body. Division of maximum cutting width to several knives possible.



##### Bore 40 mm

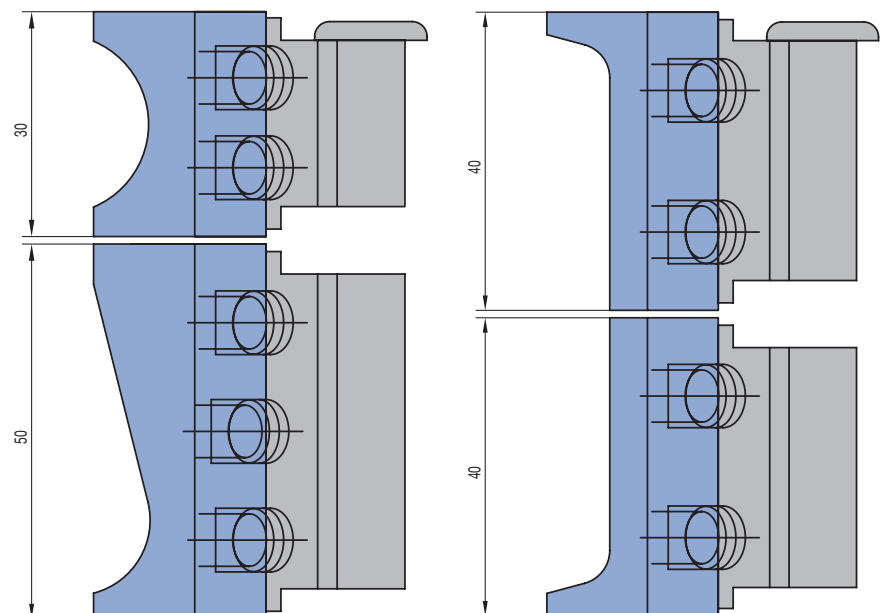
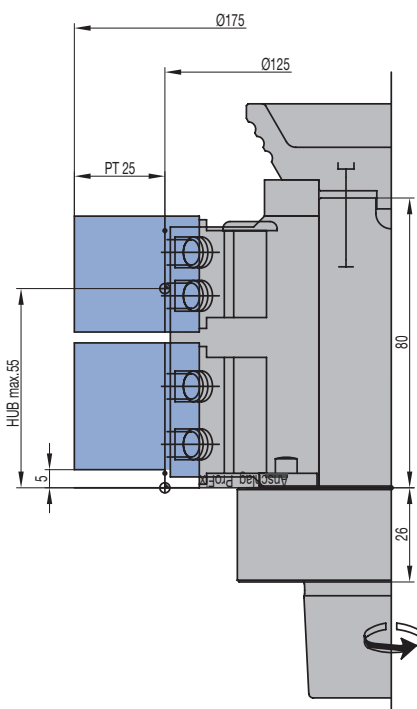
HY 500 2 25

D <sub>0</sub> mm	PT mm	SB mm	n <sub>max</sub> min <sup>-1</sup>	Z	ID
125	25	20 - 70	10000	2	014044 ●
125	25	20 - 90	10000	2	014043 ●

##### HSK 85 WS

HY 500 2 25

D <sub>0</sub> mm	PT mm	SB mm	n <sub>max</sub> min <sup>-1</sup>	BEM	Z	ID
125	25	20 - 70	10000	right/top	2	014046 □
125	25	20 - 70	10000	left/bottom	2	014048 □
125	25	20 - 90	10000	right/top	2	014045 □
125	25	20 - 90	10000	left/bottom	2	014047 □





#### Profile cutterhead VariForm

##### Application:

For cutting profiles. Different profiles with maximum 20 mm profile depth can be mounted.

##### Machine:

Moulders, double-end tenoners, edgebanding machines etc.

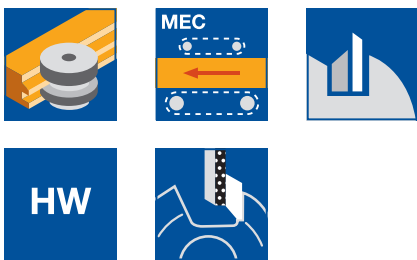
##### Workpiece material:

Softwood and hardwood (HW-30F), panel materials or glued wood (HW-10F).

##### Technical information:

Multi-purpose cutterhead for MEC feed with tungsten carbide special profile knives and backing plates.

Resharpenable 3 to 4 times.



##### Partly profiled tool body, MEC feed, Z 2 - Z 4 U profile

TT 531 2

D	TD	SB	BO	BO <sub>max</sub>	PT <sub>max</sub>	Z	n <sub>max</sub> min <sup>-1</sup>	ID
mm	mm	mm	mm	mm	mm			
165	140	40	30	40	20	2	10000	<b>135212 ●</b>
165	140	60	30	40	20	2	10000	<b>134214 ●</b>
180	165	40	30	50	20	4	9000	<b>135206 ●</b>
180	165	60	30	50	20	4	9000	<b>135208 ●</b>

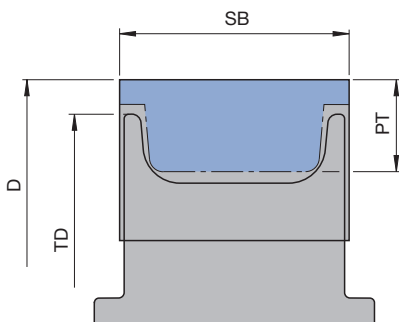
Supplied with clamping wedges, but without backing plates and knives.

##### Spare knives:

Part-no.	H	SB	ID	ID
	mm	mm	HW-10F	HW-30F
1	45	40	<b>636226 ●</b>	<b>636239 ●</b>
1	45	60	<b>636287 ●</b>	<b>636275 ●</b>

##### Spare parts:

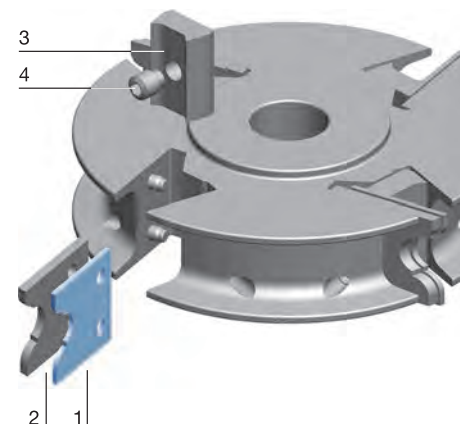
Part-no.	BEZ	ABM	for SB	ID
		mm	mm	
2	Backing plate VariForm	for knives 40x45x2.1		<b>645004 ●</b>
2	Backing plate VariForm	for knives 60x45x2.1		<b>645006 ●</b>
3	Clamping wedge	36x13.21x26	40/45	<b>009756 ●</b>
3	Clamping wedge	56x13.21x26	60	<b>009757 ●</b>
4	Allen screw with ISK 5	M10x12		<b>006044 ●</b>
	Allen key	SW 5, L100		<b>117506 ●</b>



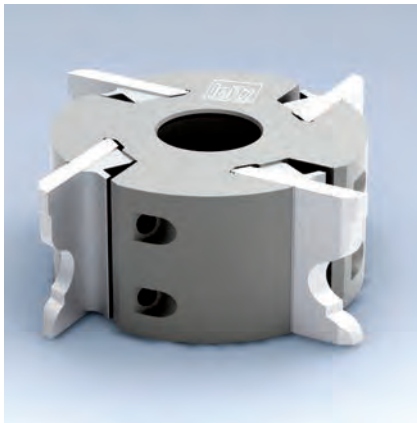
Tool body, U profile

Table of the O-diameter (D<sub>0</sub>) for adjusting the machine spindles

D	TD	D <sub>0</sub>
mm	mm	mm
150	135	110
165	140	125
180	165	140



Tool system description VariForm see section Profile Tool Systems.



#### Profile cutterheads for serrated back blank knives

##### Application:

For multi-purpose profiles in hard and/or materials likely to splinter.

##### Machine:

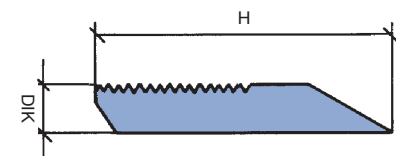
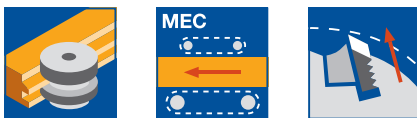
Four-sided moulders.

##### Workpiece material:

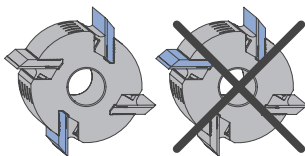
Cutting angle 20° for softwood and hardwood in general.

##### Technical information:

Profile cutterhead with 60° serration, 1.6 mm pitch. Steel tool body. Blank knives with knife thickness 8 - 10 mm and knife heights of 40 - 70 mm can be used depending on required profile depth. Cutting materials: Marathon (MC) and HW.



Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



##### Attention:

For safety reasons, always mount knives and backing plates (VE) of the same weight opposite to each other.

H	QAL	PT
mm		mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18

Table to determine maximum profile depth.

The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.

##### Cutting angle 20°

WM 501 2 05

TD	SB	BO	BO <sub>max</sub>	n <sub>max</sub>	Z	ID
mm	mm	mm	mm	min <sup>-1</sup>		
122	80	40	40	10300	2	135805 ●
122	40	40	40	10300	4	135802 ●
122	60	35	40	10300	4	135806 ●
122	60	40	40	10300	4	135808 ●
122	80	40	40	10300	4	135809 ●
122	100	35	40	10300	4	135810 ●
122	100	40	40	10300	4	135812 ●
122	130	40	40	10300	4	135814 ●
122	150	40	40	10300	4	135817 ●
122	170	40	40	10300	4	135816 ●
122	180	40	40	10300	4	135819 ●
122	230	40	40	10300	4	135821 ●
122	240	40	40	10300	4	135822 ●
137	60	40	50	9400	4	135823 ●
137	60	50	50	9400	4	135825 ●
137	80	50	50	9400	4	135826 ●
137	100	40	50	9400	4	135827 ●
137	100	50	50	9400	4	135829 ●
137	130	40	50	9400	4	135830 ●
137	130	50	50	9400	4	135831 ●
137	150	50	50	9400	4	135833 ●
137	180	50	50	9400	4	135836 ●
137	230	50	50	9400	4	135838 ●

##### Workpiece material:

Cutting angle 12° for materials likely to splinter such as oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

##### Cutting angle 12°

WM 501 2 05

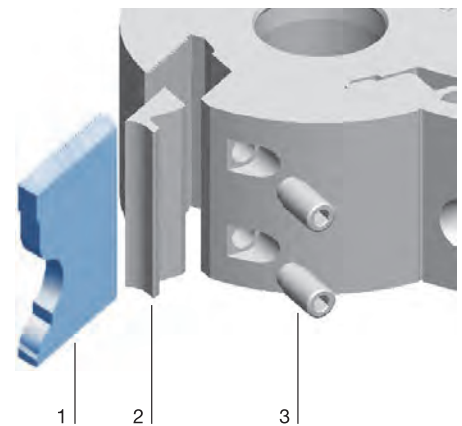
TD	SB	ND	BO	Z	ID
mm	mm	mm	mm		
122	40	40	40	4	135840
122	60	60	40	4	135841
122	80	80	40	4	135842
122	130	130	40	4	135843

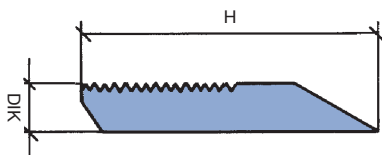
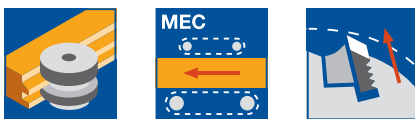
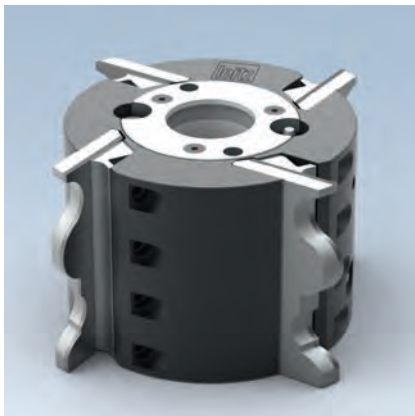
Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.

Lightweight aluminium design on request.

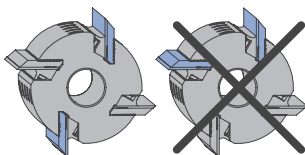
##### Spare parts:

Part-no.	BEZ	ABM mm	for SB mm	ID
2	Clamping wedge	38x25.3x10.8	40	620700 ●
2	Clamping wedge	58x25.3x10.8	60	620701 ●
2	Clamping wedge	78x25.3x10.8	80	620702 ●
2	Clamping wedge	98x25.3x10.8	100	620703 ●
2	Clamping wedge	128x25.3x10.8	130	620705 ●
2	Clamping wedge	148x25.3x10.8	150	620706 ●
2	Clamping wedge	168x25.3x10.8	170	620707 □
2	Clamping wedge	178x25.3x10.8	180	620708 □
2	Clamping wedge	228x25.43x11	230	620709 □
2	Clamping wedge	238x25.3x10.8	240	620710 □
3	Allen screw	M10x1x20		007396 ●
	Filler piece	40x30x8	40	005305 ●
	Filler piece	60x30x8	60	005306 ●
	Filler piece	80x30x8	80	005307 ●
	Filler piece	100x30x8	100	005308 ●
	Filler piece	130x30x8	130	005310 ●
	Filler piece	150x30x8	150	005311 ●
	Filler piece	170x30x8	170	620770 ●
	Filler piece	180x30x8	180	005312 ●
	Filler piece	230x30x8	230	005313 ●
	Filler piece	240x30x8	240	620771 ●
	Allen key	SW 5		117509 ●





Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



#### Attention:

For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

H	QAL	PT
mm		mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18

Table to determine maximum profile depth. The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.

### Hydro profile cutterhead for serrated back blank knives

#### Application:

Cutting of multi-purpose profiles with high feed speeds.

#### Machine:

Four-sided moulders and profile machines.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Profile cutterhead with 60°-serration, 1.6 mm pitch. Steel tool body with corrosion resistant surface protection. For blank knives with 8 - 10 mm knife thickness and 5 mm (see table) and 40 - 70 mm knife height, depending on the required profile depth. Integrated hydro clamping system with exchangeable clamping sleeves. Activated by a grease gun. Hydro profile cutterheads can only be used in combination with a clamping collar.

#### Steel tool body

HM 501 2 05

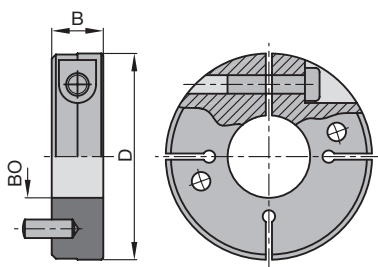
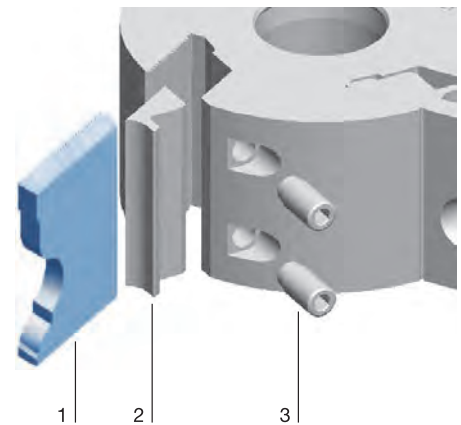
TD	SB	BO	for knife thickness	Z	$n_{\max}$	ID
mm	mm	mm	mm		min <sup>-1</sup>	
135	100	40	8 - 10	4	9400	137035
135	150	40	8 - 10	4	9400	137036
145	60	50	8 - 10	6	9100	137037
145	100	50	8 - 10	6	9100	137038
150	60	50	8 - 10	4	8800	137039 ●
150	100	50	8 - 10	4	8800	137040 ●
150	150	50	8 - 10	4	8800	137041 ●
150	230	50	8 - 10	4	8800	137042 ●
150	60	50	8 - 10	6	8800	137043 ●
150	100	50	8 - 10	6	8800	137044 ●
150	150	50	8 - 10	6	8800	137045 ●
150	230	50	8 - 10	6	8800	137046
165	60	50	8 - 10	8	8200	137047
165	100	50	8 - 10	8	8200	137048
170	60	50	8 - 10	8	8100	137049 ●
170	100	50	8 - 10	8	8100	137050
170	150	50	8 - 10	8	8100	137051 ●
190	60	50	5	12	7400	137052
190	60	50	5	14	7400	137053

Cutterhead without knives. Blanks in various dimensions and qualities see section Knives and Spare Parts.



##### Spare parts:

Part-no.	BEZ	ABM mm	for SB mm	ID
2	Clamping wedge	38x25.3x10.8	40	620700 ●
2	Clamping wedge	58x25.3x10.8	60	620701 ●
2	Clamping wedge	78x25.3x10.8	80	620702 ●
2	Clamping wedge	98x25.3x10.8	100	620703 ●
2	Clamping wedge	128x25.3x10.8	130	620705 ●
2	Clamping wedge	148x25.3x10.8	150	620706 ●
2	Clamping wedge	168x25.3x10.8	170	620707 □
2	Clamping wedge	178x25.3x10.8	180	620708 □
2	Clamping wedge	228x25.43x11	230	620709 □
2	Clamping wedge	238x25.3x10.8	240	620710 □
3	Allen screw	M10x1x20		007396 ●
	Filler piece	40x30x8	40	005305 ●
	Filler piece	60x30x8	60	005306 ●
	Filler piece	80x30x8	80	005307 ●
	Filler piece	100x30x8	100	005308 ●
	Filler piece	130x30x8	130	005310 ●
	Filler piece	150x30x8	150	005311 ●
	Filler piece	170x30x8	170	620770 ●
	Filler piece	180x30x8	180	005312 ●
	Filler piece	230x30x8	230	005313 ●
	Filler piece	240x30x8	240	620771 ●
	Allen key	SW 5		117509 ●



Clamping collar without thread

##### Clamping collars without thread

TD 870 0

D mm	B mm	BO mm	ID
100	25	40	030700 ●
100	25	50	030702 ●



#### Profile cutterhead with HSK 85 WS for serrated back blank knives

##### Application:

For multi-purpose profiles in hard and/or materials likely to splinter.

##### Machine:

Four-sided moulders with HSK 85 WS interface.

##### Workpiece material:

Cutting angle 20° for softwood and hardwood in general.

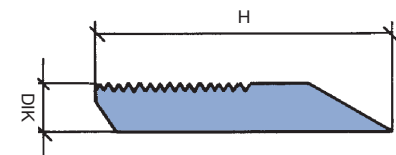
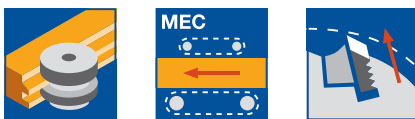
Cutting angle 12° for materials likely to splinter e.g. oak, Douglas fir, merbau and wood fibre materials, e.g. MDF.

##### Technical information:

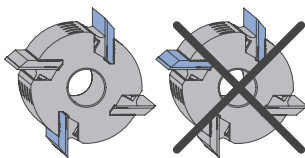
Profile cutterhead with back serration, 1.6 mm pitch, with integrated HSK.

Blanks with knife thickness 8 - 10 mm and knife heights of 40 - 70 mm can be used depending on the required profile depth. Cutting materials: Marathon (MC) and HW.

Steel tool body. High balance quality by assembly with parts of the same weight.



Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



##### Attention:

For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

##### Cutting angle 20°

WP 510 2 02

TD mm	SB mm	A mm	Z	$n_{\max}$ min <sup>-1</sup>	ID LH / bottom	ID RH / top
90	40	26	2	12000	136200	136201
90	60	26	2	12000	136202 ●	136203 ●
90	80	26	2	12000	136204 ●	136205 ●
90	100	26	2	12000	136206 ●	136207 ●
90	130	26	2	12000	136208 ●	136209 ●
90	150	26	2	12000	136210	136211
* 90	170	26	2	12000	136212 ●	136213 ●
* 90	210	26	2	12000	136216	136217
* 90	240	26	2	12000	136218 ●	136219 ●
90	270	26	2	8000	136220	136221
90	40	26	4	12000	136224 ●	136225 ●
90	60	26	4	12000	136226 ●	136227 ●
90	80	26	4	12000	136228 ●	136229 ●
90	100	26	4	12000	136230 ●	136231 ●
90	130	26	4	12000	136232 ●	136233 ●
90	150	26	4	12000	136234	136235
* 90	170	26	4	12000	136236 ●	136237 ●
* 90	210	26	4	12000	136240	136241
* 90	240	26	4	12000	136242 ●	136243 ●
* 90	270	26	4	8000	136244	136245
115	80	26	6	10000	136198 ●	136199 ●
115	130	26	6	10000	136400 ●	136401 ●
115	170	26	6	10000	136402 ●	136403 ●
115	240	26	6	8000	136404 ●	136405 ●

\* = Not for PKS blank knives H = 70 mm with  $n = 12,000 \text{ min}^{-1}$

Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.

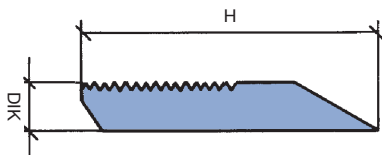
H mm	QAL	PT mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18

Table to determine maximum profile depth. The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.

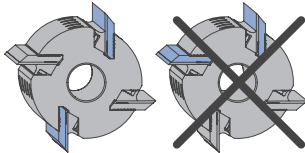
### 3. Planing and profiling

### 3.3 Profiling

#### 3.3.3 Cutterheads for multi-purpose profiling



Serrated back blank knives with high precision serration, serration angle 60°, pitch 1.6 mm.



#### Attention:

For safety reasons, always mount knives + backing plates (VE) of the same weight opposite to each other.

H mm	QAL	PT mm
50	MC	15
60	MC	20
70	MC	30
50	HW	10
60	HW	18

Table to determine maximum profile depth. The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.

#### Cutting angle 12°

WP 510 2 02

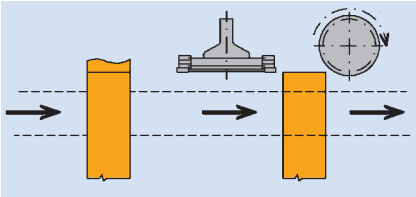
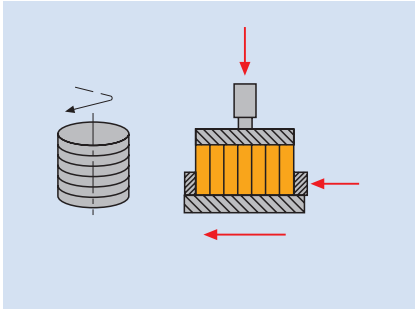
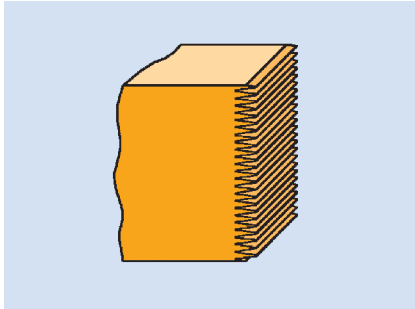
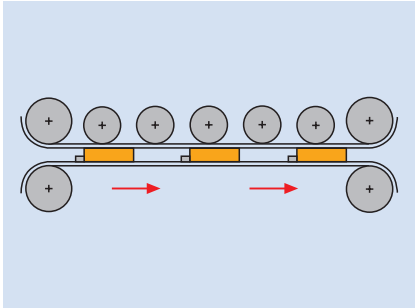
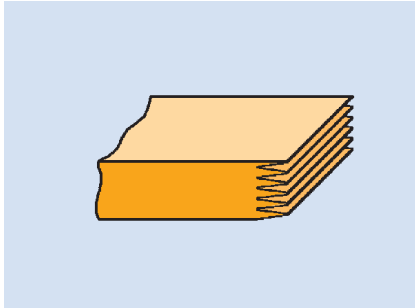
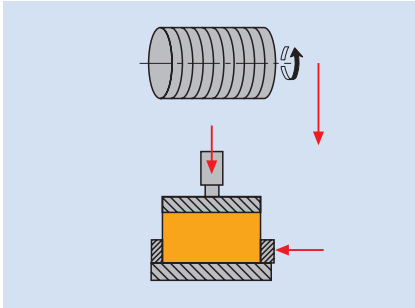
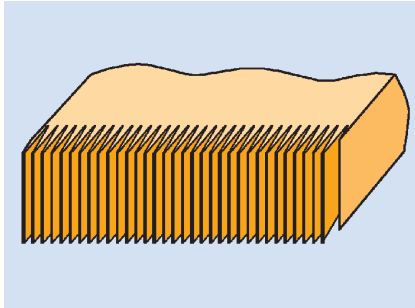
TD mm	SB mm	A mm	Z	n <sub>max</sub> min <sup>-1</sup>	ID LH / bottom	ID RH / top
90	40	26	2	12000	136248 ●	136249 ●
90	60	26	2	12000	136250 ●	136251 ●
90	80	26	2	12000	136252	136253
90	100	26	2	12000	136254 ●	136255 ●
90	130	26	2	12000	136256 ●	136257 ●
90	150	26	2	12000	136258	136259
*	90	170	2	12000	136260	136261
*	90	210	2	12000	136264	136265
*	90	240	2	12000	136266	136267
90	40	26	4	12000	136270 ●	136271 ●
90	60	26	4	12000	136272 ●	136273 ●
90	80	26	4	12000	136274 ●	136275 ●
90	100	26	4	12000	136276 ●	136277 ●
90	130	26	4	12000	136278	136279
90	150	26	4	12000	136280	136281
*	90	170	4	12000	136282	136283
115	80	26	6	10000	136192	136193
115	130	26	6	10000	136194	136195
115	170	26	6	10000	136196	136197

\* = Not for PKS blank knives H = 70 mm with n = 12,000 min<sup>-1</sup>

Cutterhead without knives. For blank knives in different dimensions and qualities, see section Knives and Spare Parts.

#### Spare parts:

BEZ	for knife thickness mm	for SB mm	ID
Clamping wedge	8/10	40	620816 ●
Clamping wedge	8/10	60	620817 ●
Clamping wedge	8/10	80	620818 ●
Clamping wedge	8/10	100	620819 ●
Clamping wedge	8/10	130	620820 ●
Clamping wedge	8/10	150	620821 ●
Clamping wedge	8/10	170	620822 ●
Clamping wedge	8/10	190	620823 ●
Clamping wedge	8/10	210	620824 ●
Clamping wedge	8/10	240	620825 ●
Clamping wedge	8/10	270	620826 ●
Clamping wedge	8/10	310	620827 ●
Allen screw			007396 ●
Filler piece		40	005305 ●
Filler piece		60	005306 ●
Filler piece		80	005307 ●
Filler piece		100	005308 ●
Filler piece		130	005310 ●
Filler piece		150	005311 ●
Filler piece		170	620770 ●
Filler piece		190	620772 ●
Filler piece		210	620773 ●
Filler piece		240	620771 ●
Filler piece		270	620774 ●
Filler piece		310	620775 ●
Dust protection cover			008244 ●
Allen key			117509 ●

<b>Process step</b>	Cutting high-strength finger joint profiles for longitudinal jointing of workpieces. The finger profiles meet the requirements of the testing institutes.
<b>Machines</b>	Single and double side finger jointing machines with and without cut-off saw or scoring saws, double-end tenoners, compact finger joint lines, cross profile and standard machines.
<b>Tools</b>	For finger joint machines without cut-off saw: Use minifinger tools with the following finger lengths: 10/10, 15/15 or 20/20 mm. For finger joint machines with cut-off saw: Use minifinger tools with the following finger lengths: 10/11, 15/16.5 or 20/22 mm.
 <p>Minifinger jointing machine with cut-off.</p>	
 <p>Vertical finger jointing machine/stack machine.</p>	
 <p>Vertical finger jointing.</p>	
 <p>Horizontal finger jointing line.</p>	
 <p>Horizontal finger jointing.</p>	
 <p>Compact finger jointing line.</p>	
 <p>Compact finger jointing. Vertical finger jointing with horizontal spindle.</p>	
<b>Feed rate</b>	Depending on the spindle RPM, no. of wings, workpiece material and condition of the minifinger tooling cutting edges.
<b>Workpiece materials</b>	Coniferous wood and hardwood, softwood and hardwood, Exotic wood, glulam (limited).

#### Recommended cutting material

	HS	Marathon (MC)	HW
Coniferous wood soft	◆	◆	◇
Coniferous wood hard		◆	◆
Deciduous wood soft		◆	◆
Deciduous wood hard		◇	◆
Exotic wood		◇	◆
Glulam			◇

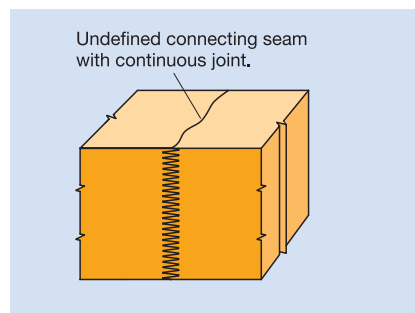
◆ suitable

◇ partly suitable

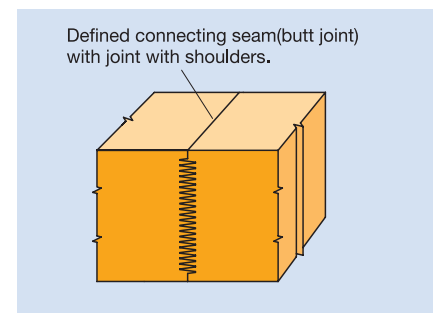
#### Joint types

#### Shoulder variations

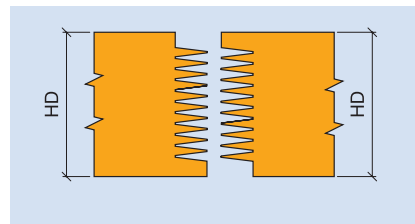
Strips with continuous joint present an irregular glue line on the side of the profile. To give a straight line (seam), the fingers are profiled with shoulder cutters. The number of fingers is determined by the wood thickness and the shoulder width.



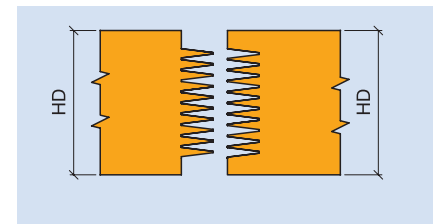
Continuous joint.



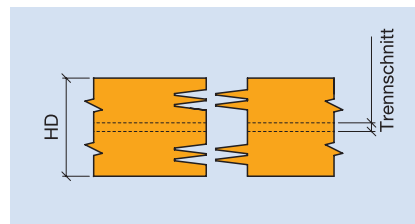
Joint with shoulders.



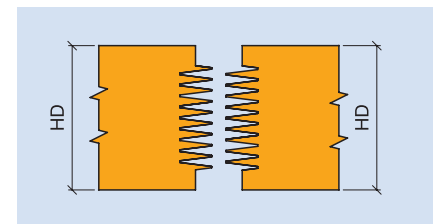
Profile 2: Staggered shoulders.



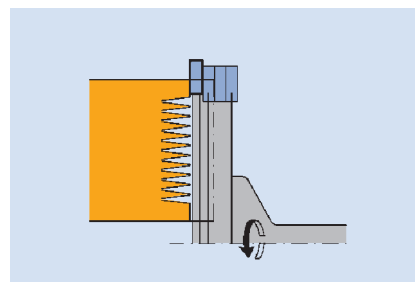
Profile 3: Level shoulders.



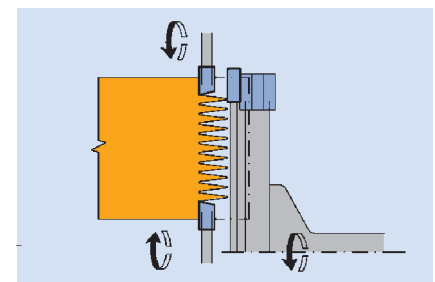
Profile 4: Shoulders for splitting.



Profile 5: Shoulder centralised.



Hogger for trimming minifingers.



Hogger and scoring saw for trimming minifingers and scoring the butt joint.

The requirements for finger joints are defined in the standards DIN 68140 and EN 385 and EN 387.

Load group I (load-bearing components):

Multi-purpose finger joints for laminated panels BSH.

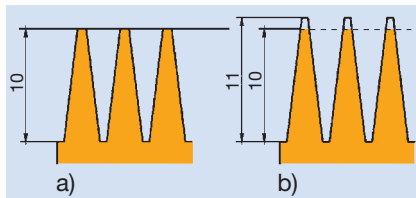
The components should be calculated according to DIN 1052.  $v \leq 0.18$ .

Load group II:

Multi-purpose finger joints for construction timber (KVH).

Finger joints with shoulders also fall into this group.  $v \leq 0.25$ .

#### Finger profiles



Minifinger profile

a – without cut-off, b – with cut-off

Finger length l mm	Finger pitch t mm	Width of finger tip b mm	Weakening degree v	Relative tip play s mm
10	3,8	0,60	0,16	0,30 – 0,50
15	3,8	0,42	0,11	0,45 – 0,75
20	5,0	0,50	0,10	0,60 – 1,00
20	6,2	1,00	0,16	0,60 – 1,00
30	6,2	0,60	0,10	0,90 – 1,50
50	12,0	2,00	0,17	1,50 – 2,50

#### Finger length 4 mm

Finger pitch 1.6 mm

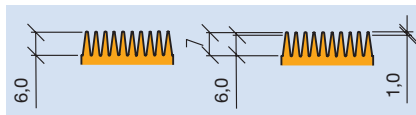
Production of mouldings, glued panels in furniture, mitre joints for windows/doors, picture frames.

#### Finger length 6/7 mm

Finger pitch 2.8 mm

Wood finishing and residual wood for precise construction parts e.g. special window blanks, frieze strips, glued wood panels in furniture.

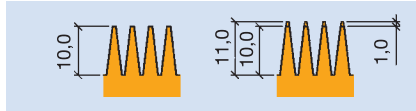
Reduced finger length to save wood. Tightly sealed finger profile feasible through the length determination of the fingers.



#### Finger length 10 mm

Finger pitch 3.8 mm

Wood finishing and wood residue recycling, lamellas for window blanks and glued panels in furniture. Finger length 10 mm to DIN 68140 (EN 385 and EN 387) for finger joints in coniferous wood for load bearing components. Finger joints present a visible tip play (S) after pressing.

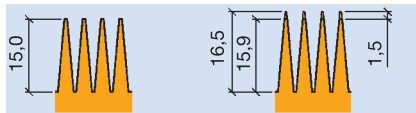


#### Finger length 15 mm

Finger pitch 3.8 mm

Wood finishing for BSH (laminated wood) and KVH (construction timber).

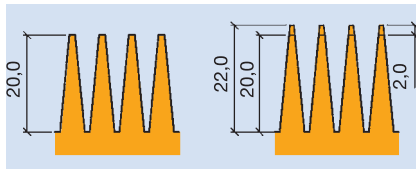
Finger joints in coniferous wood for high strength, load bearing components to DIN 68140 (EN 385 and EN 387), e.g. lamellas for laminated wood. These finger joints present a visible tip play (S) after pressing.



#### Finger length 20 mm

Finger pitch 6.2 mm

Wood finishing for laminated wood, mainly for construction timber, duo, trio and cross beams to DIN 68140, (EN 385 and EN 387) for finger joints in coniferous wood for high strength, load bearing components, e.g. lamellas for laminated wood. These finger joint present a visible tip play (S) after pressing. Because of the greater pitch the finger seam is more visible and stability lower.

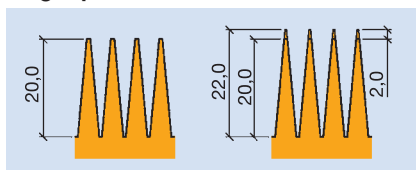


#### Finger length 20 mm

Finger pitch 5.0 mm

Wood finishing for laminated wood and KVH construction timber to DIN 68140 (EN 385 and 387) for finger joints in coniferous wood for high strength, load bearing components, e.g. lamellas for laminated wood, KVH, formwork beams. These finger joints show a visible gap after pressing.

Finger profile with higher stability than the fingers with 6.2 mm pitch. Advantage compared to ZL 15 mm: Because of greater pitch, the wood finger is more stable and easier to join together.



## Enquiry - Checklist for minifinger tools



**Customer details:** Customer number  
(if known)

--	--	--	--	--	--	--	--

☐ Enquiry  
☐ Order

Delivery date: (not binding)

--	--

KW

Company:

Street:

Date:

Post code/place:

Enquiry/order no.:

Country:

Tool Id: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

### Application:

- ☐ Vertical finger jointing  
☐ Horizontal finger jointing  
☐ Load bearing components  
☐ Not load bearing components

### Workpiece material:

Profile:

Wood thickness (mm):

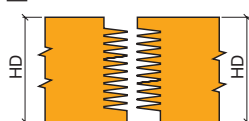
Finger length (mm):

Finger pitch:

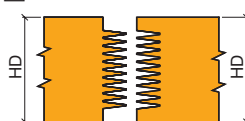
- ☐ With basic clearance  
☐ Tightly fitting profile (only for not load bearing components)  
☐ Continuous joint

With shoulder cutters

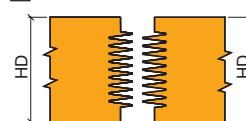
☐ Profile 2



☐ Profile 3



☐ Profile 5



### Machine:

Producer:

Type:

- ☐ One sided machine  
☐ Horizontal spindle  
☐ Continuous machine  
☐ Machine cutting in stacks  
 Table width (mm):  
☐ Feed speed
- ☐ Double sided machine  
☐ Vertical spindle  
 \_\_\_\_\_ parts/min  
 \_\_\_\_\_ tables/min  
 \_\_\_\_\_ mm  
 \_\_\_\_\_ m/min

### Tool:

	Cutter spindle	Cut-off device	Scorer on top	Scorer on bottom
RPM (min <sup>-1</sup> ):	_____	<input type="checkbox"/>	<input type="checkbox"/>	<input type="checkbox"/>
Power (KW):	_____	_____	_____	_____
Tool diam.(mm):	_____	_____	_____	_____
Spindle diam.:	_____	_____	_____	_____
Spindle length (mm):	_____	_____	_____	_____
Hydro clamping:	<input type="checkbox"/>	_____	_____	_____
Mounted on sleeve:	<input type="checkbox"/>	_____	_____	_____
Flange diameter:	_____	_____	_____	_____
Number of teeth:	_____	_____	_____	_____

### Adhesive:

Producer:

Type:

- ☐ Water-bases adhesive  
☐ PU with fibre  
☐ PU pure



### 3. Planing and profiling

### 3.4 Finger jointing

#### 3.4.1 Minifinger joint cutters

##### WF 620 2/WF 620 2 06 Minifinger joint cutter



Minifinger joint cutters with straight cut, straight back relief, staggered profile teeth, secured against twisting by design of tool body. Solid and robust cutter design with individually embedded tips.

Table for allowed RPM  $n = \text{min}^{-1}$  in relation to finger length ZL and diameter D.  
Zero-diameter  $D_0$  in relation to finger length for adjustment of the machine spindles.

ZL mm	D mm	$D_0$ mm	$n_{\text{max.}}$ $\text{min}^{-1}$
10	160	140	9,000
6	160	148	9,000
15	170	140	8,500
20	180	140	8,000
10	250	230	6,200
15	260	230	6,000
20	260	220	6,000

##### Application

For self-locking longitudinal joints for all kinds "in load bearing" components and window blanks with continuous finger joint.

##### Cutting material

HS, Marathon (MC) and HW.

##### Resharpener area

12 mm.

##### Feed rate

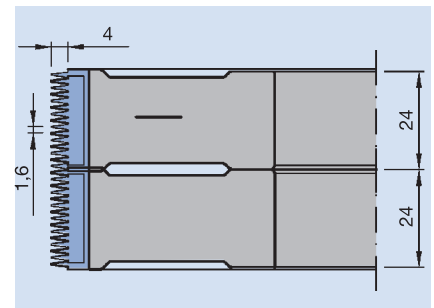
Depending on RPM up to  $24 \text{ m min}^{-1}$ .

##### Minifinger joint cutter pitch 1.6 mm

Standard cutting width  
Minifinger joint cutter WF 620 2  
Finger length = 4 mm  
D = 160 mm  
Finger pitch 1.6 mm

Table to determine the number of cutters for a given wood thickness and cutting width.

SB	25.0 mm
Hub	24.0 mm
No. of fingers	Wing row ZA 15
Wood thickness	No. of cutters
23	1
47	2
71	3
95	4
119	5



### 3. Planing and profiling

#### 3.4 Finger jointing 3.4.1 Minifinger joint cutters

##### Minifinger joint cutter

###### WF 620 2/WF 620 06

Standard minifinger joint cutter  
Finger length 10 mm and 15 mm  
D = 160/250 mm 170/260 mm

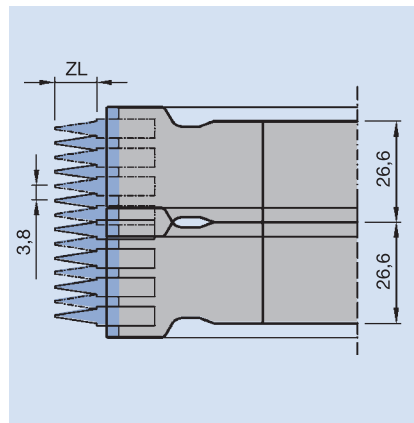
**Finger pitch = 3.8 mm**

##### Minifinger joint cutter

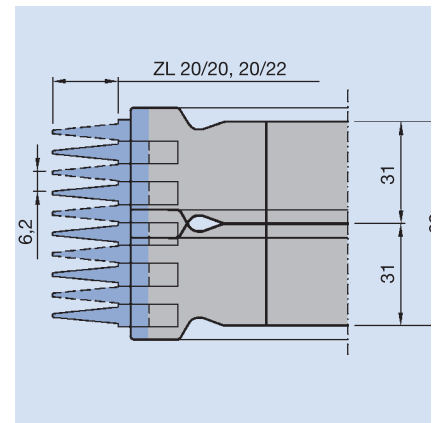
###### WF 620 2/WF 620 06

Standard minifinger joint cutter  
Finger length 20 mm  
D = 180/260 mm

**Finger pitch = 6.2 mm**



Minifinger joint cutter pitch 3.8 mm,  
finger length 10 or 15 mm.



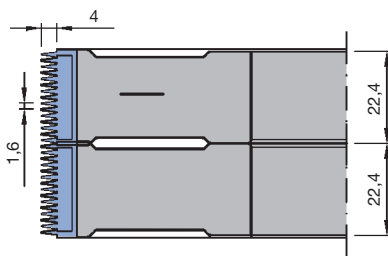
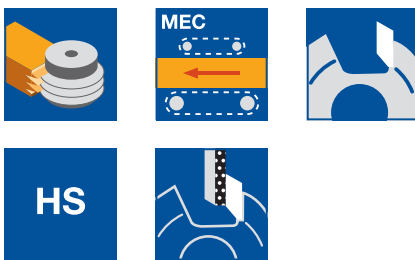
Minifinger joint cutter pitch 6.2 mm.

##### Minifinger joint cutter with pitch of 3.8 mm

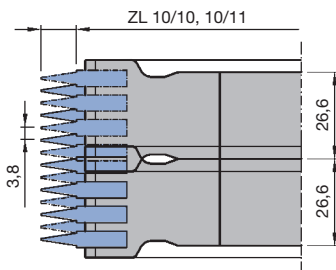
SB	28.6 mm
Hub	26.6 mm
ZA	Tooth row ZA 7
Wood thickness	Number of cutters
24	1
51	2
77	3
104	4
131	5
157	6
184	7
210	8
237	9
264	10
290	11
317	12

##### Minifinger joint cutter with pitch of 6.2 mm

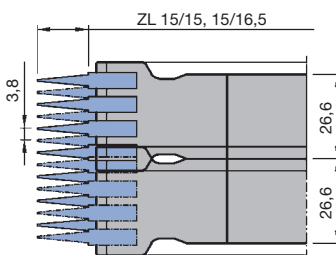
SB	33.0 mm
Hub	31.0 mm
ZA	Tooth row ZA 5
Wood thickness	Number of cutters
28	1
59	2
90	3
121	4
152	5
183	6
214	7
245	8
278	9
397	10
338	11



Minifinger joint cutter ZL 4 mm,  
TG 1.6 mm



Minifinger joint cutter ZL 10 mm,  
TG 3.8 mm



Minifinger joint cutter ZL 15 mm,  
TG 3.8 mm

### Minifinger joint cutter, HS

#### Application:

For self-locking longitudinal joints. See section introduction for additional information.

#### Machine:

Finger joint machines with/without cut-off saw, continuous machines.

#### Workpiece material:

Softwood, across grain; limited suitability for hardwood.

#### Technical information:

Reduced risk of breakage from individually brazed finger cutting edges. Design with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saw and horizontal working spindle. Cutting material HS. Resharpener area 12 mm.

#### ZL 4 mm, TG 1.6 mm

WF 620 2

D	SB	ND	BO	Z	ZA	QAL	ZL	ID
mm	mm	mm	mm		PCS		mm	
160	25	22.4	50	2/2	15	HS	4	021543 ●

#### ZL 10 mm, TG 3.8 mm

WF 620 2

D	SB	ND	BO	Z	ZA	QAL	ID	ID
mm	mm	mm	mm		PCS		ZL	ZL
							10/10	10/11
160	28.6	26.6	50	2/2	7	HS	021685 ●	021689 ●
160	28.6	26.6	50	3/3	7	HS	120313 □	021692 ●
250	28.6	26.6	50	3/3	7	HS	021688 □	021693 ●
250	28.6	26.6	50	4/4	7	HS	120316 □	120318 □

#### ZL 15 mm, TG 3.8 mm

WF 620 2

D	SB	ND	BO	Z	ZA	QAL	ID	ID
mm	mm	mm	mm		PCS		ZL	ZL
							15/15	15/16.5
170	28.6	26.6	50	2/2	7	HS	021694 ●	021696 ●
260	28.6	26.6	50	3/3	7	HS	021695 □	021697 ●
260	28.6	26.6	80	4/4	7	HS	120420	120422

#### ZL 15 mm, TG 3.8 mm, for application with PU glue

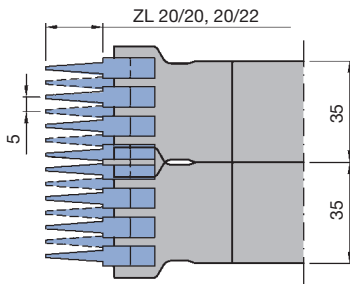
WF 620 2

D	SB	ND	BO	Z	ZA	QAL	ID	ID
mm	mm	mm	mm		PCS		ZL	ZL
							15/15	15/16.5
170	28.6	26.6	50	2/2	7	HS	120412 ●	120414 □
260	28.6	26.6	50	3/3	7	HS	120413 □	120415 □
260	28.6	26.6	80	4/4	7	HS	120421	120423

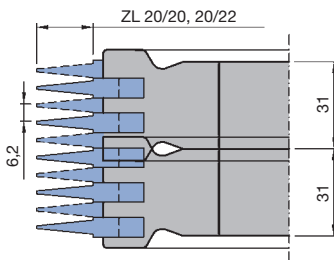
### 3. Planing and profiling

### 3.4 Finger jointing

#### 3.4.1 Minifinger joint cutters



Minifinger joint cutter ZL 20 mm,  
TG 5.0 mm



Minifinger joint cutter ZL 20 mm,  
TG 6.2 mm

#### ZL 20 mm, TG 5.0 mm

WF 620 2

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	37	35	50	2/2	7	HS	<b>021729</b> ●	<b>021730</b> □

#### ZL 20 mm, TG 6.2 mm

WF 620 2

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	33	31	50	2/2	5	HS	<b>021668</b> ●	<b>021669</b> ●
260	33	31	50	3/3	5	HS	<b>021674</b> □	<b>021670</b> □
260	33	31	80	4/4	5	HS	<b>120525</b>	<b>120527</b>

#### ZL 20 mm, TG 6.2 mm, for application with PU glue

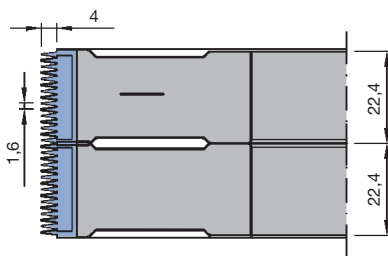
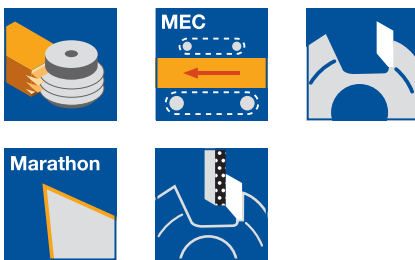
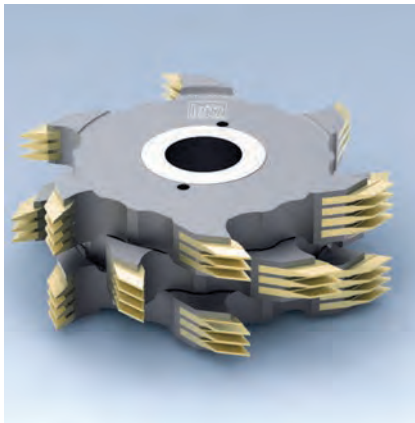
WF 620 2

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	33	31	50	2/2	5	HS	<b>120515</b> ●	<b>120516</b> ●
260	33	31	50	3/3	5	HS	<b>120510</b> □	<b>120511</b> □
260	33	31	80	4/4	5	HS	<b>120524</b>	<b>120526</b>

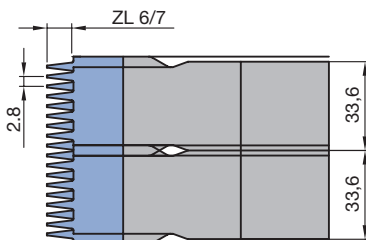
### 3. Planing and profiling

### 3.4 Finger jointing

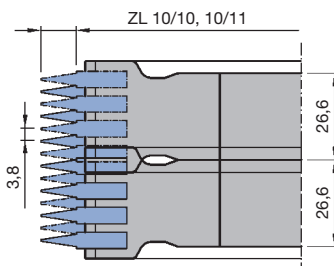
#### 3.4.1 Minifinger joint cutters



Minifinger joint cutter ZL 4 mm,  
TG 1.6 mm



Minifinger joint cutter ZL 6/7 mm,  
TG 2.8 mm



Minifinger joint cutter ZL 10 mm,  
TG 3.8 mm

### Minifinger joint cutter, Marathon

#### Application:

For self-locking longitudinal joints. See section introduction for additional information.

#### Machine:

Finger joint machines with/without cut-off saw, continuous machines.

#### Workpiece material:

Softwood, across grain; also suitable for hardwood.

#### Technical information:

Reduced risk of breakage from individually brazed finger cutting edges. Design with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws and horizontal working spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm (or 6 mm for ID 123005 and 8 mm for ID 123102).

#### ZL 4/5 mm, TG 1.6 mm

WF 620 2 06

D	SB	ND	BO	Z	ZA	QAL	ZL	ID
mm	mm	mm	mm		PCS		mm	
160	25	22.4	50	2/2	15	MC	4/5	123003
250	25	22.4	50	3/3	15	MC	4/5	123004
250	25	22.4	50	6/6	15	MC	4/5	123005 ●

#### ZL 6/7 mm, TG 2.8 mm

WF 620 2 06

D	SB	ND	BO	Z	ZA	QAL	ZL	ID
mm	mm	mm	mm		PCS		mm	
160	34	33.6	50	3/3	12	MC	6/7	123100 ●
250	34	33.6	50	4/4	12	MC	6/7	123101 ●
250	34	33.6	50	6/6	12	MC	6/7	123102 ●

#### ZL 10 mm, TG 3.8 mm

WF 620 2 06

D	SB	ND	BO	Z	ZA	QAL	ID	ID
mm	mm	mm	mm		PCS		ZL	ZL
160	28.6	26.6	50	2/2	7	MC	10/10	10/11
160	28.6	26.6	50	3/3	7	MC	120608 ●	120612 ●
160	28.6	26.6	50	3/3	7	MC	120616 □	120617 □
250	28.6	26.6	50	3/3	7	MC	120609 □	120613 ●
250	28.6	26.6	50	4/4	7	MC	120620 □	120622 □

● available ex stock

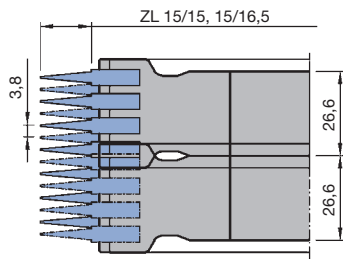
□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)

### 3. Planing and profiling

### 3.4 Finger jointing

#### 3.4.1 Minifinger joint cutters



Minifinger joint cutter ZL 15 mm,  
TG 3.8 mm

#### ZL 15 mm, TG 3.8 mm

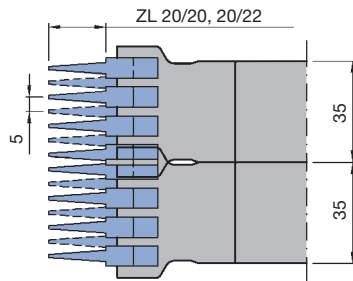
WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
170	28.6	26.6	50	2/2	7	MC	<b>120709</b> ●	<b>120713</b> ●
260	28.6	26.6	50	3/3	7	MC	<b>120710</b> □	<b>120714</b> ●
260	28.6	26.6	80	4/4	7	MC	<b>120721</b>	<b>120723</b>

#### ZL 15 mm, TG 3.8 mm, for application with PU glue

WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
170	28.6	26.6	50	2/2	7	MC	<b>120711</b> ●	<b>120715</b> □
260	28.6	26.6	50	3/3	7	MC	<b>120712</b> □	<b>120716</b> □
260	28.6	26.6	80	4/4	7	MC	<b>120722</b>	<b>120724</b>



Minifinger joint cutter ZL 20 mm,  
TG 5.0 mm

#### ZL 20 mm, TG 5.0 mm

WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	37	35	50	2/2	7	MC	<b>120818</b> □	<b>120820</b> □
260	37	35	50	3/3	7	MC	<b>120819</b> □	<b>120821</b> □

#### ZL 20 mm, TG 6.2 mm

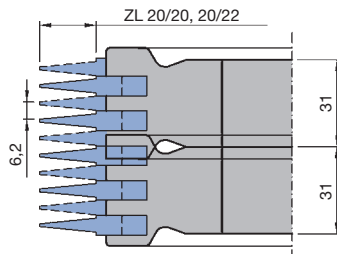
WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	33	31	50	2/2	5	MC	<b>120810</b> ●	<b>120814</b> □
260	33	31	50	3/3	5	MC	<b>120811</b> □	<b>120815</b> □
260	33	31	80	4/4	5	MC	<b>120834</b>	<b>120836</b>

#### ZL 20 mm, TG 6.2 mm, for application with PU glue

WF 620 2 06

D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
180	33	31	50	2/2	5	MC	<b>120812</b> ●	<b>120816</b> □
260	33	31	50	3/3	5	MC	<b>120813</b> □	<b>120817</b> □
260	33	31	80	4/4	5	MC	<b>120835</b>	<b>120837</b>



Minifinger joint cutter ZL 20 mm,  
TG 6.2 mm

### 3. Planing and profiling

#### 3.4 Finger jointing 3.4.1 Minifinger joint cutters



#### Minifinger joint cutter, HW

##### Application:

For self-locking longitudinal joints. See section introduction for additional information.

##### Machine:

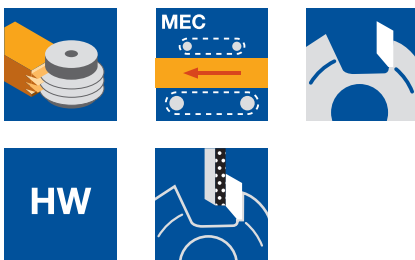
Finger joint machines with/without cut-off saws, continuous machines.

##### Workpiece material:

Hardwood, across grain.

##### Technical information:

Reduced risk of breakage from individually brazed finger cutting edges. Cutting material HW. Resharpener area 12 mm.



##### ZL 10 mm, TG 3.8 mm

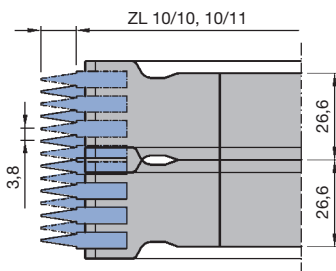
WF 620 2

D mm	SB mm	BO mm	Z	ZA PCS	QAL	n <sub>max</sub> min <sup>-1</sup>	ID ZL 10/10	ID ZL 10/11
160	28.6	50	2/2	7	HW	8000	021600 ●	021601 ●
160	28.6	50	3/3	7	HW	8000	021604 □	021603 ●
250	28.6	50	3/3	7	HW	6000	021605 □	021602 ●

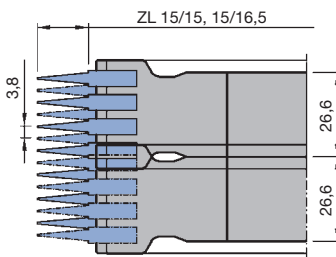
##### ZL 15 mm, TG 3.8 mm

WF 620 2

D mm	SB mm	BO mm	Z	ZA STK	QAL	n <sub>max</sub> min <sup>-1</sup>	ID ZL 15/15	ID ZL 15/16,5
170	28,6	50	2/2	7	HW	8.000	021644	021645 ●
260	28,6	50	3/3	7	HW	6.000	021652	021648



Minifinger joint cutter ZL 10 mm,  
TG 3.8 mm



Minifinger joint cutter ZL 15 mm,  
TG 3.8 mm

Table to determine the number of cutters  
for a given wood thickness.

Finger length 10 and 15 mm;

D = 160/250 mm and 170/260 mm

Finger pitch = 3.8 mm

SB	28.6 mm
Hub	26.6 mm
ZA	Tooth row ZA 7
Wood thickness	Quantity cutter
24	1
51	2
77	3
104	4
131	5
157	6
184	7
210	8
237	9
264	10
290	11
317	12

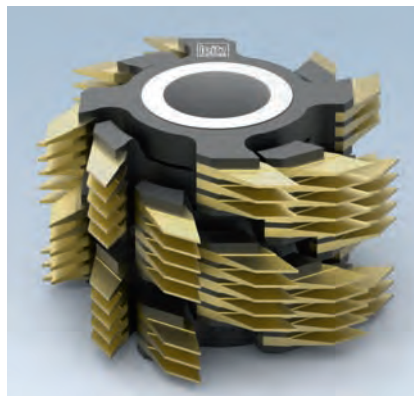
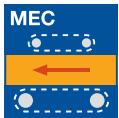


### 3. Planing and profiling

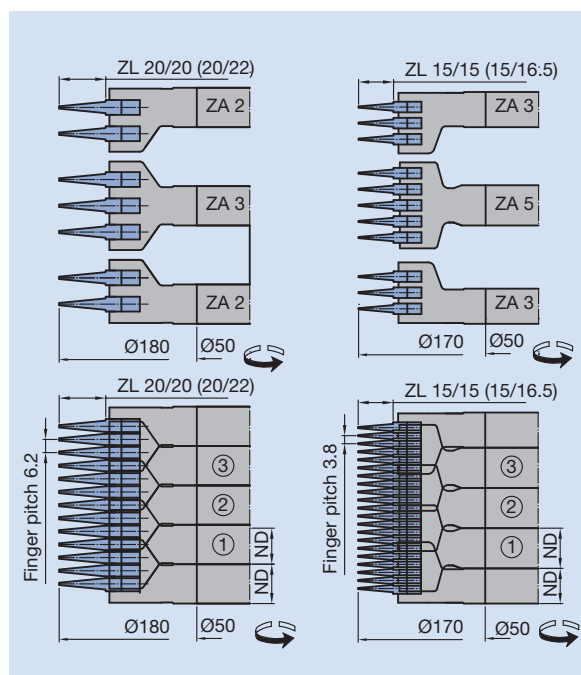
#### 3.4 Finger jointing

##### 3.4.2 High performance minifinger cutters

High performance minifinger joint cutters, real Z 4



<b>Application</b>	For self-locking finger joints for supporting and load bearing components on high performance finger joint machines.
<b>Machines</b>	High performance finger joint machines with/without cut-off saw.
<b>Workpiece material</b>	Solid woods across grain.
<b>Number of wings</b>	Real Z 4.
<b>Cutting material</b>	HS and Marathon (MC).
<b>Tool design</b>	Solid steel tool body design with individually brazed finger knives. Higher number of wings for higher feed speeds and improved joint cut quality.
<b>Feed</b>	MEC.
<b>Resharpener area</b>	12 mm.
<b>Particular benefit</b>	A tool set, comprising of basic, top and bottom cutters for the required working width/height. The spiral knife arrangement reduces the power consumption and noise.



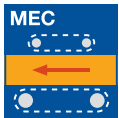
Minifinger joint cutter combinations with the finger lengths 10, 15 and 20 mm.

### 3. Planing and profiling

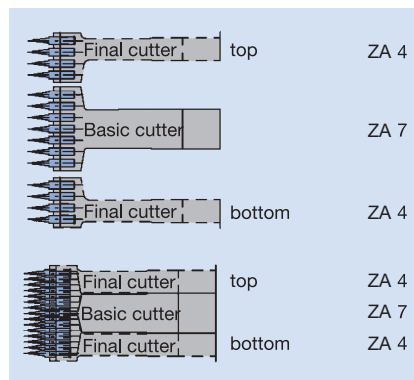
#### 3.4 Finger jointing

##### 3.4.2 High performance minifinger cutters

High performance minifinger joint cutters, real Z 6



<b>Application</b>	For self-locking finger joints for supporting and load bearing components for high performance finger joint machines.
<b>Machines</b>	High performance finger joint machines with/without cut-off saw.
<b>Workpiece material</b>	Solid woods across grain.
<b>Number of wings</b>	Real Z 6, for ZL 10 mm D = 250.
<b>Cutting material</b>	HS and Marathon (MC).
<b>Tool design</b>	Solid steel tool body with individually brazed finger knives. High number of wings for higher feed speeds and improved joint cut quality.
<b>RPM</b>	$n_{\max} = 6,000 \text{ min}^{-1}$ .
<b>Feed</b>	MEC.
<b>Resharpener area</b>	12 mm.
<b>Particular benefit</b>	A tool set, comprising basic, top and bottom cutters for the required working width/height. The spiral knife arrangement reduces the power consumption and noise.



Combination for high performance minifinger joint cutter set Z 6.

### 3. Planing and profiling

#### 3.4 Finger jointing

##### 3.4.2 High performance minifinger cutters

Table to determining the number of minifinger joint cutters with finger pitch of 3.8 mm.

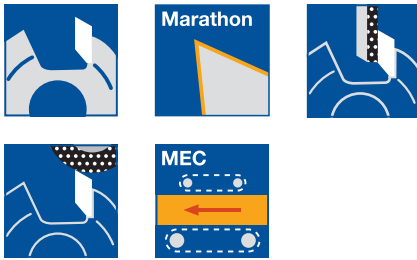
Finger length 10 and 15 mm Real Z6			TG 3.8 mm	
		Basic cutter	Final cutter top	Final cutter bottom
Tooth row	ZA	7	4	4
Hub thickness	ND	26.6 mm	19 mm	19 mm
Wood thickness	Clamping height	Number of cutters	Number of cutters	Number of cutters
HD	KLH			
27	38	0	1	1
53	64.6	1	1	1
80	91.2	2	1	1
106	117.8	3	1	1
133	144.4	4	1	1
160	171	5	1	1
186	197.6	6	1	1
213	224.2	7	1	1
239	250.8	8	1	1
266	277.4	9	1	1
293	304	10	1	1

### 3. Planing and profiling

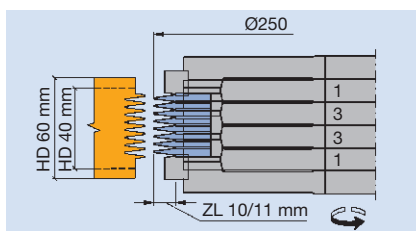
### 3.4 Finger jointing

#### 3.4.2 High performance minifinger cutters

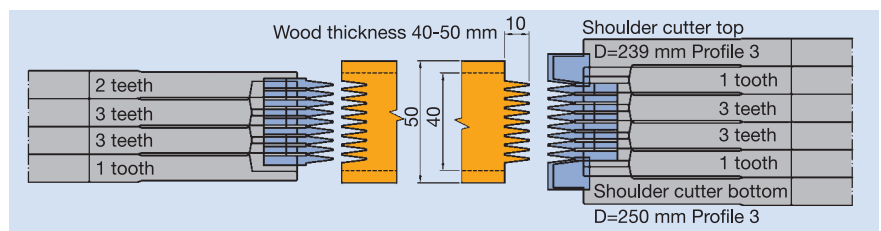
High performance minifinger joint cutters, real Z 6



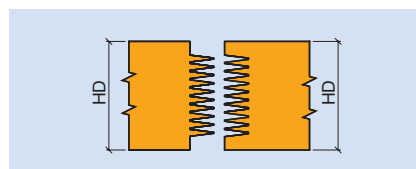
<b>Application</b>	For self-locking finger joints for load bearing components with shoulder cuts for high performance finger joint machines.
<b>Machines</b>	High performance finger joint machines with cut-off saw.
<b>Workpiece material</b>	Solid woods across grain.
<b>Number of wings</b>	Real Z 6 for D = 260 mm.
<b>Cutting material</b>	HS and Marathon (MC).
<b>Tool design</b>	Solid steel tool body with individually brazed finger cutters. High number of wings for higher feed speeds and improved joint cut quality.
<b>RPM</b>	$n_{\max} = 6,000 \text{ min}^{-1}$ .
<b>Feed</b>	MEC.
<b>Resharpener area</b>	12 mm.
<b>Particular benefit</b>	A tool set, comprising of basic, top and bottom shoulder cutters and shoulder cut for the required working width/height. The spiral arranged wings reduces the power consumption and noise.



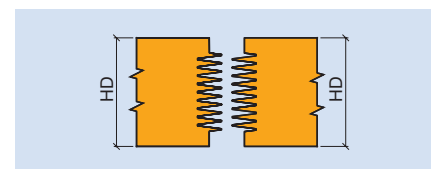
Minifinger joint cutter set real Z 6.  
Shoulder cutters central, profile 5.



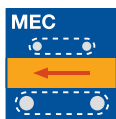
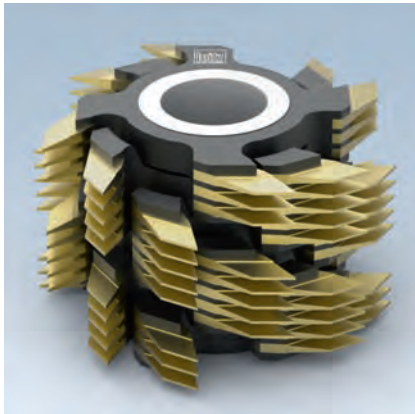
Minifinger joint cutter set real Z 6, shoulder cutters in gap.



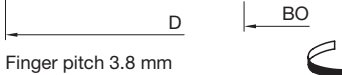
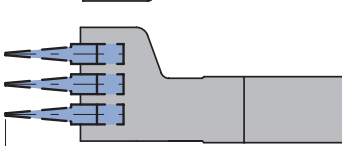
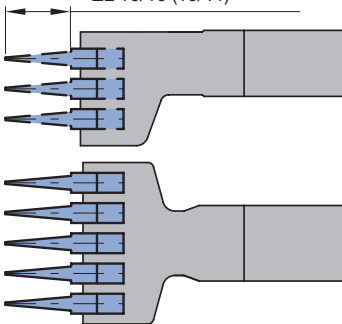
Profile 3



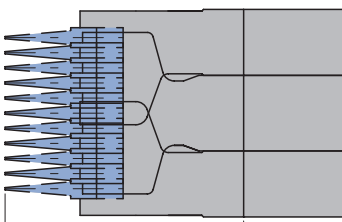
Profile 5



ZL 15/15 (15/16,5)  
ZL 10/10 (10/11)



Finger pitch 3.8 mm



Finger pitch 3.8 mm

#### Minifinger joint cutter, Marathon, real Z 4

##### Application:

For self-locking longitudinal joints. See section introduction for additional information.

##### Machine:

High performance finger joint machines with/without cut-off saws.

##### Workpiece material:

Softwood, across grain; also suitable for hardwood.

##### Technical information:

High number of teeth tool design, top and bottom final cutters required. Assembly of tool set: see section introduction. Version with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws for horizontal spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm.

##### ZL 15 mm, TG 3.8 mm

WF 620 2 06, WF 623 2 06

Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
Top final cutter	170	20.2	16.6	50	4	3	MC	<b>121700</b> □	<b>121704</b> □
Basic cutter	170	35.4	19.0	50	4	5	MC	<b>120705</b> □	<b>120707</b> □
Bottom final cutter	170	20.2	16.6	50	4	3	MC	<b>121701</b> □	<b>121705</b> □

##### ZL 15 mm, TG 3.8 mm, for application with PU glue

WF 620 2 06, WF 623 2 06

Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 15/15	ID ZL 15/16.5
Top final cutter	170	20.2	16.6	50	4	3	MC	<b>121702</b> ●	<b>121706</b> □
Basic cutter	170	35.4	19.0	50	4	5	MC	<b>120706</b> ●	<b>120708</b> □
Bottom final cutter	170	20.2	16.6	50	4	3	MC	<b>121703</b> ●	<b>121707</b> □
Top final cutter	200	20.2	16.6	70	4	3	MC	<b>121708</b>	<b>121710</b>
Basic cutter	200	35.4	19	70	4	5	MC	<b>120725</b>	<b>120726</b>
Bottom final cutter	200	20.2	16.6	70	4	3	MC	<b>121709</b>	<b>121711</b>

##### Finger length 10 and 15 mm

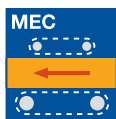
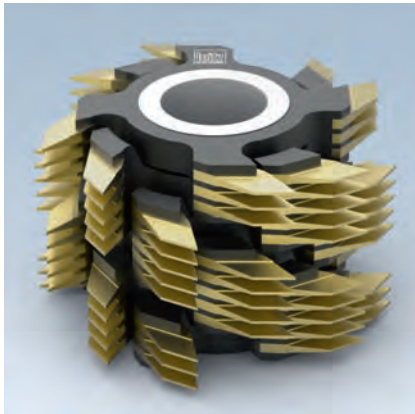
TG: 3,8 mm

Real Z4

		Basic cutter	Final cutter top	Final cutter bottom
ZA		5	3	3
ND		19	16,6	16,6
HD	KLH	Cutter quantity	Cutter quantity	Cutter quantity
19	33,2	0	1	1
38	52,2	1	1	1
57	71,2	2	1	1
76	90,2	3	1	1
95	109,2	4	1	1
114	128,2	5	1	1
133	147,2	6	1	1
152	166,2	7	1	1
171	185,2	8	1	1
190	204,2	9	1	1
209	223,2	10	1	1
228	242,2	11	1	1
247	261,2	12	1	1
266	280,2	13	1	1
285	299,2	14	1	1
304	318,2	15	1	1
323	337,2	16	1	1

HD = wood thickness

KLH = clamping height



#### Minifinger joint cutter, Marathon, real Z 4

##### Application:

For self-locking longitudinal joints. See section introduction for additional information.

##### Machine:

High performance finger joint machines with/without cut-off saws.

##### Workpiece material:

Softwood, across grain; also suitable for hardwood.

##### Technical information:

High number of teeth tool design, top and bottom final cutters required. Assembly of tool set: see section introduction. Version with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws for horizontal spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm.

##### ZL 20 mm, TG 6.2 mm

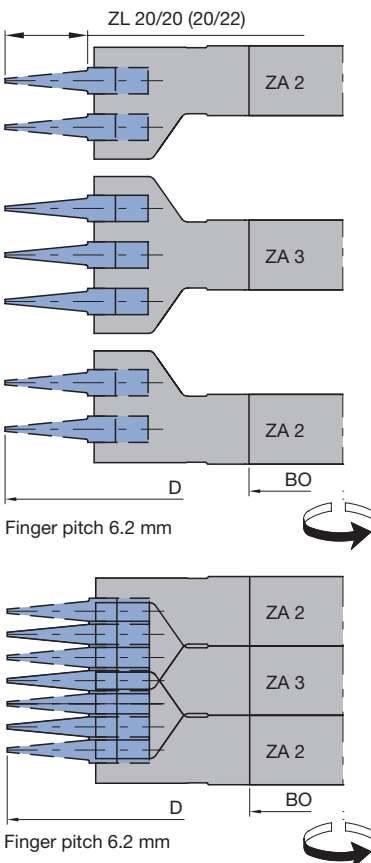
WF 623 2 06

Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
Top final cutter	180	18.6	18.6	50	4	2	MC	<b>121808</b>	<b>121810</b>
Basic cutter	180	31	18.6	50	4	3	MC	<b>120838</b>	<b>120840</b>
Bottom final cutter	180	18.6	18.6	50	4	2	MC	<b>121812</b>	<b>121814</b>

##### ZL 20 mm, TG 6.2 mm, for application with PU glue

WF 623 2 06

Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	ID ZL 20/20	ID ZL 20/22
Top final cutter	180	18.6	18.6	50	4	2	MC	<b>121809</b>	<b>121811</b>
Basic cutter	180	31	18.6	50	4	3	MC	<b>120839</b>	<b>120841</b>
Bottom final cutter	180	18.6	18.6	50	4	2	MC	<b>121813</b>	<b>121815</b>



##### Finger length 20 mm

TG: 6,2 mm

Real Z3

		Basic cutter	Final cutter top	Final cutter bottom
ZA		3	2	2
ND		18,6	18,6	18,6
HD	KLH	Cutter quantity	Cutter quantity	Cutter quantity
19	37,2	0	1	1
37	55,8	1	1	1
56	74,4	2	1	1
74	93	3	1	1
93	111,6	4	1	1
112	130,2	5	1	1
130	148,8	6	1	1
149	167,4	7	1	1
167	186	8	1	1
186	204,6	9	1	1
205	223,2	10	1	1
223	241,8	11	1	1
242	260,4	12	1	1
260	279	13	1	1
279	297,6	14	1	1
298	316,2	15	1	1
316	334,8	16	1	1

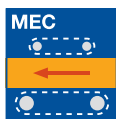
HD = wood thickness

KLH = clamping height

### 3. Planing and profiling

### 3.4 Finger jointing

#### 3.4.2 High performance minifinger cutters



#### Minifinger joint cutter, Marathon, real Z 6

##### Application:

For self-locking longitudinal joints. See section introduction for additional information.

##### Machine:

High performance finger joint machines with/without cut-off saws.

##### Workpiece material:

Softwood, across grain; also suitable for hardwood.

##### Technical information:

High number of teeth tool design, top and bottom final cutters required. Assembly of tool set: see section introduction. Version with enlarged tip gap suitable for PU adhesives and for finger joint machines without cut-off saws for horizontal spindle. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm.

##### ZL 10 mm, TG 3.8 mm

WF 620 2 06, WF 623 2 06

Tool Type	D	SB	ND	BO	Z	ZA	QAL	ZL	ID
	mm	mm	mm	mm		PCS		mm	
Top final cutter	250	26.6	19	50	6	4	MC	10/11	<b>121012 ●</b>
Basic cutter	250	49.4	26.6	50	6	7	MC	10/11	<b>120601 ●</b>
Bottom final cutter	250	26.6	19	50	6	4	MC	10/11	<b>121013 ●</b>

##### Finger length 10 mm and 15 mm

TG: 3,8 mm

Real Z6

			Basic cutter	Final cutter top	Final cutter bottom
ZA			7	4	4
ND			26,6	19	19
HD	KLH	Cutter quantity	Cutter quantity	Cutter quantity	
27	38	0	1	1	
53	64,6	1	1	1	
80	91,2	2	1	1	
106	117,8	3	1	1	
133	144,4	4	1	1	
160	171	5	1	1	
186	197,6	6	1	1	
213	224,2	7	1	1	
239	250,8	8	1	1	
266	277,4	9	1	1	
293	304	10	1	1	

HD = wood thickness

KLH = clamping height





#### Minifinger joint cutter and shoulder cutter, Marathon, real Z 6

##### Application:

For self-locking longitudinal joints with straight visible joint for horizontal joints, e.g. solid wood panels or finger jointed profile strips. See section introduction for additional information.

##### Machine:

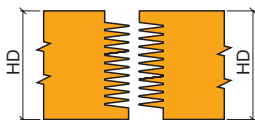
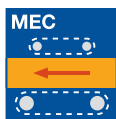
High performance finger joint machines with cut-off saw.

##### Workpiece material:

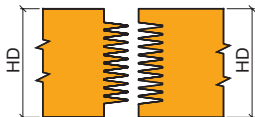
Softwood, across grain; also suitable for hardwood.

##### Technical information:

High number of teeth tool design. Tool set consists of basic cutter, extension cutter and shoulder cutters for different positions of the visible joint. Cutting width adjusted to wood thickness. Mounted on clamping sleeve. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 12 mm.



Profile 2



Profile 3

##### Basic- / extension cutter ZL 10/11 mm, TG 3.8 mm

WF 620 2 06, WF 623 2 06

Tool Type	D mm	SB mm	ND mm	BO mm	Z	ZA PCS	QAL	DRI	ID
Basic cutter	250	20.2	11.2	60	6	3	MC	RH	<b>120624</b> □
Extension cutter	250	5.0	11.2	60	6	1	MC	LH	<b>121608</b> □
Extension cutter	250	5.0	11.2	60	6	1	MC	RH	<b>121609</b> □
Extension cutter	250	12.6	11.2	60	6	2	MC	LH	<b>121610</b> □
Extension cutter	250	12.6	11.2	60	6	2	MC	RH	<b>121611</b> □

##### Shoulder cutter profile 2 and 3 for ZL 10/11 mm, TG 3.8 mm

WF 621 2 06

D mm	SB mm	BO mm	Z	QAL	ID LH	ID RH
249.7	12	60	6	MC	<b>122400</b> □	<b>122401</b> □

##### Clamping sleeve with threaded nut for LH/RH rotation

TB 270 0

D mm	BO mm	NL mm	GL mm	ID
60	50	85	105	<b>029474</b> ●
60	50	120	140	<b>029475</b> ●
60	50	150	170	<b>029476</b> ●
60	50	180	200	<b>029477</b> ●
60	50	210	230	<b>029478</b> ●
60	50	240	260	<b>029479</b> ●

##### Spacer

TR 100 0

D mm	B mm	BO mm	ID
90	3.8	60	<b>028447</b> ●
90	11.4	60	<b>028448</b> ●

### 3. Planing and profiling

### 3.4 Finger jointing

#### 3.4.3 Minifinger joint cutterheads

##### WM 620 2/WM 620 2 06 Minifinger joint cutterhead

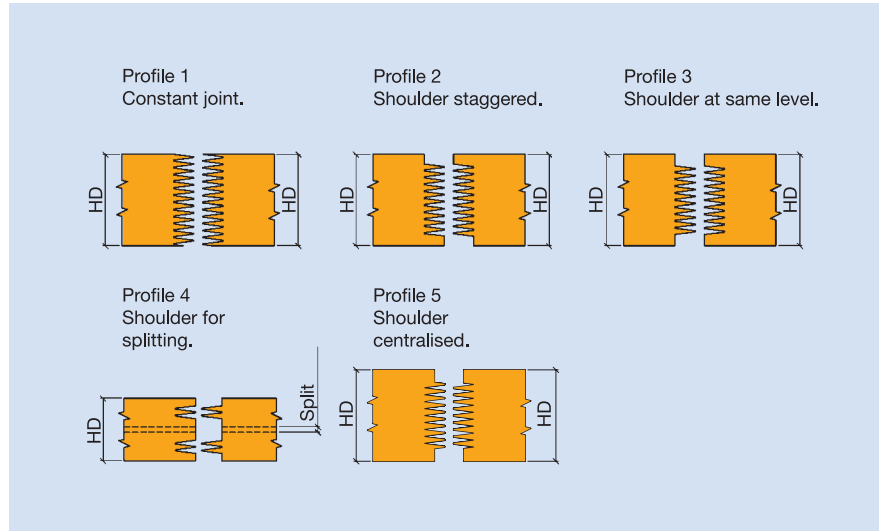
Minifinger joint cutterhead with resharpenable profile knives.  
Knives individually replaceable.  
Secure against twisting by pins.  
Cutting material with Leitz Marathon coating increases the tool life by 3-5 times compared with conventional HS, depending on the conditions of use.  
Finger length 10 can also be supplied in HW.



<b>Application</b>	For self-locking finger joints for supporting components, solid wooden panels, strips, window blanks.
<b>Cutting material</b>	HS, Marathon (MC), HW.
<b>Resharpenable area</b>	Marathon (MC) = 10 mm, HW = 6 mm.
<b>Feed rate</b>	RPM dependent up to 24 m min <sup>-1</sup> .

#### WM 620 2 01 Minifinger cutterhead

Minifinger cutterhead with resharpenable minifinger turnblade knives. Wood thickness max. 60 mm adjustable with or without shoulders. The resharpenable turnblade knives and the replaceable finger knives guarantee high flexibility and economic efficiency. Knives are resharpened on standard multi-purpose sharpening machines with cooling.



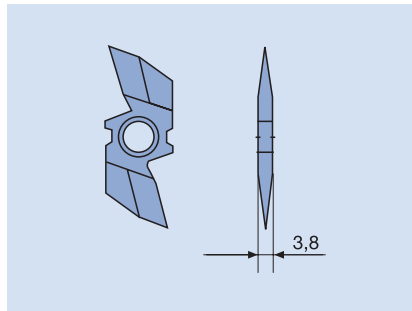
<b>Application</b>	For self-locking longitudinal joints for panel and moulding production with or without shoulders.
<b>Machines</b>	Double-end tenoners, double sided finger jointing lines with cut-off saw, single sided finger jointing lines with cut-off saw.
<b>Cutting material</b>	HW.
<b>Resharpening area</b>	2 x 6 mm.
<b>Number of teeth/finger length</b>	Z 6 or 3 + 3 at D = 250 mm , 10/11 mm finger length. Z 4 or 2 + 2 at D = 160 mm, 10/11 mm finger length.
<b>Feed rate</b>	Up to 36 m min <sup>-1</sup> , depending on spindle RPM and cutting edge arrangement.

### 3. Planing and profiling

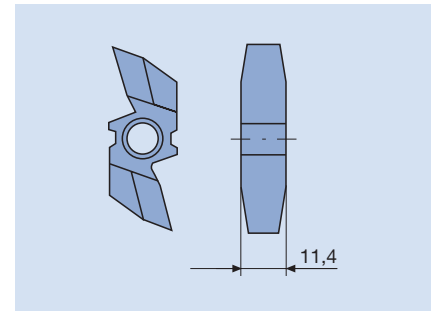
#### 3.4 Finger jointing 3.4.3 Minifinger joint cutterheads

##### Note

For wood up to 60 mm thick: joints with/without shoulders. Positioning the shoulder knives in 3.8 mm steps enables adjustment to different wood thicknesses.



Minifinger knife, 2 edges.



Shoulder knife, 2 edges.

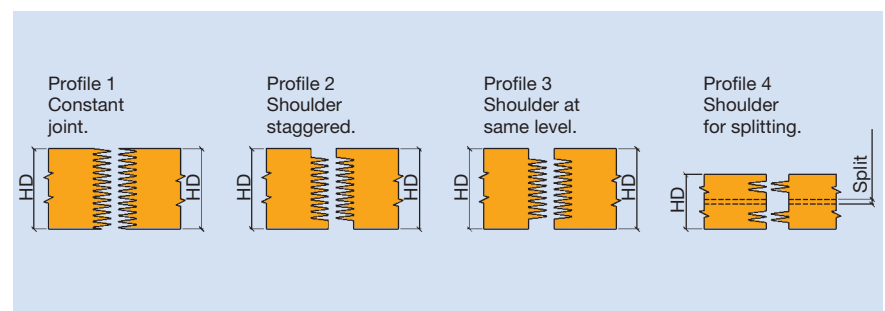
Table to determination of required number of spare knives:

HD from-to mm	ZB mm	ZA	Half shoulder (HS) mm
16 – 22	9.4	3	3.3 – 6.3
19 – 25	13.2	4	2.9 – 5.9
23 – 29	17	5	3.0 – 6.0
27 – 33	20.8	6	3.1 – 6.1
31 – 37	24.6	7	3.2 – 6.2
35 – 41	28.4	8	3.3 – 6.3
38 – 44	32.2	9	2.9 – 5.9
42 – 48	36	10	3.0 – 6.0
46 – 52	39.8	11	3.1 – 6.1
50 – 56	43.6	12	3.2 – 6.2

HD from-to mm	ZB mm	ZA	Half shoulder (S) mm
17 – 23	10.7	3	
21 – 27	14.5	4	3.2 – 6.2
25 – 31	18.3	5	3.3 – 6.3
29 – 35	22.1	6	3.4 – 6.4
33 – 39	25.9	7	3.5 – 6.5
36 – 42	29.7	8	3.1 – 6.1
40 – 46	33.5	9	3.2 – 6.2
44 – 50	37.3	10	3.3 – 6.3
48 – 54	41.1	11	3.4 – 6.4
52 – 58	44.9	12	3.5 – 6.5

##### Minifinger cutterhead Turbo Hawk

Resharpenable cutterhead system with individually replaceable HS circular knives. Production of different profiles with the same tool body. Flexible cutting edge arrangement with or without shoulders. Wood thickness to maximum 50 mm.

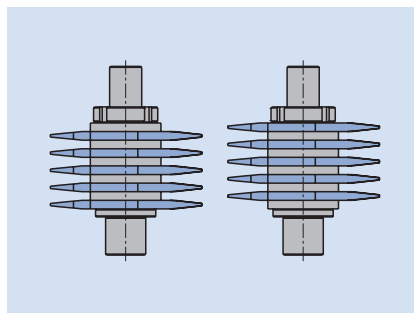


### 3. Planing and profiling

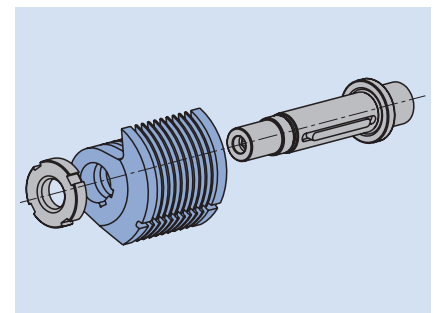
#### 3.4 Finger jointing

##### 3.4.3 Minifinger joint cutterheads

<b>Application</b>	For cutting self-locking longitudinal joints for exactly measured components, e.g. all kinds of finger joint profile mouldings, solid wood panels.
<b>Machines</b>	High performance finger jointing lines with cut-off saw.
<b>Cutting material</b>	HS, Marathon (MC).
<b>Resharpener area</b>	100 mm.
<b>Number of teeth/finger length</b>	Z 5/5 at finger length 10 mm. Z 10 at finger length 6.35 mm ( 1/4"), 9.52 mm ( 3/8").
<b>RPM</b>	4,800 min <sup>-1</sup> at wood thickness up to 40 mm 4,000 min <sup>-1</sup> at wood thickness up to 41 - 55 mm
<b>Feed rate</b>	Up to 48 m min <sup>-1</sup> depending on spindle RPM and cutting edge arrangement.
<b>Advantages</b>	Constant diameter, adjustable on the machine by gauge. Knife set can be changed as one unit on the clamping arbor resulting in short set up times when changing wood thickness. Constant balance due to clamping of the knives by a keyway on the arbor.
<b>Note</b>	With the Z 10 design, the knives are mounted without spacers. This design can only be used on machines with a raker. On other machines the knives must be mounted with spacers (Z 5/5 design).



Arbor as change unit.  
Knives mounted with spacer.  
Z 5/5 design.



Knife mounting on the arbor.  
Anti-twist keyway for the knives.



#### Minifinger joint cutterhead with replaceable knives

##### Application:

For self-locking longitudinal joints. See section introduction for additional information.

##### Machine:

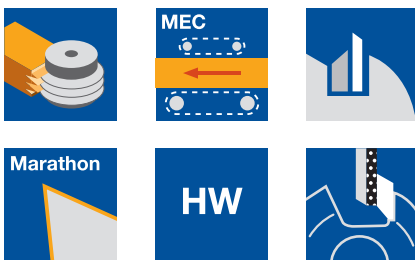
Finger joint machines with and without cut-off saw, continuous machines.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Steel tool body with block knives. Individually replaceable knives if damaged. Always resharpen sets of tools to the same diameter. Marathon coating allows up to 4 times longer tool life compared to HS version. Resharpener area 10 mm for MC or 6 mm for HW.



##### ZL 10/10 and 10/11 mm, MC

WM 620 2 06

D mm	SB mm	BO mm	ND mm	Z	TG	ZA PCS	n <sub>max</sub> min <sup>-1</sup>	ID ZL 10/10	ID ZL 10/11
160	31.4	50	30.4	2/2	3.8	8	8000	<b>135900</b>	<b>135902</b>
250	31.4	50	30.4	3/3	3.8	8	4500	<b>135901</b>	<b>135903</b>

##### ZL 10/10 and 10/11 mm, HW

WM 620 2

D mm	SB mm	BO mm	ND mm	Z	TG	ZA PCS	n <sub>max</sub> min <sup>-1</sup>	ID ZL 10/10	ID ZL 10/11
160	31.4	50	30.4	2/2	3.8	8	8000	<b>022730</b>	<b>022731</b>
250	31.4	50	30.4	3/3	3.8	8	4500	<b>022732</b>	<b>022733</b>

##### ZL 15/15 and 15/16.5 mm, MC

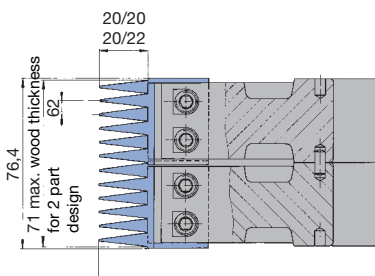
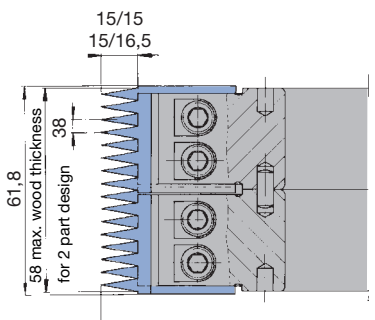
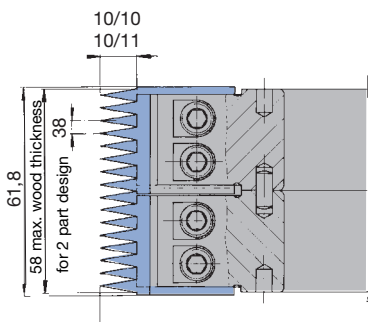
WM 620 2 06

D mm	SB mm	BO mm	ND mm	Z	TG	ZA PCS	n <sub>max</sub> min <sup>-1</sup>	ID ZL 15/15	ID ZL 15/16.5
170	31.4	50	30.4	2/2	3.8	8	8000	<b>135904</b>	<b>135906</b>
260	31.4	50	30.4	3/3	3.8	8	4500	<b>135905</b>	<b>135907</b>

##### ZL 20/20 and 20/22 mm, MC

WM 620 2 06

D mm	SB mm	BO mm	ND mm	Z	TG	ZA PCS	n <sub>max</sub> min <sup>-1</sup>	ID ZL 20/20	ID ZL 20/22
180	39.2	50	37.2	2/2	6.2	6	8000	<b>135908</b>	<b>135910</b>
260	39.2	50	37.2	3/3	6.2	6	4500	<b>135909</b>	<b>135911</b>



**Spare knives:**

QAL	Cut-off saws	Tip gap	Profile knife	ZL mm	TG	ZA PCS	ID SET 2	ID SET 3
MC	without	standard	right	10/10	3.8	4	611452	611552
MC	without	standard	left	10/10	3.8	4	611453	611553
MC	without	standard	right	15/15	3.8	4	611454	611554
MC	without	standard	left	15/15	3.8	4	611455	611555
MC	without	standard	right	20/20	6.2	3	611456	611556
MC	without	standard	left	20/20	6.2	3	611457	611557
MC	with	standard	right	10/11	3.8	4	611450	611550
MC	with	standard	left	10/11	3.8	4	611458	611558
MC	with	standard	right	15/16.5	3.8	4	611459	611559
MC	with	standard	left	15/16.5	3.8	4	611460	611560
MC	with	standard	right	20/22	6.2	3	611461	611561
MC	with	standard	left	20/22	6.2	3	611451	611551
MC	without	large	right	10/10	3.8	4	611474	611574
MC	without	large	left	10/10	3.8	4	611475	611575
MC	without	large	right	15/15	3.8	4	611476	611576
MC	without	large	left	15/15	3.8	4	611477	611577
MC	without	large	right	20/20	6.2	3	611478	611578
MC	without	large	left	20/20	6.2	3	611479	611579
HW	without	standard	right	10/10	3.8	4	611300	611350
HW	without	standard	left	10/10	3.8	4	611302	611352
HW	with	standard	right	10/11	3.8	4	611304	611354
HW	with	standard	left	10/11	3.8	4	611306	611356

Table to determine the quantity of cutterheads for given wood thickness.

Table to determine the quantity of cutterheads for given wood thickness.

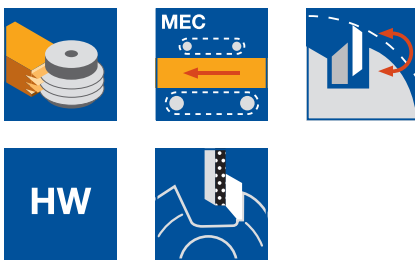
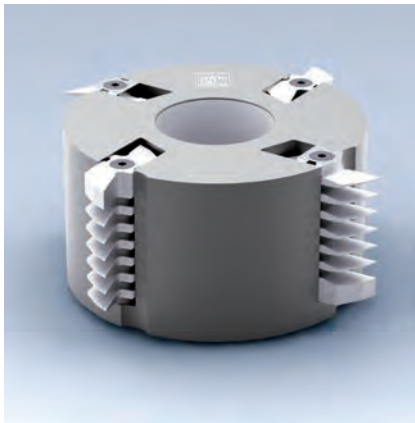
**Cutterhead - block knife  
with pitch 3.8 mm**

Finger length	
10 and 10/11 mm	
15 and 15/16.5 mm	
SB	31.4 mm
Hub	30.4 mm
ZA	Tooth row 8
Wood thickness	Quantity of cutterheads
28	1
58	2
89	3
119	4
150	5
180	6
210	7
241	8
271	9
302	10
332	11
362	12

**Cutterhead - block knife  
with pitch 6.2 mm**

Finger length	
20/20 mm	
22/22 mm	
SB	39.2 mm
Hub	37.2 mm
ZA	Tooth row 6
Wood thickness	Quantity of cutterheads
34	1
71	2
108	3
145	4
183	5
220	6
257	7
294	8
331	9
368	10





#### Minifinger cutterhead with HW turnblade knives

##### Application:

For self-locking longitudinal joints for non-supporting components, e.g. panels and strips.

##### Machine:

Finger joint machines and continuous machines with cut-off saw.

##### Workpiece material:

Softwood and hardwood, across grain.

##### Technical information:

Steel tool body with HW turnblade knives. Particularly suitable for hardwood, e.g. for horizontal joints with and without shoulders. Variable design for defined wood thicknesses from 15 to 60 mm. The rest of the knife seating must be filled with spacers and a safety washer (spare part no. 4). Individual cutting edges can be replaced if a cutting edge breaks. Resharpener area 2 x 6 mm.

##### Profile 1, ZL 10/11 mm, TG 3.8 mm

WM 620 2 01

D	SB	BO	Z	HD	n <sub>max</sub>	ID	ID
mm	mm	mm		mm	min <sup>-1</sup>	LH	RH
160	60	50	2/2	60	8000	135001 □	135000 □
250	60	50	3/3	60	5000	135005 □	135004 □

Attention: When assembling, always finish by fitting spacers with the securing device (spare part no. 4).

Tools for profile 2 - 5 on request.

##### Spare knives:

Part-no.	BEZ	P	ZL	SB	TG	QAL	ID
			mm	mm			
1	Minifinger knife		10/11	3.8	3.8	HW	618002 ●
2	Shoulder knife	2. 3. 4	10/11	11.4	3.8	HW	618005 ●
2	Shoulder knife	5	10/11	11.4	3.8	HW	618006 ●

##### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
3	Spacer for ZL 10/11	13x3.8x6.1	008199 ●
3	Spacer	15x17x5	008230 ●
4	Spacer with safety device	24.9x21x3.8	008200 ●
4	Spacer with safety device	24.9x20x6.2	008201 ●
5	Countersink screw, Torx® 20	M6x40	006090 ●
5	Countersink screw, Torx® 20	M6x50	007856 ●
5	Countersink screw, Torx® 20	M6x65	007882 ●
5	Countersink screw, Torx® 20	M6x70	007880 ●
	Torx® key	Torx® 20	006091 ●



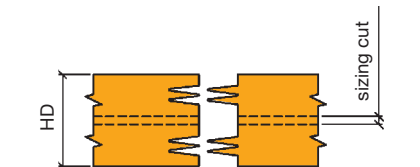
Profile 1 with continuous finger jointing



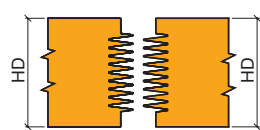
Profile 2 with staggered shoulder cutters



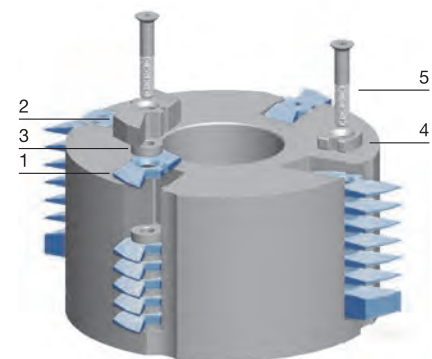
Profile 3 with shoulder cutters on the same level



Profile 4 with shoulder cutters for splitting



Profile 5 with half shoulder





### Hydro minifinger cutterhead TurboHawk with curved knives

#### Application:

For self-locking longitudinal joints for non supporting components, e.g. panels and strips.

#### Machine:

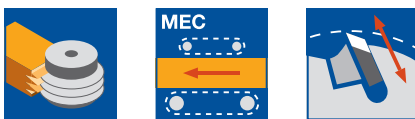
High performance finger joint machines and continuous machines with cut-off saw.

#### Workpiece material:

Softwood; limited suitability for hardwood.

#### Technical information:

Resharpenable, constant diameter and constant profile tool system with hydro clamping. No machine adjustment required. Particularly suitable for horizontal joints with and without shoulders. Variable for defined wood thicknesses from 15 to 50 mm. The remaining knife seatings must be filled with spacers and a locking nut. Minifinger curved knives with extremely large resharpening area.



#### With curved knives ZL 6.35 mm (1/4"), TG 3.53 mm

HM 620 2 05

P	D mm	BO mm	HD <sub>max</sub> mm	Z	QAL	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
1	266.67	50	50	5/5	HS	4000	<b>135524</b>	<b>135525</b>
2	266.67	50	50	5/5	HS	4000	<b>135532</b>	<b>135533</b>
3	266.67	50	50	5/5	HS	4000	<b>135540</b>	<b>135541</b>



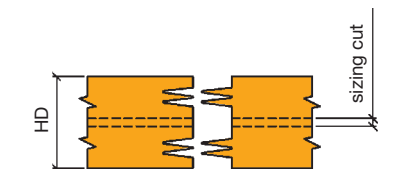
Profile 1 with continuous finger jointing



Profile 2 with staggered shoulder cutters



Profile 3 with shoulder cutters on the same level



Profile 4 with shoulder cutters for splitting

#### With curved knives ZL 9.52 mm (3/8"), TG 4.3 mm

HM 620 2 05

P	D mm	BO mm	HD <sub>max</sub> mm	Z	QAL	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
1	266.67	50	50	5/5	HS	4000	<b>135548</b>	<b>135549</b>
2	266.67	50	50	5/5	HS	4000	<b>135556</b>	<b>135557</b>
3	266.67	50	50	5/5	HS	4000	<b>135564</b>	<b>135565</b>

#### With curved knives ZL 10/11 mm, TG 3.8 mm

HM 620 2 05

P	D mm	BO mm	HD <sub>max</sub> mm	Z	QAL	n <sub>max</sub> min <sup>-1</sup>	ID LH	ID RH
1	266.67	50	50	5/5	HS	4000	<b>135500</b>	<b>135501</b>
2	266.67	50	50	5/5	HS	4000	<b>135508</b>	<b>135509</b>
3	266.67	50	50	5/5	HS	4000	<b>135516</b>	<b>135517</b>

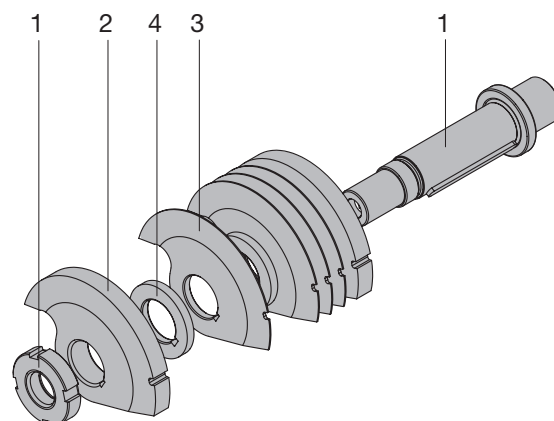
Please note the spindle arrangement. Arrangement for other wood thicknesses on request.

#### Spare knives:

Part-no.	BEZ	ABM mm	ZL mm	ID HS	ID MC
3	Minifinger knife	38.1x3.53x19.05	6.35	<b>618202</b> ●	<b>618221</b> ●
2	Shoulder knife	38.1x8.74x19.05	6.35	<b>618252</b> ●	<b>618270</b> ●
3	Minifinger knife	38.1x4.3x19.05	9.52	<b>618208</b> ●	<b>618222</b> ●
2	Shoulder knife	38.1x9.51x19.05	9.52	<b>618258</b> ●	<b>618271</b> ●
3	Minifinger knife	38.1x3.8x19.05	10/11	<b>618200</b> ●	<b>618220</b> ●
2	Shoulder knife	38.1x11.4x19.05	10/11	<b>618250</b> ●	<b>618269</b> ●

**Spare parts:**

Part- no.	BEZ	ABM mm	TG	ID
	Setting gauge	D266.67x80		005377 ●
1	Clamping arbor	HD 50 mm KL 55 mm		008226 ●
1	Clamping arbor	HD 38 mm KL 43 mm		008227 ●
1	Clamping arbor	HD 32 mm KL 34.5 mm		008228 ●
1	Clamping arbor	HD 25 mm KL 29 mm		008229 ●
	Sickle spanner	34/36 DIN 1810 A		117510 ●
	Screw driver	SW 6, L50		117508 ●
4	Filler piece for rounding knives	33x3.53x19.05,KN1.8x4.2	3.53	008224 ●
4	Filler piece for rounding knives	33x4.3x19.05,KN1.8x4.2	4.3	008225 ●
4	Filler piece for rounding knives	33x3.8x19.05,KN1.8x4.2	3.8	008223 ●



### 3. Planing and profiling

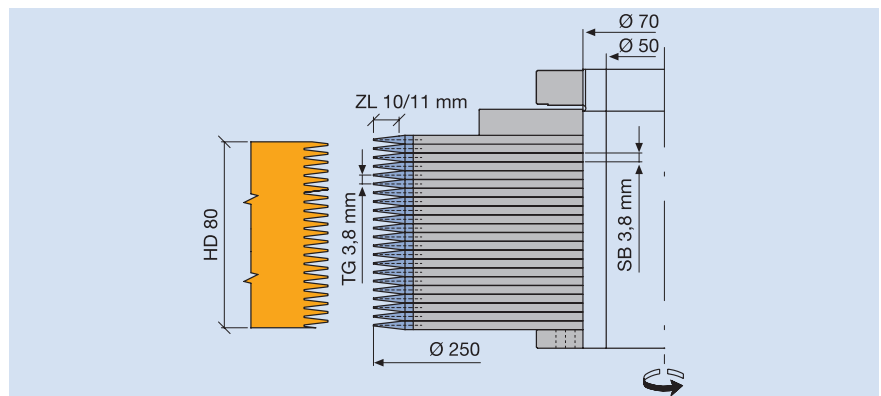
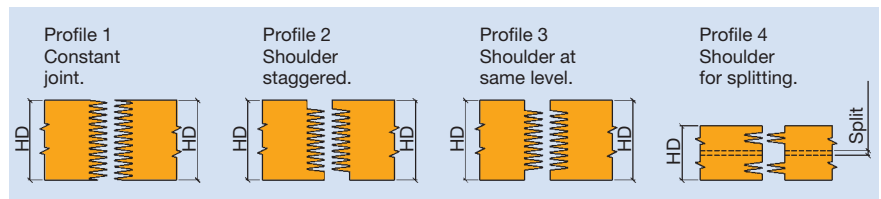
#### 3.4 Finger jointing 3.4.4 Minifinger disc cutters

##### WF 624 2 Disc cutter, minifinger profile with and without shoulders

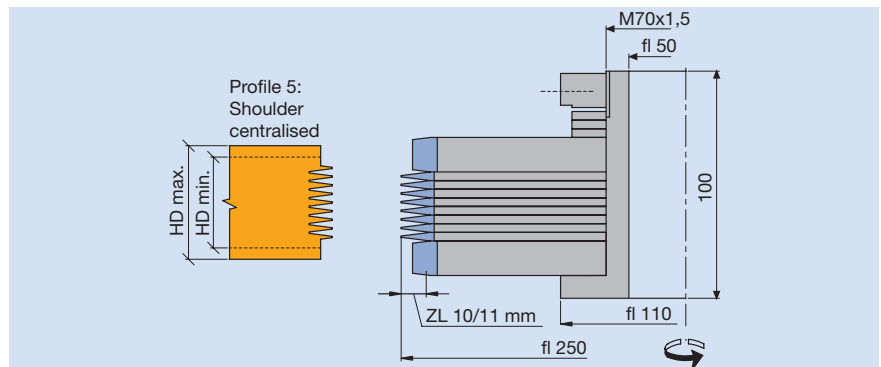
Minifinger disc cutter tipped with HW or DP cutting edges. Variable arrangement for defined wood thicknesses, with or without shoulder cutter, mounted on screwed sleeve as tool set.



<b>Application</b>	For self-locking longitudinal joints for precise measured components, e.g. finger joint solid wood panels, all kinds of mouldings, floors, parquet, stair and furniture parts, especially narrow mouldings. Finger jointing lines with cut-off saw for high feed speeds.
<b>Cutting material</b>	HW, DP.
<b>Resharpener area</b>	HW = 3.5 mm, DP = 3-5 times resharpenable.

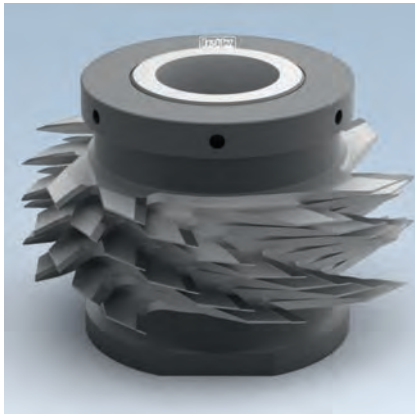


22 HW disc cutter for 80 mm wood thickness.



Minifinger shoulder cutter set with 8 finger.

**Note:**  
DP minifinger disc cutters only suitable for knotless wood and wood derived materials that are planed at right angles. Exact clamping for vibration-free cutting is required.



### Minifinger disc cutter, HW, with and without shoulder cutter

#### Application:

For self-locking longitudinal joints for non-supporting components, e.g. panels and strips.

#### Machine:

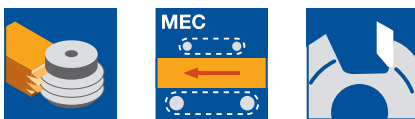
Finger joint machines with cut-off saws.

#### Workpiece material:

Hardwood and abrasive tropical wood.

#### Technical information:

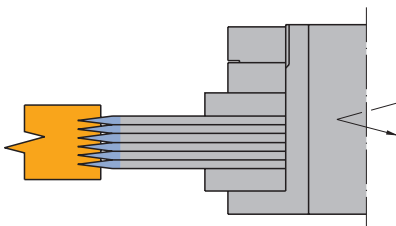
HW tipped cutters. Tool body thickness corresponds to finger pitch. Particularly suitable for horizontal joints with and without shoulders. Variable design for defined wood thicknesses from 15 to 80 mm. Suitable for small wood thicknesses. Resharpener area 3.5 mm. Design in DP on request.



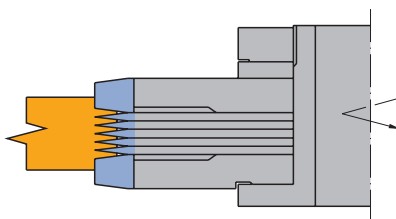
#### HW, ZL 10/11 mm, TG 3.8 mm

WF 620 2, WF 621 2

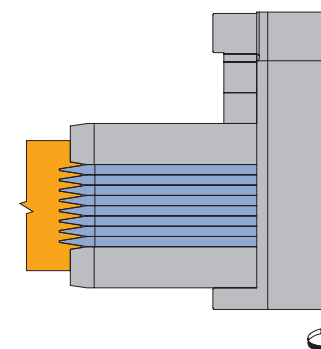
Tool Type	D mm	SB mm	BO mm	Z	$n_{\max}$ min <sup>-1</sup>	ID
Minifinger joint cutter	160	3.8	70	4	9,000	021511 ●
Minifinger joint cutter	250	3.8	70	6	6,000	021513 ●
Shoulder cutter	159.8	15.2	70	4	9,000	021762 ●
Shoulder cutter P3	249.7	15.2	70	6	6,000	021764 ●
Shoulder cutter P5	239.7	15.2	70	6	6,000	022153 ●



Minifinger joint cutterset without shoulder cutters



Minifinger joint cutterset with shoulder cutters P3



Minifinger joint cutterset with shoulder cutters P5

#### Clamping element with threaded nut

TB 270 0

d mm	BO mm	NL mm	GL mm	ID
70	50	116	146	029695 ●
70	50	80	110	029473 ●

#### Spare parts:

BEZ	ABM mm	ID
Sickle spanner adjustable	D90/155; L290; DIN1816; tenon 6	005462 ●

#### Spacers

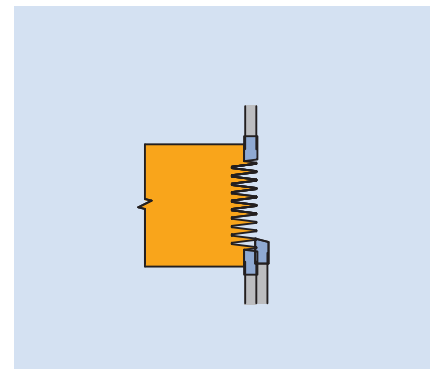
TR 100 0

D mm	B mm	BO mm	TG	ID
100	3.8	70	3.8	028437 ●
100	11.4	70	3.8	028450 ●
100	15.2	70	3.8	028439 ●
175	11.4	70	3.8	028678 ●

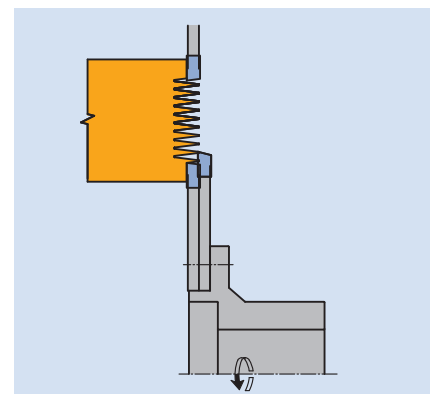
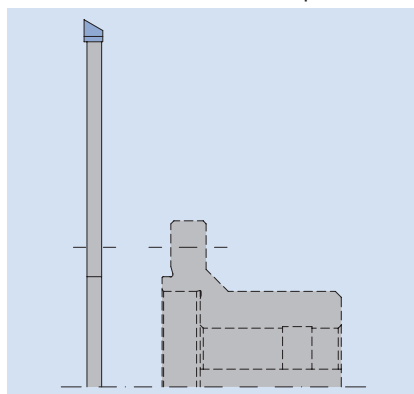
### 3. Planing and profiling

#### 3.4 Finger jointing

##### 3.4.5 Scoring sawblades and hoggers

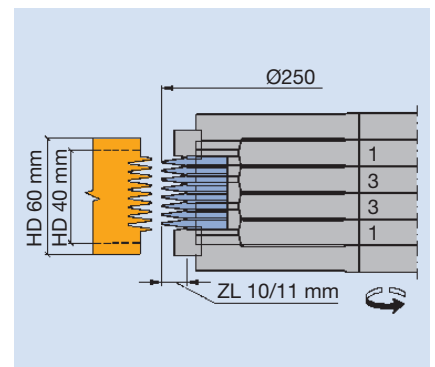
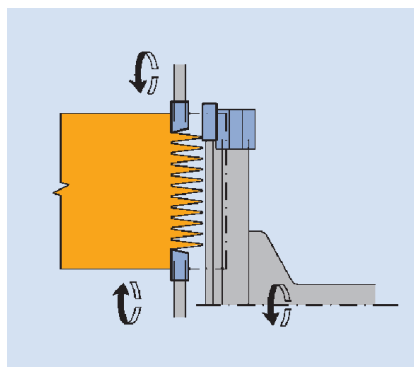


<b>Process step</b>	Scoring across grain with feed.
<b>Workpiece materials</b>	Softwood and hardwood, wood derived material.
<b>Cutting material</b>	HW.
<b>Machines</b>	Finger jointing lines with scoring and cut-off saw.
<b>Application</b>	Scoring minifingers with shoulders.
<b>Tool design</b>	HW scoring sawblade, possibly double scoring sawblade mounted on flanged sleeve with bevel one side tooth shape.
<b>Scoring saw</b>	



Double scorer scoring shoulders with minifinger joint cutters.

<b>Advantage</b>	Bevel one side teeth used with feed, for cleaner, tear-out free shoulders.
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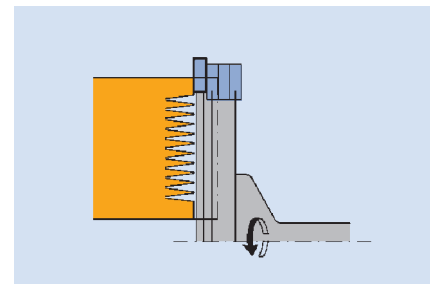


Hogger and scorer for trimming the minifinger joints and scoring the shoulder joint.

### 3. Planing and profiling

#### 3.4 Finger jointing

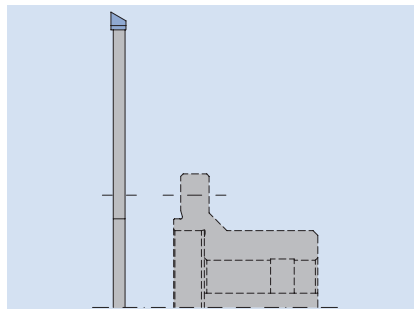
##### 3.4.5 Scoring sawblades and hoggers



Hogger for trimming minifingers.

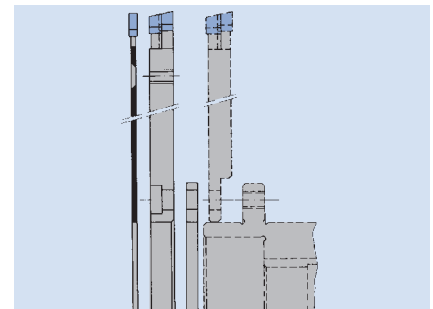
<b>Process step</b>	Hogging across grain.
<b>Workpiece materials</b>	Softwood and hardwood, wood derived material.
<b>Cutting material</b>	HW.
<b>Machines</b>	Finger jointing lines with cut-off saw.
<b>Application</b>	Trimming mini fingers.
<b>Cutting width</b>	Saw hogger: 6.35 mm and 8 mm. Hogger: 12 mm. Segment hogger: 10 – 25 mm.

#### Tool design



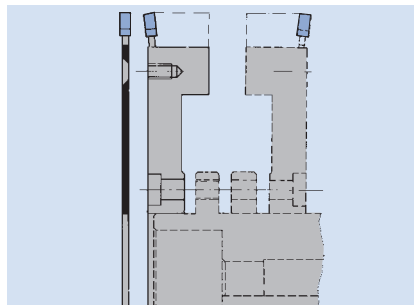
##### Saw hogger

HW circular sawblade mounted directly on flanged sleeve, bevel one side teeth.



##### Saw hogger

HW circular sawblade with hogger discs mounted on flanged sleeve (see section Panel Processing).



##### Segment hogger

HW circular sawblade with segmental tool body mounted on flanged sleeve (see section Panel Processing).

<b>Advantage</b>	One side bevel HW teeth for clean, tear-out free end grain.
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#### Scorer for shoulder minifinger joints

##### Application:

For scoring in front of the trimming hogger or for machining the face edge of shoulder joints.

##### Machine:

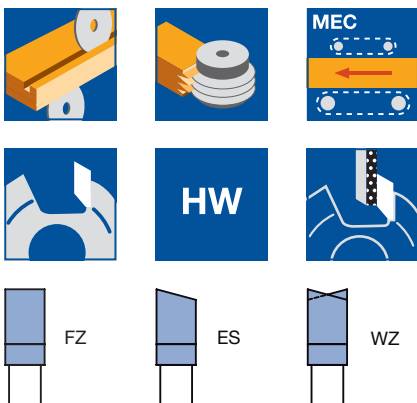
Finger joint machines with trimming and scoring aggregates.

##### Workpiece material:

Softwood, hardwood and wood derived materials.

##### Technical information:

Particularly suitable for scoring the shoulders on finger joint machines. Tear-free shoulders guaranteed.



##### Scoring sawblade for Grecon PowerJoint

WK 100 2

D	SB	BO	Z	ZF	QAL	n <sub>max</sub>	ID	ID
mm	mm	mm				min <sup>-1</sup>	LH	RH
100	4.4	20	18	FZ	HW	8000	061995 ●	061995 ●

##### Single scoring saw mounted on flanged sleeve

SK 999 2, SK 999 2

D	SB	BO	Z	ZF	QAL	n <sub>max</sub>	ID	ID
mm	mm	mm				min <sup>-1</sup>	LH	RH
200	6.5	40 DKN	48	WZ	HW	7200	061986 □	061987 □
200	4.75	40 DKN	64	ES	HW	7200	062632 □	062633 □

##### Double scoring saw mounted on flanged sleeve

SK 999 2

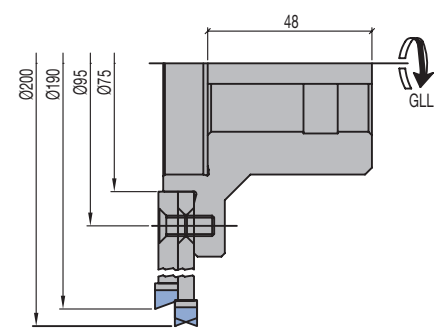
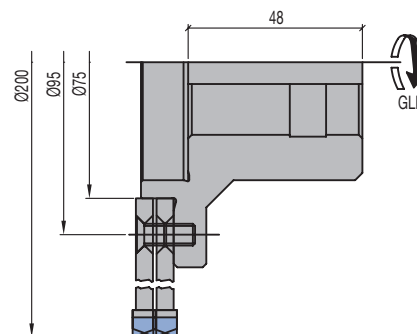
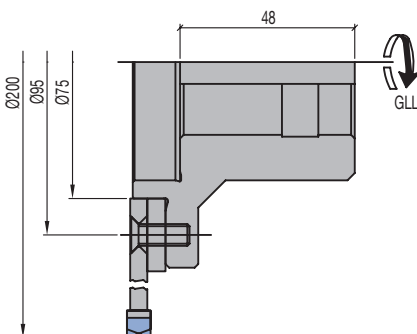
D	SB	BO	Z	ZF	QAL	n <sub>max</sub>	ID	ID
mm	mm	mm				min <sup>-1</sup>	LH	RH
200	12.2	40 DKN	48	WZ/WZ	HW	7200	061988 □	061989 □
200	12.3	40 DKN	48	ES/WZ	HW	7200	061990 □	061991 □
190								

##### Spare sawblades:

D	SB	BO	Z	ZF	NLA	QAL	n <sub>max</sub>	ID	ID
mm	mm	mm			mm		min <sup>-1</sup>	LH	RH
200	6.5	75	48	WZ	6NL TK95	HW	7200	061992 ●	061992 ●
190	6.7	75	48	ES	6NL TK95	HW	7200	061993 ●	061994 ●
200	4.75	75	64	ES	6NL TK95	HW	7200	062630 ●	062631 ●

##### Spare parts:

BEZ	ABM	L	BO	ID
	mm	mm	mm	
Flanged sleeve	113/75x61x40 DKN	61	40 DKN	061680 ●
Flanged disc	D115/BO75/TK95		75	028676 ●
Spacer	180x1x75		75	028677 ●
Countersink screw, Torx® 20	M6x16			006086 ●





#### Sawblade hogger for trimming minifingers

##### Application:

Defined trimming of the workpiece before cutting the fingers for adjusting the finger fitting.

##### Machine:

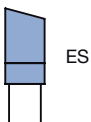
Finger joint machine with trimming aggregate, double-end profiler, tenoner.

##### Workpiece material:

Softwood, hardwood and wood derived materials.

##### Technical information:

HW circular saw blade with high number of teeth. Bevelled on one side for perfect cutting quality and reduced tear-outs.



##### Sawblade hogger mounted on flanged sleeve

SK 999 2

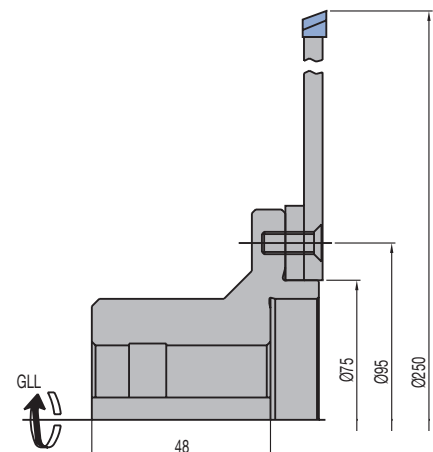
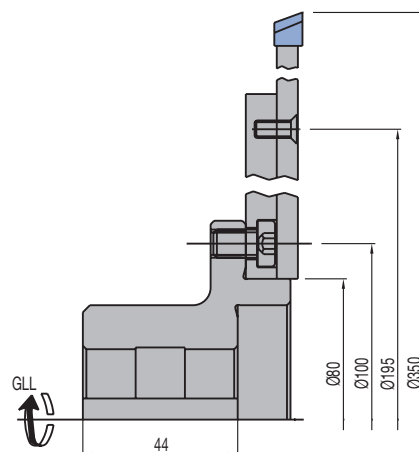
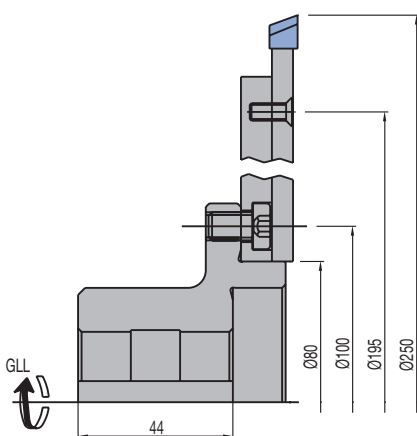
D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	6.35	40 DKN	80	ES	HW	<b>062618</b> □	<b>062619</b> □
250	8	40 DKN	60	ES	HW	<b>062620</b> □	<b>062621</b> □
350	8	40 DKN	72	ES	HW	<b>062622</b> □	<b>062623</b> □

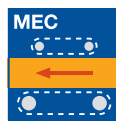
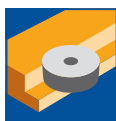
##### Spare sawblades:

D	SB	BO	Z	ZF	QAL	ID	ID
mm	mm	mm				LH	RH
250	6.35	75	80	ES	HW	<b>062624</b> ●	<b>062625</b> ●
250	8	80	60	ES	HW	<b>062626</b> ●	<b>062627</b> ●
350	8	80	72	ES	HW	<b>062628</b> ●	<b>062629</b> ●

##### Spare parts:

BEZ	ABM	L	BO	ID
	mm	mm	mm	
Flanged sleeve	113/80x59x40 DKN	59	40 DKN	<b>061679</b> ●
Flanged sleeve	113/75x61x40 DKN	61	40 DKN	<b>061680</b> ●
Flanged disc	D215/BO80/TK195		80	<b>028675</b> ●
Flanged disc	D115/BO75/TK95		75	<b>028676</b> ●
Countersink screw, Torx® 20	M6x16			<b>006086</b> ●
Countersink screw, Torx® 20	M5x12			<b>006247</b> ●
Cylindrical screw with ISK	M8x12			<b>005943</b> ●





#### Rebating cutterhead for joinery machines - HeliCut 15

##### Application:

For cutting grooves, rebate grooves, V-grooves as well as for jointing longitudinal and crosscut wood with large hogging depths in the wood construction.

##### Machine:

CNC-controlled joinery machines, as well as special machines for general wood construction with machine-specific adaptors.

##### Workpiece material:

Solid wood, preferably softwood for wood construction, hardwood (oak, ash etc.).

##### Technical information:

Carrier body constructed from high strength lightweight aluminium alloy. With 4-times turnable, spiral-shaped assembled HW turnblades. Application of the same knives as peripheral knives and spurs. The cutting bevels of the HW knives are numbered. No clamping wedges, direct tangential knife clamping. Easy handling of knife change without further mounting aid.

##### Aluminium tool body

WW 430 2 05

D	SB	BO	Z	V	ID
mm	mm	mm			
250	60	30	4x6	2 x 4+4	<b>132538</b>
250	80	30	4x8	2 x 4+4	<b>132539</b>
250	100	30	4x10	2 x 4+4	<b>132540</b>
300	20	30	4x2	2 x 4+4	<b>132541</b>
300	40	30	4x4	2 x 4+4	<b>132542</b>
300	60	30	4x6	2 x 4+4	<b>132543</b>
300	80	30	4x8	2 x 4+4	<b>132544</b>
300	100	30	4x10	2 x 4+4	<b>132545</b>
350	20	30	4x2	2 x 4+4	<b>132546</b>
350	40	30	4x4	2 x 4+4	<b>132547</b>
350	60	30	4x6	2 x 4+4	<b>132548</b>
350	80	30	4x8	2 x 4+4	<b>132549</b>
350	100	30	4x10	2 x 4+4	<b>132550</b>
400	20	30	4x2	2 x 4+4	<b>132551</b>
400	40	30	4x4	2 x 4+4	<b>132552</b>
400	60	30	4x6	2 x 4+4	<b>132553</b>
400	80	30	4x8	2 x 4+4	<b>132554</b>
400	100	30	4x10	2 x 4+4	<b>132555</b>

More dimensions on request.

##### Spare knives:

BEZ	ABM	QAL	BEM	VE	ID
	mm			PCS	
Turnblade knife	15x15x2.5	HW	HeliCut 15	10	<b>009549 ●</b>
Turnblade knife	15x15x2.5	HW-MF	HeliCut 15	10	<b>009543 ●</b>
Turnblade knife	15x15x2.5	TDC	HeliCut 15		<b>602900 ●</b>

##### Spare parts:

BEZ	ABM	ID
	mm	
Countersink screw, Torx® 20	M5x18	<b>114030 ●</b>
Torx® key	Torx® 20	<b>006091 ●</b>

#### International window systems

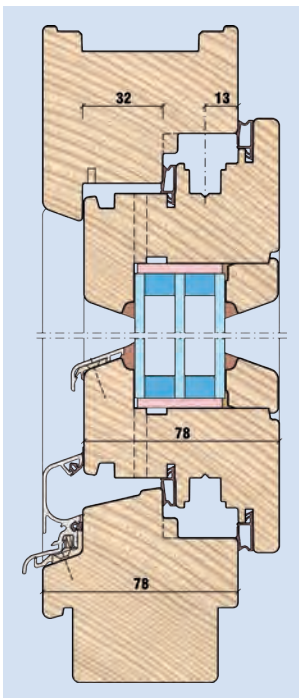


The window section is not just a matter of construction specification. More important are the national specifications to which a window must correspond for particular applications. EN 14351-1 defines these mandatory specifications. CE-marking clearly shows that a window meets all the required criteria of the intended application, defining the window construction. Leitz knows the business, and advises and supports customers on the correct design and the best tool.

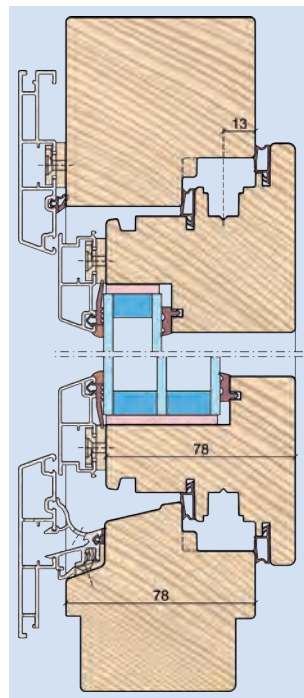
To support customers with CE certification, Leitz continental standard systems are listed on [www.CE-fix.de](http://www.CE-fix.de) ("Making CE marking easy for windows and external doors") from VBH - the world's largest trading company supplying hardware for windows and doors.

In addition to window systems from Leitz, the patented RipTec technology for corner joints by Leitz, and the PlugTec corner joint, designed by Leitz and certified by the ift-Rosenheim Institute as per FE08-1, are also part of this platform. All construction details in Leitz continental window systems have been designed as required by CE certification. Leitz's national standard domestic window programs have successfully passed the system test at an authorized testing institute, such as ift-Rosenheim.

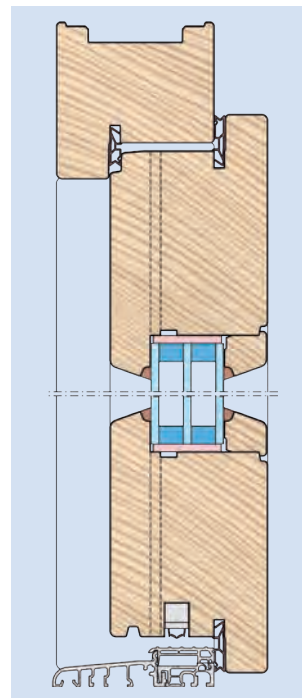
Leitz has specifically designed standard systems based on the requirements of certified window systems in order to meet country-specific requirements. These modular system solutions are characterized by high flexibility in production and design, and future-proof technical features including heat technology, noise protection and safety.



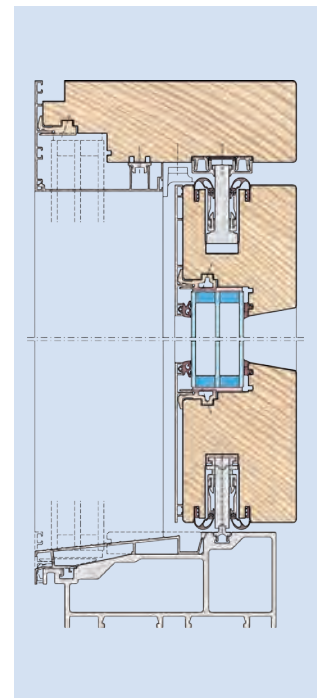
IV78 KlimaTrend  
13 mm gear axle  
32 mm distance of wind-rain block



IV78 KlimaTrend  
13 mm gear axle



Front door, single rebate  
Sash and frame sealing.  
Rotary sash sealing stop and front door threshold for barrier-free installation.



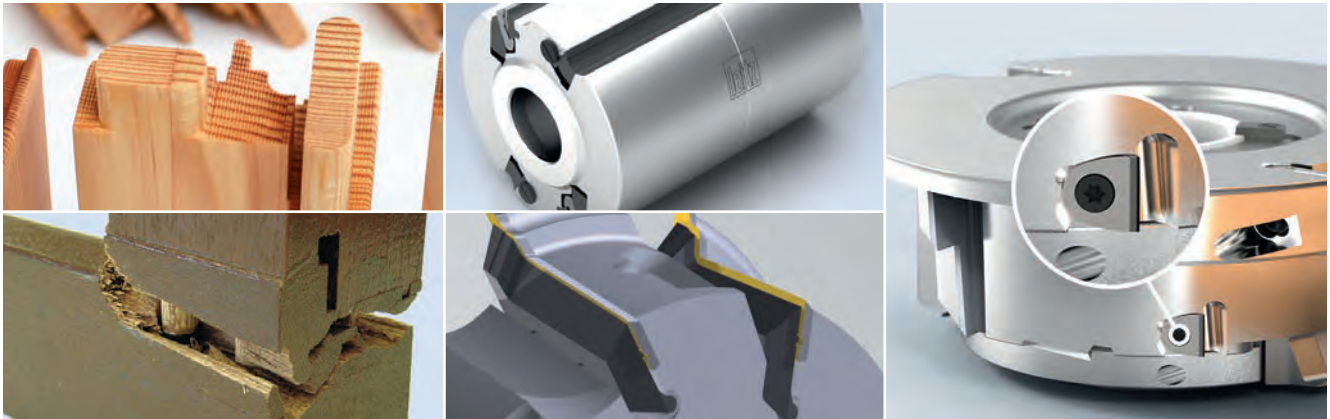
Wood/Alu sliding door  
with fixed glazing in the frame  
Ground-deep glazing with stepless exit.



#### Tool systems and processing technology

Especially for cutting technologies designed for the production of wooden windows, such as RipTec or Integral and Hybrid technology as well as toolsets of machine-specific features, allow optimal utilization of machine capacity with excellent machine quality at the same time.

The Leitz tool systems are described extensively in section Profile Tool Systems.



**Leitz RipTec:** Nearly tear-free finish and maximum stability of the joint with increased feed speed

**Leitz PlugTec:** The innovative corner joint for the most demanding applications

**Leitz Integral:** Precutting and finish processing with one single tool for increased performance time of the finish edge

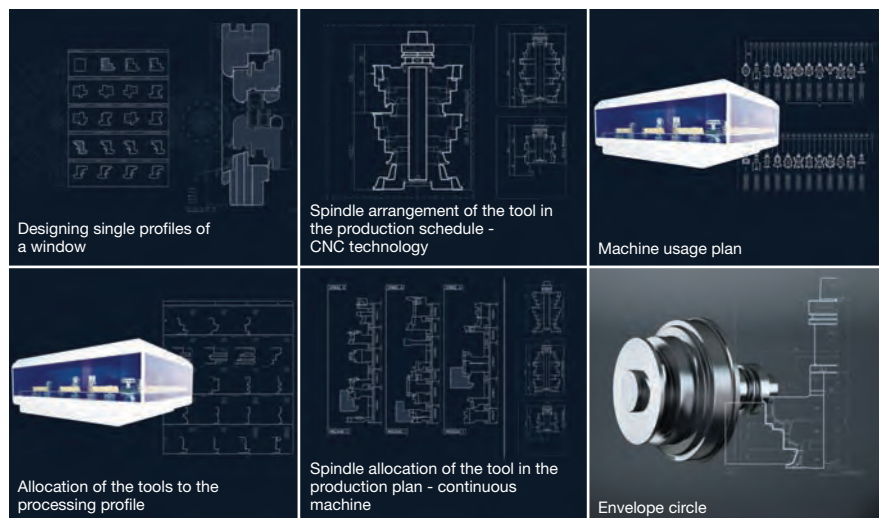
**Leitz Hybrid:** Combination of HW-tool systems with diamond edges for reduced edge wear

#### Engineering services



For a head start in an increasingly competitive international marketplace, right from the planning stage, you can count on Leitz. As your expert partner, we offer customized and efficient solutions for the production of modern window and door systems. After determining the requirements, Leitz work in cooperation with machine and software producers to ensure customers receive the most efficient service package. If maximum flexibility is required during production, then the toolsets are split. However, if productivity is the first priority then complete toolsets are the correct solution.

Leitz identify trends in the market, is in constant contact with notable international testing institutes, producers of hinges and seals, and understands what is important in window construction. Our window experts provide support in every way to carry out your objectives.



Problem	Possible cause	Action
<b>Surface defect</b> <b>Cutting quality</b>	– RPM too low	Increase RPM and thus cutting speed increase tool diameter
	– Incorrect geometry	Measure, change tool
	– Spindle and tool tolerances too high	Check motor bearing and tolerances
	– Tool balance	Check and re-balance
	– Cutting speed too high (no chip formation), relation feed to number of teeth not adequate	Increase feed speed, Reduce number of teeth and RPM
	– Number of teeth too low, feed to high	Match number of teeth and feed speed
<b>Wavy, rough surface</b>	– Workpiece feed not consistent	Check feed speed and/or transport equipment
	– Infeed rollers with insufficient pressure or worn	Increase pressure of in feed rollers and recut serrations
	– Workpiece too thin or too short	Observe the machine manufacturer guidelines
	– Chip removal too high	Use for several working steps or pre relieve
	– Resin built up on tool, tool is blunt	Remove resin or sharpen
<b>Surface defect</b> <b>Burn marks</b>	– Cutting speed too high	Reduce cutting speed
	– Relation feed speed to number of teeth not adequate	Match number of teeth and feed speed
	– Tool continues to rotate in standing workpiece	Provide for continuous feed
<b>Surface defect</b> <b>Tear-outs</b>	– Wood moisture too low	Check drying control
	– Wood with many branches (loose branches)	Optimisation with crosscut saws and longitudinal joints
<b>Surface defect</b> <b>Chip marks</b>	– Angle geometry not matched to workpiece material	Check and adjust and/or new tool
	– Gap between knife and clamping element	Clean and carefully mount clamping element and knives
	– Gullet too small	Check and increase
	– Extraction hood and extraction not suitable	Contact machine manufacturer to clarify
	– Extraction performance insufficient in tool area	Guideline: 30 m s <sup>-1</sup> air supply speed
<b>Profile defect</b> <b>Workpiece – Angle error – uneven</b>	– Tool set profiles not the same, e. g. sets with feed/against feed	Check and match tool sets
	– Stacked spindle positioned in feed direction or not at right angle to table	Check angle with clock gauge on vertically running spindle in two planes
	– Support table and fence worn out	Reprocess and/or replace support table and fence
	– Angle tolerance between support table and fence too big or fence and process edge not correctly adjusted	Check and adjust angles, align plane from fence to process edge including tool
<b>Motor power</b> <b>Feed speed</b>	– High resin build up on tool, tool blunt	Remove resin from tool and sharpen more frequently
	– Tool gullet too small	Check and increase
	– Cutting angle too small	Adjust or new tool
	– Cutting across grain too deep	Use several working steps or pre cut

#### **Wear of HS cutting edges**

When planing solid wood (softwood or hardwood) the HS cutting edges are subject to mechanical and chemical wear.

This leads to blunting of the cutting edges and will consequently affect the quality of the wood surface.

Significant blunting requires considerably more work when resharpener the knives and reduces the number of possible resharpenings.



Wear of HS cutting edges.

#### **Pitting wear at the face HS**

Chemical wear can be very high because of the consistency of the wood, e.g. machining wet wood can lead to pitting of the face.

The pitting weakens the cutting edge and results in chipping/breakage.

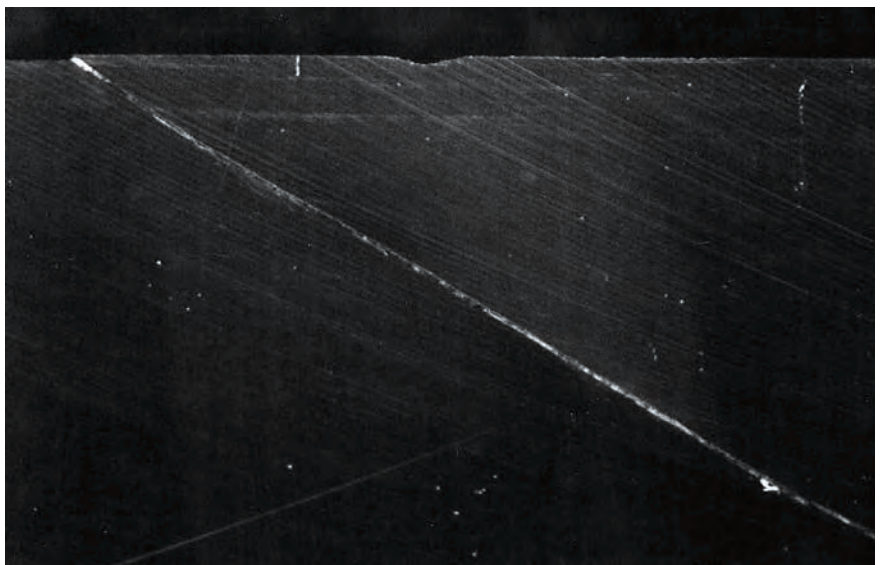


Pitting wear.

#### **Destruction of HW cutting edges**

Too large knife projection or tipping material overhang will result in breakages when machining very hard wood. Too large projection of carbide tipped planer knives, plus a low cutting angle can overstress the knife when machining very hard timber. This can result in hairline cracks or knife breakages.

The maximum knife projection, angle geometry and minimum clamping length given in the handling instructions must be adhered to.



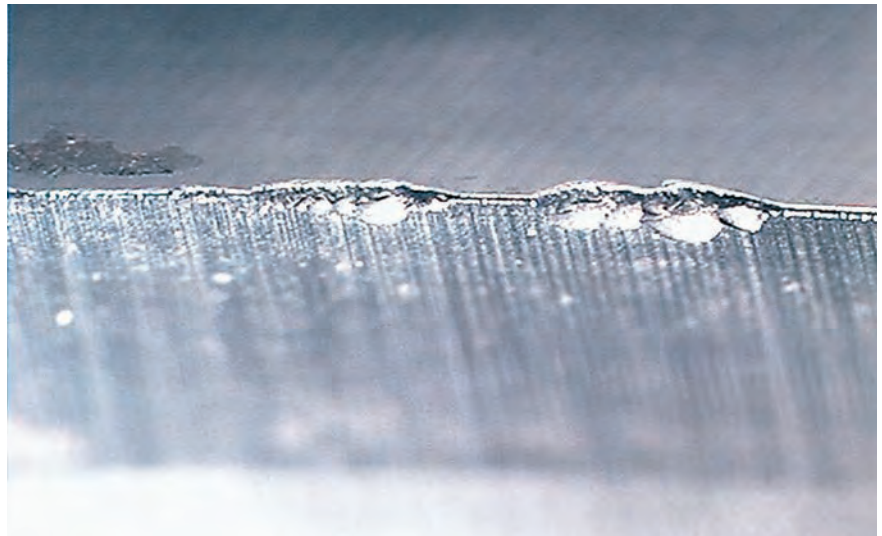
Destruction of HW cutting edges.



#### Cutting edge fractures

Dull cutting edges, unbalancing or weak feed pressure can create vibrations in the machine, especially when machining very hard materials.

An uneven cutting force can result in chipping to the cutting edge. When tools are in constant use, it is important the tools are sharpened frequently and not allowed to become too blunt. A higher cutting angle may help.

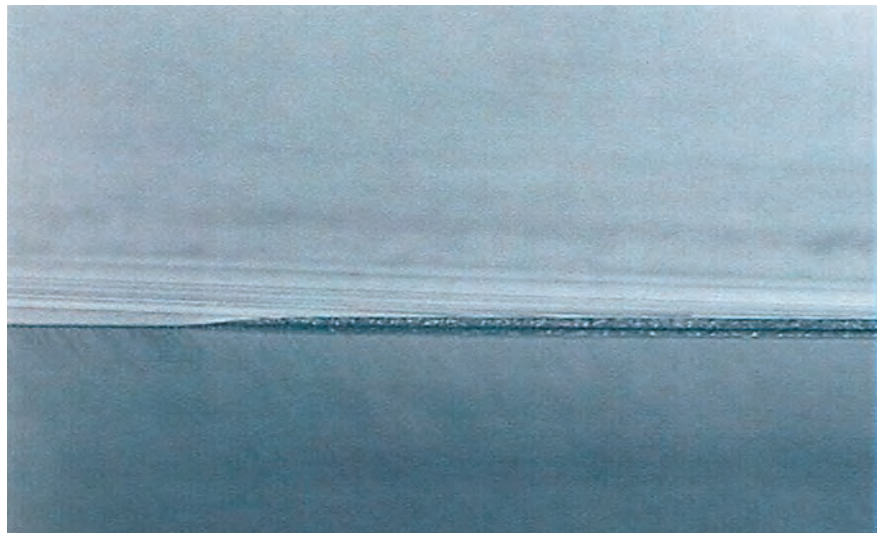


Cutting edge fractures.

#### Wear to HW cutting edges

The photograph shows the wear of a uniformly blunt cutting edge.

The cutting edge can be resharpened without a significant material loss. This increases the overall performance time of the tool.

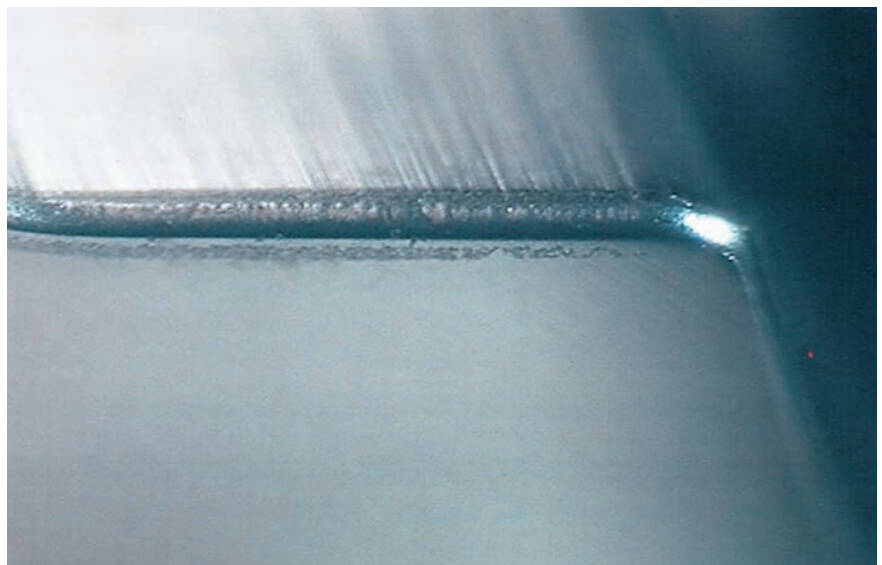


Wear of HW cutting edges.

#### Too much wear to cutting edges

When the cutting edges are very blunt, the cutting force becomes too high, the surface quality deteriorates, resulting in additional resharpening and loss of tool life.

If the cutting edge is not resharpened correctly, the performance time is reduced, resulting in cutting edge fractures.



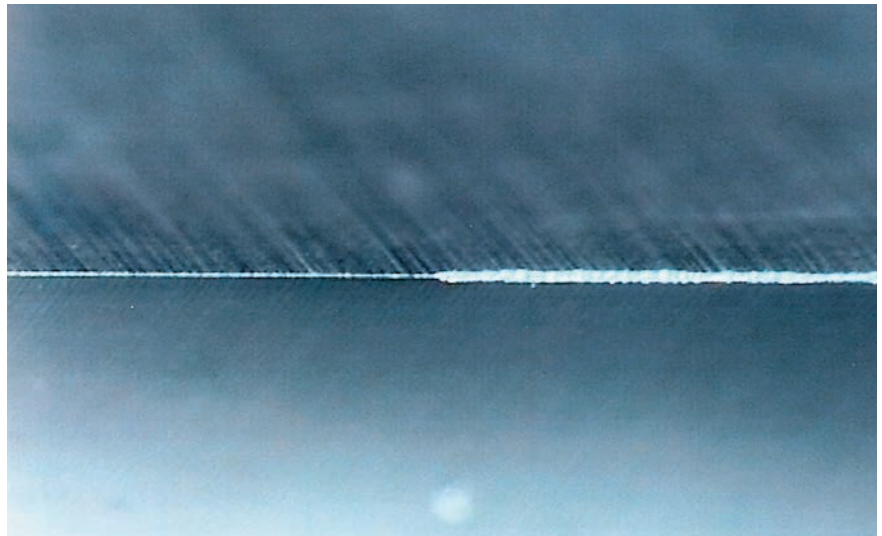
Too much wear on cutting edges.

#### Cutting edge abrasion

For largely homogenised materials, mechanical wear will lead to continuous rounding of the cutting edges.

The quality of the surface determined the level of abrasion and should normally be, as a guideline, between 0.2 to 0.3 mm maximum.

Tipped tools require resharpener to ensure the efficiency of the tools.

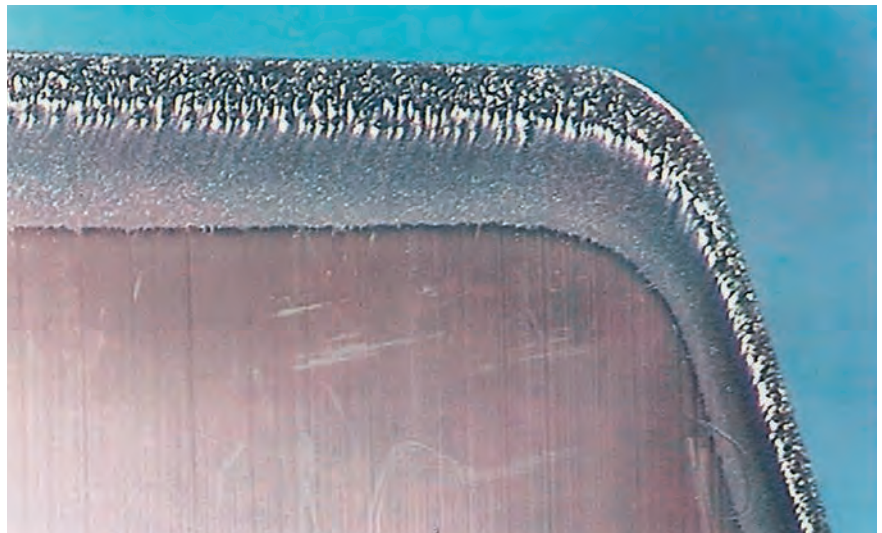


Common rounding of cutting edges after use for spruce

#### Cutting edge abrasion by chemical impact

When processing workpiece materials with a high content of tannic acids (e.g. oak), the cutting edge abrasion is mainly caused by mechanical plus chemical wear.

Cobalt, a binding agent in tungsten carbide, is washed out by chemical reaction leading to early depletion of the cutting edge.



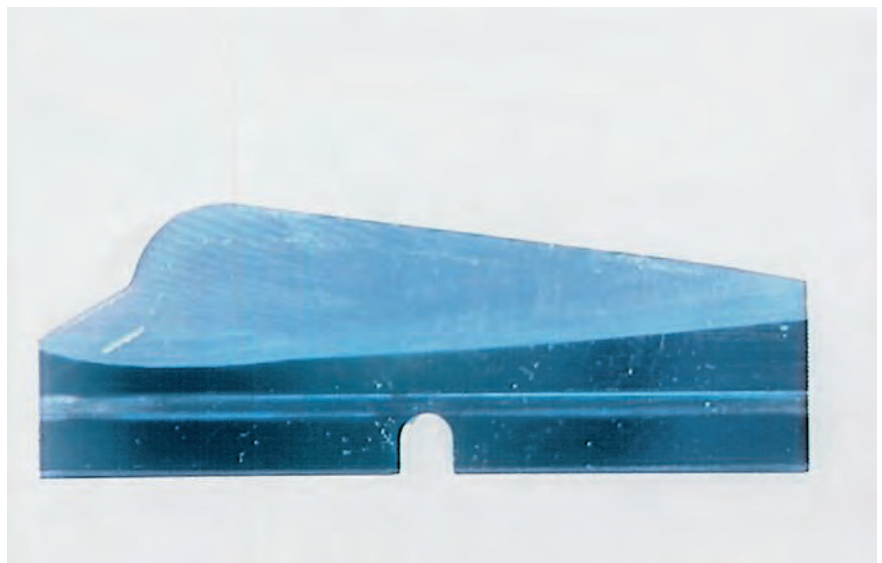
Chemical impact – Cutting edge abrasion – Application oak

#### Cutting edge damage caused by improper repair

For cutterheads/sets with HW cutting elements, the knives must be turned or replaced after reaching the end of their performance time.

Resharpener parallel to face will reduce the essential clamping forces, creating gaps between knives and clamping wedges, impair the surface quality, and is not permitted for safety reasons.

Ensure careful cleaning and mounting when changing the knives of tools with turnblade/throw away knives.



Cutting edge abrasion caused by improper repair

## Enquiry/order form special tools – planing and profiling

**Customer details:** Customer number:

(if known)

☐ Enquiry  
☐ Order

Delivery date: (not binding)

CW

Company:

Street:

Date:

Post code/place:

Enquiry/order no.:

Country:

Tool ID: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

Workpiece material:

- ☐ Solid wood Type:
- ☐ Wood material Type:
- ☐ Coating Type:
- ☐ Other Type:
- ☐ Finish hogging

Moisture:  %

Density:  g/cm<sup>3</sup>

Further information:

### Machine:

(e.g. spindle moulders, four-sided moulders  
edging machines, window making machines etc.)

Manufacturer:

Type/construction year:

Model:

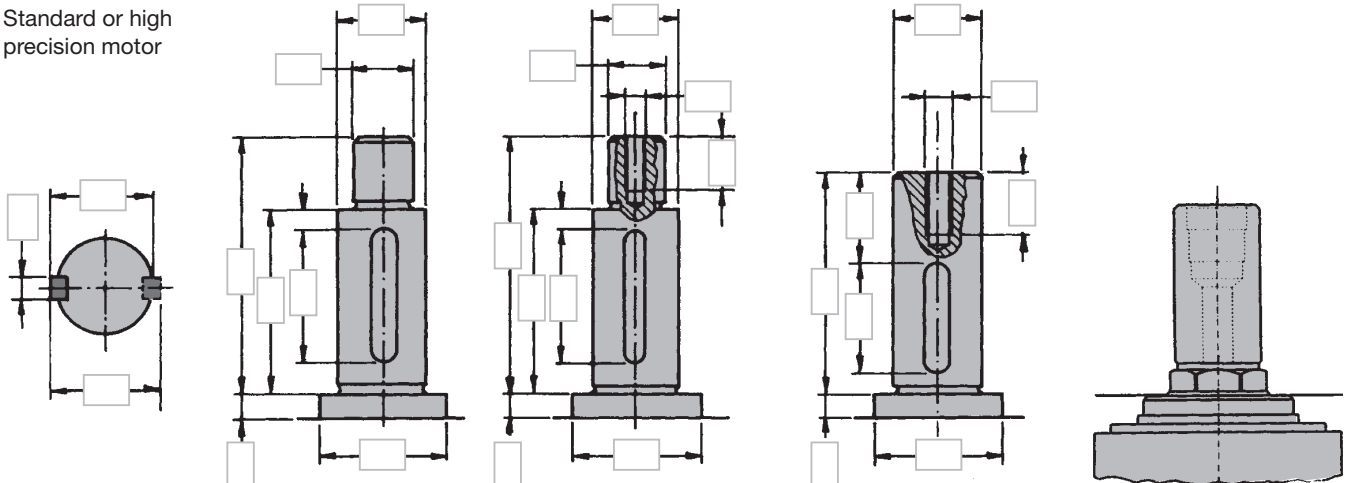
Specification of spindle sequence in feed direction

e. g.: 1 bottom, 2 right, 3 left, 4 top, 5 multi-purpose  
or: 1 scraping, 2 hogging, 3 cutting, 4 finish cutting, 5 post cutting  
or: 1 sawing, 2 slot/tenon, 3 cutting with feed, 4 cutting against feed

Motor no.:	Power:	RPM:	Spindle dimension:	Additional information:
1	<input type="text"/> kW	<input type="text"/> min <sup>-1</sup>	<input type="text"/> mm	<input type="text"/>
2	<input type="text"/> kW	<input type="text"/> min <sup>-1</sup>	<input type="text"/> mm	<input type="text"/>
3	<input type="text"/> kW	<input type="text"/> min <sup>-1</sup>	<input type="text"/> mm	<input type="text"/>
4	<input type="text"/> kW	<input type="text"/> min <sup>-1</sup>	<input type="text"/> mm	<input type="text"/>
5	<input type="text"/> kW	<input type="text"/> min <sup>-1</sup>	<input type="text"/> mm	<input type="text"/>

Direction of rotation (LH/RH) or cutting direction (with feed/against feed) must be specified for each spindle.

Standard or high  
precision motor





## Enquiry/order form special tools – planing and profiling

### Tool:

Tool type (e.g. one part/tipped tools/assembled tool, see product information)

Dimension:

Diameter: \_\_\_\_\_ mm

Cutting width: \_\_\_\_\_ mm

Bore: \_\_\_\_\_ mm

Number of teeth: \_\_\_\_\_

Cutting material:

- ☐ HL  
☐ HS  
☐ ST  
☐ HW  
☐ DP

Cutting point:

- ☐ no cutting point  
☐ sleeve with interlock  
☐ sleeve without interlock  
☐ quick clamping sleeve  
☐ hydro sleeve

Remark:

zero diameter: \_\_\_\_\_ mm

max. diam.: \_\_\_\_\_ mm

zero height: \_\_\_\_\_ mm

clamping length: \_\_\_\_\_ mm

Direction of rotation:

- ☐ right hand rotation  
☐ left hand rotation

Cutting direction:

- ☐ with feed  
☐ against feed

Kind of feed:

- ☐ manual (MAN)  
☐ mechanical (MEC)

Feed speed: \_\_\_\_\_ min<sup>-1</sup>

Cutting width (SB): \_\_\_\_\_ mm

Cutting depth: \_\_\_\_\_ mm

Application:

Solid wood

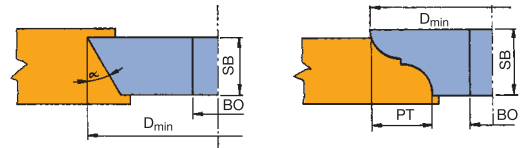
Wood materials ☐ top layer

☐ longitudinal

☐ Medium layer

☐ crosscut ☐ front

☐ Top and medium layer



### Technical information:

Tipped tools (bevel trimming cutters/profile routers):

Design: bending test, Z2, mech. feed, Z3, Z4, round shape  
 Tooth shape: with/without spur

Table for min. tool diameter.

Applicable for bevel trimming cutter

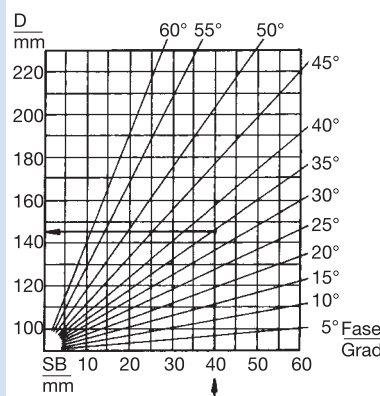
BO – 30 mm:

For bore 40 mm:

D + 10 mm

For bore 50 mm:

D + 20 mm



### Formula for min. tool diameter:

Applicable for profile routers BO – 30 mm:

For bore 40 mm: D + 10 mm

For bore 50 mm: D + 20 mm

**Formula:  $D_{min} = 100 + 2 \times PT$  (mm)**

### Note:

Bevels of more than 45° and large profile depths require large diameters. The maximum permitted RPM must be considered when calculated the cutting diameter and must not be exceeded. Profile sketches must clearly indicate whether the material (wood) or cutter is shown. Please specify motor side, direction of rotation, dimensions and any other conditions on the material sample or the drawings.

Assembled tools with turnblade/throw away knives:

**Formula:  $D_{min} = 90 + 2 \times PT$  (mm)** – Applicable for BO – 30 mm

Sketch for application plan, profile drawing, special motor spindle etc.

Please specify workpiece support and fence side and/or workpiece face side top/bottom.



## Key to pictograms



Scoring,  
top and  
bottom



Manual  
feed



Resharpenable  
cutting face



Hogging



Solid metal  
tool



Resharpenable  
clearance face



Grooving,  
horizontal  
and vertical



Tipped tool



Low noise



Jointing



Light alloy  
body



High-alloyed  
tool steel



Rebating



Interchangeable  
knives



High-speed  
steel



Profiling



Mechanical  
knife clamping,  
reversible



Tungsten  
carbide



Profiling  
joints



Centrifugal  
knife  
clamping,  
reversible



Carbide  
metal coating



Profiling  
tongue  
and groove



Mechanical knife  
clamping,  
adjustable  
- serrated



Planing



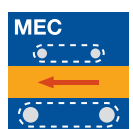
Mechanical knife  
clamping  
adjustable  
- plane echan.



Planing,  
profiling



Mechanical  
knife clamping,  
re-sharpenable and  
constant diameter



Mechanical  
feed



Hydro clamping



# Manual feed

Leitz Lexicon Edition 7

Version 2

11/2021





## Explanation of abbreviations

A	= dimension A
$a_e$	= cutting thickness (radial)
$a_p$	= cutting depth (axial)
ABM	= dimension
APL	= panel raising length
APT	= panel raising depth
AL	= working length
AM	= number of knives
AS	= anti sound (low noise design)

b	= overhang
B	= width
BDD	= thickness of shoulder
BEM	= note
BEZ	= description
BH	= tipping height
BO	= bore diameter

CNC	= Computerized Numerical Control
-----	----------------------------------

d	= diameter
D	= cutting circle diameter
D0	= zero diameter
DA	= outside Diameter
DB	= diameter of shoulder
DFC	= Dust Flow Control (optimised chip clearance)
DGL	= number of links
DIK	= thickness
DKN	= double keyway
DP	= polycrystalline diamond
DRI	= rotation

FAB	= width of rebate
FAT	= depth of rebate
FAW	= bevel angle
FLD	= flange diameter
$f_z$	= tooth feed
$f_{z\text{ eff}}$	= effective tooth feed

GEW	= thread
GL	= total length
GS	= Plunging edge

H	= height
HC	= tungsten carbide, coated
HD	= wood thickness (thickness of workpiece)
HL	= high-alloyed tool steel
HS	= high-speed steel (HSS)
HW	= tungsten carbide (TCT)

ID	= ident number
IV	= insulation glazing

KBZ	= abbreviation
KLH	= clamping height
KM	= edge breaker
KN	= single keyway
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60

L	= length
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LH	= left hand rotation
----	----------------------

M	= metric thread
MBM	= minimum order quantity
MC	= multi-purpose steel, coated
MD	= thickness of knife
$\text{min}^{-1}$	= revolutions per minute (RPM)
MK	= morse taper
$\text{m min}^{-1}$	= metres per minute
$\text{m s}^{-1}$	= metres per second

n	= RPM
$n_{\text{max}}$	= maximum permissible RPM
NAL	= position of hub
ND	= thickness of hub
NH	= zero height
NL	= cutting length
NLA	= pinhole dimensions
NT	= grooving depth

P	= profile
POS	= cutter position
PT	= profile depth
PG	= profile group

QAL	= cutting material quality
-----	----------------------------

R	= radius
RD	= right hand twist
RH	= right hand rotation
RP	= radius of cutter

S	= shank dimension
SB	= cutting width
SET	= set
SLB	= slotting width
SLL	= slotting length
SLT	= slotting depth
SP	= tool steel
ST	= Cobalt-basis cast alloys, e.g. Stellite™
STO	= shank tolerance
SW	= cutting angle

TD	= diameter of tool body
TDI	= thickness of tool
TG	= pitch
TK	= reference diameter

UT	= cutting edges with irregular pitch
----	--------------------------------------

V	= number of spurs
$v_c$	= cutting speed
$v_f$	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
-----	----------------------

Z	= number of teeth
ZA	= number of fingers
ZF	= tooth shape (cutting edge shape)
ZL	= finger length

### Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



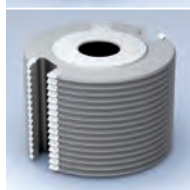
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<b>Application</b>	To produce different groove widths, manual or mechanical feed, along or across the grain.
<b>Workpiece material</b>	Softwood and hardwood, glulam, chipboard and fibre materials, uncoated, veneered, plastic and paper coated. Plastics and foams.
<b>Machines</b>	Portable machines, spindle moulders, moulders, double-end tenoners, machining centres, edgebanding machines etc.
<b>Type of feed</b>	Manual feed: Application only against feed.  Mechanical feed: Application with or against feed, for minimum tear out, use with feed necessary.

#### Tool design



Tipped tools:  
With HW or DP. DP tips suitable for abrasive materials.

Replaceable tip tools:  
Design with HW turnblade cutters for constant diameter and constant cutting widths.

Two and multiple part tools:  
Designed so the cutting width can be adjusted either by spacers (adjustment steps of 0.10 mm) or by a continuously adjustable sleeve for HW or DP tipped tools.

Single tools:  
Suitable for use as set.

Optimised gullet design DFC:  
The DFC concept directs the chips away from the workpiece, so leaving the tool cutting area unhindered. DFC increases tool performance.

Benefits:

- Better product quality by eliminating chip marks or damage to the workpiece edges.
- Reduced tool cutting edge wear by eliminating multiple cutting.

#### Recommended value for tooth feed rate $f_z$ (in mm)

<b>Solid wood</b>	
Along	0.60 – 0.80 mm
Across	0.30 – 0.40 mm
<b>Glulam</b>	0.40 – 0.50 mm
<b>Chipboard and fibre material</b>	
Without coating	0.50 – 0.70 mm
Coated	0.20 – 0.40 mm
Veneered	0.10 – 0.15 mm
<b>Wood derived materials</b>	
Middle layer	0.30 – 0.60 mm
Top layer	0.08 – 0.12 mm
Plastic	0.20 – 0.50 mm
Polymer compound	0.05 – 0.05 mm
Non-ferrous metals	0.03 – 0.05 mm

$$v_f = f_z \cdot n \cdot Z / 1000$$



### Grooving cutters for manual feed

#### Application:

For grooving with (MEC) or against feed (MAN).

#### Machine:

Spindle moulders, moulders and double-end tenoners.

#### Workpiece material:

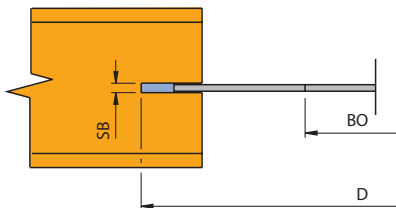
Solid wood; uncoated, coated and veneered wood derived materials.

#### Technical information:

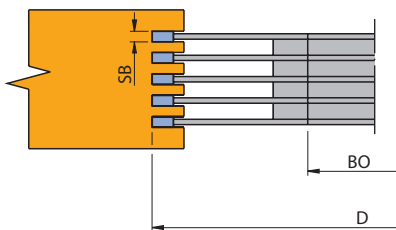
Tool body design with round, closed shape.

#### Z 12

WF 100 1 05



Scheme: Grooving in middle layer



Scheme: Set assembly for lock corner joint

D mm	SB mm	TDI mm	BO mm	BO <sub>max</sub> mm	Z	n min <sup>-1</sup>	ID
125	1.5	0.8	30	50	12	6200 - 13700	020241 ●
125	2.0	1.2	30	50	12	6200 - 13700	020243 ●
125	2.5	1.4	30	50	12	6200 - 13700	020245 ●
125	3.0	2.0	30	50	12	6200 - 13700	020246 ●
125	3.5	2.2	30	50	12	6200 - 13700	020247 ●
125	4.0	2.5	30	50	12	6200 - 13700	020248 ●
125	4.5	3.0	30	50	12	6200 - 13700	020249 ●
150	1.5	0.8	30	60	12	5200 - 11400	020265 ●
150	2.0	1.2	30	60	12	5200 - 11400	020267 ●
150	2.5	1.4	30	60	12	5200 - 11400	020269 ●
150	3.0	2.0	30	60	12	5200 - 11400	020250 ●
150	3.5	2.2	30	60	12	5200 - 11400	020251 ●
150	4.0	2.5	30	60	12	5200 - 11400	020252 ●
150	4.5	3.0	30	60	12	5200 - 11400	020253 ●
150	5.0	3.5	30	60	12	5200 - 11400	020254 ●
150	6.0	4.5	30	60	12	5200 - 11400	020255 ●
150	7.0	5.0	30	60	12	5200 - 11400	020256 ●
150	8.0	6.0	30	60	12	5200 - 11400	020257 ●
150	9.0	7.0	30	60	12	5200 - 11400	160100 ●
150	10.0	8.0	30	60	12	5200 - 11400	160101 ●
180	4.0	2.5	30	70	12	4300 - 9500	020260 ●
180	5.0	3.5	30	70	12	4300 - 9500	020261 ●
180	6.0	4.5	30	70	12	4300 - 9500	020262 ●
180	8.0	6.0	30	70	12	4300 - 9500	020263 ●
180	10.0	8.0	30	70	12	4300 - 9500	160102 ●

Groove cutter for MEC, see section Panel Processing.

For spacers TR 100 0 used as a set, see section Knives and Spare Parts.



## Grooving cutter - lamello joints

**Application:**

For grooving lamello joints and for cutting grooves for corner joints and longitudinal joints (e.g. picture frames, furniture doors).

**Machine:**

Portable power tools - grooving cutters (e.g. Lamello etc.).

**Workpiece material:**

Solid wood; uncoated, coated and veneered wood derived materials.

**Technical information:**

Tool body design with round, closed shape.

**HW tipped**

WF 102 1 01

D	SB	BO	NLA	Z	V	QAL	n	ID
mm	mm	mm	mm				min <sup>-1</sup>	
100	4.0	22	4/4.5/36	2	4	HW	7800 - 13300	<b>020124 ●</b>

**DP tipped**

WF 100 1 DP

D	SB	BO	NLA	Z	QAL	n	ID
mm	mm	mm	mm			min <sup>-1</sup>	
100	4	22	4/4.5/36	4	DP	7800 - 13300	<b>090017 ●</b>

**Grooving cutterhead**

WW 102 1 01

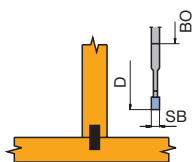
D	SB	BO	NLA	Z	V	QAL	n	ID
mm	mm	mm	mm				min <sup>-1</sup>	
100	4	22	4/4.5/36	2/2	2/2	HW	7800 - 13300	<b>020131 ●</b>

**Spare knives:**

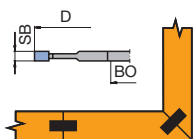
Part-no.	BEZ	QAL	VE	ID
			PCS	
1	Turnblade knife	HW	10	<b>005114 ●</b>
2	Turnblade spur VS4	HW	10	<b>005130 ●</b>

**Spare parts:**

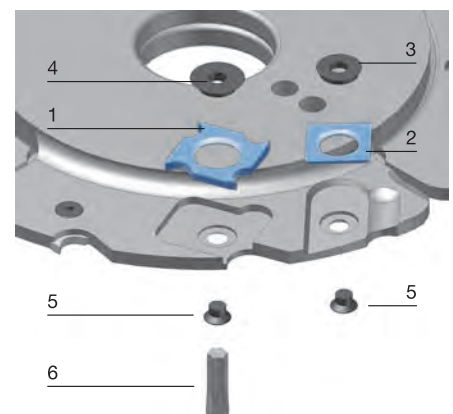
Part-no.	BEZ	ABM	ID
		mm	
3	Special nut for VS	M9.9/1.60	<b>005654 ●</b>
4	Special nut for WPL	M11.9/2.20	<b>005653 ●</b>
5	Countersink screw, Torx® 9	M4x0.5x3.2	<b>006057 ●</b>
6	Torx® key	Torx® 9	<b>005463 ●</b>

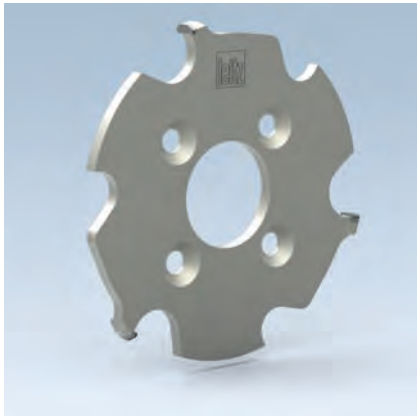


Lamello - T-joint



Lamello - Longitudinal/corner joint





### Grooving cutter Lamello® Clamex® P-System®

#### Application:

For grooving lamello joints and for cutting grooves for corner joints and longitudinal joints.

#### Machine:

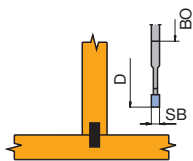
Portable power tools - grooving cutters (e.g. Lamello etc.) and for use on CNC machining centres.

#### Workpiece material:

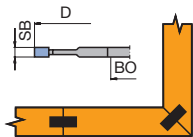
Solid wood; uncoated, coated and veneered wood derived materials.

#### Technical information:

Tool body design with round, closed shape.



Lamello - T-joint



Lamello - Longitudinal/corner joint

#### DP tipped for Clamex P - connector

WK 100 3 DP, WK 103 2 DP

D	SB	BO	NLA	Z	QAL	n	ZF	DRI	ID
mm	mm	mm	mm			min <sup>-1</sup>			
100.4	7	16	4/5,5/28	3	DP	7800 - 13300	TR	RH	<b>192297 ●</b>
100.4	7	22	4/4,3/36	3	DP	7800 - 13300	TR	RH	<b>192294 ●</b>
100.4	7	30	4/6,6/48	3	DP	7800 - 13300	TR	LH	<b>192295 ●</b>
100.4	7	30	4/6,6/48	3	DP	7800 - 13300	TR	RH	<b>090018 ●</b>
100.4	7	30	4/6,6/48	6	DP	7800 - 13300	TR	RH	<b>192298 ●</b>
100.4	7	30	4/6,9/52	6	DP	7800 - 13300	TR	LH,	<b>192311 ●</b>
			4/6,9/48					RH	
100.4	7	40	4/5,5/52	3	DP	7800 - 13300	TR	RH	<b>192296 ●</b>

Suitable arbors see section Clamping Systems. Drills for access bore see section Drilling.

#### Arbors with shank to mount the grooving cutter

S16x50,d30,l4,L85 ID **041429**

S25x60,d=30,l=4,L=102 ID **041367**

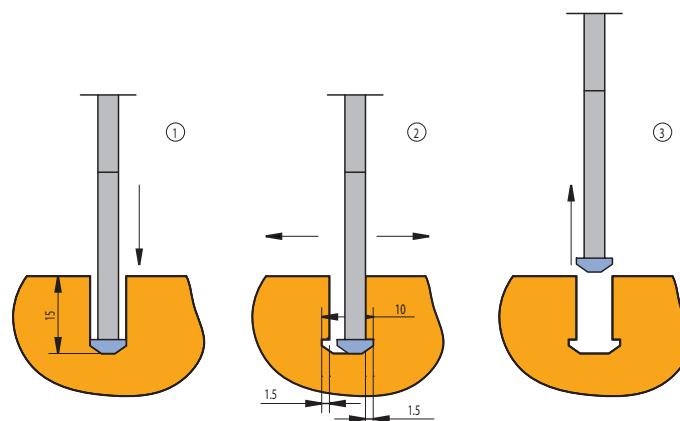
S20x50,d=30,l=4,L=102 ID **041368**

S25x60,d=30,l=4,L=127 ID **042980**

#### Drill for access bore hole

D = 6 mm ID **034116**

Shank cutter for CNC: ID **039161**



1. 15 mm plunge.
2. 1.5 mm left and right side recesses.
3. Leaving from the middle position.



### Grooving cutterset, adjustable with spacers

#### Application:

For cutting different groove widths.

#### Machine:

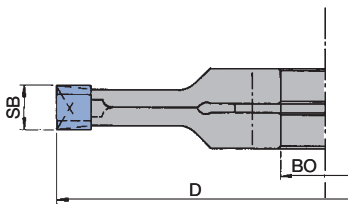
Spindle moulders, moulders, edgebanding machines and stationary routers with/without CNC control, double-end tenoners.

#### Workpiece material:

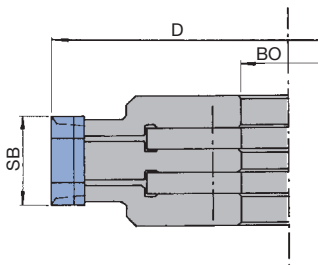
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials in top layer and middle layer.

#### Technical information:

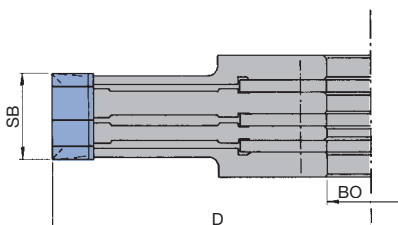
Adjustment of cutting widths with spacers (adjustment 0.10 mm).



Grooving cutterset, 2 part design



Grooving cutterset with 1 additional extension part



Grooving cutterset with 2 additional extension parts

#### 2 part with spurs; SB 1.8 - 23.5 mm

SF 501 1 01

D	SB	BO	BO <sub>max</sub>	Z	V	NT	n	ID
mm	mm	mm	mm			mm	min <sup>-1</sup>	
140	1.8 - 3.4	30	35	4	4	20	5500 - 9500	020545 ●
140	1.8 - 3.4	35	35	4	4	20	5500 - 9500	020546 □
140	1.8 - 3.4	40	45	4	4	20	5500 - 9500	020547 □
140	2.2 - 4.0	30	35	4	4	20	5500 - 9500	020549 ●
140	2.2 - 4.0	35	35	4	4	20	5500 - 9500	020550 □
140	2.2 - 4.0	40	40	4	4	20	5500 - 9500	020551 □
140	2.2 - 4.0	50	50	4	4	20	5500 - 9500	020552 □
150	4.0 - 7.5	30	35	4	4	37.5	5200 - 8900	020573 ●
150	4.0 - 7.5	40	45	4	4	30	5200 - 8900	020575 □
150	4.0 - 7.5	50	50	4	4	27.5	5200 - 8900	020576 □
150	7.5 - 14.5	30	35	4	4	37.5	5200 - 8900	020580 ●
150	7.5 - 14.5	35	45	4	4	30	5200 - 8900	020581 □
150	7.5 - 14.5	40	45	4	4	30	5200 - 8900	020582 □
150	7.5 - 14.5	50	50	4	4	27.5	5200 - 8900	020583 □
180	6.0 - 11.5	30	35	4	4	45	4300 - 7400	020584 ●
180	12.0 - 23.5	30	35	4	4	45	4300 - 7400	020585 ●
180	12.0 - 23.5	40	45	4	4	45	4300 - 7400	020586 □

#### 2 part; SB 5.2 - 14 mm

SF 501 1 03

D	SB	BO	BO <sub>max</sub>	NLA	Z	V	NT	n	ID
mm	mm	mm	mm	mm			mm	min <sup>-1</sup>	
250	5.2 - 10	30	35	2/10/60	8	8	40	3500 - 6000	020693 ●
250	5.2 - 10	35	60		8	8	40	3100 - 5300	020694 □
250	7.2 - 14	35	60		8	8	40	3100 - 5300	020697

#### 3 / 4 part; SB 4.0 - 30 mm

SF 501 1, SF 501 1 02

D	SB	BO	BO <sub>max</sub>	NLA	Z	V	NT	n	ID
mm	mm	mm	mm	mm			mm	min <sup>-1</sup>	
150	7.5 - 28	50	50		4+4	4	22	5200 - 8900	020661
160	4 - 13	30	35		4	4	35	5000 - 10700	020667 ●
220	5 - 30	30	35	2/10/60	4+4	4	55	3500 - 6000	020662 ●



## 4. Manual feed

### 4.1 Grooving

#### 4.1.1 Grooving cutters



#### Grooving cutterset, adjustable with spacers

##### Application:

For cutting different groove widths. 2 part design.

##### Machine:

Spindle moulders, moulders, edgebanding machines and double-end tenoners.

##### Workpiece material:

Uncoated, coated and veneered wood derived materials.

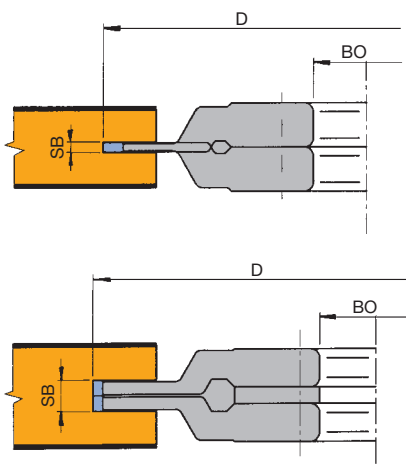
##### Technical information:

Adjustment of cutting width with spacers (adjustment 0.10 mm).  
Diamaster PRO design. Tip height 3.0 mm.

#### 2 part; Diamaster PRO; SB 5.0 - 9.5 mm

SF 501 1 DP

D	SB	BO	BO <sub>max</sub>	NT	Z	n	ID
mm	mm	mm	mm	mm		min <sup>-1</sup>	
180	5.0 - 9.5	30	50	25	4/4	4300 - 7400	090301 ●



Application examples of grooving in the middle layer



### Grooving cutterhead set adjustable with spacers

#### Application:

For cutting different groove widths.

#### Machine:

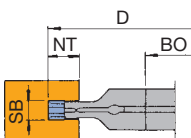
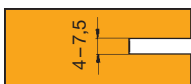
Spindle moulders, moulders, edgebanding machines and stationary routers with/without CNC control, double-end tenoners.

#### Workpiece material:

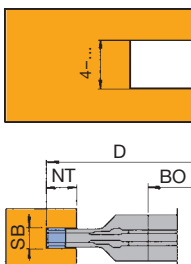
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials in top layer and middle layer.

#### Technical information:

Adjustment of cutting widths with spacers (adjustment 0.10 mm).



Grooving cutterhead set, 2 part design



Grooving cutterhead set, multi part design

#### 2 part; SB 4.0 - 7.5 mm

SW 501 1 01

D mm	SB mm	BO mm	BO <sub>max</sub> mm	NT mm	Z	n min <sup>-1</sup>	ID
150	4.0 - 7.5	30	50	20	2/2	5200 - 10100	<b>128100 ●</b>
180	4.0 - 7.5	30	50	35	2/2	4300 - 8400	<b>128101 ●</b>

#### Extension parts SB 3.8 mm

WW 200 1 NN

D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	n min <sup>-1</sup>	ID
150	3.8	30	50	2	5200 - 10100	<b>128130</b>
180	3.8	30	50	2	4300 - 8400	<b>128131</b>

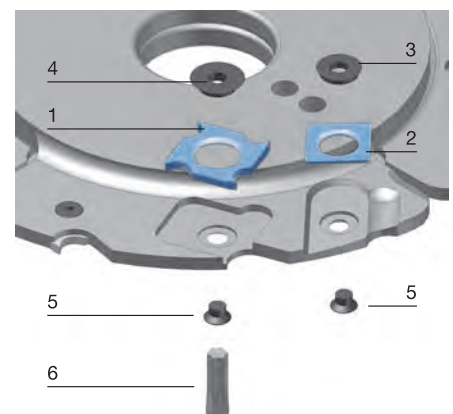
Each extension part increases the cutting widths by 3.6 mm.

#### Spare knives:

Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	18x18x1.95	HW	10	<b>005114 ●</b>
2	Turnblade spur VS4	14x14x1.2	HW	10	<b>005130 ●</b>

#### Spare parts:

Part-no.	BEZ	ABM mm	ID
3	Special nut for VS	M9.9/1.60	<b>005654 ●</b>
4	Special nut for WPL	M11.9/2.20	<b>005653 ●</b>
5	Countersink screw, Torx® 9	M4x0.5x3.2	<b>006057 ●</b>
6	Torx® key	Torx® 9	<b>005463 ●</b>
	Setting gauge for knives	0.3/0.8	<b>005374 ●</b>





### Grooving cutterhead set adjustable with spacers

#### Application:

For cutting different groove widths.

#### Machine:

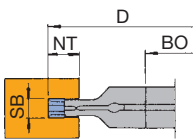
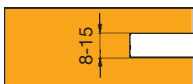
Spindle moulders, moulders, edgebanding machines and stationary routers with/without CNC control, double-end tenoners.

#### Workpiece material:

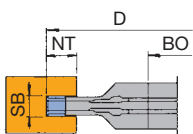
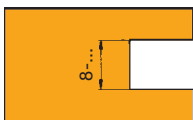
Solid wood along grain and across grain; uncoated, coated and veneered wood derived materials.

#### Technical information:

Adjustment of cutting widths with spacers (adj. range 0.1 mm). Multi part design.



Grooving cutterhead set, 2 part design



Grooving cutterhead set, multi part design

#### Multi part; SB 8.0 - 30.0 mm

SW 501 1, SW 501 1 01

D mm	SB mm	BO mm	NT mm	Z	n min <sup>-1</sup>	ID
150	8.0 - 15.4	30	20	2/2	5200 - 10100	<b>128104 ●</b>
180	8.0 - 15.4	30	35	2/2	4300 - 8400	<b>128105 ●</b>
200	8.0 - 15.4	30	45	2/2	3900 - 7600	<b>128106 ●</b>
220	8.0 - 30.0	30	58	2/2	3500 - 6000	<b>024663 ●</b>

#### Extension part

SW 501 1, WW 200 1 NN

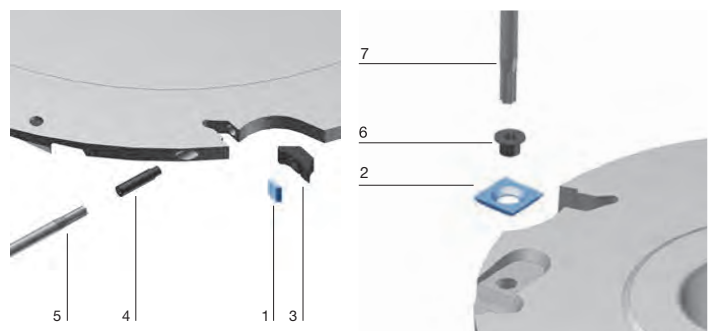
D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	n min <sup>-1</sup>	ID
150	7.7	30	50	2	5200 - 10100	<b>128134</b>
180	7.7	30	50	2	4300 - 8400	<b>128135 ●</b>
200	7.7	30	50	2	3900 - 7600	<b>128136 ●</b>
220	15	30	45	2	3500 - 6000	<b>024666 ●</b>

#### Spare knives:

Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	7.7x8x1.5	HW-05	10	<b>005053 ●</b>
1	Turnblade knife	14.7x8x1.5	HW-05	10	<b>005056 ●</b>
2	Turnblade spur VS1	14x14x2	HW-F	10	<b>005099 ●</b>
2	Turnblade spur VS2	19x19x2	HW-F	10	<b>005115 ●</b>

#### Spare parts:

Part-no.	BEZ	ABM mm	ID
3	Clamping wedge	7x18.75x8.27	<b>009763 ●</b>
3	Clamping wedge	13x18.75x8.27	<b>009670 ●</b>
4	Allen screw with shank, Torx® 15	M5x20	<b>007380 ●</b>
4	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 ●</b>
5	Torx® key	Torx® 15	<b>117507 ●</b>
5	Torx® key	Torx® 25	<b>117504 ●</b>
6	Countersink screw, Torx® 20	M6x0.5x4.9	<b>006243 ●</b>
7	Torx® key	Torx® 20	<b>117503 ●</b>
	Setting gauge for knives	0.3/0.8	<b>005374 ●</b>





### Grooving cutterhead - steplessly adjustable

#### Application:

For cutting different groove widths.

#### Machine:

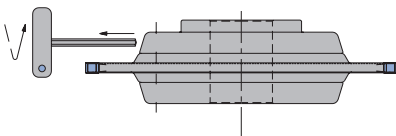
Spindle moulders, moulders, edgebanding machines and double-end tenoners.

#### Workpiece material:

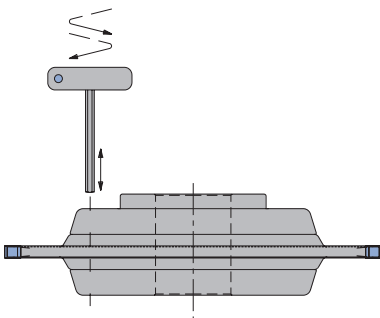
Solid wood; uncoated, coated and veneered wood derived materials.

#### Technical information:

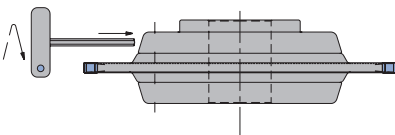
Stepless adjustment of cutting width possible when installed on machine.  
2 part design.



Opening the clamping system



Adjustment: SB larger „+“,  
SB smaller „-“



Closing the clamping system

After the tool is mounted on the spindle  
it can be adjusted and clamped using a  
hexagon key

#### Mounted on sleeve; SB 4.0 - 15.0 mm

SW 502 1 01

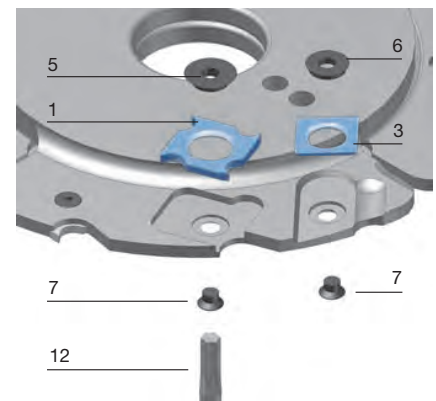
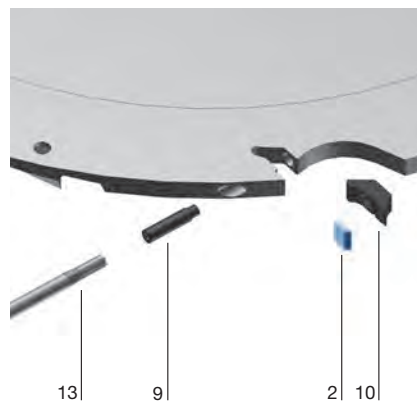
D	SB	BO	BO <sub>max</sub>	NT	Z	n	ID
mm	mm	mm	mm	mm		min <sup>-1</sup>	
180	4.0 - 7.5	30	35	40	2/2	4300 - 8400	<b>128154</b> ●
180	8.0 - 15.0	30	35	40	2/2	4300 - 8400	<b>128155</b> ●
180	4.0 - 7.8	40	50	35	2/2	4300 - 8400	<b>128156</b> ●
180	8.0 - 15.0	40	50	35	2/2	4300 - 8400	<b>128157</b> ●

#### Spare knives:

Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	18x18x1.95	HW	10	<b>005114</b> ●
2	Turnblade knife	7.7x8x1.5	HW-05	10	<b>005053</b> ●
3	Turnblade spur VS4	14x14x1.2	HW	10	<b>005130</b> ●
4	Turnblade spur VS2	19x19x2	HW-F	10	<b>005115</b> ●

#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
5	Special nut for WPL	M11.9/2.20	<b>005653</b> ●
6	Special nut for VS	M9.9/1.60	<b>005654</b> ●
7	Countersink screw, Torx® 9	M4x0.5x3.2	<b>006057</b> ●
8	Countersink screw, Torx® 20	M6x0.5x4.9	<b>006243</b> ●
9	Allen screw with shank, Torx® 15	M5x20	<b>007380</b> ●
10	Clamping wedge	7x18.75x8.27	<b>009763</b> ●
11	Torx® key	Torx® 20	<b>117503</b> ●
12	Torx® key	Torx® 9	<b>005463</b> ●
13	Torx® key	Torx® 15	<b>117507</b> ●
	Setting gauge for knives	0.3/0.8	<b>005374</b> ●



## 4. Manual feed

### 4.1 Grooving 4.1.3 Profile cutter



#### Profile cutter - pitch pockets

**Application:**

Optimized for milling pitch pockets.

**Machine:**

Portable machine Lamello Standard and Lamello Top.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

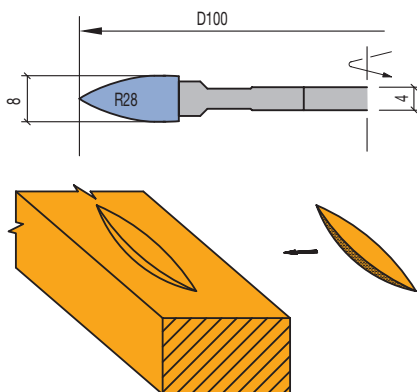
Two reciprocal cutting knives.

**Radii profile**

WF 502 1

D	SB	BO	BEM	Z	ID
mm	mm	mm			
100	8	22	Size 1-3	1+1	020126 ●

**RPM:**  $n = 7700 - 13000 \text{ min}^{-1}$

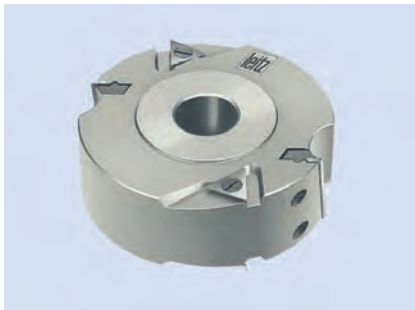


## 4. Manual feed

### 4.2 Jointing, rebating and bevelling

<b>Type of operation</b>	Rebate tools cut on the periphery and the side. The rebated edge is produced by spurs.
<b>Workpiece material</b>	Softwood and hardwood, glulam, chipboard and fibre materials, uncoated, veneered, plastic and paper coated. Plastics and foams.
<b>Machines</b>	Spindle moulders. Edgebanding machines; double-end tenoners. Four-sided moulders.
<b>Application</b>	Jointing and rebating against feed: all panel materials with or without coating. Jointing and rebating with feed: machining solid wood with heavily twisted fibres and risk of tear outs. Only for machines with mechanical feed. Note: Difficult chip removal. Jump cutting: jointing with or against feed across grain to avoid tear outs at the front and rear workpiece edges after edgebanding or lipping.

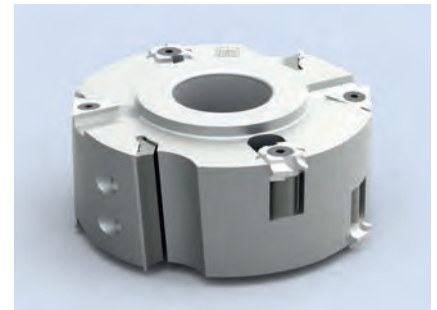
#### Tool design



Turnblade rebating cutterhead with alternate shear angle:  
Reduced feed and cutting forces achieve clean and tear out free rebating edges. Suitable for all coated and uncoated panel materials as well as solid wood.

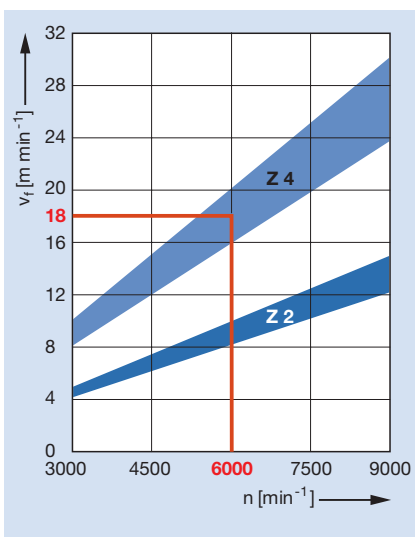


2 part tools with alternate shear angle:  
Can also be used as adjustable grooving tools.

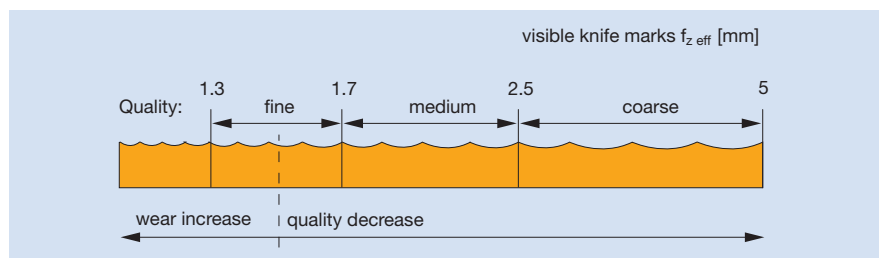


Turnblade rebating cutterhead with additional knives (edge knives):  
Multi-purpose tool for jointing, rebating and rounding/bevelling.

#### Feed speed depending on RPM and no. of teeth



#### Relation between surface quality and length of knife marks $f_{z \text{ eff}}$

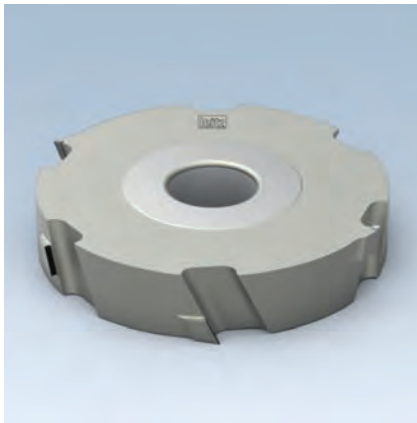


With multi blade tools, only the marks of one knife show on the surface (one knife finish).  
Z 2 and Z 4 tools produce the same surface quality with the same machine setting.  
High numbers of teeth are required for a high hogging performance.

## 4. Manual feed

### 4.2 Jointing, rebating and bevelling

#### 4.2.1 Jointing and rebating cutters



#### Jointing and rebating cutter Diamaster PRO

##### Application:

Optimized for rebating and jointing with and against feed (e.g. jump cutting). Manual feed only against feed.

##### Machine:

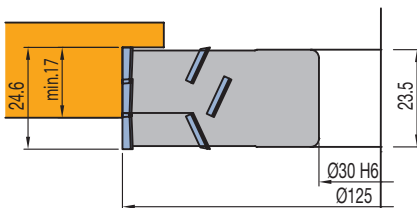
Spindle moulders and edgebanding machines, double-end tenoners.

##### Workpiece material:

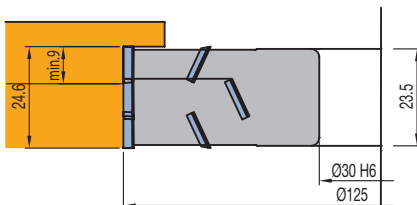
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.) uncoated, laminated veneer lumber (plywood etc.), plastomers, solid surface material (Corian, Varicor etc.) fibre reinforced plastics (GFRP, CFRP etc.).

##### Technical information:

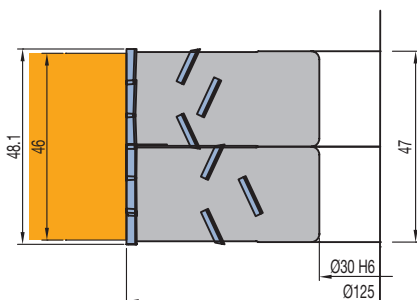
Composite tool with alternate shear angle and main blades with pre-cutting function. Long performance times through polished cutting area. Diamaster PRO design for two resharpening cycles with standard wear. Double sided rebating possible. For larger cutting widths a stacking of various tools is possible. 3.5 mm tipping height. 1.5 mm resharpening area.



Jointing cutter ID **090853**  
Rebate height min. 17 mm



Jointing cutter ID **090872**  
Rebating height min. 9 mm



Set existing of ID **090853** and ID **090872**

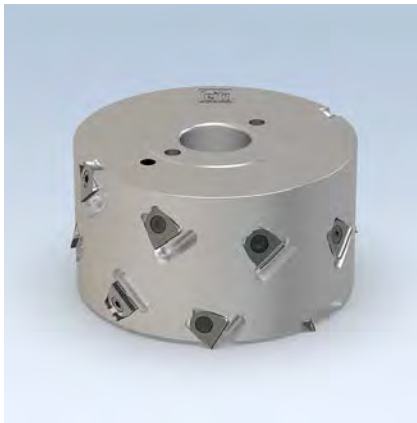
##### Diamaster PRO

WF 400 1 DP

D	SB	BO	Z	ID
mm	mm	mm		
125	24.6	30	2/2/2	<b>090853</b> ●
125	24.6	30	2/2/2	<b>090872</b> ●

RPM: n = 6200 - 13600 min<sup>-1</sup>





#### Jointing and rebating cutter WhisperCut EdgeExpert

##### Application:

Optimized for noise reduced rebating and jointing particularly for sensitive decorative papers, foil coatings and veneers.

##### Machine:

Spindle moulders and edgebanding machines.

##### Workpiece material:

Chip and fibre boards (MDF etc.) raw, veneered, painted and coated; especially for plastic, paper, HPL and anti-fingerprint coatings. Also suitable for surfaces in mat, high gloss or with relief structures.

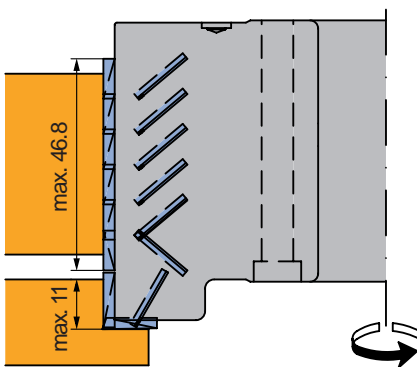
##### Technical information:

DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. With rebating knife for tear-free rebating edges (up to 11 mm rebating width). Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Noise reduced design with up to 5 dB(A) noise reduction. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable knives. 0.6 mm resharpening area.

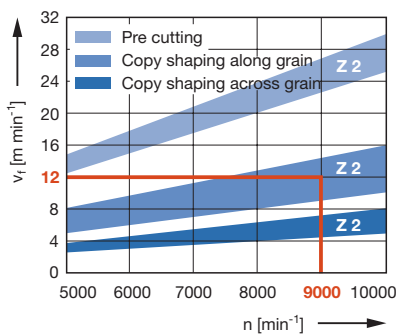
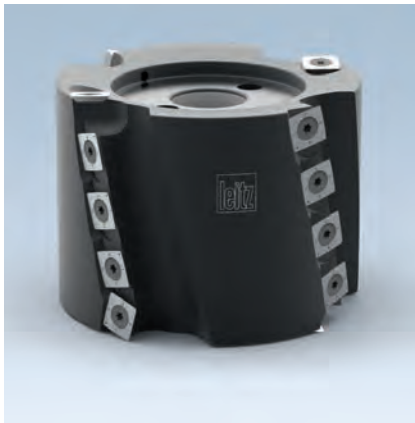
##### Diamaster WhisperCut EdgeExpert - LowNoise, aluminium tool body

WM 430 2 01

D	SB	BO	$n_{\max}$	Z	DRI	ID
mm	mm	mm	$\text{min}^{-1}$			
125	59.8	30	13,700	2/2	RH	192309 ●



Diamaster WhisperCut EdgeExpert  
jointing and rebating cutterhead



**Feed speed  $v_f$  depending on the number of teeth  $Z$  and speed  $n$  for solid wood (pre trimming and copy shaping)**

**Example for tool diameter 125 mm:**  
 $n = 9000 \text{ min}^{-1}$

$Z = 2$

Application: copy shaping along the grain

$v_f = 12 \text{ m min}^{-1}$

### Copy shaping cutterhead - HeliCut 15

#### Application:

For pre-cutting, jointing and copy shaping of large cutting depths. For copy shaping of curved workpieces with template, ball bearing and guide ring.

#### Machine:

Spindle moulders and profile milling machines, double-end tenoner, stationary routers with and without CNC control.

#### Workpiece material:

Softwood and hardwood, glulam, chipboard and fibre materials (MDF etc.) uncoated, plastic coated, veneered etc.

#### Technical information:

Noise reduced design with staggered edges and very deep gullets for improved chip removal. Tungsten carbide cutting edges with Microfinish for perfect surface quality. Rebate tools cut on the periphery and the side.

#### Cutterhead for copy shaping, grooving and rebating

WW 230 2 07

D	SB	BO	Z	V	QAL	AM	ID
mm	mm	mm				PCS	
60	81.5	20	2	2	HW-MF	16	<b>132600 ●</b>
80	81.5	30	2	2	HW-MF	16	<b>132608 ●</b>
125	93.7	30	2	2+2	HW-MF	20	<b>132604 ●</b>
125	116.6	30	2	2+2	HW-MF	24	<b>132605 ●</b>

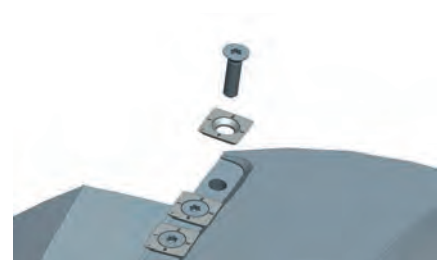
**RPM:** D 60 mm:  $n_{\max} = 20000 \text{ min}^{-1}$   
 D 80 mm:  $n_{\max} = 18000 \text{ min}^{-1}$   
 D 125 mm:  $n_{\max} = 12000 \text{ min}^{-1}$

#### Spare knives:

BEZ	ABM	QAL	BEM	VE	ID
	mm			PCS	
Turnblade knife	15x15x2,5	HW-MF	HeliCut 15	10	<b>009543 ●</b>
Turnblade knife	15x15x2,5	HW	HeliCut 15	10	<b>009549 ●</b>

#### Spare parts:

BEZ	ABM	for D	ID
	mm	mm	
Countersink screw, Torx® 20	M5x12	60	<b>007898 ●</b>
Countersink screw, Torx® 20	M5x14.2-8.8	80	<b>007394 ●</b>
Countersink screw, Torx® 20	M5x18	125	<b>114030 ●</b>
Torx® key	Torx® 20		<b>006091 ●</b>





### Rebating cutterhead

#### Application:

For jointing, rebating and grooving.

#### Machine:

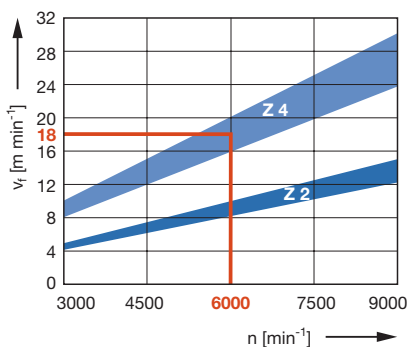
Spindle moulders (running against feed), double-end tenoners, edgebanding machines etc. (running with feed or against feed e.g. jump cutting). Stationary routers with/without CNC control.

#### Workpiece material:

Softwood and hardwood, glulam, plastics etc.

#### Technical information:

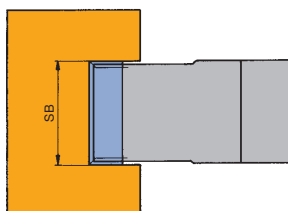
Cutterhead with alternate shear angle and triangular spurs.



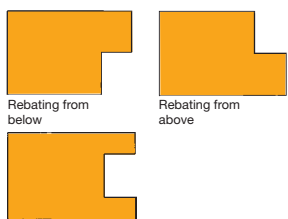
**Feed speed  $v_f$  depending on the number of teeth  $Z$  and speed  $n$  for solid wood along grain**

#### Example:

$n = 6000 \text{ min}^{-1}$ ,  $Z 4$ :  $v_f = 18 \text{ m min}^{-1}$



Tool set



Grooving

#### Turnblade rebating cutterhead

WW 420 1, WW 420 1 02

D	SB	BO	BO <sub>max</sub>	Z	V	n <sub>max</sub>	ID
mm	mm	mm	mm			min <sup>-1</sup>	
85	51	30	40	2	4	20200	024555
100	51	30	40	2	4	17100	024568
125	41	30	40	2	4	13700	024546 ●
125	51	30	50	2	4	13800	024569 ●
125	51	40	50	2	4	13800	024570 □
125	51	50	50	2	4	13800	024571 □
125	81	30	50	2	4	13700	024723 ●
150	51	30	40	2	4	11400	024548 ●
150	61	30	50	4	4	11400	024543 ●

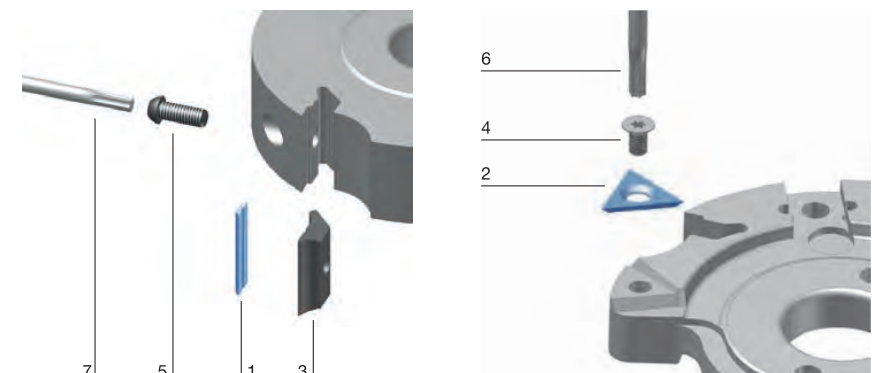
#### Spare knives:

Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	40x8x1.5	HW-30F	10	005074 ●
1	Turnblade knife	50x8x1.5	HW-30F	10	005075 ●
1	Turnblade knife	60x8x1.5	HW-30F	10	005076 ●
1	Turnblade knife	80x8x1.5	HW-30F	10	601613 ●
2	Turnblade spur VS2	19x19x2	HW-F	10	005115 ●

Alternative turnblade knife qualities see section Knives and Spare Parts

#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
3	Clamping wedge	38x18.75x8.27	009675 ●
3	Clamping wedge	48x18.75x8.27	009677 ●
3	Clamping wedge	58x18.75x8.27	009678 ●
3	Clamping wedge	78x18.75x8.27	009680 ●
4	Countersink screw, Torx® 20	M5x8.5	007808 ●
5	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
6	Torx® key	Torx® 20	117503 ●
7	Torx® key	Torx® 25	117504 ●
	Setting gauge for knives	0.3/0.8	005374 ●





### Rebating cutterset, 2 part design

#### Application:

For jointing, rebating and grooving.

#### Machine:

Spindle moulders (running against feed), double-end tenoners and edgebanding machines etc. (running with feed or against feed).

#### Workpiece material:

Softwood and hardwood, glulam, plastics etc.

#### Technical information:

2 part with spacers adjustable tool set with alternate shear angle and triangular spurs.

#### SB 26.4 - 98 mm

SW 531 1 01

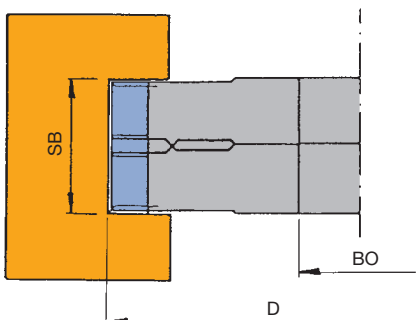
D	SB	VSB	BO	BO <sub>max</sub>	Z	V	n	ID
mm	mm		mm	mm			min <sup>-1</sup>	
160	20	26.4 - 38	30	45	4	4	4900 - 9500	024456 ●
160	20	26.4 - 38	50	50	4	4	4900 - 9500	024458 □
160	50	56.4 - 98	40	45	4	4	4900 - 9500	024455

#### Spare knives:

Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	19.7x8x1.5	HW-30F	10	005071 ●
1	Turnblade knife	50x8x1.5	HW-30F	10	005075 ●
1	Turnblade knife	30x8x1.5	HW-30F	10	005072 ●
2	Turnblade spur VS2	19x19x2	HW-F	10	005115 ●

#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
3	Clamping wedge	18x18.75x8.27	009671 ●
3	Clamping wedge	48x18.75x8.27	009677 ●
3	Clamping wedge	28x18.75x8.27	009673 ●
4	Countersink screw, Torx® 20	M6x0.5x4.9	006243 ●
5	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
6	Torx® key	Torx® 20	117503 ●
7	Torx® key	Torx® 25	117504 ●
	Setting gauge for knives	0.3/0.8	005374 ●



Tool set



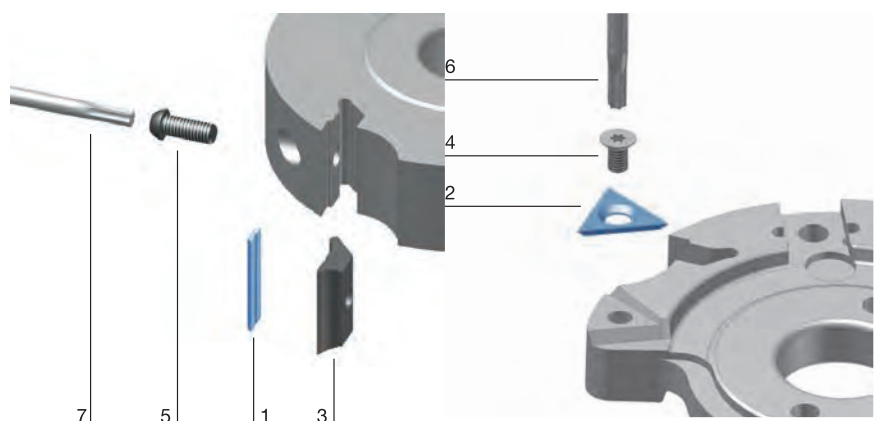
Rebating from below



Rebating from above



Grooving





### Jointing and rebating cutterhead

#### Application:

For rebating and jointing, rounding and profiling at the same time.

#### Machine:

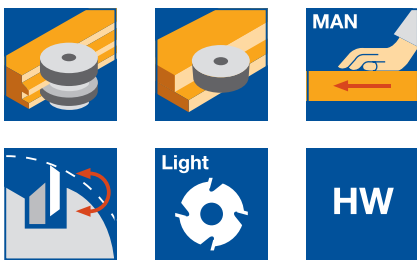
Spindle moulders and moulders, double-end tenoners. Stationary routers with/without CNC control.

#### Workpiece material:

Softwood and hardwood, glulam, plastics etc.

#### Technical information:

Cutterhead with turnblade knives. With alternate shear angle, triangle spurs and seating to adapt edging knives.



#### Cutterhead with seatings for edging knives

WW 420 1 01

D	SB	BO	Z	KM	n	QAL	ID
mm	mm	mm		PCS	min <sup>-1</sup>		
125	51	30	2	4	6200 - 10600	HW	029073 ●
125	101	30	2	4	6200 - 10600	HW	029074 ●
170	51	30	2	4	4500 - 7800	HW	029075 ●

#### Spare knives:

Part-no.	BEZ	ABM	R	FAW	QAL	VE	ID
		mm	mm	°		PCS	
1	Turnblade knife	50x8x1.5			HW-30F	10	005075 ●
2	Turnblade spur VS2	19x19x2			HW-F	10	005115 ●
3	Edging knife 45°	KM 21/0		45°	HW-F		008292 ●
3	Edging knife R1.5	KM 22/4	1.5		HW-F		008295 ●
3	Edging knife R2	KM 22/3	2		HW-F		008309 ●
3	Edging knife R3	KM 22/0	3		HW-F		008293 ●
3	Edging knife R5	KM 24/0	5		HW-F		008305 ●
3	Edging knife R5	KM 24/1	5		HW-F		008306 ●

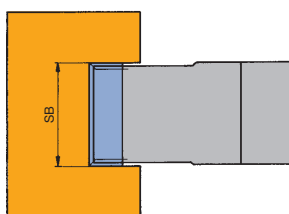
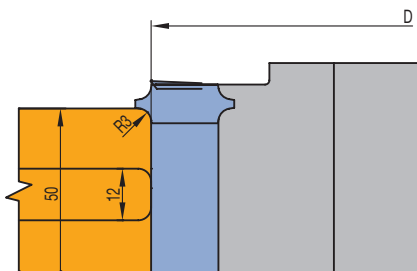
#### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
5	Clamping wedge	48x18.75x8.27	009677 ●
6	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
9	Countersink screw, Torx® 20	M6x30	006089 ●
	Torx® key	Torx® 20	117503 ●
	Torx® key	Torx® 25	117504 ●
	Setting gauge for knives	1.0	005350 ●
	Spacer	13/6.1x0.1	028034 ●
	Spacer	13/6.1x0.3	028035 ●
	Spacer	13/6.1x0.5	028036 ●
	Spacer	13/6.1x1	028037 ●
	Spacer	13/6.1x3	028040 ●
	Spacer	13/6.1x5	028042 ●

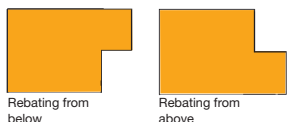
#### Edging knife set: 2 edging knives each + countersunk screw + set of spacers

TE 540 0

BEZ	FAW	R	QAL	ID
	°	mm		
Edge cutterset	45°		HW	009091 ●
Edge cutterset		1.5	HW	009092 ●
Edge cutterset		3	HW	009093 ●
Edge cutterset		5	HW	009097 ●
Edge cutterset		5	HW	009098 ●



Tool set



Rebating from below

Rebating from above



Grooving





### Rebate cutterset UniCut

#### Application:

For rebating, jointing, grooving, bevelling and rounding.

#### Machine:

Spindle moulders, moulders etc.

#### Workpiece material:

Softwood and hardwood, glulam, plastics etc.

#### Technical information:

2 part with spacers adjustable tool set for multi-purpose application.

**With seatings for edging knives and turnblade grooving knives; SB 30 - 60 mm**  
AW 330 1 01

Tool no.	D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	V	n min <sup>-1</sup>	ID
1 + 2	160	30 - 60	30	50	2/2	2/2	4900 - 8300	024056 ●
1 + 2	160	30 - 60	40		2/2	2/2	4900 - 8300	024062 □

Tool complete with edge rounding knife R 2.

Additionally:

2 grooving knives SB 4 mm with countersunk screws

1 set of spacers D 70 mm for adjusting the tool parts

1 set of spacers D 13.70 mm to adjust the edging/grooving knives

1 setting gauge 0.3/0.8 mm

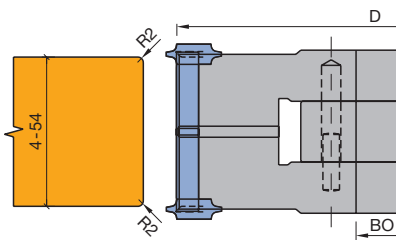
Tool set in wooden box, BO 30.

#### Spare knives:

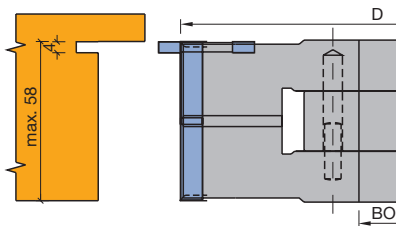
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	30x8x1.5	HW-30F	10	005072 ●
2	Turnblade spur VS2	19x19x2	HW-F	10	005115 ●
3	Edging knife 45°	KM 21/0	HW-F		008292 ●
3	Edging knife R2	KM 22/3	HW-F		008309 ●
4	Turnblade grooving knife NB4	36x20x4	HW-F		008323 ●

#### Spare parts:

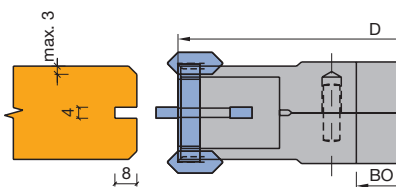
Part-no.	BEZ	ABM mm	ID
5	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
6	Countersink screw, Torx® 20	M6x30	006089 ●
7	Countersink screw, Torx® 20	M6x0.5x4.9	006243 ●
8	Clamping wedge	28x18.75x8.27	009673 ●
9	Torx® key	Torx® 20	117503 ●
10	Torx® key	Torx® 25	117504 ●
	Setting gauge for knives	0.3/0.8	005374 ●



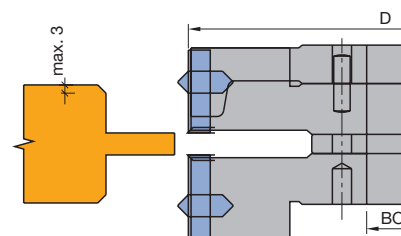
Jointing, rounding



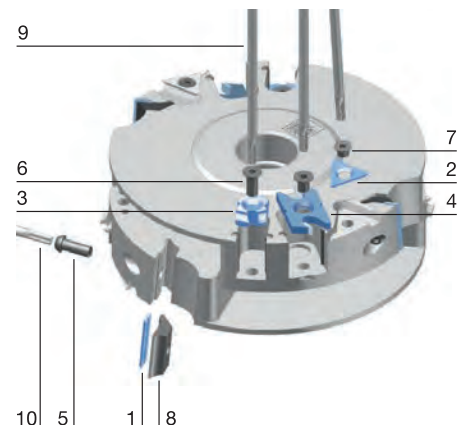
Rebating and seal groove



Groove and chamfers



Tongue profile

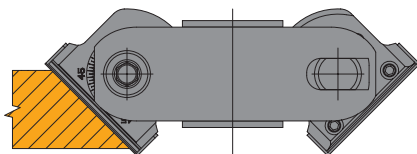


● available ex stock

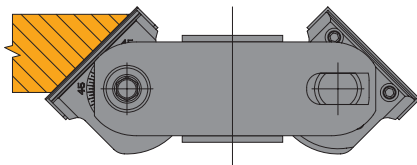
□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)





Bevelling from above



Bevelling from below

**Bevel cutterhead turnblade, swivelling****Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

Spindle moulders, moulders, edgebanding machines, double-end tenoners and special machines.

**Workpiece material:**

Softwood and hardwood, laminated veneer lumber, plastomers, limited suitable for MDF and chipboard (uncoated or coated).

**Technical information:**

Knife holder swivelling adjustable from 0 - 90°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Free of marks cutting result due to 1-part, continuous cutting edge. Economical due to changeable tungsten carbide turnblades with two cutting edges. Optimized gullet design for improved chip removal.

**Turnblade, adjustable bevel angle**

WW 430 1 05

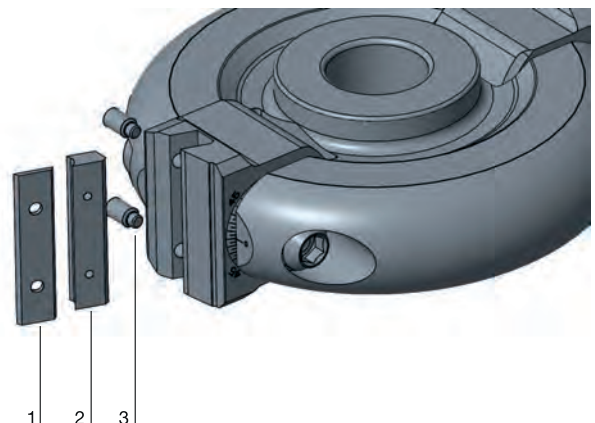
D	SB	BO	BO <sub>max</sub>	Swivel range	n	Z	ID
mm	mm	mm	mm	°	min <sup>-1</sup>		
150	50	30	40	0 - 90	5000 - 9000	2	024169 ●
150	50	31.75	40	0 - 90	5000 - 9000	2	024170 □
150	50	40	40	0 - 90	5000 - 9000	2	024171 □
170	50	50	60	0 - 90	5000 - 9000	2	024172 □

**Spare knives:**

Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade knife	50x12x1,5	HW-05F	10	005086 ●

**Spare parts:**

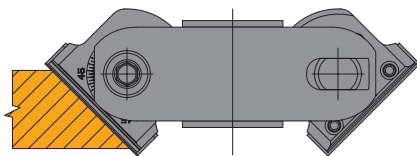
Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge with pin	48x10,88x6	009766 ●
3	Allen screw	M6x12	006035 ●
	Allen key	SW 3	005433 ●
	Allen key	SW 8, L 100	005437 ●
	Setting gauge for knives	43x12x6	005350 ●



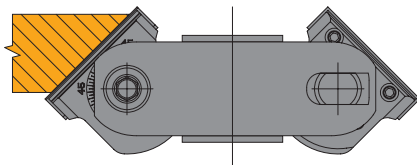




HW



Bevelling from above



Bevelling from below

**Bevel cutterhead HeliCut, swivelling****Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

Spindle moulders, moulders, edgebanding machines and double-end tenoners.

**Workpiece material:**

Softwood and hardwood, laminated veneer lumber, plastomers, technical foams (XPS, PU), limited suitable for MDF and chipboard (uncoated or coated).

**Technical information:**

Knife holder can be swivelled steplessly on both sides from 0 - 65°. Quick and easy adjustment of conventional angles (15°, 30°, 45°, 60°) due to additional locking positions in 15° steps. Design with divided cutting edges and optimized gullet areas for low-noise working with low cutting pressure even at high cutting performance. Workpiece edges free of tear-out on both sides even in critical materials due to alternating tool angle. Cutting edges with particularly precise geometry and polishing for long tool life and machining of „soft“ materials. Economical due to partially exchangeable solid carbide blades with 4 cutting chamfers.

**HeliCut, adjustable bevel angle**

WW 430 1 05

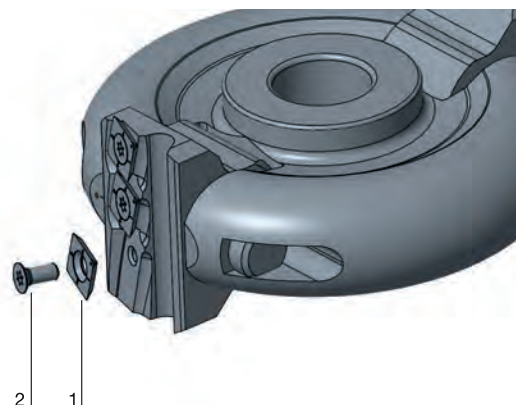
D	SB	BO	BO <sub>max</sub>	Swivel range	n	Z	ID
mm	mm	mm	mm	°	min <sup>-1</sup>		
150	55	30	40	0 - 65	5000 - 9000	1/1	024290 ●
150	55	31.75	40	0 - 65	5000 - 9000	1/1	024262 □
150	55	40	40	0 - 65	5000 - 9000	1/1	024264 □
170	55	50	60	0 - 65	5000 - 9000	1/1	024273 □

**Spare knives:**

Part-no.	BEZ	ABM	ID
		mm	
1	Turnblade knife	15x15x2,5	009543 ●

**Spare parts:**

Part-no.	BEZ	ABM	ID
		mm	
2	Countersink screw, Torx® 20	M5x12	007898 ●
	Torx® key	Torx® 20	006091 ●
	Allen key	SW 8, L 100	005437 ●





### Bevel cutterhead WhisperCut, swivelling

**Application:**

For jointing and bevelling with adjustable bevel angle.

**Machine:**

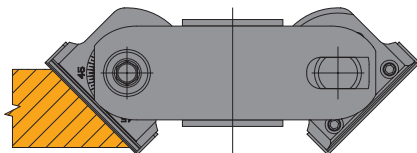
Spindle moulders, moulders, edgebanding machines and double-end tenoners.

**Workpiece material:**

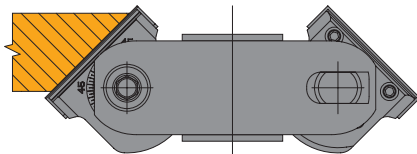
Hardwood, chip and fibre board (chipboard, MDF, HDF etc.), plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), solid surface material (e.g. Corian®, Varicor® etc.), fibre reinforced plastics (e.g. GRP, CFRP).

**Technical information:**

Knife holder swivelling adjustable from 0 - 65°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Workpiece edges tear-free on both sides due to alternating shear angles. Economical due to partial change of diamond cutting edges. Noise reduced design with optimized gullet design for improved chip removal.



Bevelling from above



Bevelling from below

**WhisperCut, adjustable bevel angle**

WW 430 1 05

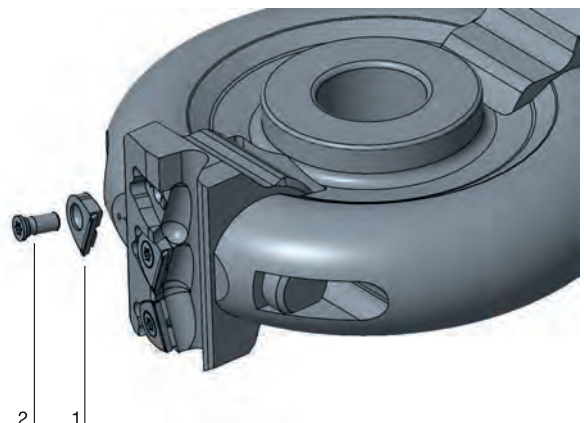
D	SB	BO	BO <sub>max</sub>	Swivel range	n	Z	ID
mm	mm	mm	mm	°	min <sup>-1</sup>		
150	55	30	40	0 - 65	5000 - 9000	1/1	024291 ●
150	55	31.75	40	0 - 65	5000 - 9000	1/1	024263 □
150	55	40	40	0 - 65	5000 - 9000	1/1	024265 □
170	55	50	60	0 - 65	5000 - 9000	1/1	024274 □

**Spare knives:**

Part-no.	BEZ	ABM	ID
		mm	
1	WhisperCut-knife SB14	14x14.2x4.3	091074 ●

**Spare parts:**

Part-no.	BEZ	ABM	ID
		mm	
2	Countersink screw, Torx® 20/59°	M5x11.5	007899 ●
	Torx® key	Torx® 20	006091 ●
	Allen key	SW 8, L 100	005437 ●



## 4. Manual feed

### 4.3 Longitudinal, width and mitre joints

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#### Types of operation

The tools in the following section are suitable for producing glue joints, divided into glue joints (along the grain) and mitre joints.

---

#### Glue joints along grain

Glue joint profiles for length grain glue joints have a low profile depth to minimise the material loss at each glue joint. Glue joint profiles do not increase the stability of the glue joint. The profile is used to position the wood precisely, so it does not slip during pressing. Length grain glue joint profiles are not self-locking. The workpieces must remain pressed together until the glue has hardened completely. Profile tools for glue joints along the grain are not suitable for mitre joints.

---

#### Workpiece material

Softwood and hardwood.

---

#### Machine

Spindle moulders with or without power feed.  
Four-sided moulders.  
Double-end tenoners.

---

#### Application

Against the feed, always along the grain.

---

#### Mitre joint

Solid wood and wood-derived materials cannot be glued on the end faces side without glue joint profiles. Compared to glue joints along the grain, mitre glue joint profiles increase the stability of the joint. These profiles have a greater profile depth, generally 10 mm. Mitre joint profiles must have a straight edge area to create a defined straight joint in the visible area. The profiles are slightly self-locking. This means the workpieces need to be pressed together briefly and can only be machined after the glue has hardened. Mitre joints are typically used to produce segments for arched windows or profiled mouldings.

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#### Workpiece material

Softwood and hardwood.

---

#### Machine

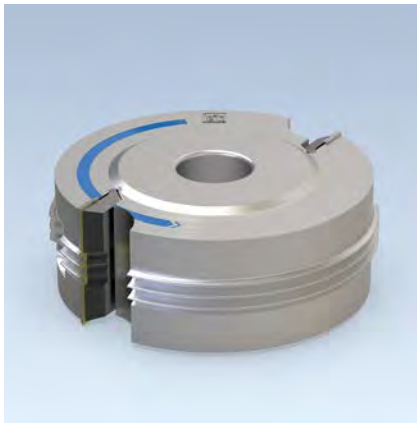
Spindle moulders with clamping device and sliding table.  
Double-end tenoners.  
Window machines.  
Stationary routers with or without CNC control.

---

#### Application

Against feed, across or along the grain.

---



### Profile cutterhead ProfilCut Q for glue joint profiles

#### Application:

To cut glue joint profiles with high fit accuracy. Profile P2-4 for processing with the grain for precise positioning of the wood to be glued. Profile 1 is especially suitable for mitre joint profile/longitudinal glue joint profile and for frames.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Finger profile in rounded design (softline). Effective wood use through small profile depth.



#### MAN feed

WE 600 1 53

P	D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	n min <sup>-1</sup>	ID
1	135	30	30	50	2	5700 - 9900	<b>125125 ●</b>
2	135	50	30	50	2	5700 - 9900	<b>125126 ●</b>
3	135	60	30	50	2	5700 - 9900	<b>125127 ●</b>
3	135	60	50		2	5700 - 9900	<b>125390 □</b>
4	135	80	30	50	2	5700 - 9900	<b>125128 ●</b>

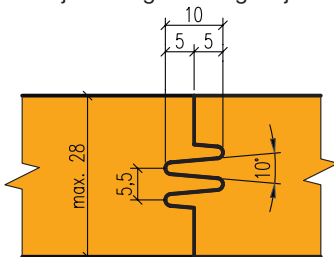
#### Spare knives:

Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife	30x16x2	MC	<b>619237 ●</b>
1	ProfilCut Q knife	50x16x2	MC	<b>619234 ●</b>
1	ProfilCut Q knife	60x16x2	MC	<b>619235 ●</b>
1	ProfilCut Q knife	80x16x2	MC	<b>619236 ●</b>

#### Spare parts:

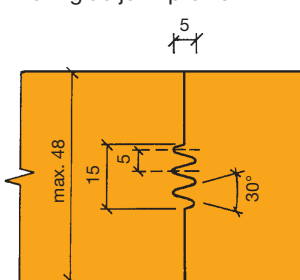
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	48x23.73x8.27	<b>629219</b>
2	Clamping wedge profiled	58x23.73x8.27	<b>629220</b>
2	Clamping wedge profiled	78x23.73x8.27	<b>629221</b>
2	Clamping wedge profiled	28x23.73x8.27	<b>629222</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 ●</b>
4	Torx® key	Torx® 25	<b>117504 ●</b>

Mitre joint/longitudinal glue joint profile

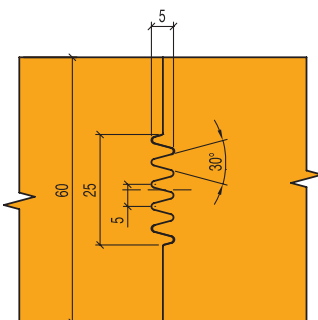


P1

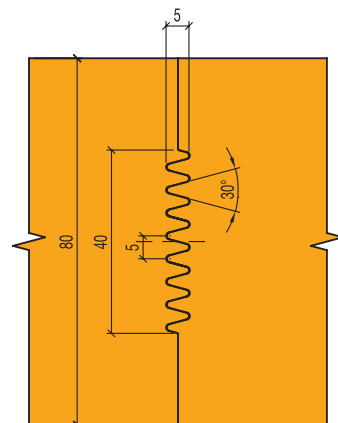
Width glue joint profile



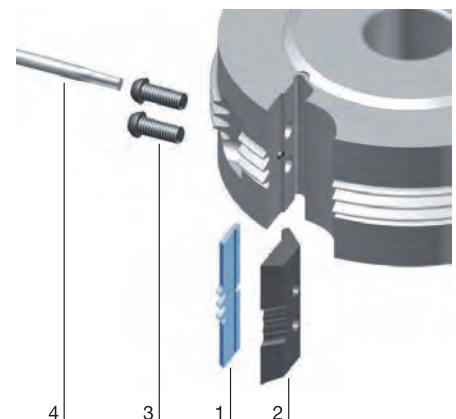
P2



P3



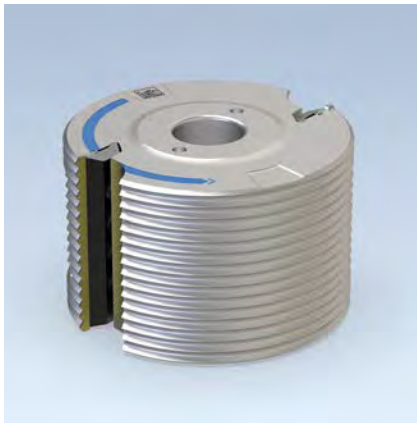
P4



## 4. Manual feed

### 4.3 Longitudinal, width and mitre joints

#### 4.3.1 Glue joint cutterheads



#### Profile cutterhead ProfilCut Q for glue joint profiles

##### Application:

To cut glue joint profiles in fibre direction with high fit accuracy.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Finger profile in rounded design (softline). Effective wood use through small profile depth.



##### Profile cutterhead set

SE 600 1 53

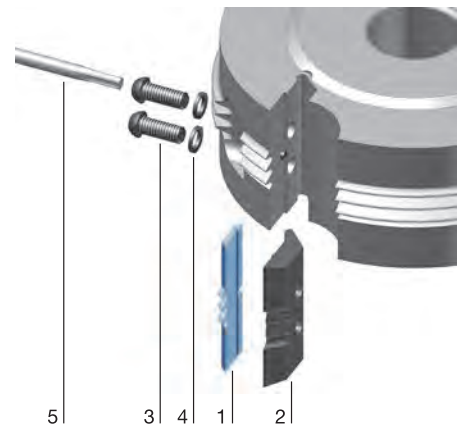
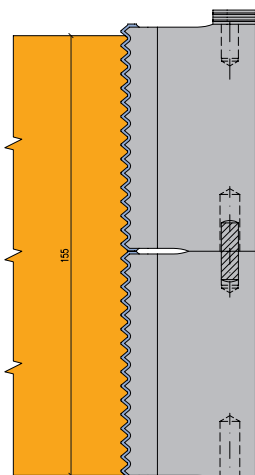
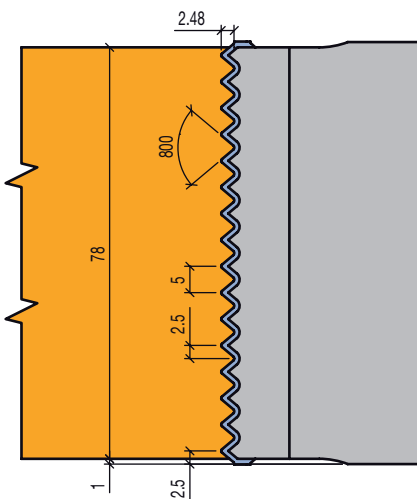
D	SB	BO	Z	ID
mm	mm	mm		
125	78	30	2	126097 ●
125	78	50	2	126098 ●

##### Spare knives:

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	ProfilCut Q knife	80.2x14x2.4	MC	619523

##### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	78x20x8.27	629214
3	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
4	Torx® key	Torx® 25	117504 ●

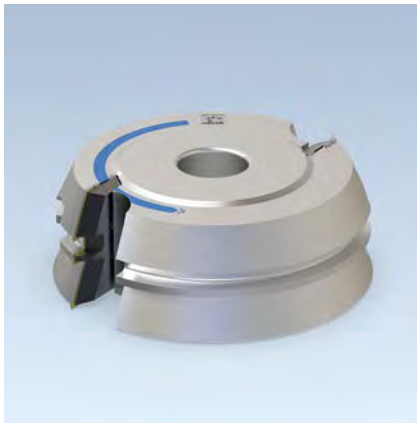


Tool stackable

## 4. Manual feed

### 4.3 Longitudinal, width and mitre joints

#### 4.3.2 Mitre joint cutterheads



#### Profile cutterhead ProfilCut Q for glue joints along the grain and mitre joints

##### Application:

For glue joint profiles along grain with precise positioning. Exact positioning of the wood to be glued together and for producing corner joints.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood, veneered panel materials.

##### Technical information:

Wood thickness 15 to 48 mm; basic clearance 0.3 mm, side clearance 0.1 mm. Economic wood use due to small profile depth.

##### Profile depth 6.4 mm

WE 600 1 53

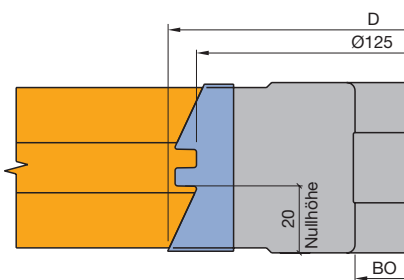
D	SB	BO	BO <sub>max</sub>	Z	n	ID
mm	mm	mm	mm		min <sup>-1</sup>	
142	50	30	50	2	5500 - 9400	<b>125129</b>

##### Spare knives:

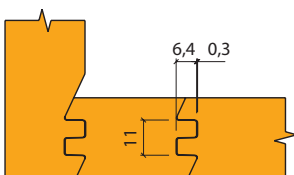
Part-no.	BEZ	ABM	QAL	ID
		mm		
1	ProfilCut Q knife	50x22x2	MC	<b>619238</b>

##### Spare parts:

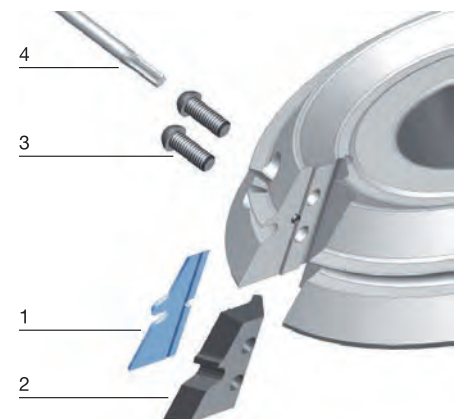
Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	48x31.93x8.27	<b>629223</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 ●</b>
4	Torx® key	Torx® 25	<b>117504 ●</b>



Adjustment scheme



Profile example





### Profile cutterhead ProfilCut Q for glue joints along the grain and mitre joints

#### Application:

For 45° glue joint profiles along grain with precise positioning. Exact positioning of the wood to be glued together and for producing corner joints.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood, veneered panel materials.

#### Technical information:

Not suitable for melamine or paper coated panel materials.



#### Profile cutterhead ProfilCut Q 45°

WE 610 1 53

D	SB	HD	BO	Z	BO <sub>max</sub>	n	ID
mm	mm	mm	mm		mm	min <sup>-1</sup>	
175	40	28	30	2	50	4400 - 7600	125130 ●
175	40	28	50	2	50	4400 - 7600	125131 □

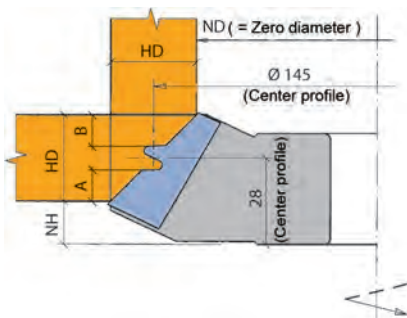
#### Profile adjustment

Height adjustment by profiling the workpiece flat on the table and vertical against the fence:

Profile height: PH 8.00 mm

Correct adjustment, if dimension A is the same as dimension B.

Formula:  $A(B) = (HD - PH) / 2$



$$0\text{-height (NH)} = 28 - \frac{\text{wood thickness (HD)}}{2}$$

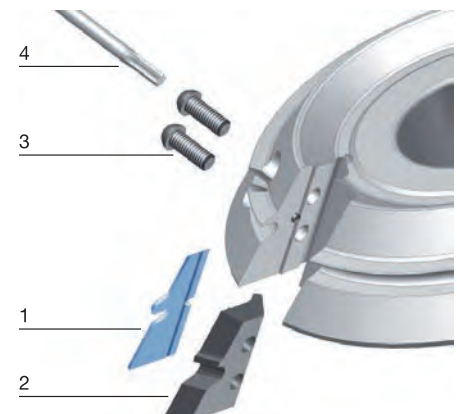
$$0\text{-diameter (ND)} = \varnothing 145 - \text{wood thickness (HD)}$$

#### Spare knives:

Part-no.	BEZ	ABM	QAL	ID
1	ProfilCut Q knife	mm 40x22x2	MC	619239 ●

#### Spare parts:

Part-no.	BEZ	ABM	ID
2	Clamping wedge profiled	mm 38x32.11x8.27	629224
3	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
4	Torx® key	Torx® 25	117504 ●





## 4. Manual feed

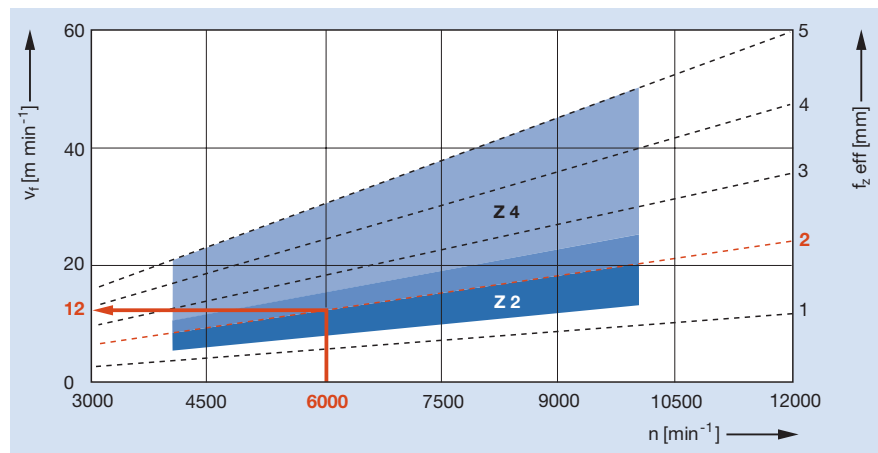
### 4.4 Profiling

#### 4.4.1 – 4.4.6 Different profile cutterheads

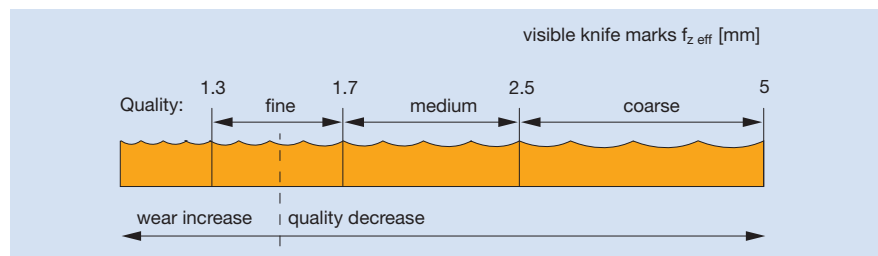
##### Type of operation

Profiling in craft and industry. As there are many different applications, the features of the tool and the wood types to be processed are described in the respective product pages.

##### Feed speeds depending on RPM, length of knife marks and number of teeth



##### Relation between surface quality and length of knife marks $f_{z\ eff}$

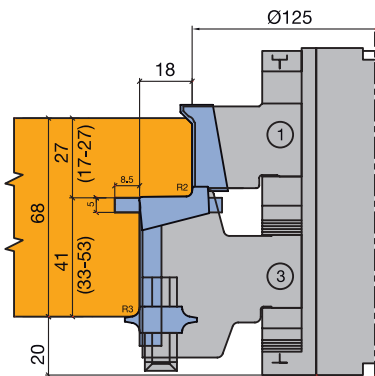
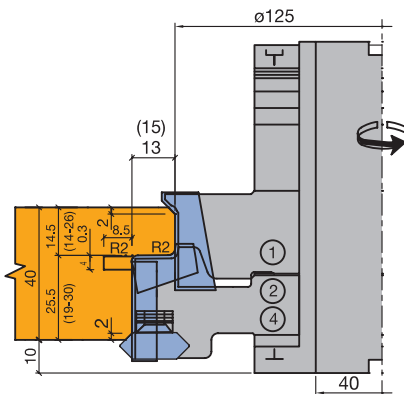


With multi blade tools, only the marks of one knife show on the surface (one knife finish).

Z 2 and Z 4 tools produce the same surface quality with the same machine setting. High numbers of teeth are required for a high hogging performance.

##### Workpiece material Machines Application

Please refer to the relevant product pages, depending on the operation and profile.



## Turnblade ProfilCut Q profile cutterhead set for internal door production

### Application:

For external door profiles with single rebate, rebating depth 13/15/18 mm. Extendable for double rebate 12/15 and 15/15.

### Machine:

Spindle moulders and moulders.

### Workpiece material:

Softwood and hardwood.

### Technical information:

Combinable for front door, single and double rebate. Double rebate profiles by using additional tools. Tool body of aluminium. ProfilCut jointing cutterhead with chamfers to edges, rebate cutterhead with turnblade knives, spurs and seatings for edge knives and seal groove knives.

### Turnblade / profile cutterhead set

SE 540 1 53

BEM	Tool no.	D <sub>0</sub> mm	BO mm	Z	FAT mm	n <sub>max</sub> min <sup>-1</sup>	ID
Single rebate	1/2	125	40	2	13	7200	<b>126051</b>
Single rebate	1/4	125	40	2	15	7200	<b>126052</b>
Single rebate	1/3	125	40	2	18	7200	<b>126053</b>
Double rebate	1/4/5	125	40	2	15/12	7200	<b>126054</b>
Double rebate	1/4/6	125	40	2	15/15	7200	<b>126055</b>

Set completely mounted on VDS-sleeve.

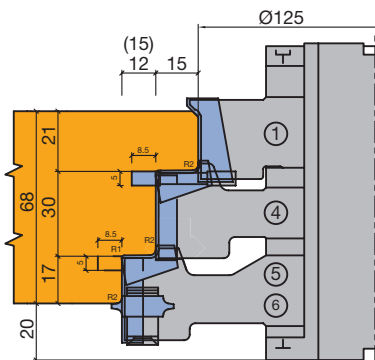
### Single tools

TB 100 0 01, WE 500 1 53

BEZ	ABM mm	Tool no.	Z	ID
ProfilCut Q tool	133x30x50	1	2	<b>125132</b>
ProfilCut Q tool	151.2x35x50	2	2	<b>125133</b>
ProfilCut Q tool	161.2x54.5/58.5x50	3	2	<b>125134</b>
ProfilCut Q tool	155.2x35x50	4	2	<b>125135</b>
ProfilCut Q tool	179.2x35x50	5	2	<b>125136</b>
ProfilCut Q tool	185.2x35x50	6	2	<b>125137</b>
Reducing sleeve without collar	40x96x30			<b>028302 ●</b>

### Spare knives:

BEZ	ABM mm	Tool no.	QAL	ID
ProfilCut Q knife	30.2x14.1x2	1	MC	<b>619240</b>
ProfilCut Q knife	20.1x12.62x2	2	MC	<b>413043</b>
ProfilCut Q knife	25x12.76x2	3	MC	<b>413017</b>
ProfilCut Q knife	20.1x12.61x2	4	MC	<b>413045</b>
ProfilCut Q knife	20.1x11.89x2	5	MC	<b>413011</b>
ProfilCut Q knife	20.1x12.9x2	6	MC	<b>413015</b>
Turnblade knife	30x8x1.5	2/4/5/6	HW-05	<b>005059 ●</b>
Edging knife 45°	KM 21/0	2/4	HW-F	<b>008292 ●</b>
Edging knife R2	KM 22/3	5/6	HW-F	<b>008309 ●</b>
Edging knife R3	KM 22/0	3	HW-F	<b>008293 ●</b>
Turnblade grooving knife NB4	36x20x4	2/4	HW-F	<b>008323 ●</b>
Turnblade grooving knife NB5	36x20x5	2 - 6	HW-F	<b>008324 ●</b>



## Spare parts:

BEZ	ABM	Tool no.	ID
	mm		
Clamping wedge ProfilCut Q	28x20x8.27	1	629208
Clamping wedge ProfilCut Q	17x21.22x7.25	2/4/6	629267
Clamping wedge	28x18.75x8.27	2/4/5/6	009673 ●
Clamping wedge ProfilCut Q	22x21.11x7.25	3	629227
Clamping wedge	48x18.75x8.27	3	009677 ●
Clamping wedge ProfilCut Q	17x20x7.25	5	629226
Clamping screw w. disc, Torx® 25	M6x18.5	1 - 6	007442 ●
Countersink screw, Torx® 20	M6x20	2/4	006087 ●
Countersink screw, Torx® 20	M6x40	3	006090 ●
Countersink screw, Torx® 20	M6x25	5/6	006088 ●
Countersink screw, Torx® 20	M6x12	2 - 6	006084 ●
Cylindrical screw with ISK	M6x93		007834 ●
Torx® key	Torx® 25	1 - 6	117504 ●
Torx® key	Torx® 20	1 - 6	117503 ●
Allen key	SW 5		005452 ●



R 1,5 = ID 619391  
R 2,0 = ID 619392  
R 3,0 = ID 619393  
R 4,0 = ID 619394  
R 5,0 = ID 619395



ID 619396

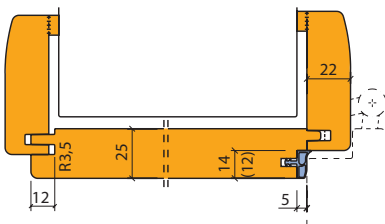


ID 619397

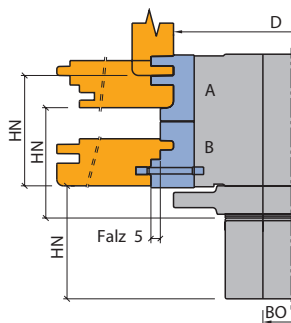


ID 184008678

Cut-out for DP edging knives on request



Door lining profile



Lining/decorative panel and rebate lining

**Profile cutterhead ProfilCut Q****Application:**

For door casing and door linings with 5 mm rebate.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood, uncoated, plastic coated and veneered chipboard and fibre materials.

**Technical information:**

Material thickness: 24 to 27 mm (option up to 32 mm with jointing). Seal 14 and 12 mm possible by fitting spacers. Adjustable rebate of 5 mm or 4 mm by changeable profile knives. Rebate 7 mm, 8 mm and 11 mm on request.

**Rebate 5 mm**

SE 640 1 53

Tool Type	D mm	BO mm	BO <sub>max</sub> mm	Z	FAT mm	n min <sup>-1</sup>	ID
With jointing and rounding	125	30	50	2	5	5100 - 8800	<b>126056 ●</b>
Without jointing and rounding	125	30	50	2	5	5100 - 8800	<b>126057</b>

**Rebate 4 mm**

SE 640 1 53

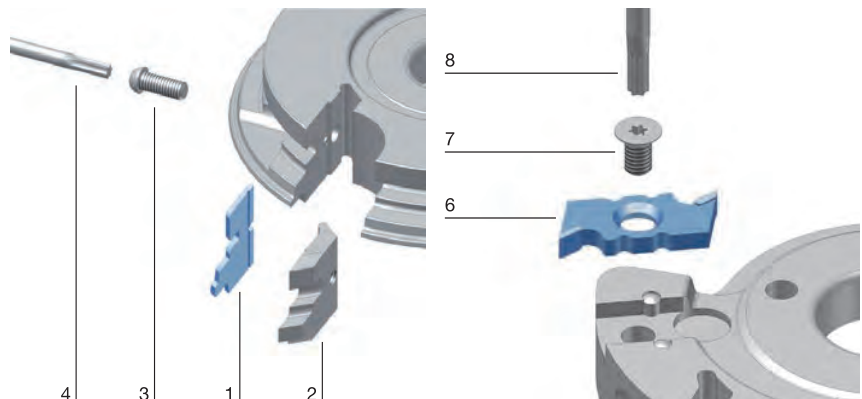
Tool Type	D mm	BO mm	BO <sub>max</sub> mm	Z	FAT mm	n min <sup>-1</sup>	ID
With jointing and rounding	125	30	50	2	4	5100 - 8800	<b>126058</b>
Without jointing and rounding	125	30	50	2	4	5100 - 8800	<b>126059</b>

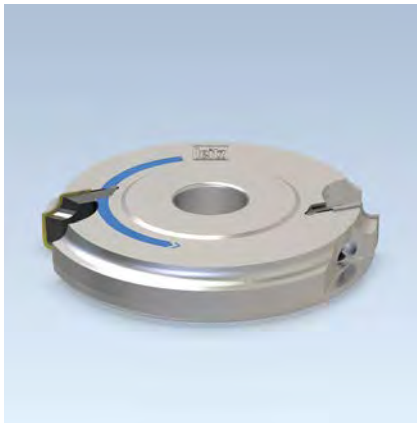
**Spare knives:**

Part-no.	BEZ	ABM mm	QAL	ID
1	ProfilCut Q knife A for jointing	35x22.75x2	MC	<b>619241</b>
1	ProfilCut Q knife B 5 mm rebate	35x23.82x2	MC	<b>619242</b>
1	ProfilCut Q knife A without jointing	35x22.75x2	MC	<b>619243</b>
1	ProfilCut Q knife B 4 mm rebate	35x23.29x2	MC	<b>619244</b>
6	Turnblade grooving knife NB4	36x20x4	HW-F	<b>008323 ●</b>

**Spare parts:**

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge A	33x27.89x8.27	<b>629229</b>
2	Clamping wedge B	33x32.72x2	<b>629230</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 ●</b>
4	Torx® key	Torx® 25	<b>117504 ●</b>
7	Countersink screw, Torx® 20	M6x12	<b>006084 ●</b>
8	Torx® key	Torx® 20	<b>117503 ●</b>



**Profile cutterhead ProfilCut Q****Application:**

For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Production of counter profile possible by combining with the fluting profile. Tool can be used on both sides as panel raising cutter (straight panel raising).

**Radii profile R 2; 3; 5; 7 mm**

WE 500 1 53

D	SB	BO	BO <sub>max</sub>	Z	R	n	ID
mm	mm	mm	mm		mm	min <sup>-1</sup>	
139	25	30	50	2	5	5500 - 9600	<b>125387 •</b>

**Radii profile R 12; 15; 16; 18; 20 mm**

WE 500 1 53

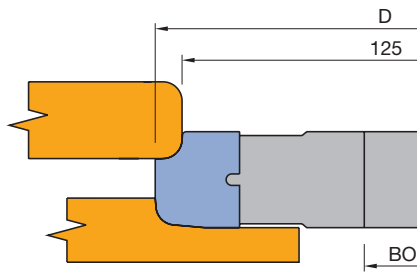
D	SB	BO	BO <sub>max</sub>	Z	R	n	ID
mm	mm	mm	mm		mm	min <sup>-1</sup>	
167	40	30	50	2	12	4600 - 10200	<b>125391 •</b>

**Spare knives:**

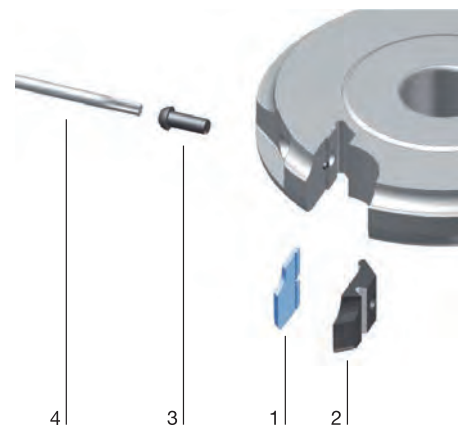
Part-no.	BEZ	ABM	QAL	R	ID
		mm		mm	
1	ProfilCut Q knife	25x25x2.4	MC	2	<b>619504</b>
1	ProfilCut Q knife	25x25x2.4	MC	3	<b>619505</b>
1	ProfilCut Q knife	25x25x2.4	MC	5	<b>619501</b>
1	ProfilCut Q knife	25x25x2.4	MC	7	<b>619502</b>
1	ProfilCut Q knife	40x32.6x2.4	MC	12	<b>619516</b>
1	ProfilCut Q knife	40x32.6x2.4	MC	15	<b>619517</b>
1	ProfilCut Q knife	40x32.6x2.4	MC	16	<b>619518</b>
1	ProfilCut Q knife	40x32.6x2.4	MC	18	<b>619519</b>
1	ProfilCut Q knife	40x32.6x2.4	MC	20	<b>619520</b>

**Spare parts:**

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	23x35.5x8.27	<b>629458</b>
2	Clamping wedge profiled	38x43x8.27	<b>629460</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 •</b>
4	Torx® key	Torx® 25	<b>117504 •</b>



Radii profile cutterhead





### Profile cutterhead set ProfilCut Q - radii profile

#### Application:

For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Cutterhead with changing knives R 5/8, R 6/9, R 7/10, R 3/12, bevelling knives 30/45/60° and axially parallel knives. For cutting radii and dowel profiles as well as bevelling and copy-shaping of curved workpieces using templates.



#### Radii profile R 5 - 12 mm or 30/45/60° bevel

AE 540 1 53

exist. of	D mm	SB mm	BO mm	BO <sub>max</sub> mm	R mm	Z	ID
Profile cutterhead	140	25	30	50		2	<b>126546 •</b>
Radius knife					5/8		
Radius knife					6/9		
Radius knife					7/10		
Radius knife					3/12		
Bevel knife					30/45/60°		

Set completely in wooden box including radii/bevel knives.

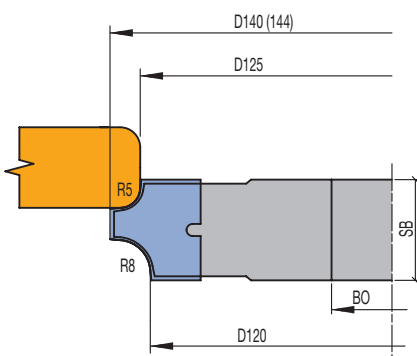
Standard values for feed speed  $v_f$  at speed  $n = 6000 \text{ min}^{-1}$ :

Machining along grain: 8 to 10  $\text{m min}^{-1}$ .

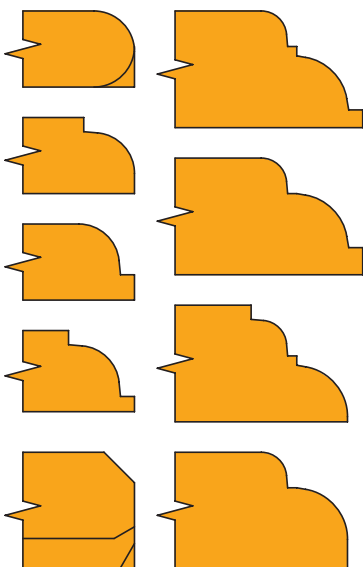
Machining across grain: 3 to 5  $\text{m min}^{-1}$ .

RPM:  $n = 5400 - 9200 \text{ min}^{-1}$

Zero diameter: 120/125 mm



Profile cutterhead D-140(144) mm



Left = 1 working step  
Right = 2 working steps

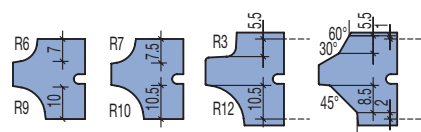
#### Spare knives:

Part-no.	BEZ	ABM mm	QAL	R mm	FAW °	ID
1	ProfilCut Q knife	25x22x2	MC	5/8		<b>619445</b>
1	ProfilCut Q knife	25x22x2	MC	6/9		<b>619446</b>
1	ProfilCut Q knife	25x22x2	MC	7/10		<b>619447</b>
1	ProfilCut Q knife	29x24.17x2	MC	3/12		<b>619448</b>
1	ProfilCut Q knife	29x24.17x2	MC		30/45/60°	<b>619449</b>

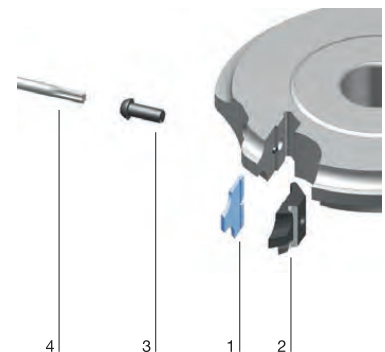
#### Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge	23x32.5x8.27	<b>629286 •</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 •</b>
4	Torx® key	Torx® 25	<b>117504 •</b>

Ball bearing and guide rings - see Lexicon section Knives and Spare Parts.



Profile knives radius / bevel



## 4. Manual feed

### 4.4 Profiling

#### 4.4.3 Radius profile cutterheads



#### Profile cutterhead ProfilCut Q

##### Application:

For radii and bevel profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Cutterhead with change knives and straight cut. Multi-purpose application for different profiles.



##### Radii profile R 12 - 20 mm or 45° bevel

WE 500 1 53

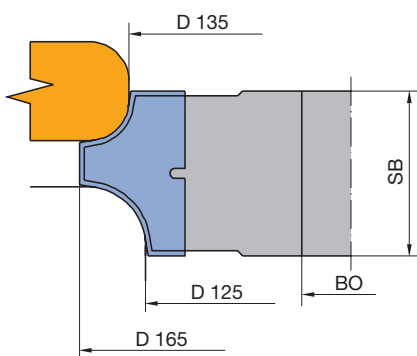
D	SB	BO	BO <sub>max</sub>	Z	R	n	ID
mm	mm	mm	mm		mm	min <sup>-1</sup>	
165	50	30	50	2	12/18	5500 - 5900	<b>125388 •</b>

##### Spare knives:

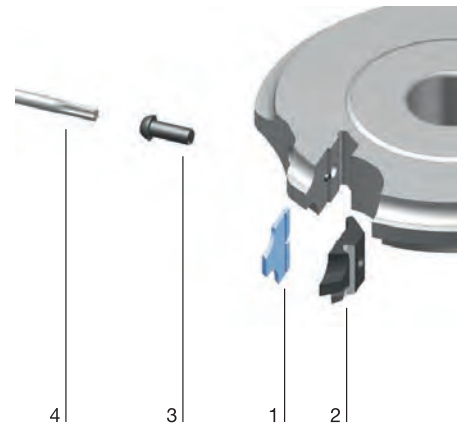
Part-no.	BEZ	ABM	QAL	R	FAW	ID
		mm		mm	°	
1	ProfilCut Q knife	50x33.8x2.4	MC	12/18		<b>619512</b>
1	ProfilCut Q knife	50x33.8x2.4	MC	14/20		<b>619513</b>
1	ProfilCut Q knife	50x33.8x2.4	MC		45	<b>619514</b>

##### Spare parts:

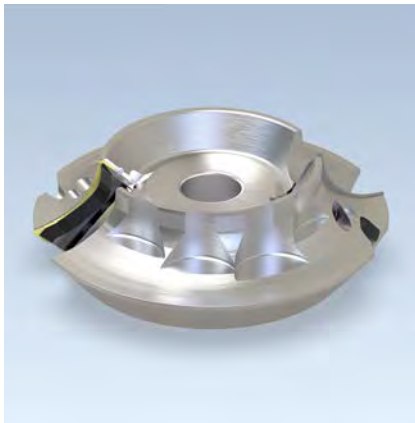
Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	48x43.5x8.27	<b>629099</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 •</b>
4	Torx® key	Torx® 25	<b>117504 •</b>



Profile cutterhead D-165 mm







#### Profile cutterhead ProfilCut Q

##### Application:

For different radii profiles with different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Height and diameter adjustment through recess in the tool basic body per radius. Cutterhead extendable for radii R 12.5 - 30 mm. Replacement knives for dowel cuts on request.



##### Radii profile R 12.5 - 30 mm

WE 500 1 53

D	SB	BO	BO <sub>max</sub>	D <sub>0</sub>	Z	R	n	ID
mm	mm	mm	mm	mm		mm	min <sup>-1</sup>	
180	32	30	50	112	2	30	4300 - 7400	125359 ●

For ball bearings and guide rings see section Knives and Spare Parts.

Standard values for feed speed  $v_f$ :

Machining along grain: 8 to 10 m min<sup>-1</sup>

Machining across grain: 3 to 5 m min<sup>-1</sup>

at speed  $n = 6000 \text{ min}^{-1}$ .

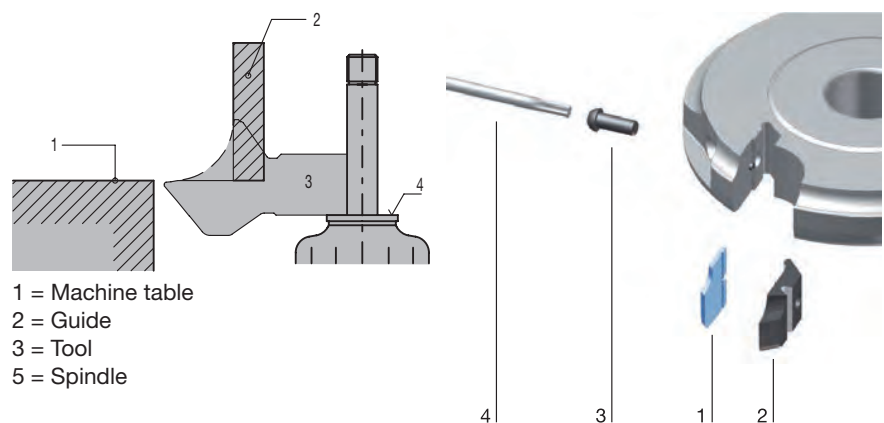
##### Spare knives:

Part-no.	BEZ	ABM	QAL	R	ID
		mm		mm	
1	ProfilCut Q knife	50x22x2	MC	12.5	619431
1	ProfilCut Q knife	50x22x2	MC	15	619432
1	ProfilCut Q knife	50x22x2	MC	20	619433
1	ProfilCut Q knife	50x22x2	MC	25	619434
1	ProfilCut Q knife	50x22x2	MC	30	619430

##### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	48x29x8.27	629284 □
3	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
4	Torx® key	Torx® 25	117504 ●

Machine adjustment by recessing the tool.



**Profile cutterhead ProfilCut Q****Application:**

For different radii profiles with 10 different profile knives. Copy shaping of curved workpieces using template and ball bearing guide ring.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Height and diameter adjustment through recess in the tool basic body. Cutterhead extendable for radii R 30 - 50 mm. Replacement knives for dowel cuts on request.

**Radii profile R 30 - 50 mm**

AE 540 1 53

D	SB	BO	BO <sub>max</sub>	D <sub>0</sub>	Z	R	n	ID
mm	mm	mm	mm	mm		mm	min <sup>-1</sup>	
227	57	30	50	125	2	40	3400 - 7500	125360 ●

For ball bearings and guide rings see section Knives and Spare Parts.

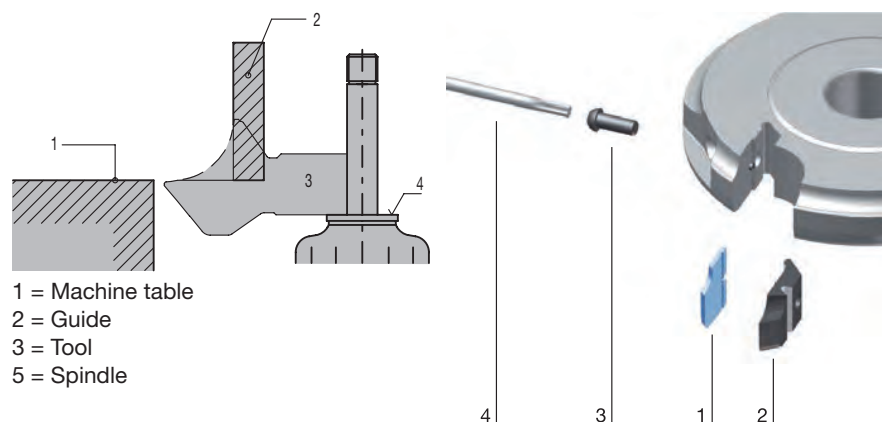
**Spare knives:**

Part-no.	BEZ	ABM mm	QAL	R mm	ID with relief angle	ID without relief angle
1	ProfilCut Q knife	80.1x30.78x2	MC	30	619436	619440
1	ProfilCut Q knife	80.1x30.56x2	MC	35	619437	619441
1	ProfilCut Q knife	80.1x31.08x2	MC	40	619435	619442
1	ProfilCut Q knife	80.1x29.98x2	MC	45	619438	619443
1	ProfilCut Q knife	80.1x29.56x2	MC	50	619439	
1	ProfilCut Q knife	80.1x29.66x2	MC	50		619444

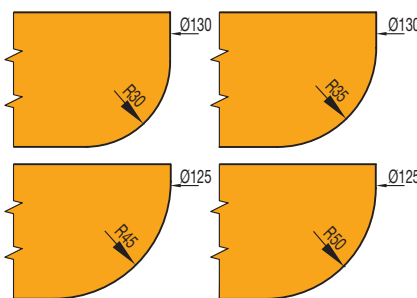
**Spare parts:**

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge ProfilCut	78x39x8.27	629285 □
3	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
4	Torx® key	Torx® 25	117504 ●

Machine adjustment by recessing the tool.



Profile cutterhead D-227 mm



**Profile cutterhead ProfilCut Q****Application:**

For radii and counter profiles. Copy shaping of curved workpieces using template and ball bearing guide ring.

**Machine:**

Spindle moulders and moulders etc.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Cutterhead with change knives, straight cut. Multi-purpose use for different profiles in one or several working steps.

**Radii profile R 3 - 10 mm**

WE 500 1 53

D	SB	BO	BO <sub>max</sub>	Z	n	ID
mm	mm	mm	mm		min <sup>-1</sup>	
132	40	30	40	2	5900 - 10100	<b>125389 •</b>

Standard values for feed speed  $v_f$ :

Machining along grain: 8 to 10 m min<sup>-1</sup>

Machining across grain: 3 to 5 m min<sup>-1</sup>

at speed  $n = 6000$  min<sup>-1</sup>

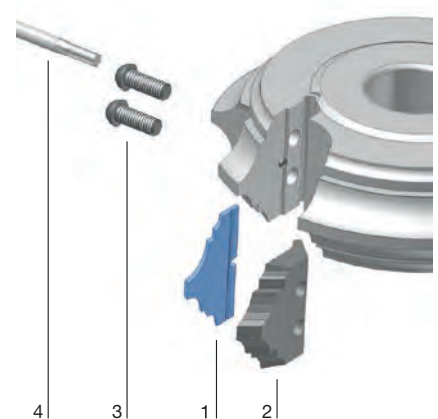
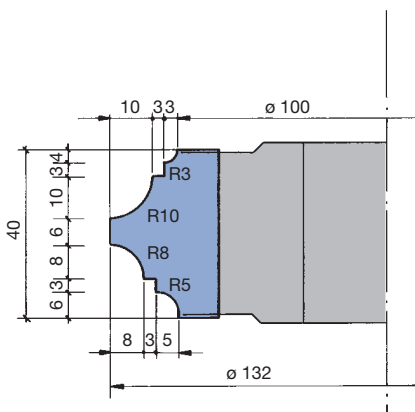
For ball bearings and guide rings see section Knives and Spare Parts.

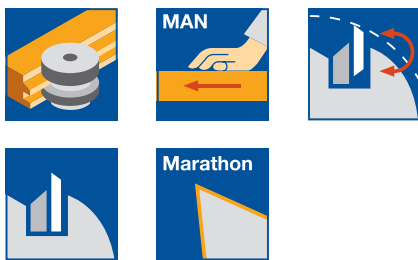
**Spare knives:**

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	ProfilCut Q knife	40.2x28.5x2.4	MC	<b>619515</b>

**Spare parts:**

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	38x34.5x8.27	<b>629459</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 •</b>
4	Torx® key	Torx® 25	<b>117504 •</b>



**Profile cutterhead set ProfilCut Q - bevelling / rounding****Application:**

Multi-purpose tool set for bevelling, rounding and jointing the workpiece edges at the same time.

**Machine:**

Spindle moulders, copy shaping and profile moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

With a combination of jointing and bevelling/rounding cutterheads, different profiles and wood thicknesses can be machined. Profile knives with different radii/bevels can be mounted in one cutterhead.

**Manual feed**

SE 541 1 53

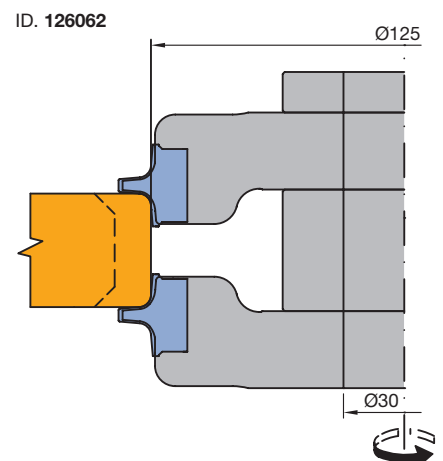
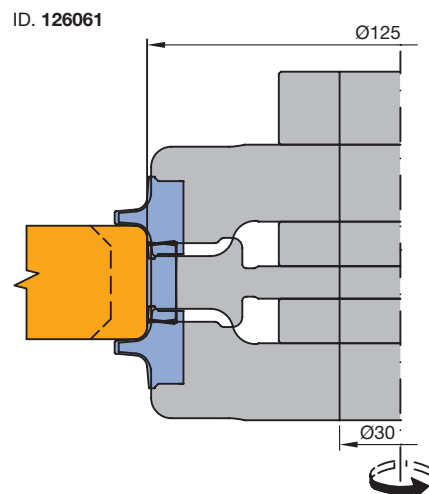
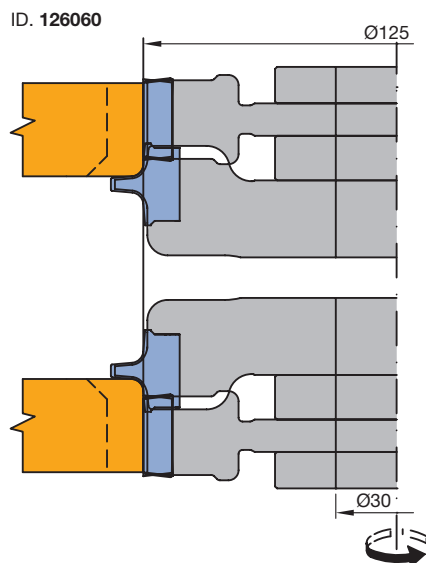
Tool Type	D <sub>0</sub> mm	AW PCS	n min <sup>-1</sup>	Z	ID
Jointing-rounding	125	2	4200 - 7100	2	<b>126060</b>
Rounding-jointing-rounding	125	3	4200 - 7100	2	<b>126061</b>
Rounding-rounding	125	2	4200 - 7100	2	<b>126062</b>

Further radii are available at short notice.

**Spare parts:**

Part-no.	BEZ	ABM mm	Tool no.	ID
3	Clamping wedge	18x22x8.27	1/2/11/12	<b>629231</b>
3	Clamping wedge	33x28x8.27	3/4/13/14	<b>629232</b>
3	Clamping wedge	38x29.71x8.27	5/15	<b>629233</b>
3	Clamping wedge	38x29.71x8.27	6/16	<b>629234</b>
3	Clamping wedge	48x31.73x8.27	7/17	<b>629235</b>
3	Clamping wedge	48x31.73x8.27	8/18	<b>629236</b>
4	Clamping wedge	18x18.75x8.27	20	<b>009671</b> ●
4	Clamping wedge	33x18.75x8.27	35	<b>009674</b> ●
4	Clamping wedge	48x18.75x8.27	50	<b>009677</b> ●
5	Clamping screw w. disc, Torx® 25	M6x18.5		<b>007442</b> ●
6	Torx® key	Torx® 25		<b>117504</b> ●

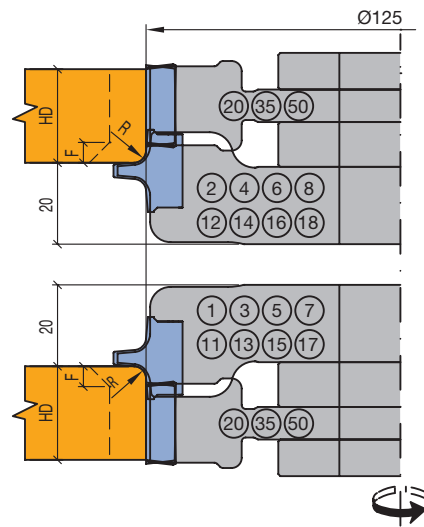
Part nos. 1 and 2 - ProfilCut Q and turnblade knives - see detailed information on the following pages.



## ID. 126060

Order example:

- Combination ID 126060
- Profile description top down RL
- jointingSB35/R5 or R5/jointingSB35
- Bore diameter 30



Wood thickness (HD):

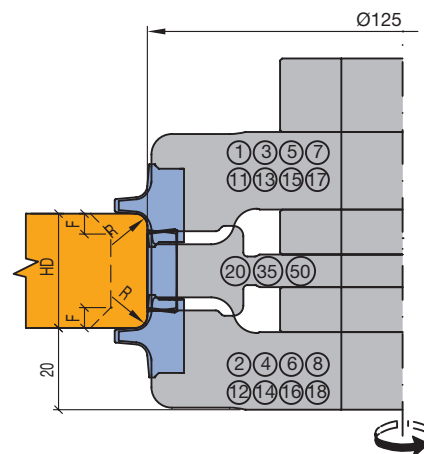
Jointing tool	20	35	50
max. HD	18+R (F)	33+R (F)	48+R (F)

F (bevel) max. = 3, 5, 7x45° or 8x40°

## ID. 126061

Order example:

- Combination ID 126061
- Profile description top down RL
- R5/jointingSB35/R5
- Bore diameter 30



Jointing tool			
Radii tools	20	35	50
No.1(11)+2(12)	6	12	24
No.1(11)+4(14)	13	19	31
No.1(11)+6(16)	18	24	36
No.1(11)+8(18)	28	34	46
No.3(13)+2(12)	13	19	31
No.3(13)+4(14)	20	26	38
No.3(13)+6(16)	25	31	43
No.3(13)+8(18)	35	41	53
No.5(15)+2(12)	18	24	36
No.5(15)+4(14)	25	31	43
No.5(15)+6(16)	30	36	48
No.5(15)+8(18)	40	46	58
No.7(17)+2(12)	28	34	46
No.7(17)+4(14)	35	41	53
No.7(17)+6(16)	40	46	58
No.7(17)+8(18)	50	56	68
max. HD	18+R+R (F+F)	33+R+R (F+F)	48+R+R (F+F)

F (bevel) max. = 3, 5, 7x45° or 8x40°

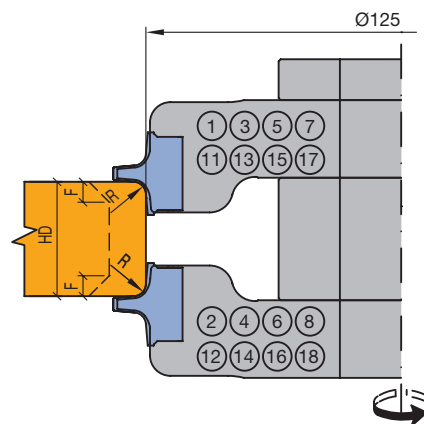
Wood thicknesses are calculated with max. bevel

Minimum wood thickness

## ID. 126062

Order example:

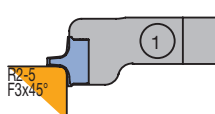
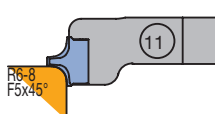
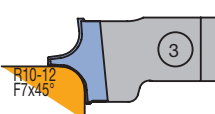
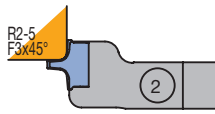
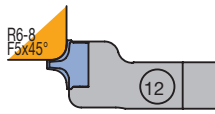
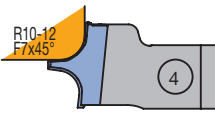
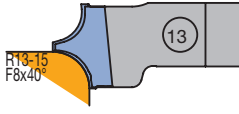
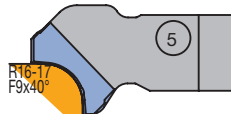
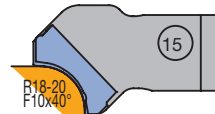

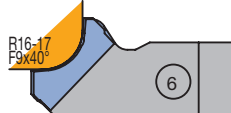



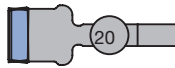
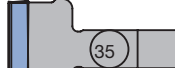

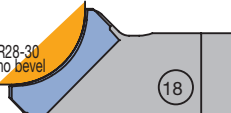


- Combination ID 126062
- Profile description top down RL
- R5/R5
- Bore diameter 30



Radii tools		Minimum wood thickness
No.1(11)+2(12)	-2	
No.1(11)+4(14)	5	
No.1(11)+6(16)	10	
No.1(11)+8(18)	20	
No.3(13)+2(12)	5	
No.3(13)+4(14)	12	
No.3(13)+6(16)	17	
No.3(13)+8(18)	27	
No.5(15)+2(12)	10	
No.5(15)+4(14)	17	
No.5(15)+6(16)	22	
No.5(15)+8(18)	32	
No.7(17)+2(12)	20	
No.7(17)+4(14)	27	
No.7(17)+6(16)	32	
No.7(17)+8(18)	42	

## 4. Manual feed

### 4.4 Profiling 4.4.3 Radius profile cutterheads

<p>Spare part: clamping wedge 629231</p>  <p>WZ 125375 R2 ME 619245</p>	<p>WZ 125138 R3 ME 619246</p> <p>WZ 125139 R4 ME 619247</p> <p>WZ 125140 R5 ME 619248</p> <p>WZ 125141 F3x45° ME 619252</p>	<p>Spare part: clamping wedge 629231</p>  <p>WZ 125146 R6 ME 619249</p> <p>WZ 125147 R7 ME 619250</p> <p>WZ 125148 R8 ME 619251</p> <p>WZ 125149 F5x45° ME 619253</p>	<p>Spare part: clamping wedge 629232</p>  <p>WZ 125154 R10 ME 619254</p> <p>WZ 125155 R11 ME 619255</p> <p>WZ 125156 R12 ME 619256</p> <p>WZ 125157 F7x45° ME 619261</p>
<p>Spare part: clamping wedge 629231</p>  <p>WZ 125376 R2 ME 619245</p>	<p>WZ 125142 R3 ME 619246</p> <p>WZ 125143 R4 ME 619247</p> <p>WZ 125144 R5 ME 619248</p> <p>WZ 125145 F3x45° ME 619252</p>	<p>Spare part: clamping wedge 629231</p>  <p>WZ 125150 R6 ME 619249</p> <p>WZ 125151 R7 ME 619250</p> <p>WZ 125152 R8 ME 619251</p> <p>WZ 125153 F5x45° ME 619253</p>	<p>Spare part: clamping wedge 629232</p>  <p>WZ 125158 R10 ME 619254</p> <p>WZ 125159 R11 ME 619255</p> <p>WZ 125160 R12 ME 619256</p> <p>WZ 125161 F7x45° ME 619261</p>
<p>Spare part: clamping wedge 629232</p>  <p>WZ 125162 R13 ME 619257</p> <p>WZ 125163 R14 ME 619258</p> <p>WZ 125164 R15 ME 619259</p> <p>WZ 125165 F8x40° ME 619262</p>	<p>Spare part: clamping wedge 629233</p>  <p>WZ 125170 R16 ME 619263</p> <p>WZ 125171 R17 ME 619264</p> <p>WZ 125172 F9x40° ME 619269</p>	<p>Spare part: clamping wedge 629233</p>  <p>WZ 125176 R18 ME 619265</p> <p>WZ 125177 R19 ME 619266</p> <p>WZ 125178 R20 ME 619267</p> <p>WZ 125179 F10x40° ME 619270</p>	
<p>Spare part: clamping wedge 629232</p>  <p>WZ 125166 R13 ME 619257</p> <p>WZ 125167 R14 ME 619258</p> <p>WZ 125168 R15 ME 619259</p> <p>WZ 125169 F8x40° ME 619262</p>	<p>Spare part: clamping wedge 629234</p>  <p>WZ 125173 R16 ME 619271</p> <p>WZ 125174 R17 ME 619272</p> <p>WZ 125175 F9x40° ME 619277</p>	<p>Spare part: clamping wedge 629234</p>  <p>WZ 125180 R18 ME 619273</p> <p>WZ 125181 R19 ME 619274</p> <p>WZ 125182 R20 ME 619275</p> <p>WZ 125183 F10x40° ME 619278</p>	
<p>Spare part: clamping wedge 629235</p>  <p>WZ 125184 R25 ME 619279</p> <p>WZ 125185 R26 ME 619280</p> <p>WZ 125186 R27 ME 619281</p>	<p>Spare part: clamping wedge 629235</p>  <p>WZ 125190 R28 ME 619282</p> <p>WZ 125191 R29 ME 619283</p> <p>WZ 125192 R30 ME 619284</p>	<p>SB 20</p>  <p>WZ 23015 ME 5071 VE 10 pcs.) Wedge 9671</p>	
		<p>SB 35</p>  <p>WZ 23016 ME 5073 VE 10 pcs.) Wedge 9674</p>	
<p>Spare part: clamping wedge 629236</p>  <p>WZ 125187 R25 ME 619285</p> <p>WZ 125188 R26 ME 619286</p> <p>WZ 125189 R27 ME 619287</p>	<p>Spare part: clamping wedge 629236</p>  <p>WZ 125193 R28 ME 619288</p> <p>WZ 125194 R29 ME 619289</p> <p>WZ 125195 R30 ME 619290</p>	<p>SB 50</p>  <p>WZ 23017 ME 5075 VE 10 pcs.) Wedge 9677</p>	
		<p>Spacer set (one set per cutterhead necessary)</p>  <p>60x20x30</p>	





### Profile cutterhead ProfilCut Q for internal doors

#### Application:

For internal door profiles and counter profiles.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

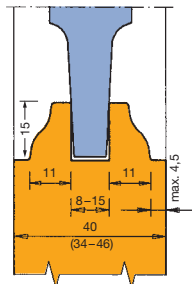
Cutterhead with change knives, straight cut.

#### Tool combination DOUBLE profile with jointing

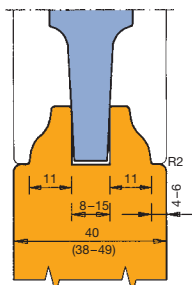
AE 341 1 53, AW 341 1

Tool Type	Tool no.	BO mm	BO <sub>max</sub> mm	ID
Profile 1 (P2-P5 on request)	1/2/3	30	50	<b>126532</b> ●
Profile 1.1 (P2.1-P5.1 on request)	1/2/3/4/5	30	50	<b>126533</b>
Profile 6/7	2/4/5/6/7	30	50	<b>126534</b>
Profile 6.1/7	2/4.1/5.1/6/7	30	50	<b>126535</b>
Profile 8	2/8/9/10	30	50	<b>126536</b>
Profile 8.1	2/8.1/9.1/10	30	50	<b>126537</b>
Addition for rebates and/or one side	15/16	30	50	<b>126538</b>

Combinations complete in wooden boxes.



Profile P 1 closed joint



Profile P 1.1 with open joint

#### Single tools

SW 501 1, WE 500 1 53, WW 200 1 NN, WW 210 1 NN, WW 410 1 NN

Tool Type	Tool no.	D mm	SB mm	BO mm	ID
Profile cutterhead *	1	155	25	30	<b>125250</b> ●
Grooving cutterhead	2	155.2	8 - 15	30	<b>125089</b> ●
Profile cutterhead	3	155	25	30	<b>125251</b> ●
Profile cutterhead	4	161	30	30	<b>125252</b>
Profile cutterhead	5	161	30	30	<b>125253</b>
Profile cutterhead	6	155.1	25	30	<b>125254</b>
Profile cutterhead	7	155.1	25	30	<b>125255</b>
Profile cutterhead	8	165	25	30	<b>125256</b>
Profile cutterhead bevel	8.1	165	25	30	<b>125257</b>
Profile cutterhead	9	165	25	30	<b>125258</b>
Profile cutterhead bevel	9.1	165	25	30	<b>125259</b>
Jointing cutterhead	10	125	15	30	<b>125013</b>
Rebating cutterhead	15	155	35	30	<b>125018</b>
Jointing cutterhead	16	125	30	30	<b>125019</b>

\* = Profile cutterheads supplied with profile P1.

#### Spare knives:

Part- no.	BEZ	ABM mm	P	Tool no.	QAL	VE PCS	ID
1	ProfilCut Q knife	25x27x2	1	1	MC		<b>619291</b>
1	ProfilCut Q knife	25x27x2	2	1	MC		<b>619292</b>
1	ProfilCut Q knife	25x27x2	3	1	MC		<b>619293</b>
1	ProfilCut Q knife	25x27x2	4	1	MC		<b>619294</b>
1	ProfilCut Q knife	25x27x2	5	1	MC		<b>619295</b>
1	ProfilCut Q knife	25x27x2	1	1	MC		<b>619296</b>
1	ProfilCut Q knife	25x27x2	2	3	MC		<b>619297</b>
1	ProfilCut Q knife	25x27x2	3	3	MC		<b>619298</b>
1	ProfilCut Q knife	25x27x2	4	3	MC		<b>619299</b>
1	ProfilCut Q knife	25x27x2	5	3	MC		<b>619300</b>
1	ProfilCut Q knife	30x31x2	6/7	3	MC		<b>619301</b>
1	ProfilCut Q knife	30x31x2	6/7	5	MC		<b>619302</b>
1	ProfilCut Q knife	25x27x2	6/6.1/7	6	MC		<b>619303</b>
1	ProfilCut Q knife	25x27x2	6/6.1/7	7	MC		<b>619304</b>
1	ProfilCut Q knife	25x32x2	8	8	MC		<b>619305</b>
1	ProfilCut Q knife	25x32x2	8.1	8.1	MC		<b>619306</b>

● available ex stock

□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)



## 4. Manual feed

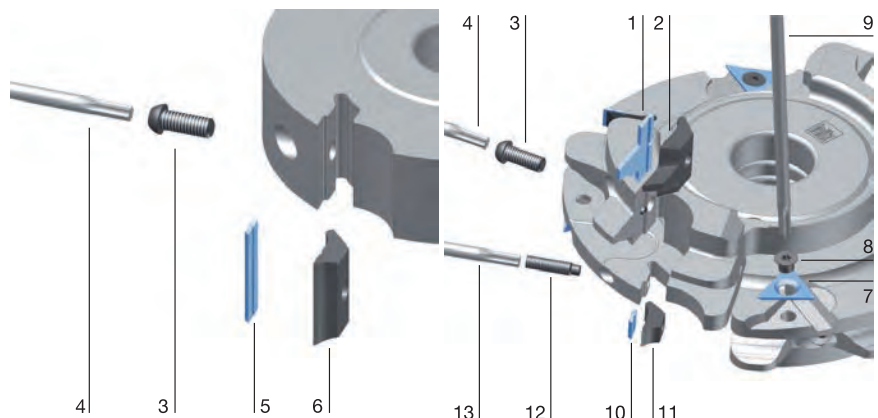
### 4.4 Profiling

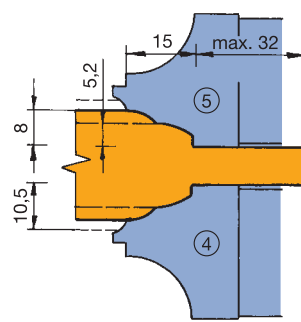
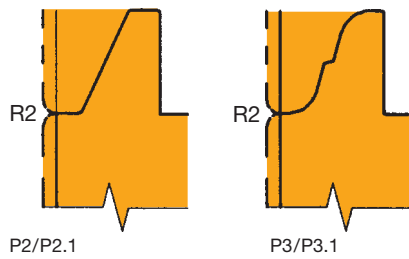
#### 4.4.4 Profile and counter profile cutterheads

Part-no.	BEZ	ABM mm	P	Tool no.	QAL	VE PCS	ID
1	ProfilCut Q knife	25x32x2	8	9	MC		619307
1	ProfilCut Q knife	25x32x2	8.1	9.1	MC		619308
5	Turnblade knife	14.7x8x1.5		10	HW-30F	10	005070 ●
5	Turnblade knife	30x8x1.5		16	HW-30F	10	005072 ●
5	Turnblade knife	35x8x1.5		15	HW-30F	10	005073 ●
7	Turnblade spur VS2	19x19x2		2/5	HW-F	10	005115 ●
10	Turnblade knife	7.7x8x1.5		2	HW-30F	10	005068 ●

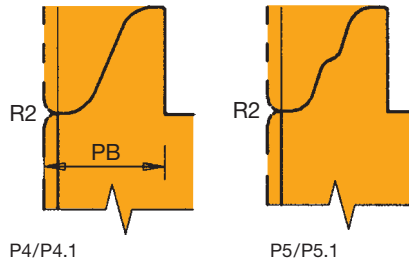
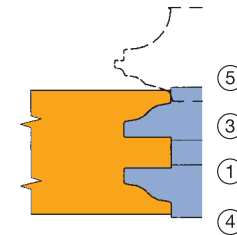
#### Spare parts:

Part-no.	BEZ	ABM mm	P	Tool no.	ID
2	Clamping wedge profiled	23x30x8.27		3	629237
2	Clamping wedge profiled	23x30x8.27		1	629238
2	Clamping wedge profiled	28x38x8.27	6/6.1/7	4/4.1	629239
2	Clamping wedge profiled	28x38x8.27	6/6.1/7	5/5.1	629240
2	Clamping wedge profiled	23x37.32x8.27	6/6.1/7	6	629241
2	Clamping wedge profiled	23x37.32x8.27	6/6.1/7	7	629242
2	Clamping wedge profiled	23x37.2x8.27	8/8.1	8/8.1	629243
2	Clamping wedge profiled	23x37.2x8.27	8/8.1	9/9.1	629244
3	Clamping screw w. disc, Torx® 25	M6x18.5			007442 ●
4	Torx® key	Torx® 25			117504 ●
6	Clamping wedge	13x18.75x8.27		6	009670 ●
6	Clamping wedge	28x18.75x8.27	1/2/16	4	009673 ●
6	Clamping wedge	33x18.75x8.27	15	5	009674 ●
8	Countersink screw, Torx® 20	M6x0.5x4.9			006243 ●
9	Torx® key	Torx® 20			117503 ●
11	Clamping wedge	7x18.75x8.27	2	2	009763 ●
12	Allen screw with shank, Torx® 15	M5x20			007380 ●
13	Torx® key	Torx® 15			117507 ●
	Magnetic setting gauge	0.3/0.8			005376 ●



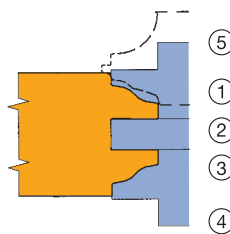


Double profile

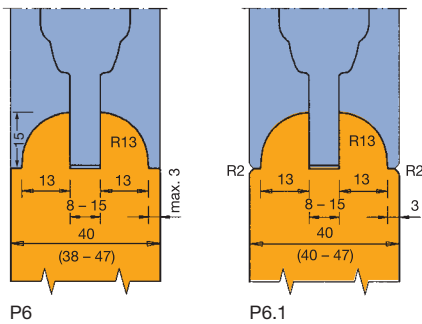
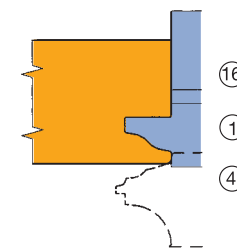


These profile cutterheads can be used for panel raising.

Fig.: Combination options of single tools  
Double profile



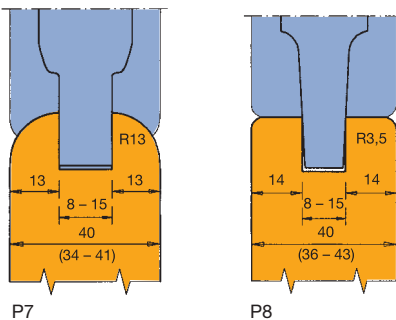
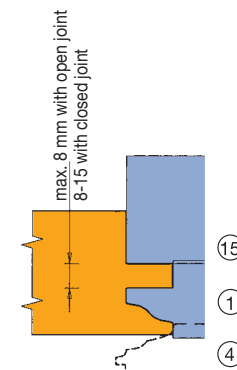
Profiles P1 - P5.1 counter profile



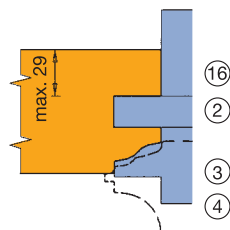
For profiles P1 - P5.1 along grain



Rebate\*

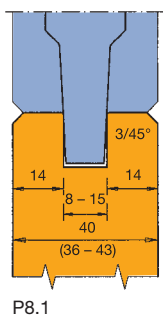
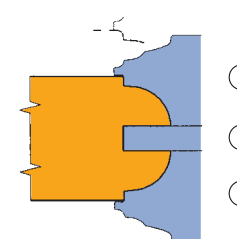


Rebate\*



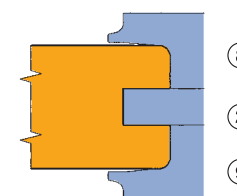
On one side\*

\* Profiles P1 - P8 (rebate possible and on one side)



On one side\*

Profiles P6 - P7 along grain

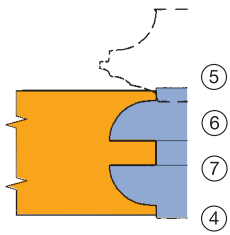


Profile P8 along grain

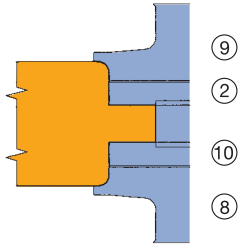
## 4. Manual feed

### 4.4 Profiling

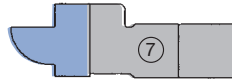
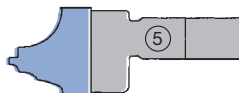
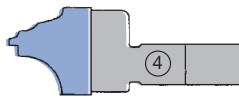
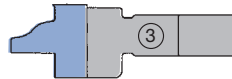
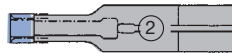
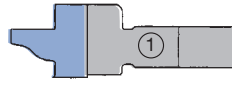
#### 4.4.4 Profile and counter profile cutterheads



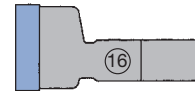
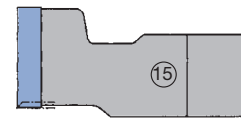
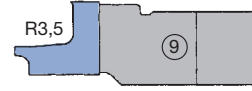
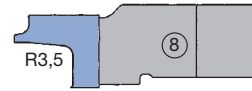
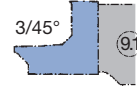
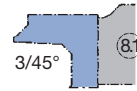
Profiles P6 - P7 counter profile



Profile P8 counter profile



Single tools





### Profile cutterhead ProfilCut Q for furniture doors

#### Application:

For profiles and counter profiles for furniture doors.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

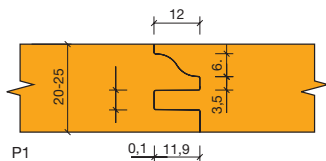
#### Technical information:

Cutterhead with change knives, straight cut.

#### SB 20 - 25 mm; with closed joint

WE 640 1 53

D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	P	n min <sup>-1</sup>	ID
150	40	30	50	2	1	5200 - 8900	125262 ●
150	40	50		2	1	5200 - 8900	125392 □



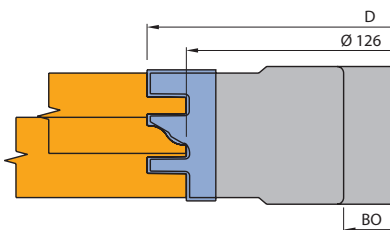
P2

P3



P4

P5



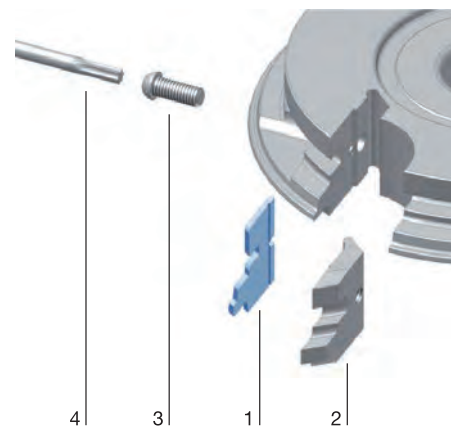
Profile cutterhead

#### Spare knives:

Part-no.	BEZ	ABM mm	P	QAL	ID
1	ProfilCut Q knife	40x26x2	1	MC	619311
1	ProfilCut Q knife	40x26x2	2	MC	619312
1	ProfilCut Q knife	40x26x2	3	MC	619313
1	ProfilCut Q knife	40x26x2	4	MC	619314
1	ProfilCut Q knife	40x26x2	5	MC	619315

#### Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	38x36.5x8.27	629245
3	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
4	Torx® key	Torx® 25	117504 ●





### Profile cutterhead ProfilCut Q - panel raising

**Application:**

For profiling and panel raising 5 different profiles by knife change.

**Machine:**

Spindle moulders and moulders, double-end tenoners.

**Workpiece material:**

Softwood and hardwood (along and across grain).

**Technical information:**

Cutterhead with change knives, shear angle.

**Profiling and panel raising, panel raising profile curved**

AE 342 1 53

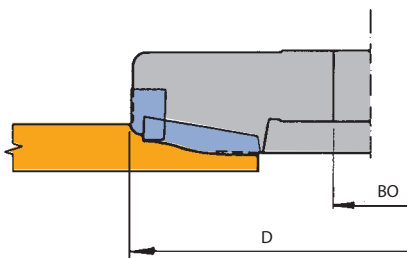
P	D	SB	BO	BO <sub>max</sub>	Z	n	DRI	ID
	mm	mm	mm	mm		min <sup>-1</sup>		
1	190	40	30	50	2/2	4100 - 7000	RH	125265 ●

**Spare knives:**

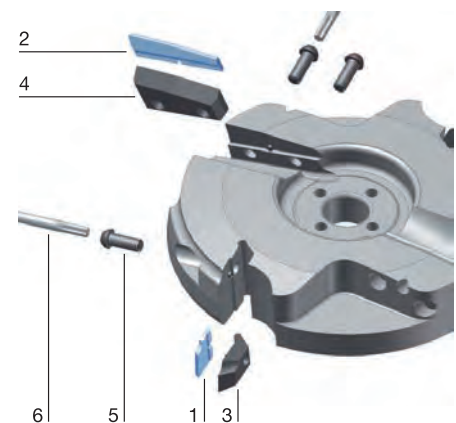
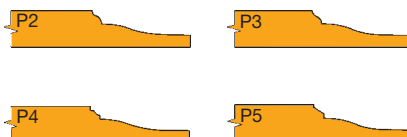
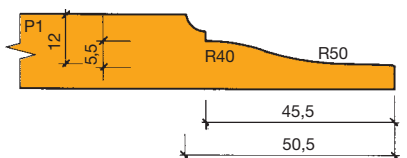
Part-no.	BEZ	ABM	P	ID
		mm		
1	ProfilCut Q knife	20x16x2	1	619321 ●
1	ProfilCut Q knife	20x16x2	2	619322 ●
1	ProfilCut Q knife	20x16x2	3	619323 ●
1	ProfilCut Q knife	20x16x2	4	619324 ●
1	ProfilCut Q knife	20x16x2	5	619325 ●
2	ProfilCut Q knife (pan.rais.)	50x11.68x2		619326 ●

**Spare parts:**

Part-no.	BEZ	ABM	ID
		mm	
3	Clamping wedge profiled	18x26.46x8.27 (P1-5)	629248
4	Clamping wedge profiled	47x20.18x7.25 (raised panel)	629249
5	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
6	Torx® key	Torx® 25	117504 ●



Single side panel raising





### Profile cutterhead ProfilCut Q - panel raising

**Application:**

For profiling and panel raising 5 different profiles by knife change.

**Machine:**

Spindle moulders and moulders, double-end tenoners.

**Workpiece material:**

Softwood and hardwood (along and across grain).

**Technical information:**

Cutterhead with change knives, shear angle.

**Profiling and panel raising, panel raising profile straight**

AE 342 1 53

P	D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	n min <sup>-1</sup>	DRI	ID
1	204	33	30	50	2/2	3800 - 6500	RH	<b>125266</b>
1	220	33	30	50	2/2	3500 - 6000	RH	<b>125267</b>
1	220	33	50	50	2/2	3500 - 6000	RH	<b>125268</b>

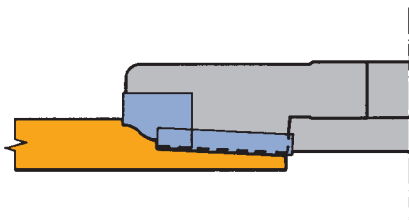
P1 = Profile cutterhead P1.

**Spare knives:**

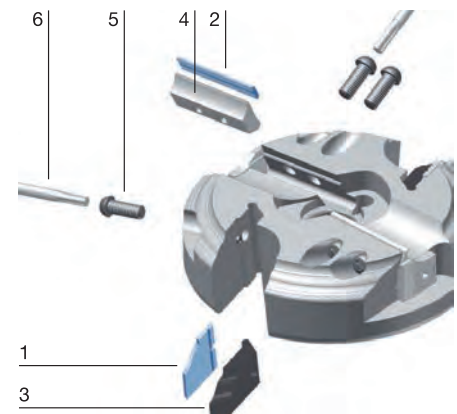
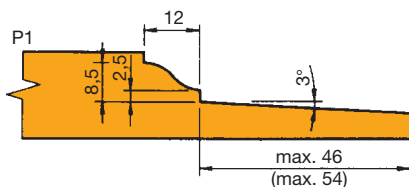
Part-no.	BEZ	ABM mm	P	VE PCS	ID
1	ProfilCut Q knife	20x27x2	1		<b>619327</b>
1	ProfilCut Q knife	20x27x2	2		<b>619328</b>
1	ProfilCut Q knife	20x27x2	3		<b>619329</b>
1	ProfilCut Q knife	20x27x2	4		<b>619330</b>
1	ProfilCut Q knife	20x27x2	5		<b>619331</b>
2	Turnblade knife	50x8x1.5		10	<b>005075 •</b>
2	Turnblade knife	60x8x1.5		10	<b>005076 •</b>

**Spare parts:**

Part-no.	BEZ	ABM mm	P	ID
3	Clamping wedge profiled	18x37.46x8.27	1-5	<b>629250</b>
4	Clamping wedge panel raising cutter	47x16.8x7.25		<b>009578 •</b>
4	Clamping wedge panel raising cutter	57x16.8x7.25		<b>009579 •</b>
5	Clamping screw w. disc, Torx® 25	M6x18.5		<b>007442 •</b>
6	Torx® key	Torx® 25		<b>117504 •</b>



Single side panel raising



## 4. Manual feed

### 4.4 Profiling

#### 4.4.5 Panel raising profile cutterheads



#### Profile cutterhead ProfilCut Q - panel raising

##### Application:

For profiling and panel raising 4 different profiles by knife change.

##### Machine:

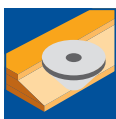
Spindle moulders and moulders, double-end tenoners.

##### Workpiece material:

Softwood and hardwood, three layer laminate.

##### Technical information:

Cutterhead with change knives and shear angle. Tool with 4 profile variants (bevel and quarter round).



#### Profiling and panel raising using one knife, panel raising profile straight

WE 550 1 53

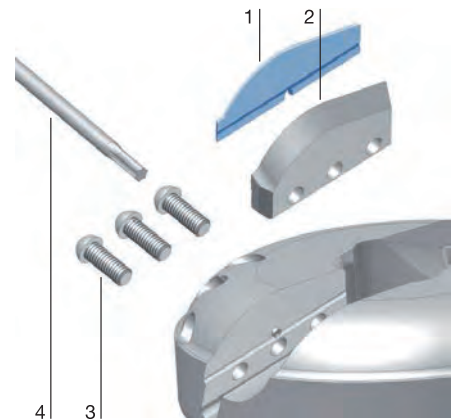
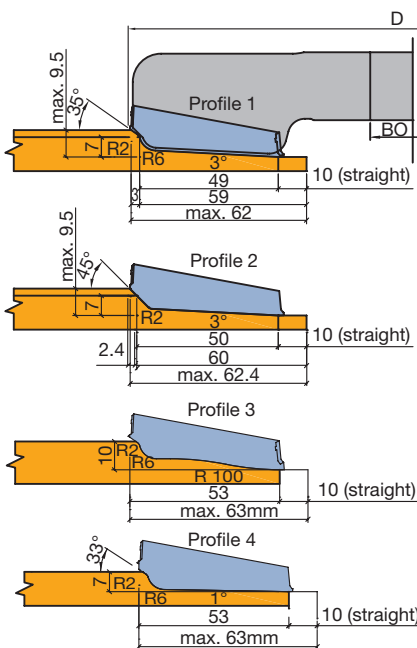
P	D	SB	BO	BO <sub>max</sub>	Z	n	ID
	mm	mm	mm	mm		min <sup>-1</sup>	
1	200	10 - 37	30	50	2	3900 - 6600	125269 ●

##### Spare knives:

Part-no.	BEZ	ABM	P	QAL	ID
		mm			
1	ProfilCut Q knife	60x14.5x2	1	MC	619332 ●
1	ProfilCut Q knife	60x14.56x2	2	MC	619333 ●
1	ProfilCut Q knife	60x14.5x2	3	MC	619489
1	ProfilCut Q knife	60x14.5x2	4	MC	619490

##### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	57x23x7.25	629251
3	Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
4	Torx® key	Torx® 25	117504 ●







### Profile cutterhead set ProfilCut Q

**Application:**

For panel raising of cabinet doors, table tops and worktops.

**Machine:**

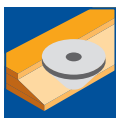
Spindle moulders and moulders, double-end tenoners.

**Workpiece material:**

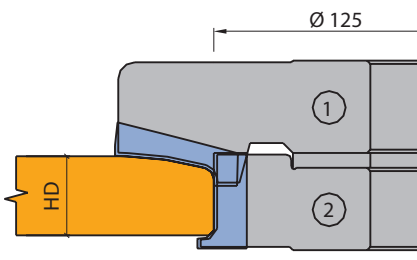
Softwood and hardwood, wood derived materials.

**Technical information:**

Cutterhead with throwaway knives and shear angle. Can be used either as single tool without jointing or as set with jointing cutterhead.



Profile 1.1



P1.1



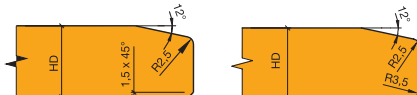
P1.2



P1.3



P2.2



P2.1



P2.3

**Profile cutterhead set with jointing**

SE 500 1 53

Tool no.	D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	P	n min <sup>-1</sup>	ID
1 / 2	185	29 - 29.5	30	50	22	1.1	4200 - 7200	<b>126066 ●</b>

**Single tools**

WE 500 1 53, WE 550 1 53

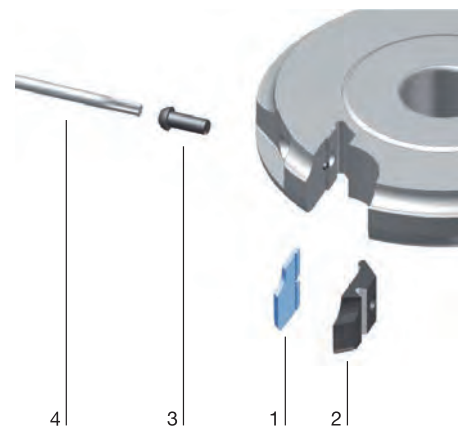
Tool no.	D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	n min <sup>-1</sup>	ID
1	185	10 - 38	30	50	2	4200 - 7200	<b>125263</b>
2	135	29 - 29.5	30	50	2	5700 - 9800	<b>125264</b>

**Spare knives:**

Part-no.	BEZ	ABM mm	P	Tool no.	QAL	ID
1	ProfilCut Q knife	40x13.21x2	1	1	MC	<b>619316</b>
1	ProfilCut Q knife	40x13.21x2	2	1	MC	<b>619317</b>
1	ProfilCut Q knife	30x15.9x2	1	2	MC	<b>619318</b>
1	ProfilCut Q knife	30x15.9x2	2	2	MC	<b>619319</b>
1	ProfilCut Q knife	30x15.9x2	3	2	MC	<b>619320</b>

**Spare parts:**

Part-no.	BEZ	ABM mm	Tool no.	ID
2	Clamping wedge profiled	37x21.38x8.27	1	<b>629246 ●</b>
2	Clamping wedge profiled	28x24x8.27	2	<b>629247 ●</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5		<b>007442 ●</b>
4	Torx® key	Torx® 25		<b>117504 ●</b>



## 4. Manual feed

### 4.4 Profiling 4.4.6 Common profiles



#### Profile cutterhead ProfilCut Q for handrail profile

##### Application:

For handrails. Copy shaping of curved workpieces using template and ball bearing guide ring.

##### Machine:

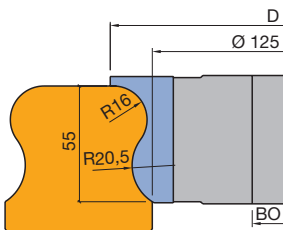
Spindle moulders and moulders, machines with/without CNC control.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Cutterhead with change knives and straight cut.



Handrail profile

##### Handrail profile

WE 500 1 53

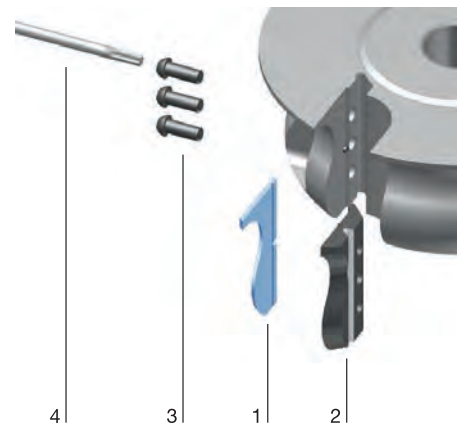
D	SB	BO	BO <sub>max</sub>	Z	n	ID
mm	mm	mm	mm		min <sup>-1</sup>	
165	60 - 61	30	50	2	4700 - 8100	<b>125386 •</b>

##### Spare knives:

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	ProfilCut Q knife	60x32.7x2.4	MC	<b>619500</b>

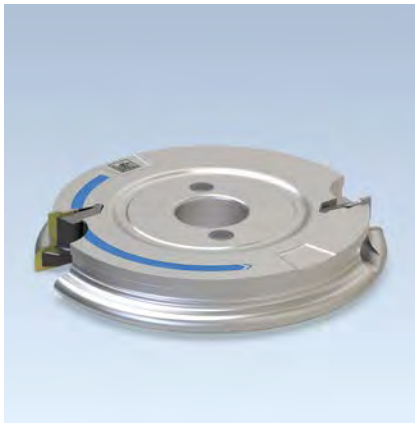
##### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	58x35x8.27	<b>629463</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 •</b>
4	Torx® key	Torx® 25	<b>117504 •</b>



## 4. Manual feed

### 4.4 Profiling 4.4.6 Common profiles



#### Profile Cutterhead ProfilCut Q for grip rails

##### Application:

For cutting recessed grips.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood, chip and fibre board, raw or plastic coated, glulam etc.

##### Technical information:

Maximum operating comfort due to lightweight construction of the tool body. Longer lasting consistent finish cutting quality due to Marathon high performance coating.

##### MAN feed

WE 500 1 53

D	SB	BO	BO <sub>max</sub>	Z	ID
mm	mm	mm	mm		
150	25	30	50	2	<b>125380 ●</b>

**RPM:**  $n_{\max} = 12500 \text{ min}^{-1}$

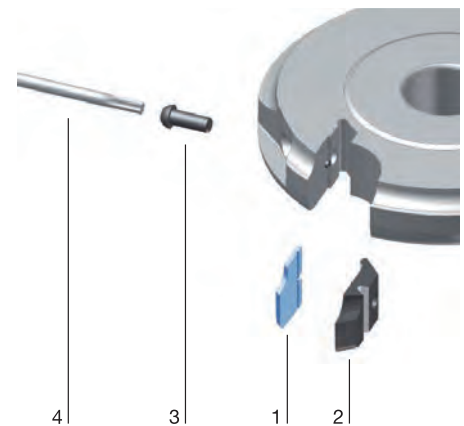
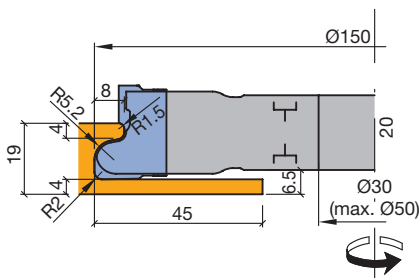
Throwaway knives for other profile variants available on request.

##### Spare knives:

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	ProfilCut Q knife	25.1x21x2.4	MC	<b>619475</b>

##### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge profiled	21x29.5x8.27	<b>629464</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 ●</b>
4	Torx® key	Torx® 25	<b>117504 ●</b>



## 4. Manual feed

### 4.4 Profiling 4.4.6 Common profiles



#### Profile cutterhead ProfilCut Q for gear grooves

##### Application:

For gear grooves.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Cutterhead with change knives. User friendliness by lightweight construction of the tool body. Longer performance and cut quality due to Marathon high performance coating.



##### Gear groove

WE 500 1 53

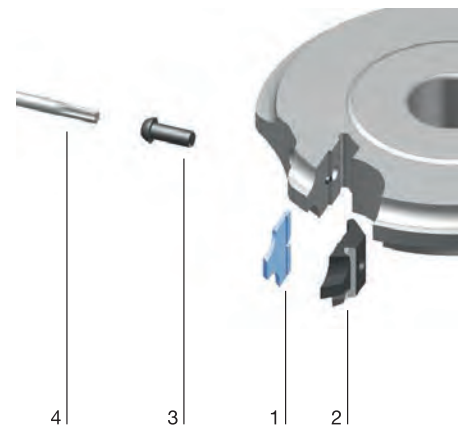
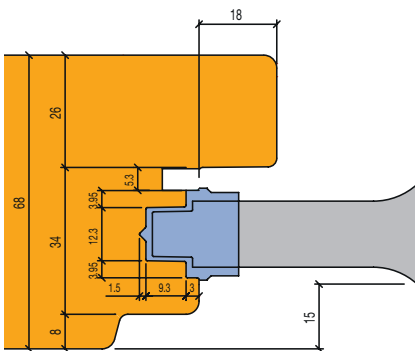
D	SB	BO	BO <sub>max</sub>	Z	n	ID
mm	mm	mm	mm		min <sup>-1</sup>	
188.6	21.3/23.1	30	50	2	4100 - 9100	<b>125393 •</b>

##### Spare knives:

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	ProfilCut Q knife	21.3x25x2.4	MC	<b>619521</b>

##### Spare parts:

Part-no.	BEZ	ABM	ID
		mm	
2	Clamping wedge	15.7x33x8.27	<b>629461</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 •</b>
4	Torx® key	Torx® 25	<b>117504 •</b>



## 4. Manual feed

### 4.4 Profiling

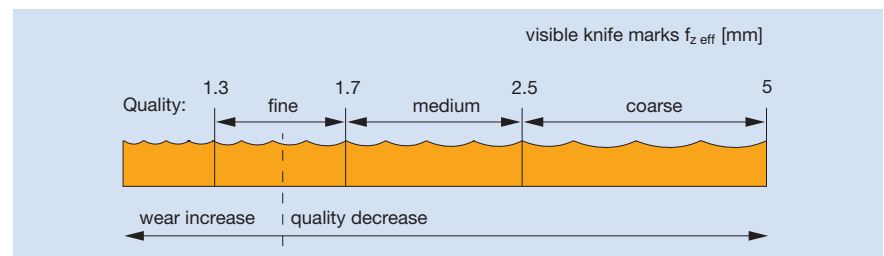
#### 4.4.7 Multi-purpose profile cutterheads

##### Type of operation

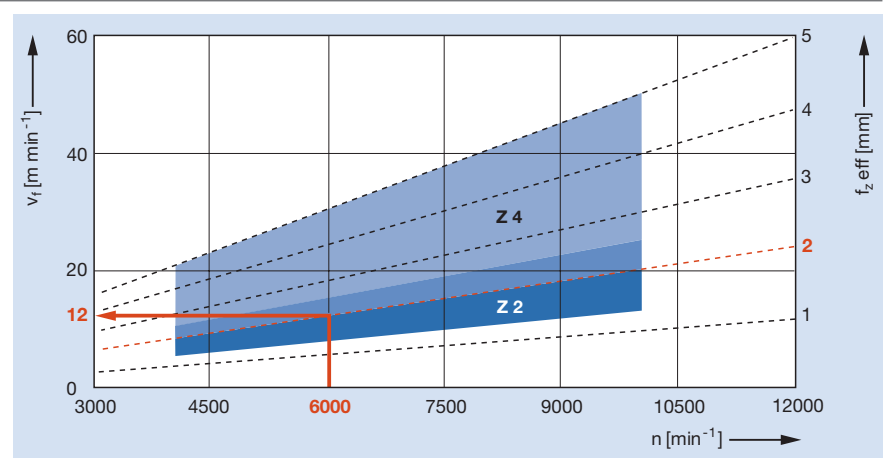
The tools described in the following section are suitable for making many different profiles. This includes profiling in craft or industry, the relevant product descriptions provide a reference when using a specific tool, and the type of woods processed.

The introduction to each section gives general notes and application regulations.

##### Relation between surface quality and length of knife marks $f_{z\text{ eff}}$



##### Feed speeds depending on RPM, length of knife marks and number of teeth



With multi blade tools, only the marks of one knife show on the surface (one knife finish). Z 2 and Z 4 tools produce the same surface quality with same machine setting. High numbers of teeth are required for a high hogging performance.

##### Workpiece materials, machines, application

Please refer to the relevant product pages depending on the operation and profile.

##### Tool system



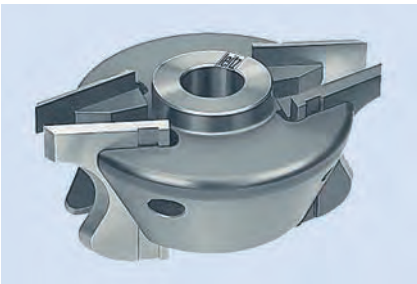
WM 500 1 04 Profile cutterhead with limiter, tool body in aluminium.

For profile depths up to maximum 15 mm and cutting widths of 50 mm. (WM 510 1 03)  
 For profile depths up to maximum 15 mm and cutting widths of 40 mm. (WM 500 1 04)  
 For small companies or craft. For spindle moulders or combination machines. More than 127 standard profile cutters and limitors available. If required Leitz can supply profile knives and limitors in HS quality to a special shape. Only a drawing or wood sample of the required profile is necessary to produce the special knives.

## 4. Manual feed

### 4.4 Profiling

#### 4.4.7 Multi-purpose profile cutterheads



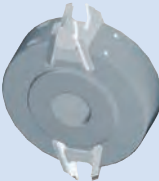
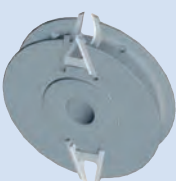

WM 530 1 01 Profile cutterhead.  
WM 530 1 02 Profile cutterhead.  
WM 520 1 Profile cutterhead.  
WM 540 1 Profile cutterhead.

For big profile depths up to maximum 45 mm and cutting widths up to 80 mm. Suitable for small and medium sized companies to produce special profiles. For machines with manual feed. Special profile knives in HS quality can be produced by the Leitz service stations on request. Only a sketch or wood sample of the required profile is necessary to produce special profile knives.



Profile cutterhead VariForm.

**VariForm** cutterheads are available in different designs and dimensions. The tool body is designed for mech. feed without limiter or for manual feed with limiter depending on the application. Please select the correct type of cutterhead for each application from the diagram below.

Design variation	Profile depth up to 15/19 mm	Profile depth up to 20 mm	Profile depth up to 35 mm
<b>MAN-feed</b> For spindle moulders	 Multi-purpose tool body	 Part profiled tool body, U-profile	 Profiled tool body, cranked right/left
Cutting width	40/45 mm a. 50/60 mm	45/45 mm a. 50/60 mm	40 mm to 60 mm



### Profile cutterhead, aluminium tool body

**Application:**

For profiling, jointing and rebating.

**Machine:**

Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Profile cutterhead with aluminium tool body for standard and special profile knives up to 50 mm cutting width and maximum profile depth 15 mm. Constant diameter by using changeable profile knives. Knife thickness 4 mm.


**D 108 mm - 148 mm**

WM 500 1 04, WM 500 1 06

D mm	SB mm	BO mm	BO <sub>max</sub> mm	Z	n min <sup>-1</sup>	QAL	ID
108	40	30	30	2	6000 - 10000	SP	<b>025685 ●</b>
128	40 - 50	30	40	2	6000 - 9000	SP	<b>025815 ●</b>
128	80	30	40	2	6000 - 8000	SP	<b>025816 ●</b>
148	40 - 50	30	50	2	5500 - 7000	SP	<b>025691 ●</b>

See section Knives and Spare Parts.

Table for diameters when using rebating and profile knives:

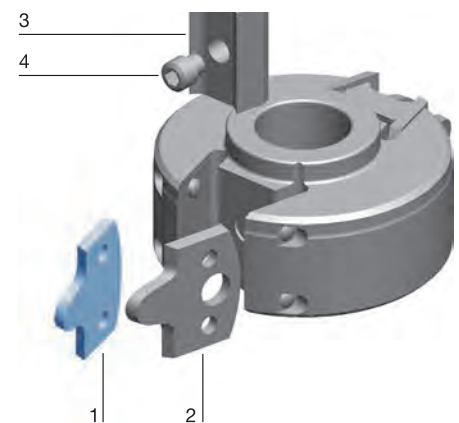
D-mm Tool body	D-mm with rebating knife	D-mm with profile knife
93	108	130
114	128	150

**Spare knives:**

Part-no.	BEZ	ABM mm	QAL	ID
1	Rebate knife	40x32.8x4	SP	<b>007104 ●</b>
2	Limiter	38.4x32.8x4	ST	<b>005586 ●</b>

**Spare parts:**

Part-no.	BEZ	ABM mm	ID
3	Clamping wedge	36x13.21x26	<b>009756 ●</b>
3	Clamping wedge	56x13.21x26	<b>009757 ●</b>
4	Allen screw with ISK 5	M10x12	<b>006044 ●</b>
	Allen key	SW 5	<b>005446 ●</b>







### Profile cutterhead

**Application:**

For deep one-sided profiles, maximum 45 mm depth.

**Machine:**

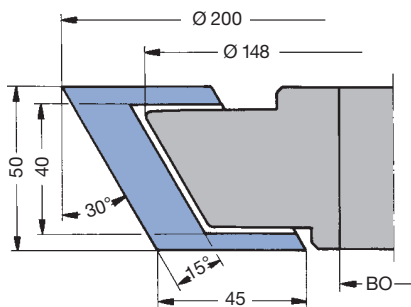
Spindle moulders and moulders.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Cutting width up to 50 mm. See illustration for usable profile area. Knife thickness 4.0 mm.


**MAN feed, for one sided profiles with SB 50 mm**

WM 530 1 01

D	TD	SB	BO	BO <sub>max</sub>	Z	n	ID
mm	mm	mm	mm	mm		min <sup>-1</sup>	
200	148	50	30	40	2	4500 - 7000	<b>029636 ●</b>

Sales unit without knives and limitors.

Note: State direction of rotation when ordering knives.

**Spare knives:**

BEZ	BEM	ABM	QAL	ID
		mm		
Blank Knife	R/T	50.4x45x4	HS	<b>007297 ●</b>
Blank Knife	R/B	50.4x45x4	HS	<b>007298 ●</b>
Limiter blank	R/T	48.8x45x4	SP	<b>005603 ●</b>
Limiter blank	R/B	48.8x45x4	SP	<b>005604 ●</b>

**Spare parts:**

BEZ	ABM	ID
	mm	
Allen screw	M10x16	<b>006046 ●</b>
Allen key	SW 5	<b>005446 ●</b>
Double wedge	49.2x13.2x26	<b>009927 ●</b>

**HS-special profiles and SP-profile limitors**

Profile knives set inc. limitor	PG I	SB = 50 mm
Profile knives set inc. limitor	PG II	SB = 50 mm
Set consists of:	2 HS-Profile knives; 2 SP-Limitors	

Profile knives and limitors produced to customer's profile.

**Only use this cutterhead with original Leitz profile knives and limitors!**

## 4. Manual feed

### 4.4 Profiling

#### 4.4.7 Multi-purpose profile cutterheads



#### Profile cutterhead

##### Application:

For deep one-sided profiles with large profile depth, maximum 45 mm depth. Easy to use, no setting gauge required.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Cutting width up to 80 mm. See illustration for usable profile area. Knife thickness 4.0 mm.



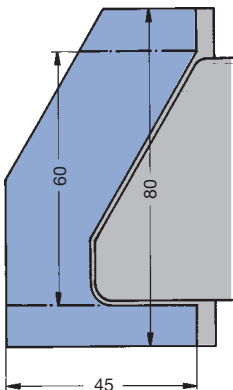
#### MAN feed, for one sided profiles with SB 60 - 80 mm

WM 530 1 02

D	SB	BO	BO <sub>max</sub>	HD	PT <sub>max</sub>	Z	n	ID
mm	mm	mm	mm	mm	mm		min <sup>-1</sup>	
180	60 - 80	30	40	80	45	2	4500 - 6000	<b>026768</b> ●
180	60 - 80	40	40	80	45	2	4500 - 6000	<b>026769</b> □

Sales unit without knives and limitors.

Note: State direction of rotation when ordering knives.



#### Spare knives:

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	Blank Knife R/B	60x60x6	HS	<b>007280</b> ●
1	Blank Knife R/B	80x60x6	HS	<b>007281</b> ●
1	Blank Knife R/T	60x60x6	HS	<b>007282</b> ●
1	Blank Knife R/T	80x60x6	HS	<b>007283</b> ●
2	Limiter blank R/B (60)	58x59.2x6	SP	<b>005596</b> ●
2	Limiter blank R/B (80)	78x59.2x6	SP	<b>005597</b> ●
2	Limiter blank R/T (60)	58x59.2x6	SP	<b>005598</b> ●
2	Limiter blank R/T (80)	78x59.2x6	SP	<b>005599</b> ●

#### Spare parts:

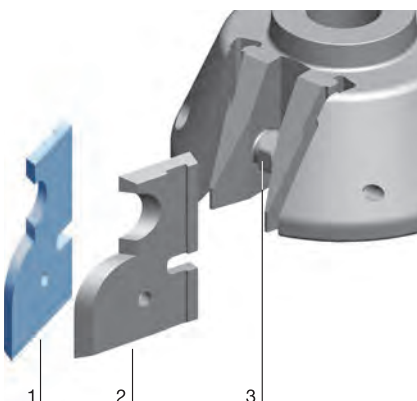
Part-no.	BEZ	ABM	ID
		mm	
3	Clamping screw	M16x1.5x36 LH/RH	<b>005958</b> ●
	Key	SW 17	<b>005456</b> ●

#### HS-special profiles and SP-profile limitors

PG I	Set of profile knives	SB = 60 mm
PG II	Set of profile knives	SB = 60 mm
PG I	Set of profile knives	SB = 80 mm
PG II	Set of profile knives	SB = 80 mm
Set consists of:		2 HS-Profile knives
		2 SP-Limitors

Profile knives and limitors are produced to customer's profile.

**Only use this cutterhead with original Leitz profile knives and limitors!**



## 4. Manual feed

### 4.4 Profiling

#### 4.4.7 Multi-purpose profile cutterheads



#### Profile cutterhead

##### Application:

For deep profiles with large profile depth, maximum 45 mm depth, with resharpenable profile knives and limitors. Easy to use, no setting gauge required.

##### Machine:

Spindle moulders and moulders.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Cutting width up to 80.0 mm. Symmetrical tool body for right hand or left hand rotation as required.



##### MAN feed for symmetric profiles SB 60 - 80 mm

WM 520 1

D	SB	BO	BO <sub>max</sub>	HD	PT <sub>max</sub>	Z	n	ID
mm	mm	mm	mm	mm	mm		min <sup>-1</sup>	
180	60 - 80	30	40	80	45	2	4500 - 6000	026651 ●
180	60 - 80	40	40	80	45	2	4500 - 6000	026652 □

Sales unit without knives and limitors.

Note: State direction of rotation when ordering knives.

##### Spare knives:

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	Blank Knife	60x60x6	HS	007278 ●
1	Blank Knife	80x60x6	HS	007279 ●
2	Limiter blank	58x59.2x6	SP	005594 ●
2	Limiter blank	78x59.2x6	SP	005595 ●

##### Spare parts:

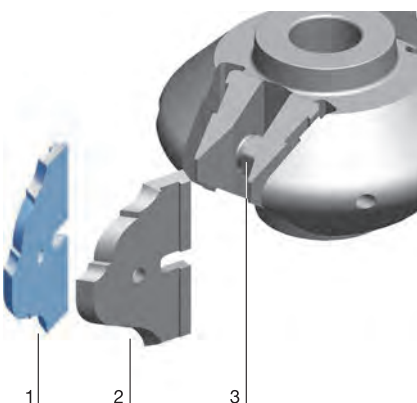
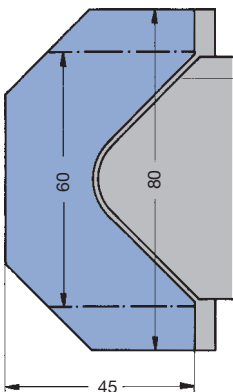
Part-no.	BEZ	ABM	ID
		mm	
3	Clamping screw	M16x1.5x36 LH/RH	005958 ●
	Key	SW 17	005456 ●

##### HS-special profiles and SP-profile limitors

PG I	Set of profile knives	SB = 60 mm
PG II	Set of profile knives	SB = 60 mm
PG I	Set of profile knives	SB = 80 mm
PG II	Set of profile knives	SB = 80 mm
Set consists of:		2 HS-Profile knives
		2 SP-Limitors

Profile knives and limitors are produced to customer's profile.

**Only use this cutterhead with original Leitz profile knives and limitors!**





### Profile cutterhead

#### Application:

For deep profiles with large profile depth, maximum 45 mm depth, with resharpenable profile knives and limitors. Easy to use, no setting gauge required.

#### Machine:

Spindle moulders and moulders.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Cutting width up to 80.0 mm. Symmetrical tool body for right hand or left hand rotation as required.



#### MAN feed for symmetric closed profiles SB 60 - 80 mm

WM 540 1

D	SB	BO	BO <sub>max</sub>	HD	PT <sub>max</sub>	Z	n	ID
mm	mm	mm	mm	mm	mm		min <sup>-1</sup>	
180	60 - 80	30	40	80	45	2	4500 - 6000	026865 ●
180	60 - 80	40	40	80	45	2	4500 - 6000	026866 □

Sales unit without knives and limitors.

Note: State direction of rotation when ordering knives.

#### Spare knives:

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	Blank Knife	60x60x6	HS	007276 ●
1	Blank Knife	80x60x6	HS	007277 ●
2	Limiter blank	58x59.2x6	SP	005600 ●
2	Limiter blank	78x59.2x6	SP	005601 ●

#### Spare parts:

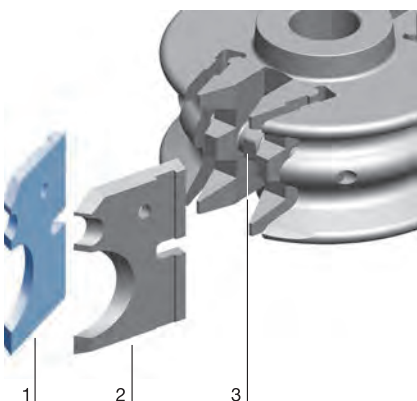
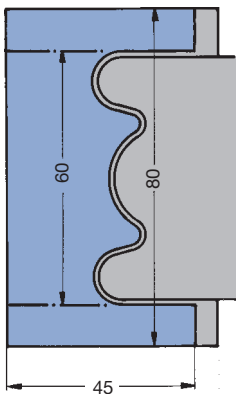
Part-no.	BEZ	ABM	ID
		mm	
3	Clamping screw	M16x1.5x36 LH/RH	005958 ●
	Key	SW 17	005456 ●

#### HS-special profiles and SP-profile limitors

PG I	Set of profile knives	SB = 60 mm
PG II	Set of profile knives	SB = 60 mm
PG I	Set of profile knives	SB = 80 mm
PG II	Set of profile knives	SB = 80 mm
Set consists of:		2 HS-Profile knives
		2 SP-Limitors

Profile knives and limitors are produced to customer's profile.

**Only use this cutterhead with original Leitz profile knives and limitors!**





### Profile cutterhead VariForm

#### Application:

For cutting profiles. Different knives with maximum 15 mm profile depth can be mounted.

#### Machine:

Spindle moulders and moulders, double-end tenoners, edgebanding machines etc.

#### Workpiece material:

Softwood and hardwood (HW-30F), panel materials or glued wood (HW-10F).

#### Technical information:

Multi-purpose profile cutterhead for MAN feed with tungsten carbide special profile knives and backing plates and limitors. Resharpenable 3 to 4 times.



#### Tool body, MAN feed, Z 2

TT 531 1

D	TD	SB	BO	BO <sub>max</sub>	PT <sub>max</sub>	Z	n <sub>max</sub>	ID
mm	mm	mm	mm	mm	mm		min <sup>-1</sup>	
150	116	40 - 45	30	50	15	2	8000	135100 ●
150	116	50 - 60	30	50	15	2	8000	135101 ●

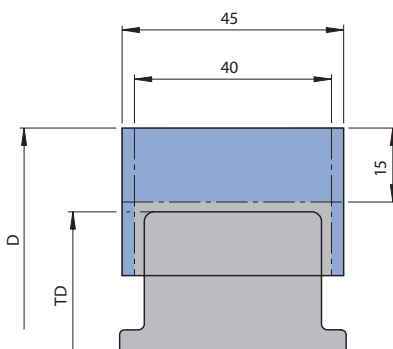
Supplied with clamping wedges, but without backing plates, limitors and knives.

#### Spare knives:

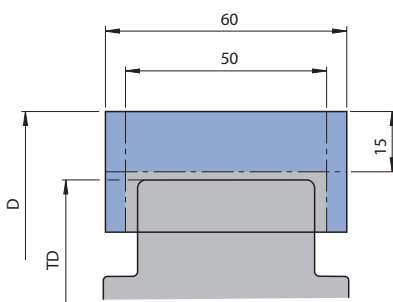
Part-no.	SB	H	PT <sub>max</sub>	ID	ID
	mm	mm	mm	HW-10F	HW-30F
1	40	40	15	636227 ●	636240 ●
1	45	40	15	636231 ●	636244 ●
1	50	40	15	636284 ●	636272 ●
1	60	40	15	636288 ●	636276 ●

#### Spare parts:

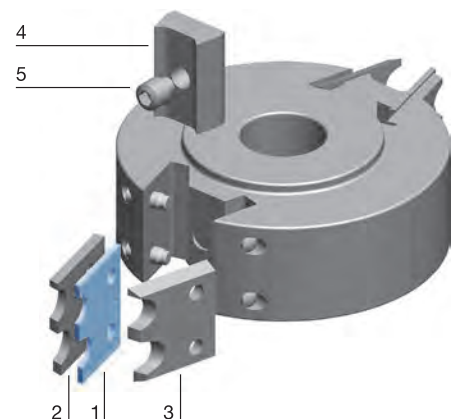
Part-no.	BEZ	ABM	for SB	ID
		mm	mm	
2	Backing plate VariForm	for knives 40x40x2.1	40	645000 ●
2	Backing plate VariForm	for knives 45x40x2.1	45	645001 ●
2	Backing plate VariForm	for knives 50x40x2.1	50	645002 ●
2	Backing plate VariForm	for knives 60x40x2.1	60	645003 ●
3	Limiter VariForm	for knives 40x40x2.1		640000 ●
3	Limiter VariForm	for knives 45x40x2.1		640001 ●
3	Limiter VariForm	for knives 50x40x2.1		640002 ●
3	Limiter VariForm	for knives 60x40x2.1		640003 ●
4	Clamping wedge	36x13.21x26	40/45	009756 ●
4	Clamping wedge VariForm	44x13.21x24.25	50/60	009760 ●
5	Allen screw with ISK 5	M10x12		006044 ●
	Allen key	SW 5, L100		117506 ●



Tool body, SB 40/45 mm



Tool body, SB 50/60 mm





### Profile cutterhead VariForm

**Application:**

For cutting profiles. Different knives with maximum 20 mm profile depth can be mounted.

**Machine:**

Spindle moulders and moulders, double-end tenoners, edgebanding machines etc.

**Workpiece material:**

Softwood and hardwood (HW-30F), panel materials or glued wood (HW-10F).

**Technical information:**

Multi-purpose profile cutterhead for MAN feed with tungsten carbide special profile knives and backing plates and limitors. Resharpenable 3 to 4 times.


**Part profiled tool body, MAN feed, Z 2 (U-profile).**

TT 531 1

D	TD	SB	BO	BO <sub>max</sub>	PT <sub>max</sub>	Z	n <sub>max</sub> min <sup>-1</sup>	ID
mm	mm	mm	mm	mm	mm			
180	165	40	30	50	20	2	7200	135120 ●
180	165	60	30	50	20	2	7200	135122 ●

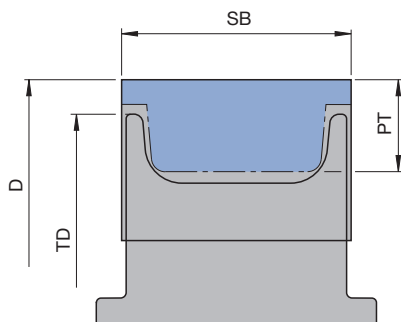
Supplied with clamping wedges, but without backing plates, limitors and knives.

**Spare knives:**

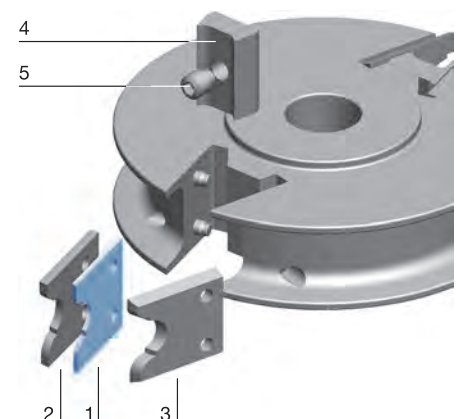
Part-no.	SB	H	PT	ID	ID
	mm	mm	mm	HW-10F	HW-30F
1	40	45	20	636226 ●	636239 ●
1	60	45	20	636287 ●	636275 ●

**Spare parts:**

Part-no.	BEZ	ABM mm	for SB mm	ID
2	Backing plate VariForm	for knives 40x45x2.1		645004 ●
2	Backing plate VariForm	for knives 60x45x2.1		645006 ●
3	Limiter VariForm	for knives 40x45x2.1		640004 ●
3	Limiter VariForm	for knives 60x45x2.1		640006 ●
4	Clamping wedge	36x13.21x26	40/45	009756 ●
4	Clamping wedge	56x13.21x26	60	009757 ●
5	Allen screw with ISK 5	M10x12		006044 ●
	Allen key	SW 5, L100		117506 ●



Tool body, U profile



Problem	Possible cause	Action
<b>Surface errors</b> <b>Cutting quality</b>	– RPM too low	Increase RPM and cutting speed, increase tool diameter
	– Wrong cutting geometry (shear angle too small for solid wood)	Measure, change tool
	– Spindle and tool tolerances too big	Check motor bearings and tolerances
	– Unbalanced tool	Check and balance
	– Cutting speed too high (tool rubs), number of teeth: feed speed ratio incorrect	Increase feed speed, reduce no. of teeth and RPM
	– Too few teeth, too high feed speed	Adjust number of teeth and feed speed accordingly
<b>Wavy, rough surface</b>	– Irregular workpiece feed	Check feed or conveyor unit
	– Low feed roller pressure, worn feed rollers	Increase feed roller pressure and re-machine grooves in rollers
	– Workpieces too narrow or too short	Pay attention to machine manufacturer's guidelines
	– Chip removal too high	Pre-relieve or machine in several passes
	– Resin built up, or blunt tool	Clean and sharpen tool regularly
<b>Surface errors</b> <b>Burn marks</b>	– Cutting speed too high	Reduce RPM
	– Feed speed: number of teeth ratio wrong	Adjust number of teeth and feed speed accordingly
	– Tool rotates on stationary workpiece	Ensure constant feed through the machine
<b>Surface errors</b> <b>Tear outs</b>	– Wood moisture content too low	Check drying process
	– Knotty wood	Optimise with crosscut saw and longitudinal joints
<b>Surface errors</b> <b>Chip marks</b>	– Incorrect cutting geometry for workpiece material	Check, adjust or use new tool
	– Gap between knife and wedges	Clean and carefully mount knife and wedge
	– Gullet too small	Check and enlarge
	– Extraction hood and chip removal unit insufficient	Contact machine manufacturer
	– Weak dust extraction	Guideline: 30 m s <sup>-1</sup> air speed
<b>Profile error in workpiece – angle error – uneven</b>	– Tool profile sets not identical, e.g. with sets for cutting with/against feed	Check and adjust tool set
	– Spindle not exactly vertical in feed direction or table plane	Check spindle is vertical with dial gauge at two positions with moving spindle (top and bottom of spindle)
	– Worn table and fence	Rework or replace table and fence
	– Angle tolerance between table and fence too large or incorrect adjustment of fence and zero line	Check and adjust angles, adjust fence to tool zero diameter
<b>Power consumption of motor</b> <b>Feeding force</b>	– Resin built up on tool, blunt tool	Clean and sharpen tool regularly
	– Tool gullet too small	Check and correct
	– Shear angle too small	Correct or use new tool
	– Cutting section too large	Relieve profile or machine in several passes

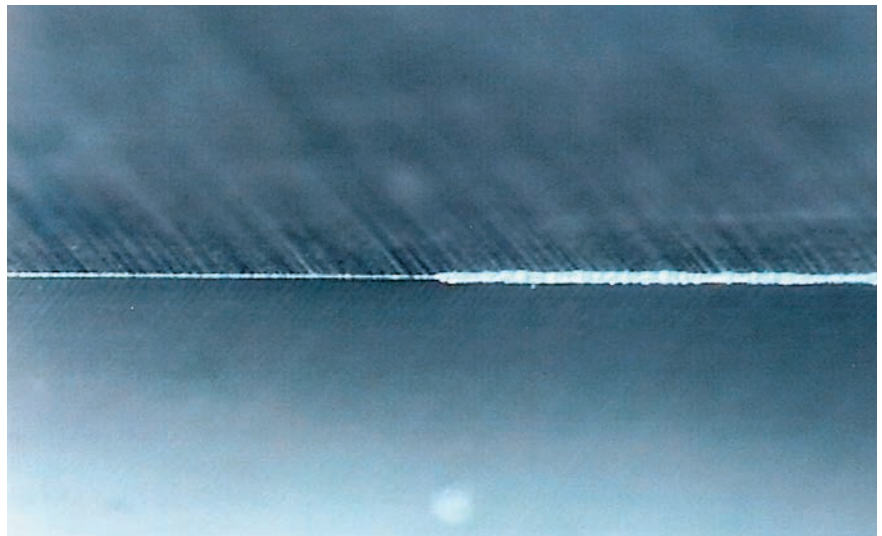


### Rounding of cutting edges

Mechanical abrasion causes continuous rounding to the cutting edge when machining uniform materials.

The machined surface quality determines the size of the cutting edge wear. As a standard the width of wear VB of 0.2 to maximum 0.3 mm should not be exceeded.

Tipped tools must be resharpened regularly to ensure the economic efficiency of the tool.

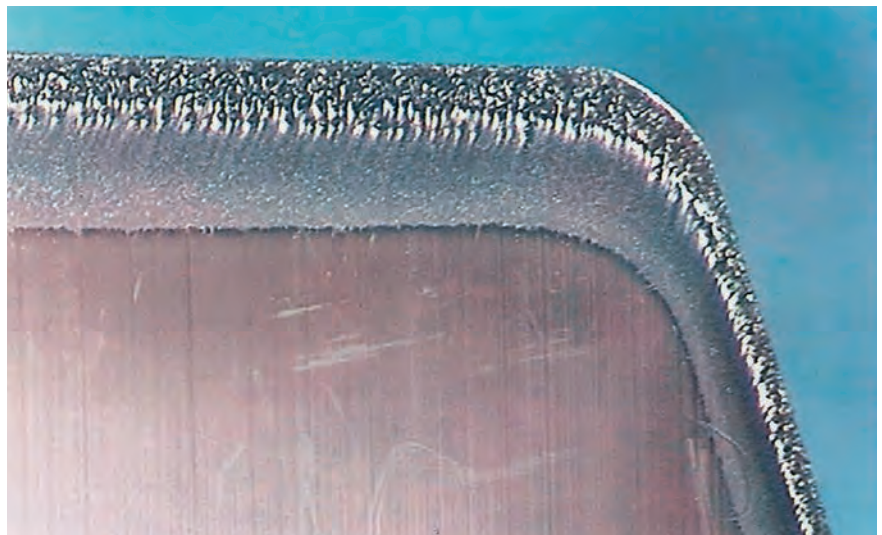


Typical cutting edge wear after machining spruce.

### Chemical wear to cutting edges

When machining workpiece materials with a high tannic acid content (e.g. oak), the wear to the cutting edges is a combination of mechanical and chemical wear.

The cobalt binder material in the tungsten carbide is etched away by a chemical action prematurely damaging the cutting material.



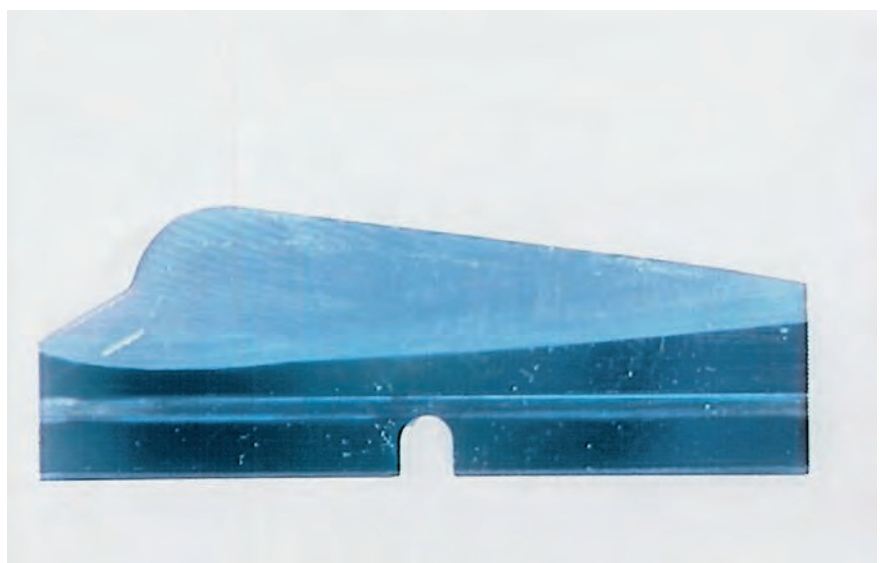
Chemical influence – cutting edge wear – after machining of oak.

### Cutting edge damage through incorrect repair

With cutterhead/cutter set tools with HW cutting edges, the knives must be turned or replaced at the end of their performance time.

Resharpener on the face is not possible for safety reasons as it leads to a loss of clamping force and gaps between the knife and the clamping wedge, affect the surface quality.

Tools with turnblade/replaceable knives must be thoroughly cleaned and carefully mounted when changing knives.



Damaged cutting edges due to incorrect repair.

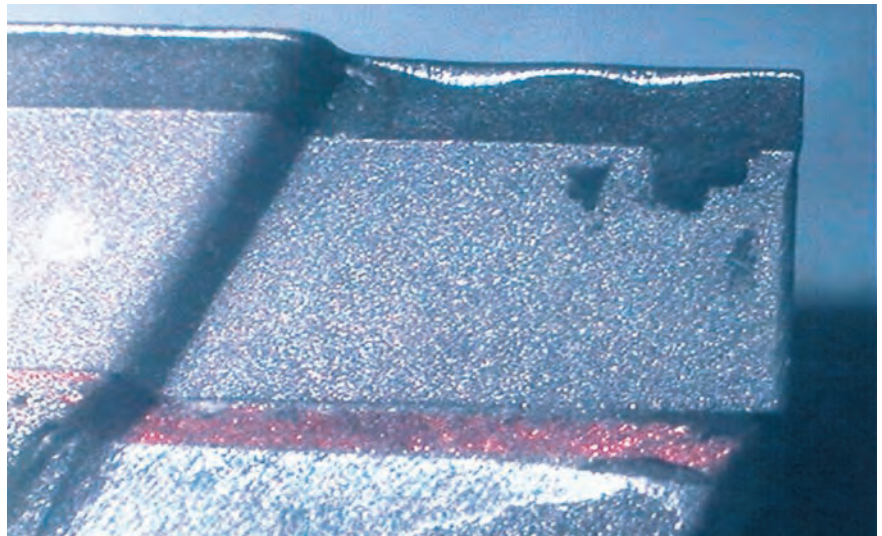
### Rounding of cutting edges

Mechanical abrasion causes continuous rounding to the cutting edge when machining uniform materials.

Resin build up can develop on the cutting edges because of the long performance time.

The machined surface quality determines the size of the cutting edge wear. As a standard the width of wear VB of 0.2 to maximum 0.3 mm should not be exceeded.

Run time performance can be increased by removing the resin build-up.



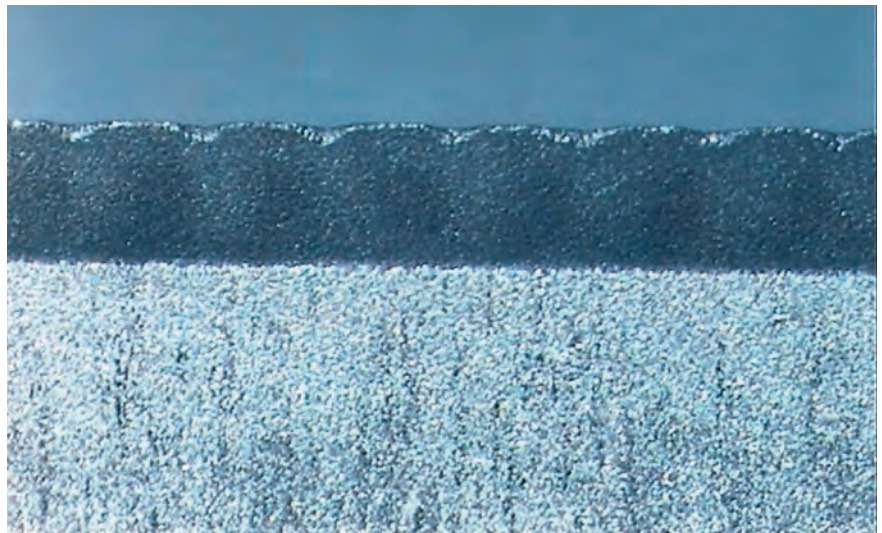
Cutting edge wear after machining GFK.

### Rounding cutting edges and small chips

The cutting edge is damaged by small chips not caused by the usual wear when machining some wood-derived materials.

This is usually caused by foreign objects such as mineral particles in the work-piece material.

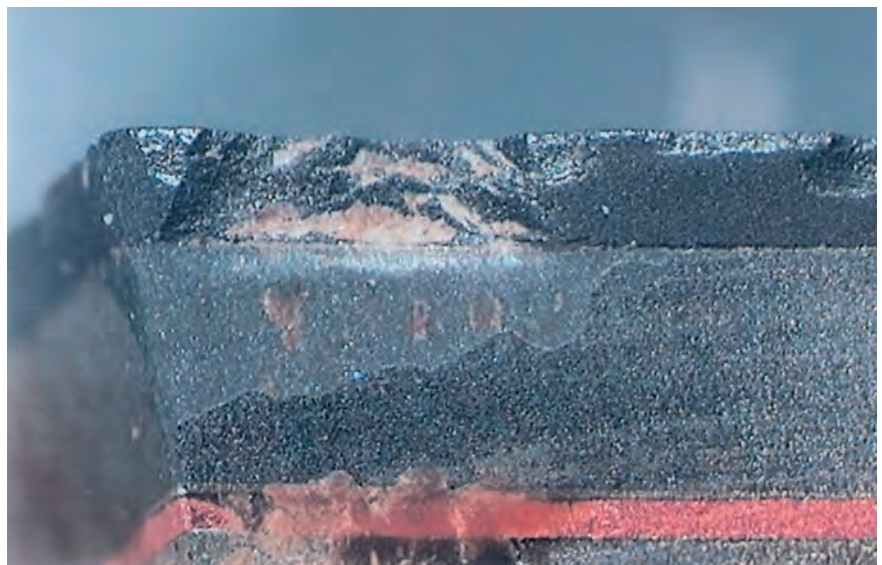
The wear to the cutting edges and the size of the chips to the cutting edge are important factors for economically efficient repair. Increasing cutting forces can totally destroy the cutting edges.



Cutting edge wear and cracks after machining HPL/CPL.

### Cutting edge destruction

The cutting edge can be destroyed when machining non-uniform materials containing mineral or metallic particles. These particles cannot be detected prior to machining and limit the use of DP (DIA) tools for machining such materials.



Cutting edge destruction by metallic particles.



## Enquiry/order form special tools – manual feed

**Customer details: Customer number:**          
(if known)

☐ Enquiry  
☐ Order

Delivery date: (not binding)   CW

Company:

Street:

Date:

Town/Postcode:

Enquiry/order no.:

Country:

Tool ID: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

### Work piece material:

☐ Solid wood Type: \_\_\_\_\_  
☐ Wood-derived mat. Type: \_\_\_\_\_  
☐ Coating Type: \_\_\_\_\_  
☐ Other Type: \_\_\_\_\_  
☐ Finish hogging

Moisture content: \_\_\_\_\_ %  
 Density: \_\_\_\_\_ g/cm<sup>3</sup>  
 Additional information: \_\_\_\_\_

### Machine:

(Spindle moulder, moulder, double-end tenoner  
edgebanding machines, window machines etc.)

Manufacturer: \_\_\_\_\_  
 Year: \_\_\_\_\_  
 Type: \_\_\_\_\_

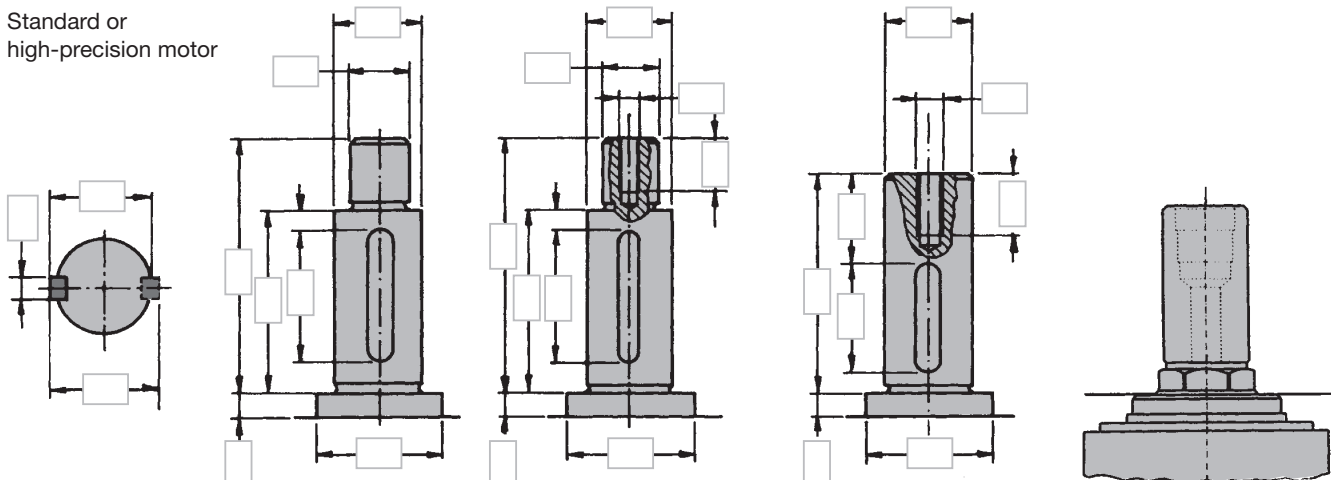
Spindle sequence in feed direction:

e.g.: 1 bottom, 2 right hand, 3 left hand, 4 top, 5 multi-purpose  
 or: 1 scoring, 2 hogging, 3 cutting, 4 square cutting, 5 finish cutting  
 or: 1 sawing, 2 slotting/tenoning, 3 cutting with feed, 4 cutting against feed

Motor no.:	Power:	RPM:	Spindle dimension:	add. Information:
1	kW	min <sup>-1</sup>	mm	
2	kW	min <sup>-1</sup>	mm	
3	kW	min <sup>-1</sup>	mm	
4	kW	min <sup>-1</sup>	mm	
5	kW	min <sup>-1</sup>	mm	

Please state direction of rotation (LH/RH) or cutting direction (GGL/GLL) for each spindle.

Standard or  
high-precision motor



## Tool:

Tool type (see product information): (e.g. single part/tipped-/tool combination)

Dimension:

Diameter mm

Cutting width: mm

Bore: mm

No. of teeth:

Cutt. mat:

- ☐ HL  
☐ HS  
☐ ST  
☐ HW  
☐ DP

Adapter:

- ☐ No adaptor required  
☐ Sleeve with anti-twist device  
☐ Sleeve without anti-twist device  
☐ Quick clamping element  
☐ Hydro clamping element

Notes:

Zero-diameter: mm

Max. diameter.: mm

Zero-height: mm

Clamping length: mm

Direction of rotation:

- ☐ Right hand rotation  
☐ Left hand rotation

Cutting direction:

- ☐ Against feed  
☐ With feed

Type of feed:

- ☐ Manual feed (MAN)  
☐ Mechanical feed (MEC)

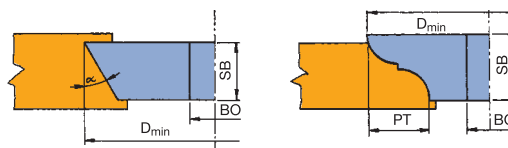
Feed speed: min<sup>-1</sup>

Cutting width (SB): mm

Cutting depth: mm

Application:

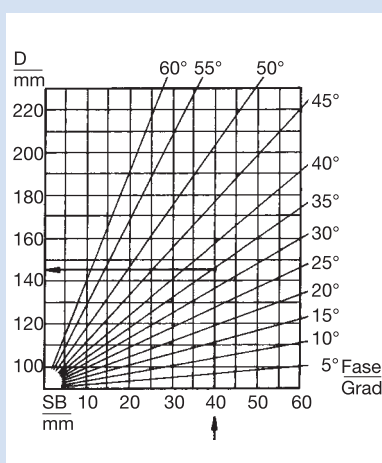
- |              |                                      |                                       |   |
|--------------|--------------------------------------|---------------------------------------|---|
| Solid wood   | <input type="checkbox"/> along grain | <input type="checkbox"/> across grain | <input type="checkbox"/> end grain                  |
| Wood-derived | <input type="checkbox"/> top layer   | <input type="checkbox"/> middle layer | <input type="checkbox"/> top layer and middle layer |



## Technical information:

Tipped tool (bevel-/profile router):  
 Design: BG-Test, Z 2, round design  
 mech. feed, Z 3, Z 4, round design,  
 tooth shape: with/without spurs

Chart to determine min. tool diameter:  
 Valid for bevel cutterblock BO – 30 mm:  
 For bore 40 mm:  
 $D + 10 \text{ mm}$   
 For bore 50 mm:  
 $D + 20 \text{ mm}$



## Formula to determine tool diameter:

Valid for profile cutterblock BO – 30 mm:

For bore 40 mm:  $D + 10 \text{ mm}$

For bore 50 mm:  $D + 10 \text{ mm}$

**Formula:**  $D_{\min} = 100 + 2 \times PT \text{ (mm)}$

## Note:

Angles exceeding 45° and large profile depths require large diameters. The maximum possible RPM for the cutterblock diameter must not be exceeded. Profile sketches or profile drawings must show clearly if the workpiece material (wood) or cutterblock is shown. Please state side to table, direction of rotation, dimensions and conditions of application on all workpiece samples or drawings.

Tool combination with turnblade-/exchangeable knives:

**Formula:**  $D_{\min} = 80 \times 2 \times PT \text{ (mm)}$  – Valid for BO – 30 mm

Sketch for application plan, profile drawing, special motor spindle, etc.

Please specify workpiece support and fence side and/or workpiece face side top/bottom.

## Key to pictograms



Grooving,  
horizontal  
and vertical



Interchangeable  
knives



Jointing



Mechanical  
knife clamping,  
reversible



Copy  
shaping



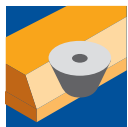
Mechanical  
knife clamping,  
non-adjustable



Rebating



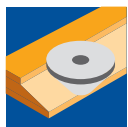
Resharpenable  
cutting face



Bevelling



Resharpenable  
clearance face



Panel  
raising



Alloyed  
tool steel



Profiling



High-speed  
steel



Profiling  
joints



Tungsten  
carbide



Manual  
feed



Polycrystalline  
diamond (PCD)



Tipped tool



Carbide  
metal coating



Light alloy  
body



# Routing

Leitz Lexicon Edition 7

Version 2

05/2022





## Explanation of abbreviations

A	= dimension A
$a_e$	= cutting thickness (radial)
$a_p$	= cutting depth (axial)
ABM	= dimension
APL	= panel raising length
APT	= panel raising depth
AL	= working length
AM	= number of knives
AS	= anti sound (low noise design)

b	= overhang
B	= width
BDD	= thickness of shoulder
BEM	= note
BEZ	= description
BH	= tipping height
BO	= bore diameter

CNC	= Computerized Numerical Control
-----	----------------------------------

d	= diameter
D	= cutting circle diameter
D0	= zero diameter
DA	= outside Diameter
DB	= diameter of shoulder
DFC	= Dust Flow Control (optimised chip clearance)
DGL	= number of links
DIK	= thickness
DKN	= double keyway
DP	= polycrystalline diamond
DRI	= rotation

FAB	= width of rebate
FAT	= depth of rebate
FAW	= bevel angle
FLD	= flange diameter
$f_z$	= tooth feed
$f_{z\text{ eff}}$	= effective tooth feed

GEW	= thread
GL	= total length
GS	= Plunging edge

H	= height
HC	= tungsten carbide, coated
HD	= wood thickness (thickness of workpiece)
HL	= high-alloyed tool steel
HS	= high-speed steel (HSS)
HW	= tungsten carbide (TCT)

ID	= ident number
IV	= insulation glazing

KBZ	= abbreviation
KLH	= clamping height
KM	= edge breaker
KN	= single keyway
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60

L	= length
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LH	= left hand rotation
----	----------------------

M	= metric thread
MBM	= minimum order quantity
MC	= multi-purpose steel, coated
MD	= thickness of knife
$\text{min}^{-1}$	= revolutions per minute (RPM)
MK	= morse taper
$\text{m min}^{-1}$	= metres per minute
$\text{m s}^{-1}$	= metres per second

n	= RPM
$n_{\text{max}}$	= maximum permissible RPM
NAL	= position of hub
ND	= thickness of hub
NH	= zero height
NL	= cutting length
NLA	= pinhole dimensions
NT	= grooving depth

P	= profile
POS	= cutter position
PT	= profile depth
PG	= profile group

QAL	= cutting material quality
-----	----------------------------

R	= radius
RD	= right hand twist
RH	= right hand rotation
RP	= radius of cutter

S	= shank dimension
SB	= cutting width
SET	= set
SLB	= slotting width
SLL	= slotting length
SLT	= slotting depth
SP	= tool steel
ST	= Cobalt-basis cast alloys, e.g. Stellite™
STO	= shank tolerance
SW	= cutting angle

TD	= diameter of tool body
TDI	= thickness of tool
TG	= pitch
TK	= reference diameter

UT	= cutting edges with irregular pitch
----	--------------------------------------

V	= number of spurs
$v_c$	= cutting speed
$v_f$	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
-----	----------------------

Z	= number of teeth
ZA	= number of fingers
ZF	= tooth shape (cutting edge shape)
ZL	= finger length

### Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



## 5. Routing



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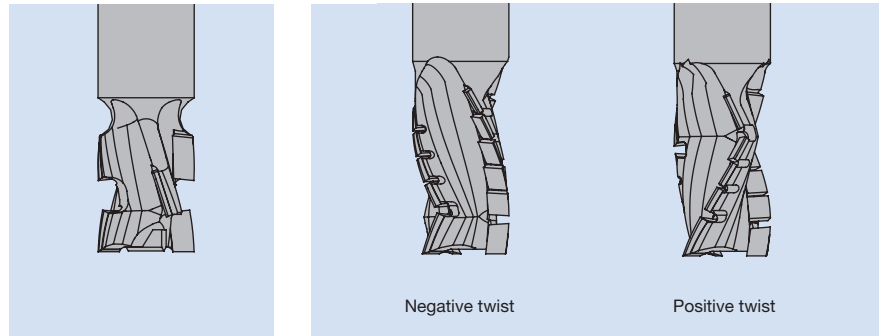
## 5. Routing

### 5.1 Sizing and grooving

<b>Working step/Application</b>	Sizing and grooving.
<b>Workpiece material [recommended cutting material]</b>	Softwood and hardwood [SP - softwood only, HS, HW, HW solid]. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. [HW, HW solid, DP]. Plywood [HW, HW solid, DP]. Duromers [HW, HW solid, DP]. Plastomers [HS, HW, HW solid, DP]. Solid surface material (Corian, Varicor etc.) [HW, HW solid, DP]. Decorative laminates (HPL-compact laminate, Trespa etc.) [HW solid, DP]. Non-ferrous metal (Aluminium, copper etc.) [HS, HW, HW solid, DP].
<b>Machine</b>	Stationary routers with/without CNC control. Milling machines with spindles to mount shank tools. Portable routers.
<b>Operation</b>	Sizing, separating cuts (full cut), climb cut, conventional cut.

#### Cutting edge type

##### Straight cutting edge



Straight edges with shear angle.

Straight edges with shear angle, spiral design.

##### Spiral cutting edges

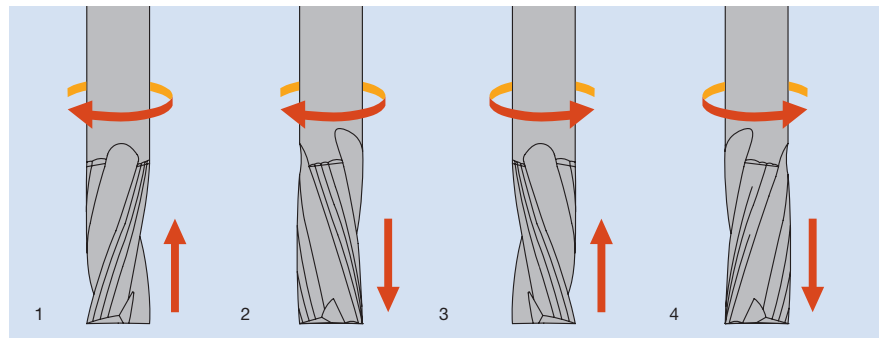


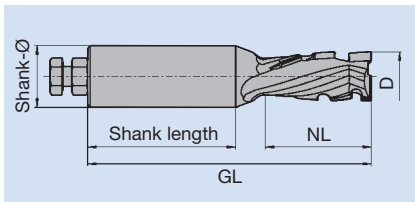
Fig. 1: RH-RD  
positive twist,  
workpiece face side to bottom,  
good chip flow into dust extraction.

Fig. 2: RH-LD  
negative twist,  
workpiece face side to top,  
supports workpiece clamping.

Fig. 3: LH-LD  
positive twist,  
workpiece face side to bottom,  
good chip flow into dust extraction.

Fig. 4: LH-RD  
negative twist,  
workpiece face side to top,  
supports workpiece clamping.

#### Technical features



The dimensions in the table below refer to the following tool parameters:

D	Diameter of the cutting edge
NL	Usable cutting length with specified number of teeth
AL	Possible working length, reached in separate steps
GL	Total length of the tool
d	Diameter of the shank, e.g. S25 x 60 -> Ø 25 mm
l	Maximum clamping length of the shank, e.g. S25 x 60 -> 60 mm

#### Shank tolerances

Tools for	Shank diameter	
	< 12 mm	≥ 12 mm
CNC routers	h6	g6
Portable routers	g7/h8	–

#### Application parameters

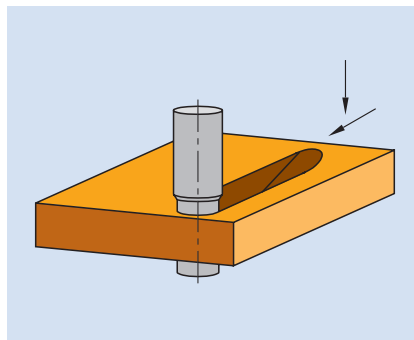
##### RPM/feed speed

The recommended RPM and feed speeds are detailed in the diagrams next the tool tables.

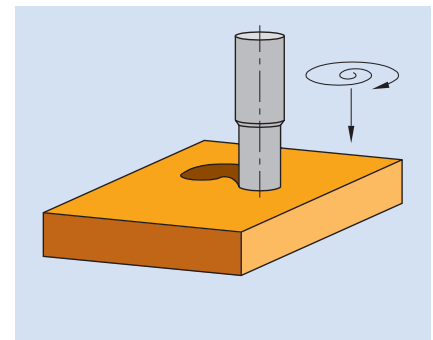
#### Operation notes

##### Recommended plunging methods:

The following plunging methods are recommended for sizing and grooving tools:

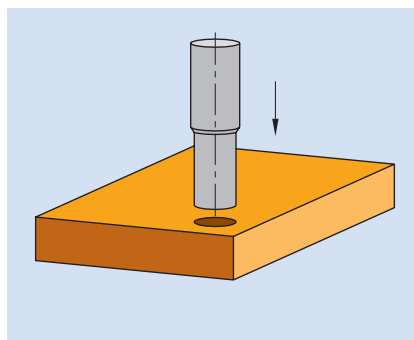


Ramp plunging



Spiral plunging

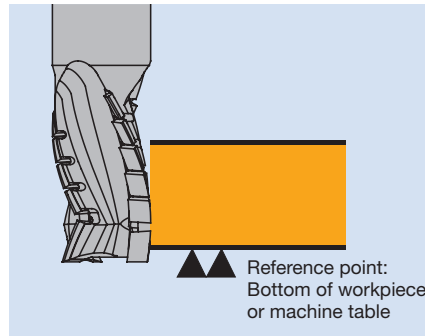
Router bits with mainly negative cutting shear angles and HW solid router bits with RH/LD and LH/RD and router bits without plunging edge are not suitable for axial plunging.



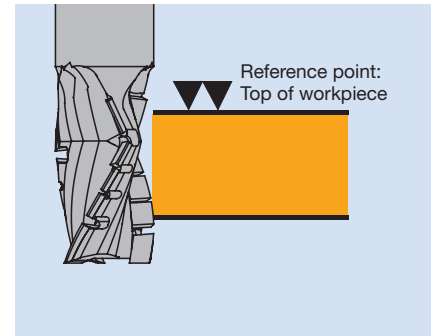
Axial plunging

#### Position the tool relative to the workpiece

Tools with high negative shear angle.



Tools with high positive shear angle..



#### Workpiece clamping

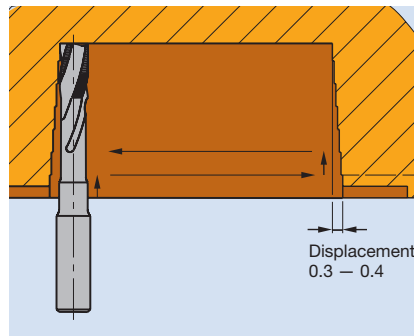
Sufficient workpiece clamping is very important on stationary machines. Insufficient clamping can reduce both the cut quality and tool life considerably. Panels can be held in place with vacuum clamping, but sometimes additional mechanical clamping is required. Small and arched workpieces in particular require special jigs or clamping devices which must be made by the customer or sourced from specialist suppliers.

#### Chip removal

For optimum chip removal, tools with predominantly or only positive shear cut should be used. Check there is sufficient workpiece clamping.

#### Machining deep slots

Cutting lock mortises in door production.



Reducing the slot cutting width by approx 0.1 mm per stroke reduces the risk of breakage as the tool does not touch the side of the slot with the full length of the tool.

## 5. Routing

### 5.1 Sizing and grooving

#### 5.1.1 Shank cutters HW and HW turnblade



#### Grooving cutter, straight cut

##### Application:

Router cutter for grooving.

##### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools, portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.), non-ferrous metals (aluminium, copper etc.), PVC profile extrusions.



##### Technical information:

Straight cut. End-ground for plunging. Large resharpening area. Good cutting performance in plastic and compound materials.

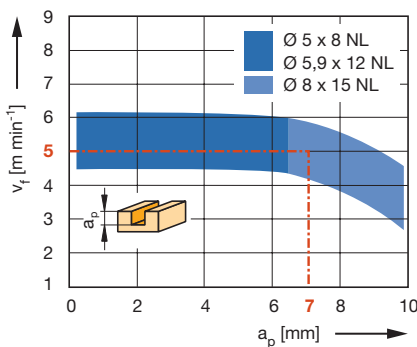
##### HW solid, Z 1

WO 120 2

D	GL	NL	S	QAL	DRI	ID
mm	mm	mm	mm			
8	70	27	8x30	HW solid	RH	044468 ●

RPM:  $n_{\max} = 24000 \text{ min}^{-1}$

Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Duromers, plastomers, compound materials

**Operation:** Grooving, sizing

**Speed:**  $n = 16000 - 18000 \text{ min}^{-1}$



### Grooving cutter, straight cut

#### Application:

Router cutter for sizing and grooving.

#### Machine:

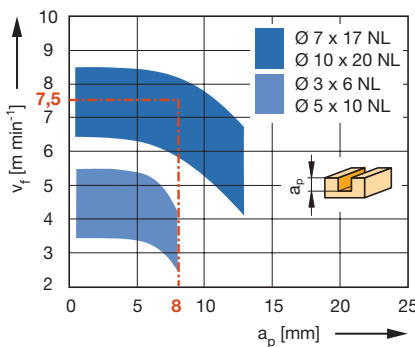
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools, portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.), non-ferrous metals (aluminium, copper etc.), PVC profile extrusions.



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

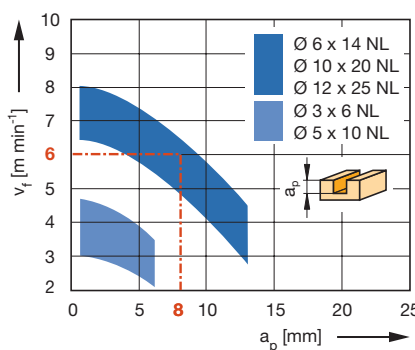
**Operation:** Grooving

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Solid wood = 0.8; Glulam = 0.8;

Machining across grain = 0.7



#### Technical information:

Straight cut. End-ground for plunging. Large resharpening area. Short design for increased stability and reduced vibration. Long design for increased cutting depth (recommended in several steps).

#### HW solid, Z 2, short design

WO 120 1 16

D mm	GL mm	NL mm	S mm	DRI	ID
3	50	6	6x30	RH	041979 ●
4	50	7	6x30	RH	041952 ●
4.5	50	8	6x30	RH	041953 ●
5	50	10	6x30	RH	041954 ●
6	50	14	6x30	RH	041956 ●
7	55	17	8x30	RH	041958 ●
8	55	20	8x30	RH	041985 ●
9	70	18	10x40	RH	041961 ●
10	70	20	10x40	RH	041962 ●
12	70	25	12x40	RH	041963 ●

#### HW solid, Z 2, short design, reinforced shank

WO 120 1 16

D mm	GL mm	NL mm	S mm	DRI	ID
3	55	6	8x40	RH	041981 ●
4	55	10	8x40	RH	041982 ●
5	55	12	8x40	RH	041983 ●
6	55	14	8x40	RH	041984 ●

#### HW solid, Z 2, long design

WO 120 1 16

D mm	GL mm	NL mm	S mm	DRI	ID
3	60	12	6x30	RH	041964 ●
4	60	12	6x40	RH	041965 ●
5	80	18	6x40	RH	041966 ●

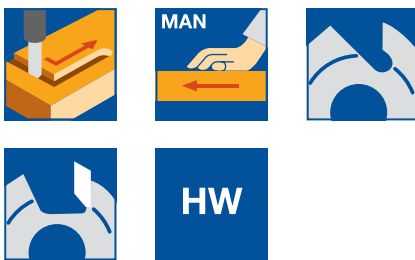
**RPM:**  $n_{\max} = 24000 \text{ min}^{-1}$

**Workpiece material:** Duromers, plastomers, Corian

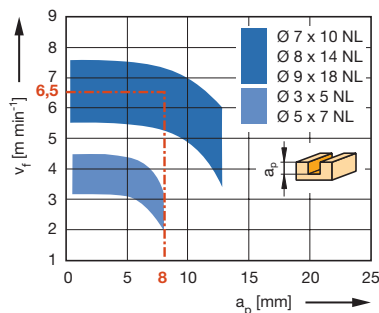
**Operation:** Grooving

**Speed:**  $n = 16000 - 18000 \text{ min}^{-1}$





Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

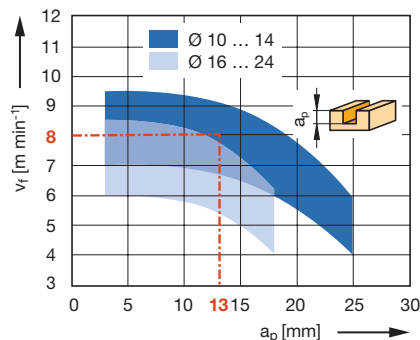
**Operation:** Grooving

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Solid wood = 0.8; Glulam = 0.8;

Machining across grain = 0.7



### Grooving cutter, Z 2

#### Application:

Router cutter for sizing and grooving.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools, portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Straight cut, tungsten carbide plunging tip.

#### HW, Z 2, shank 9.5 / 12 mm

WO 120 1 01

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
3	34	5	9.5x20	HW solid	RH	038014 ●
5	39	7	9.5x20	HW solid	RH	038018 ●
10	52	20	9.5x20	HW	RH	038028 ●
12	72	25	12x40	HW	RH	038115 ●
13	72	25	12x40	HW	RH	038116 ●
14	76	28	12x40	HW	RH	038117 ●
15	80	30	12x40	HW	RH	038118 ●
16	90	35	12x40	HW	RH	038147 ●
18	90	35	12x40	HW	RH	038148 ●
20	90	35	12x40	HW	RH	038149 ●
25	92	41	12x40	HW	RH	038125 ●

#### HW, Z 2, shank 10 mm

WO 120 1 01

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
4	49	10	10x35	HW solid	RH	038053 ●
5	49	12	10x35	HW solid	RH	038054 ●
6	53	14	10x35	HW solid	RH	038055 ●
7	55	17	10x35	HW solid	RH	038056 ●
8	60	20	10x35	HW solid	RH	038057 ●
10	70	23	10x35	HW	RH	038058 ●
12	70	23	10x35	HW	RH	038059 ●

**RPM:**  $n = 16000 - 36000 \text{ min}^{-1}$

**Workpiece material:** Plastic coated chipboard

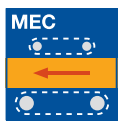
**Operation:** Grooving

**Speed:**  $n = 18000 \text{ min}^{-1}$

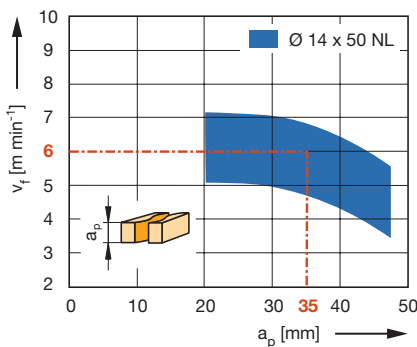
**Correction factor for  $v_f$ :**

Solid wood = 0.8; Glulam = 0.8;

Machining across grain = 0.7



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated or veneered chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Machining across grain = 0.7

### Grooving cutter with shear angle

#### Application:

Router cutter for sizing, grooving and cutting apertures.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Finishing type Z 1+1 particularly to machine apertures in furniture and doors. Cutting edges with alternating shear angles for tear-free edges on both sides.

#### HW, Z 1+1, finishing cut processing

WO 140 2

D mm	GL mm	NL mm	S mm	DRI	ID
14	100	50	12x50	RH	038204 ●
14	100	50	14x50	RH	038205 ●
14	120	50	25x60	RH	038206 ●

**RPM:**  $n_{\max} = 24000 \text{ min}^{-1}$



#### Roughing router cutter in turnblade design

##### Application:

Router cutter for sizing and grooving to roughing quality.

##### Machine:

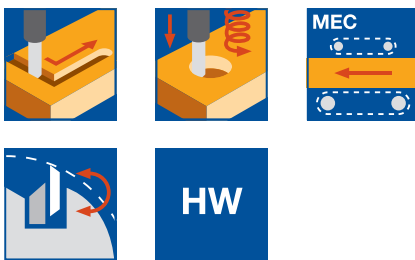
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Tungsten carbide turnblade knives arranged in irregular pitch for quiet cutting. With turnblade knife plunging tip.



##### HW, Z 1+1

WL 101 2

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
22	125	55	25x60	RH	041922 ●

RPM:  $n = 16000 - 24000 \text{ min}^{-1}$

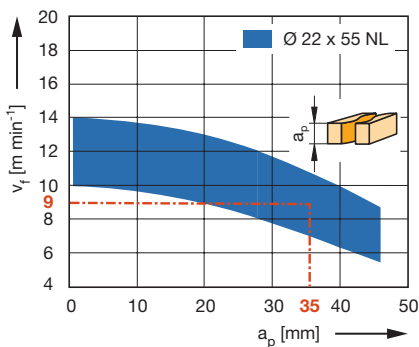
##### Spare knives:

BEZ	ABM	QAL	VE	ID
	mm		PCS	
Turnblade knife	9x12x1.5	HW-05F	10	005158 ●
Turnblade knife	12x12x1.5	HW-05F	10	005081 ●

##### Spare parts:

BEZ	ABM	ID
	mm	
Oval head screw Torx® 15	M4x5	007037 ●
Oval head screw Torx® 15	M4x6	006225 ●
Torx® key	Torx® 15	005457 ●

Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8



### Roughing router cutter in turnblade design - HeliCut 11

#### Application:

Router for sizing and grooving to roughing/finishing quality. Cutting of tenons for frame constructions.

#### Machine:

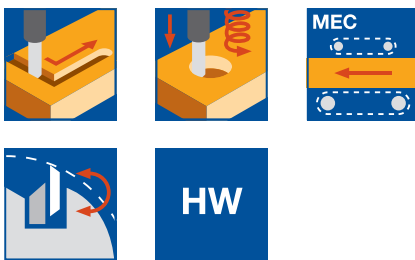
Stationary routers with/without CNC control, machining centres, joinery machines, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, glulam and laminated wood.

#### Technical information:

Spiral shaped edge arrangement of the tungsten carbide turnblades (4 times turnable). Tungsten carbide turnblade plunging knife with chipbreakers for good chip removal (for D = 40 mm). Tangential fixing of the knives in the dust protected area. Deep boreholes are to be cut circularly.



#### HW, Z 2+2

WL 101 2

D mm	GL mm	NL mm	S mm	DRI	ID
30	125	60	20x50	RH	041928 ●
30	195	120	30x53	RH	041929 ●
40	235	160	30x53	RH	041927 ●

RPM:  $n = 6000 - 18000 \text{ min}^{-1}$

#### Note:

Tool shank S30x53 with recess suitable for many conventional joinery machines. Not suitable for use in shrink-fit chucks.

On machines with automatic tool changer use collet chuck ER40 together with collet  $d = 30 \text{ mm}$ , ID **679039**.

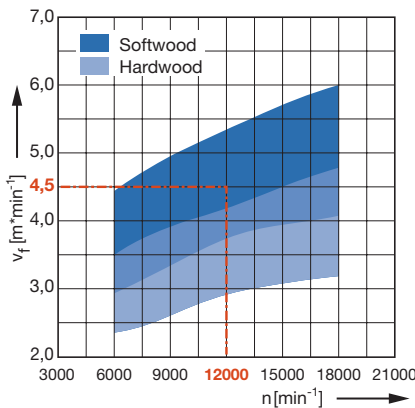
#### Spare knives:

BEZ	Knife	ABM mm	for D mm	QAL	VE PCS	ID
Turnblade knife	Peripheral tip	11x11x1.5		HW	10	602515 ●
Turnblade knife	Peripheral tip	11x11x1.5		TDC		602904 ●
Exchange knife	Plunging tip	20,6x12.7x2	30	HW	10	602531 ●
Exchange knife	Plunging tip	22x12.7x2	40	HW	10	602516 ●

#### Spare parts:

BEZ	ABM mm	ID
Countersink screw, Torx® 15	M4x6	114039 ●
Countersink screw, Torx® 20	M5x6	114040 ●
Torx® key	Torx® 15	005457 ●
Torx® key	Torx® 20	117520 ●

Feed speed  $v_f$  depending on RPM  $n$

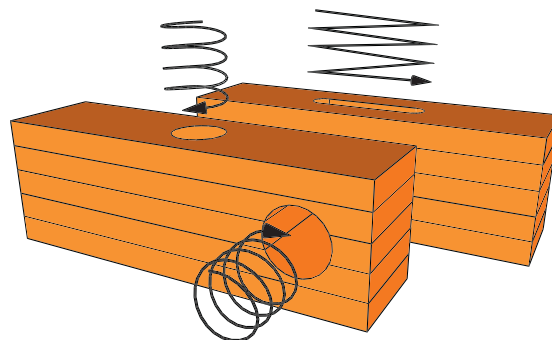


**Workpiece material:** Softwood, Hardwood

**Operation:** Sizing and grooving

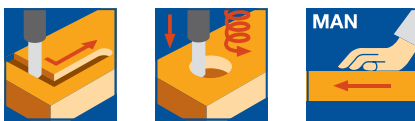
**Axial infeed:**  $a_p = 20 - 50 \text{ mm}$

**Correction factor for  $v_f$ :** Glulam = 0.8

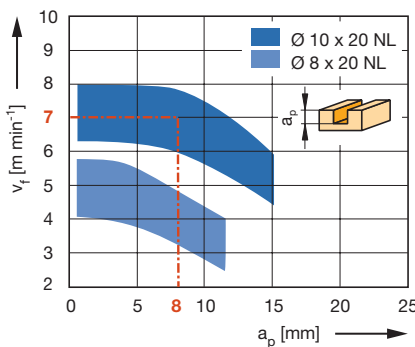


#### Application notes:

Circular pockets and boreholes of a depth  $> 1xD$  have to be cut circularly. Use ramp-in cutting to produce mortises.



Feed speed  $v_f$  depending on cutting depth  $a_p$

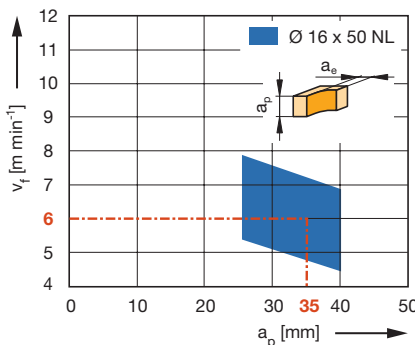


**Workpiece material:** Plastic coated chipboard

**Operation:** Grooving, sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8



### Grooving router cutter in turnblade design

#### Application:

Router cutter for sizing and grooving to finish quality.

#### Machine:

Portable routers, limited suitable: stationary routers with/without CNC control, machining centres.

#### Workpiece material:

Softwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.

#### Technical information:

Tungsten carbide turnblade knife clamped by wedge. Design without plunging tip only suitable for ramp plunging. Design with plunging tip limited suitable for axial plunging.

#### HW, Z 1, without plunging tip

WL 100 1

D mm	GL mm	NL mm	S mm	DRI	ID
8	65	20	10x40	RH	041624 ●
9	65	20	10x40	RH	041631 ●
10	65	20	10x40	RH	041638 ●
10	70	25	10x40	RH	041643 ●
11	75	30	10x40	RH	041655 ●
12	76	30	10x40	RH	041667 ●
14	86	40	12x40	RH	041679 ●
16	94	50	12x40	RH	041685 ●
16	109	50	16x50	RH	041714 ●

**RPM:** D 8 - 12 mm:  $n = 18000 - 24000 \text{ min}^{-1}$

D 14 - 20 mm:  $n = 16000 - 24000 \text{ min}^{-1}$

#### Spare knives:

BEZ	ABM mm	for D mm	NL mm	QAL	VE PCS	ID
Turnblade knife	20x4.1x1.1	8 - 9	20	HW-05	10	005186 ●
Turnblade knife	20x5.5x1.1	10 - 12	20	HW-05	10	005187 ●
Turnblade knife	25x5.5x1.1	10	25	HW-05	10	005188 ●
Turnblade knife	30x5.5x1.1	11 - 24	30	HW-05	10	005189 ●
Turnblade knife	40x5.5x1.1	14	40	HW-05	10	005190 ●
Turnblade knife	50x5.5x1.1	14 - 24	50	HW-05	10	005191 ●

#### Spare parts:

BEZ	ABM mm	for D mm	NL mm	ID
Clamping wedge	17.5x5.15x2.8	8 - 9	20	009258 ●
Clamping wedge	17.5x6.45x4	10 - 11	20	009259 ●
Clamping wedge	22.5x6.54x4	10	25	009260 ●
Clamping wedge	27.5x6.45x4	11	30	009261 ●
Clamping wedge	27.5x7.35x3.7	12 - 14	30	009263 ●
Clamping wedge	37.5x7.35x3.7	14	40	009264 ●
Clamping wedge	47.5x10.28x4.2	16 - 24	50	009266 ●
Countersink screw, Torx® 8	M2.5x5.7	8 - 11		006231 ●
Countersink screw, Torx® 8	M3x7.6	12 - 14		006233 ●
Countersink screw, Torx® 15	M4x9.5	16		007847 ●
Countersink screw, Torx® 15	M4x11.5	16 - 20		006234 ●

**Workpiece material:** Plastic coated chipboard

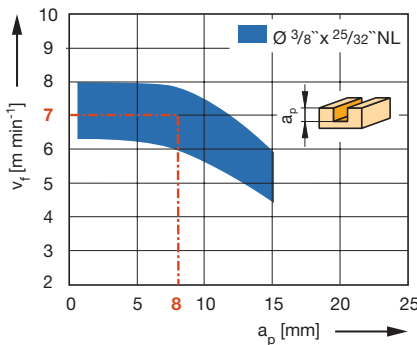
**Operation:** Jointing (max.  $a_e = 3 \text{ mm}$ )

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8



Feed speed  $v_f$  depending on cutting depth  $a_p$

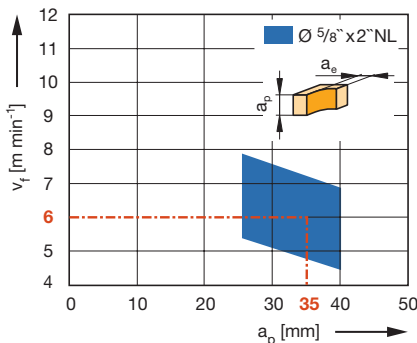


**Workpiece material:** Plastic coated chipboard

**Operation:** Grooving, sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8



**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing

(maximum chip removal  $a_e = 3 \text{ mm}$ )

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8

## Grooving router cutter in turnblade design

### Application:

Router cutter for sizing and grooving to finish quality.

### Machine:

Portable routers, stationary routers with/without CNC control, machining centres.

### Workpiece material:

Softwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.

### Technical information:

Tungsten carbide turnblade knife clamped by wedge. Design without plunging tip only suitable for ramp plunging. Design with plunging tip limited suitable for axial plunging.

### HW, Z 1, with plunging tip

WL 100 1

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
14	107	45	12x40	RH	041722 ●

**RPM:**  $n = 16000 - 24000 \text{ min}^{-1}$

### Spare knives:

BEZ	ABM	NL	QAL	VE	ID
	mm	mm		PCS	
Turnblade knife	50x5.5x1.1	50	HW-05	10	005191 ●

### Spare parts:

BEZ	ABM	ID
	mm	
Clamping wedge with plunging tip	45x3.7x7.35	009749 ●
Countersink screw, Torx® 8	M3x7.6	006233 ●

### HW, Z 1, without plunging tip, inch types

WL 100 1

D	NL	GL	S	DRI	ID
in	in	in	in		
1/2"	1 3/16"	2 3/4"	1/2" x 1 3/8"	RH	041060 ●
3/4"	2"	3 7/8"	3/4" x 1"	RH	041067 ●

**RPM:** D 1/2":  $n = 18000 - 24000 \text{ min}^{-1}$

D 3/4":  $n = 16000 - 24000 \text{ min}^{-1}$

### Spare knives:

BEZ	ABM	for D	NL	QAL	VE	ID
	mm	in	in		PCS	
Turnblade knife	30x5.5x1.1	1/2"	1 3/16"	HW-05	10	005189 ●
Turnblade knife	50x5.5x1.1	5/8" - 3/4"	2"	HW-05	10	005191 ●

### Spare parts:

BEZ	ABM	for D	NL	ID
	mm	in	in	
Clamping wedge	27.5x7.35x3.7	1/2" - 35/64"	1 3/16"	009263 ●
Clamping wedge	47.5x10.28x4.2	5/8" - 3/4"	2"	009266 ●
Countersink screw, Torx® 8	M3x7.6	1/2"		006233 ●
Countersink screw, Torx® 15	M4x11.5	5/8" - 3/4"		006234 ●



### Router cutter in turnblade design

#### Application:

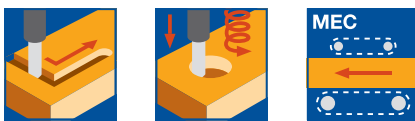
Router cutter for sizing and grooving to finish quality. For grooving with constant tool diameter.

#### Machine:

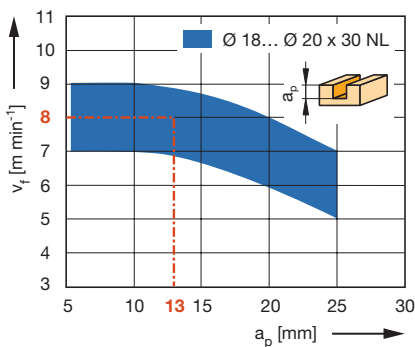
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).



Feed speed  $v_f$  depending on cutting depth  $a_p$

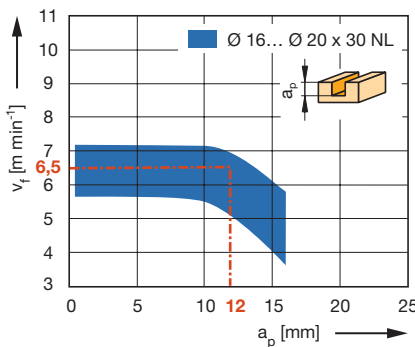


**Workpiece material:** Plastic coated chipboard

**Operation:** Grooving, sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8



#### Technical information:

Straight cut. Knife tip designed for seamless cut. Teflon coated tool body for reduced resin and glue build up. With tungsten carbide plunging tip. Suitable for machining the narrow edge of painted or foil coated MDF.

#### HW, Z 1, NL 30 mm

WL 101 1

D mm	GL mm	NL mm	S mm	ID LH	ID RH
16	85	30	12x40		040867 ●
16	95	30	16x50	040877 ●	040878 ●
16	95	30	20x50		040879 ●
16	105	30	25x60		040872 ●
18	85	30	12x40		040869 ●
20	85	30	12x40		040871 ●
20	95	30	20x50		040882 ●

**RPM:**  $n = 16000 - 20000 \text{ min}^{-1}$

#### Spare knives:

BEZ	Knife	ABM mm	for D mm	QAL	VE PCS	ID
Turnblade knife	Plunging tip	7.6x12x1.5	16 - 18	HW-05F	10	005080 ●
Turnblade knife	Plunging tip	9x12x1.5	20 - 24	HW-05F	10	005158 ●
Turnblade knife	Peripheral tip	30x12x1.5		HW-05F	10	005161 ●

#### Spare parts:

BEZ	Knife	ABM mm	for D mm	ID
Screw	Plunging tip	M3.5x4 (head D7)	16 - 20	006068 ●
Screw	Peripheral tip	M3.5x4 (head D9)	16 - 20	006226 ●
Torx® key		Torx® 15		005457 ●

**Workpiece material:** Hardwood, along grain

**Operation:** Grooving, sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Machining across grain = 0.8





### Router cutter in turnblade design

#### Application:

Router cutter for sizing and grooving to finish quality. For grooving with constant tool diameter.

#### Machine:

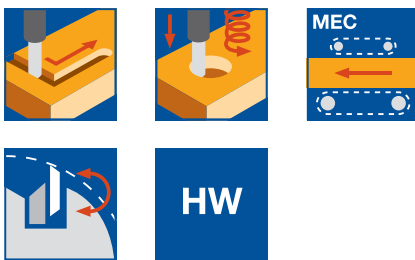
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools or portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).

#### Technical information:

Straight cut. Knife tip designed for seamless cut. Teflon coated tool body for reduced resin and glue build up. With tungsten carbide turnblade knife plunging edge.



#### HW, Z 1, inch types

WL 101 1

D	NL	GL	S	DRI	ID
in	in	in	in		
5/8"	1 11/64"	3 5/8"	1/2" x 1 3/8"	RH	041084 ●

RPM:  $n = 16000 - 20000 \text{ min}^{-1}$

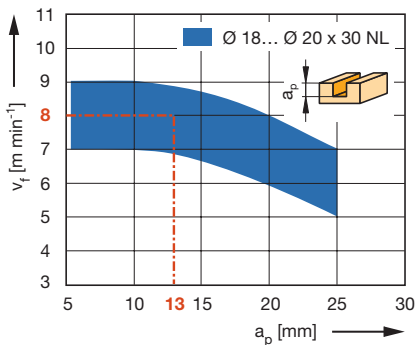
#### Spare knives:

BEZ	Knife	ABM	QAL	VE	ID
		mm		PCS	
Turnblade knife	Plunging tip	7.6x12x1.5	HW-05F	10	005080 ●
Turnblade knife	Peripheral tip	30x12x1.5	HW-05F	10	005161 ●

#### Spare parts:

BEZ	Knife	ABM	ID
		mm	
Screw	Plunging tip	M3.5x4 (head D7)	006068 ●
Screw	Peripheral tip	M3.5x4 (head D9)	006226 ●
Torx® key		Torx® 15	005457 ●

Feed speed  $v_f$  depending on cutting depth  $a_p$

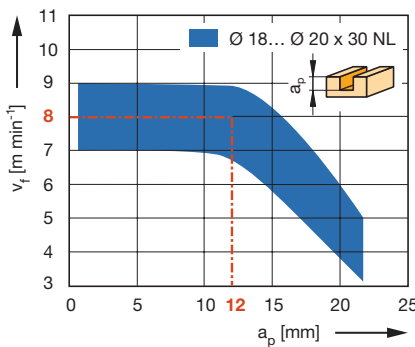


**Workpiece material:** Plastic coated chipboard

**Operation:** Grooving, sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8



**Workpiece material:** Softwood, along grain

**Operation:** Grooving, sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Machining across grain = 0.8



### Router cutter in turnblade design

#### Application:

Router cutter for sizing and grooving. For grooving with constant tool diameter.

#### Machine:

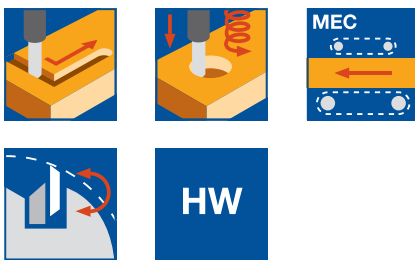
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.

#### Technical information:

Straight cut. Teflon coated tool body for reduced resin and glue build up. Limited suitable for finish cut. Cutting edge overlap visible on workpiece. With tungsten carbide turnblade knife plunging tip.



#### HW, Z 1+1, with staggered cutting edges

WL 101 2

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
18	125	50	25x60	RH	<b>040925 ●</b>
20	133	58	25x60	RH	<b>040928 ●</b>

**RPM:**  $n = 16000 - 20000 \text{ min}^{-1}$

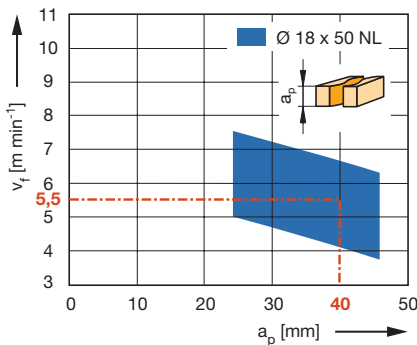
#### Spare knives:

BEZ	Knife	ABM mm	for D mm	QAL	VE PCS	ID
Turnblade knife	Plunging tip	7.6x12x1.5	16 - 18	HW-05F	10	<b>005080 ●</b>
Turnblade knife	Plunging tip	9x12x1.5	20 - 24	HW-05F	10	<b>005158 ●</b>
Turnblade knife	Peripheral tip	30x12x1.5		HW-05F	10	<b>005161 ●</b>

#### Spare parts:

BEZ	Knife	ABM mm	for D mm	ID
Oval head screw Torx® 15	Plunging tip	M4x5	18 - 24	<b>007037 ●</b>
Oval head screw Torx® 15	Peripheral tip	M4x5	18 - 24	<b>007038 ●</b>
Torx® key		Torx® 15		<b>005457 ●</b>

Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8



### Router cutter in turnblade design

#### Application:

Router cutter for sizing and grooving to finish quality. For grooving with constant tool diameter.

#### Machine:

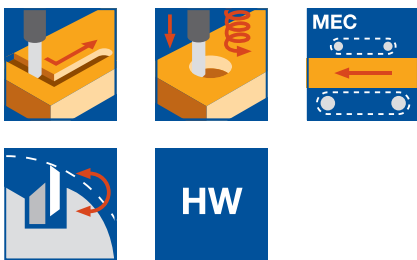
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.

#### Technical information:

Straight cut. Teflon coated tool body for reduced resin and glue build up. Limited suitable for finish cut. Cutting edge overlap visible on workpiece. With tungsten carbide turnblade knife plunging tip.



#### HW, Z 1+1, with 50 mm/30 mm turnblade knives

WL 101 1

D mm	GL mm	NL mm	S mm	ID LH	ID RH
18	115	50	16x50		040847 ●
18	115	50	20x50		040848 ●
18	125	50	25x60	040849 ●	040850 ●

RPM:  $n = 16000 - 20000 \text{ min}^{-1}$

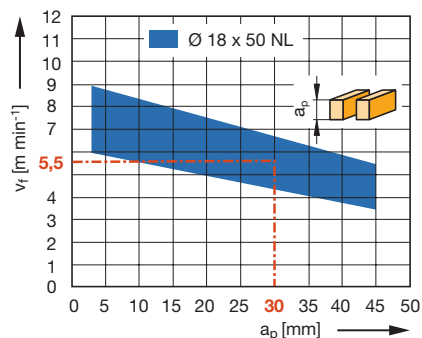
#### Spare knives:

BEZ	Knife	ABM mm	QAL	VE PCS	ID
Turnblade knife	Plunging tip	7.6x12x1.5	HW-05F	10	005080 ●
Turnblade knife	Peripheral tip	30x12x1.5	HW-05F	10	005161 ●
Turnblade knife	Peripheral tip	50x12x1.7	HW-05F	10	007668 ●

#### Spare parts:

BEZ	Knife	ABM mm	ID
Oval head screw Torx® 15	Plunging tip	M4x5	007037 ●
Oval head screw Torx® 15	Peripheral tip	M4x5	007038 ●
Torx® key		Torx® 15	005457 ●

Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8



### Router cutter in turnblade design

#### Application:

Router cutter for sizing, grooving and finish cutting to finish quality. Z 2 for increased feed rates.

#### Machine:

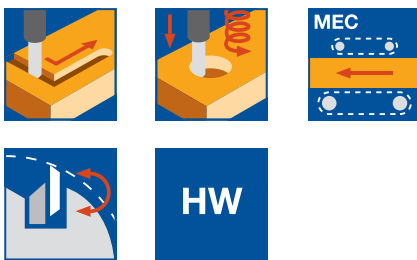
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

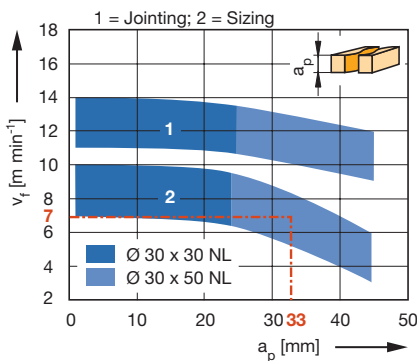
Straight cut. Knife tip designed for seamless cut. Design with plunging tip limited suitable for axial plunging. Suitable for machining the narrow edge of painted or foil coated MDF.



Feed speed  $v_f$  depending on grooving depth  $a_p$

1 = Jointing cut  $a_e = 0.5 - 2$  mm

2 = Sizing cut



**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing, sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Machining across grain = 0.7; MDF = 0.8

#### HW, Z 2

WL 101 2

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
25	125	50	25x60	040857 ●	040858 ●
30	105	30	25x60		040854 ●
30	125	50	25x60		040853 ●

**RPM:**  $n = 14000 - 20000 \text{ min}^{-1}$

#### Spare knives:

BEZ	Knife	ABM	for D	QAL	VE	ID
		mm	mm		PCS	
Turnblade knife	Plunging tip	7.6x12x1.5	25	HW-05F	10	005080 ●
Turnblade knife	Plunging tip	12x12x1.5	30	HW-05F	10	005081 ●
Turnblade knife	Peripheral tip	30x12x1.5	30	HW-05F	10	005161 ●
Turnblade knife	Peripheral tip	50x12x1.5	25/30	HW-05F	10	006506 ●

#### Spare parts:

BEZ	Knife	ABM	for D	ID
		mm	mm	
Oval head screw Torx® 15	Plunging tip	M4x5	25/30	007037 ●
	Peripheral tip		25	
Oval head screw Torx® 15	Peripheral tip	M4x5	30	007038 ●
Torx® key		Torx® 15		005457 ●



### Spiral roughing/finishing router cutter Marathon

#### Application:

Router cutter for sizing and grooving in roughing/finishing quality.

#### Machine:

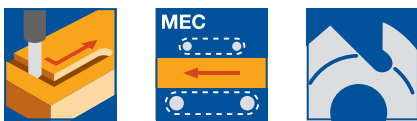
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.), decorative laminates (HPL-compact laminate, Trespa etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.).

#### Technical information:

Solid tungsten carbide. Tungsten carbide grade and Marathon coating for increased performance time, particularly in abrasive materials. Recommended for abrasive materials such as HPL/CPL.

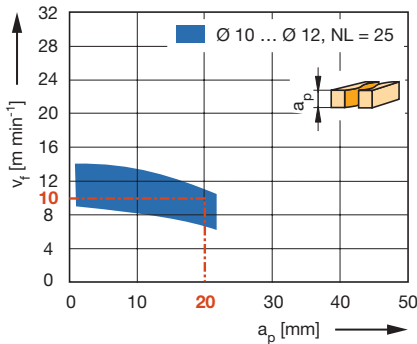


#### HW, Z 2, short design

WO 160 2 15

D	D	GL	GL	NL	NL	S	S	Z	Twist	DRI	ID
mm	in	mm	in	mm	in	mm	in				
12.7	1/2"	88.9	3 1/2"	38.1	1 1/2"	12.7x40	1/2"x1 1/2"	2	RD	RH	240515 ●

Feed speed  $v_f$  depending on cutting depth  $a_p$



Workpiece material: Softwood

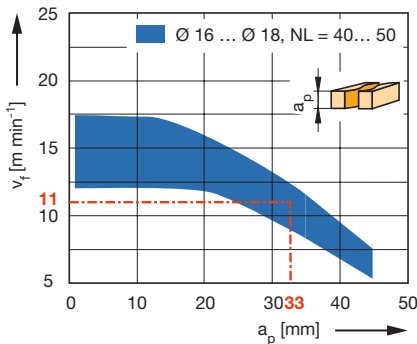
Operation: Sizing

Speed:  $n = 18000$  min<sup>-1</sup>

Correction factor for  $v_f$ :

Hardwood = 0.8; Chipboard = 1.3;

Glulam = 0.9



#### HW, Z 2, short design, for abrasive materials

WO 160 2 15

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
10	70	25	10x40	2	RD	RH	240200 ●
12	70	25	12x40	2	RD	RH	240201 ●
16	100	40	16x50	2	RD	RH	240202 ●

RPM:  $n_{\max} = 24000$  min<sup>-1</sup>

Workpiece material: Softwood

Operation: Sizing

Speed:  $n = 18000$  min<sup>-1</sup>

Correction factor for  $v_f$ :

Hardwood = 0.8; Chipboard = 1.2;

Glulam = 0.9



### Spiral roughing/finishing router cutter Marathon

#### Application:

Router cutter for sizing and grooving in roughing/finishing quality.

#### Machine:

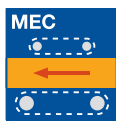
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

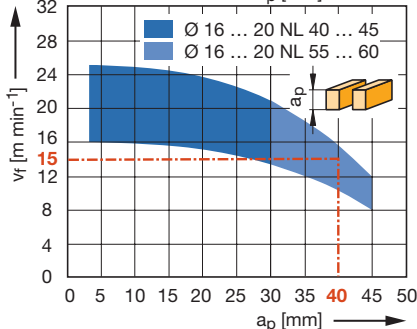
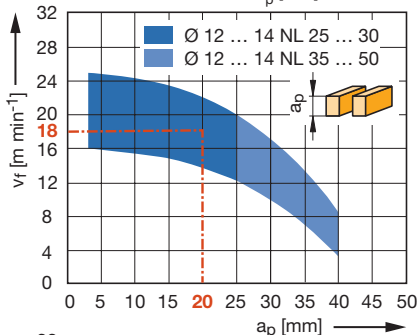
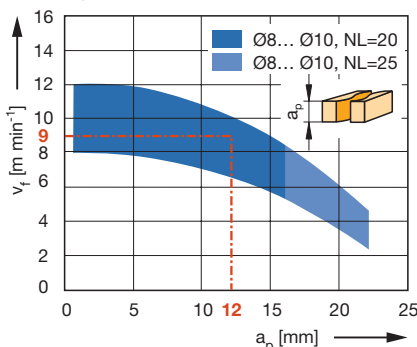
Softwood and hardwood, laminated wood for window construction, chipboard and fibre working materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.), plastomers, solid surface material (Corian, Varicor etc.), PVC window profiles.

#### Technical information:

Solid tungsten carbide. Marathon coating for increased performance time. Short design for increased stability. Long design for increased cutting depth (recommended in several steps). Higher feed speeds than conventional roughing cutters. Extremely smooth running.



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### Z 2 / Z 3, short design

WO 160 2 12

D mm	GL mm	NL mm	S mm	Z	Twist	ID LH	ID RH
8	65	20	8x40	2	RD		042277 ●
10	70	25	10x40	2	RD		042278 ●
10	70	25	10x40	2	LD		042279 ●
12	70	25	12x40	3	RD		042280 ●
12	70	25	12x40	3	LD		042281 ●
14	80	30	14x45	3	RD		042282 ●
16	100	40	16x55	3	RD		042273 ●
16	100	40	16x55	3	LD	042283 ●	042284 ●
18	90	35	18x50	3	RD		042285 ●
20	100	45	20x50	3	RD		042286 ●
25	120	60	25x55	3	RD		042287 ●

#### Z 2 / Z 3, long design

WO 160 2 12

D mm	GL mm	NL mm	S mm	Z	Twist	ID LH	ID RH
8	80	25	8x55	2	RD		042288 ●
12	80	35	12x40	3	RD		042270 ●
12	80	35	12x40	3	LD	042289 ●	042290 ●
12	90	42	12x40	3	RD		042271 ●
14	110	50	14x55	3	RD		042272 ●
14	110	50	14x55	3	LD		042291 ●
16	110	55	16x55	3	RD		042274 ●
16	110	55	16x55	3	LD	042292 ●	042293 ●
18	120	60	18x55	3	RD		042294 ●
20	120	60	20x55	3	RD		042275 ●
20	120	60	20x55	3	LD	042295 ●	042296 ●
20	130	75	20x50	3	RD		042276 ●
20	130	75	20x50	3	LD	042297 ●	

#### RPM:

Wood/wood derived material:  $n = 16000 - 24000 \text{ min}^{-1}$

Plastics:  $n = 12000 - 18000 \text{ min}^{-1}$

$n_{\text{max}} = 24000 \text{ min}^{-1}$

**Workpiece material:** Softwood

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

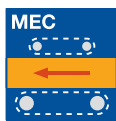
Hardwood = 0.8; Chipboard = 1.3;

Glulam = 0.9

● available ex stock

□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)



### Spiral roughing/finishing router cutter Marathon

#### Application:

Router cutter for sizing and grooving in roughing/finishing quality.

#### Machine:

Stationary routers with/without CNC control, machining centres, joinery machines, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, glulam, glue-laminated timber and laminated wood.

#### Technical information:

Solid tungsten carbide. Marathon coating for increased performance times. Long design for large cutting depths. Higher feed rates with conventional roughing cutters possible. Extremely smooth running.

#### Z 3, long design, shank 30 mm

WO 160 2 12

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
30	195	120	30x53	3	RD	RH	240305 ●
40	195	120	30x53	3	RD	RH	240306 ●
40	235	160	30x53	3	RD	RH	240307 ●

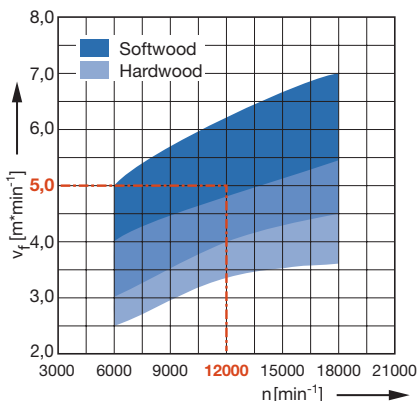
RPM:  $n = 6000 - 18000 \text{ min}^{-1}$

#### Note:

Tool shank S30x53 with recess suitable for many conventional joinery machines. Not suitable for use in shrink-fit chucks.

On machines with automatic tool changer use collet chuck ER 40 together with collet  $d = 30 \text{ mm}$ , ID 679039.

Feed speed  $v_f$  depending on cutting depth  $a_p$



Workpiece material: Softwood

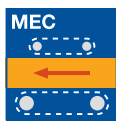
Operation: Sizing

Axial infeed:  $a_p = 20 - 50 \text{ mm}$

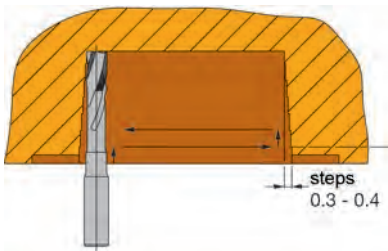
Correction factor for  $v_f$ :

Hardwood = 0.7; Glulam = 0.8





Application example for mortise slot production



#### Application data:

Infeed at:

$a_p$  4 - 8 mm per stroke in solid wood;  
 $v_f$  10 - 16 m min<sup>-1</sup>;  
 $n$  = 12000 - 18000 min<sup>-1</sup>

$a_p$  8 - 15 mm per stroke in chipboard;  
 $v_f$  12 - 18 m min<sup>-1</sup>;  
 $n$  = 12000 - 18000 min<sup>-1</sup>

### Spiral roughing/finishing router cutter Marathon

#### Application:

Router cutter for sizing, grooving and mortise slots in roughing/finishing quality.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, modified timber for window construction, chipboard and fibre working materials (MDF, HDF etc.) uncoated, laminated veneer lumber (plywood, multiplex plywood etc.), PVC window profiles.

#### Technical information:

Solid tungsten carbide. Marathon coating for increased performance time. Extra long design for increased cutting depth (in several steps). Higher feed speeds than conventional spiral roughing cutters, extremely smooth running.

#### Z 2 / Z 3, extra long design, for mortise slots

WO 160 2 13

D mm	GL mm	NL mm	AL mm	S mm	Z	Twist	DRI	ID	ID Set HSK-F 63
8	80	25	51	8x25	2	LD	RH	240010 ●	240500 □
10	90	30	51	10x35	2	LD	RH	240011 ●	240501 □
12	120	35	80	12x35	3	LD	RH	240012 ●	240502 □
12	120	35	80	12x35	3	RD	RH	240000 ●	
14	170	30	95	16x50	3	RD	RH	240001 ●	
14	190	30	120	16x50	3	RD	RH	240002 ●	
16	170	50	105	16x50	3	RD	RH	240003 ●	
16	179	30	120	16x58	*	3	RD	RH	240004 ●
16	179	30	120	16x58	*	3	RD	RH	240013 ●
16	179	30	120	20x58	*	3	RD	RH	240005 ●
16	179	30	120	20x58	3	RD	RH	240014 ●	
16	205	30	135	20x50	3	RD	RH	240006 ●	
17	190	30	120	20x50	3	RD	RH	240008 ●	
18	170	50	115	20x50	3	RD	RH	240009 ●	

RPM: Wood/wood derived material: D 10-12 mm:  $n$  = 18000 - 24000 min<sup>-1</sup>

Wood/wood derived materials: D 14-18 mm:  $n$  = 12000 - 20000 min<sup>-1</sup>

Plastics:  $n$  = 12000 - 18000 min<sup>-1</sup>

\* with clamping flat for HOMAG/WEEKE lock case trimming unit

#### Note:

Set HSK-F 63 = tools marked with the note „Set HSK-F 63“ will be supplied mounted in shrink-fit chuck HSK-F 63.



### Spiral roughing/finishing router cutter Marathon

#### Application:

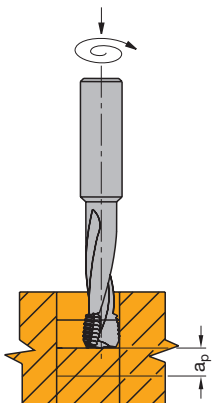
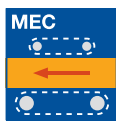
Router cutter for sizing and cutting spyholes and keyholes in roughing/finishing quality.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, modified timber for window construction, chipboard and fibre working materials (MDF, HDF etc.) uncoated, laminated veneer lumber (plywood, multiplex plywood etc.).



#### Technical information:

Solid tungsten carbide. Marathon coating for increased performance time. Extra long design for increased cutting depth (in several steps). Higher feed speeds than conventional spiral roughing cutters, extremely smooth running.

#### Z 3, extra long design for cutting spyholes and keyholes

WO 160 2 14

D mm	GL mm	NL mm	AL mm	S mm	Z	DRI	ID	ID Set HSK-F 63
10	95	45		10x40	3	RH	<b>240100</b> ●	
12	120	15	75	12x40	2	RH	<b>240102</b> ●	
12	140	20	95	12x40	2	RH	<b>240103</b> ●	
14	130	50	75	14x50	3	RH	<b>240104</b> ●	
14	170	30	95	16x60	3	RH	<b>240108</b> ●	<b>240601</b> □
16	130	75		16x50	3	RH	<b>240105</b> ●	
16	170	50	105	16x55	3	RH	<b>240107</b> ●	<b>240600</b> □
16	170	30	95	16x60	3	RH	<b>240106</b> ●	
25	200	120		25x65	3	RH	<b>240300</b> ●	<b>240800</b> □

**RPM:** D 10-12 mm: n = 18000 - 24000 min<sup>-1</sup>

D 14-18 mm: n = 12000 - 20000 min<sup>-1</sup>

#### Note:

Set HSK-F 63 = tools marked with the note „Set HSK-F 63“ will be supplied mounted in shrink-fit chuck HSK-F 63.

Production of keyholes and spyholes by circular cutting

#### Application data:

a<sub>p</sub> 4 - 8 mm per stroke in solid wood;  
v<sub>f</sub> 10 - 16 m min<sup>-1</sup>;  
n = 12000 - 18000 min

a<sub>p</sub> 8 - 15 mm per stroke in chipboard;  
v<sub>f</sub> 12 - 18 m min<sup>-1</sup>;  
n = 12000 - 18000 min<sup>-1</sup>



### Spiral roughing/finishing router cutter Marathon alternate twist

#### Application:

Routers for sizing and grooving in roughing/finishing quality and tear-free cutting edges on both sides.

#### Machine:

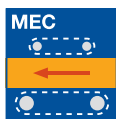
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

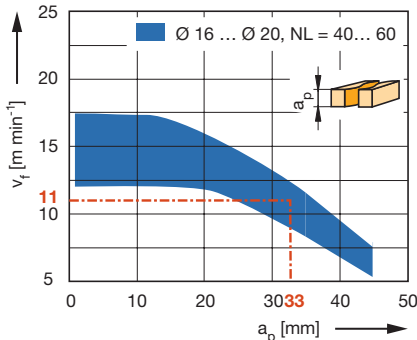
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, laminated veneer lumber (plywood, multiplex plywood etc.), plastomers, solid surface material (Corian, Varicor etc.).

#### Technical information:

Solid tungsten carbide. Marathon coating for increased performance time. Alternate twist for tear-free cut edges on both sides. Higher feed speeds possible than with conventional roughing cutters. Extremely smooth running.



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Softwood

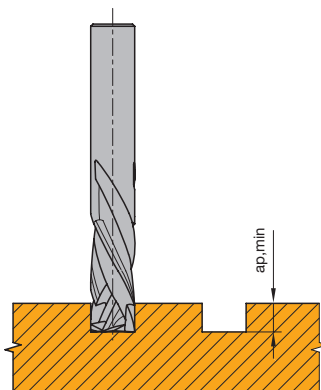
**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Hardwood = 0.8; Chipboard = 1.2;

Glulam = 0.9



Minimum grooving depth  $a_{p \min}$  for tear-free cut

#### Z 2+2

WO 160 2 16

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
16	100	40	16x50	RH	240402 ●
16	110	55	16x50	RH	240408 ●
20	120	45	20x50	RH	240400 ●
20	140	75	20x50	RH	240403 ●

#### Z 2+2, Nesting types

WO 160 2 16

D	D	GL	GL	NL	NL	S	S	$a_{p \min}$	DRI	ID
mm	in	mm	in	mm	in	mm	in	mm		
12		80		25		12x40		6	RH	240404 ●
12		90		35		12x40		12	RH	240405 ●
12.7	1/2"	76.2	3"	25	1"	12.7x40	1/2"x1 1/2"	6	RH	240406 ●
12.7	1/2"	88.9	3 1/2"	35	1 3/8"	12.7x40	1/2"x1 1/2"	12	RH	240407 ●

**RPM:**  $n_{\max} = 24000 \text{ min}^{-1}$



#### Spiral finishing router cutter

##### Application:

Router for grooving plastic and aluminium profile extrusions. Especially to produce drainage grooves in plastic window profiles.

##### Machine:

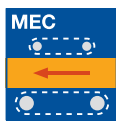
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Softwood and hardwood, duromers, plastomers, sandwich panels (PU foam cores with aluminium covers etc.), NF-metals (aluminium, copper etc.).

##### Technical information:

When cutting aluminium, suitable lubrication (spray or minimum volume lubrication) is necessary.

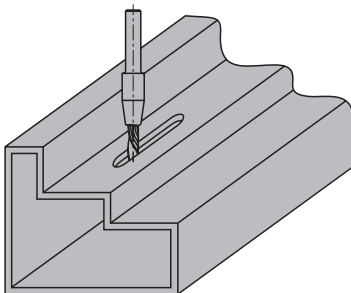


##### HW solid, Z 1, extended version

WO 160 2 07

D	GL	NL	AL	S	Z	Twist	DRI	ID
mm	mm	mm	mm	mm				
5	78	20	30	8x40	1	RD	RH	<b>042539 ●</b>
5	95	20	30	8x40	1	RD	RH	<b>042540 ●</b>
5	110	25	45	8x40	1	RD	RH	<b>042541 ●</b>

**RPM:** n = 18000 - 24000 min<sup>-1</sup>



Slotting extrusions



### Spiral finishing router cutter

#### Application:

Router cutter for sizing, grooving and finish cutting. For high demands on finish quality.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.), NF-metals (aluminium, copper etc.).



#### Technical information:

Large twist angle for high shear cut. Check twist direction for good top layer cut quality. Maximum cutting depth 1.0 - 1.5 x D. Short design for increased stability and reduced vibration. Long design for increased cutting depth (recommended in several steps).

#### HW solid, Z 1, short design

WO 160 2 03

D	D	GL	GL	NL	NL	S	S	Z	Twist	DRI	ID
mm	in	mm	in	mm	in	mm	in				
3		50		6		6x30		1	RD	RH	042723 ●
3		50		6		6x30		1	LD	RH	042724 ●
4		50		8		6x30		1	RD	RH	042725 ●
4		50		8		6x30		1	LD	RH	042726 ●
5		50		10		6x30		1	RD	RH	042727 ●
5		50		10		6x30		1	LD	RH	042728 ●
6		50		14		6x30		1	RD	RH	042729 ●
6		50		14		6x30		1	LD	RH	042730 ●
6.35	1/4"	50.8	2"	15.88	5/8"	6.35x30	1/4"x1 1/8"	1	RD	RH	240512 ●
8		65		20		8x40		1	RD	RH	042731 ●
8		65		20		8x40		1	LD	RH	042732 ●
10		70		20		10x40		1	RD	RH	042733 ●

#### HW solid, Z 1, long design

WO 160 2 03

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
4	60	12	6x40	1	RD	RH	042739 ●
4	60	12	6x40	1	LD	RH	042740 ●
5	80	18	6x40	1	RD	RH	042741 ●
5	80	18	6x40	1	LD	RH	042742 ●
6	80	22	6x40	1	RD	RH	042743 ●
6	80	22	6x40	1	LD	RH	042744 ●
8	80	25	8x40	1	RD	RH	042745 ●
8	80	25	8x40	1	LD	RH	042746 ●
10	90	32	10x40	1	RD	RH	042747 ●
10	90	32	10x40	1	LD	RH	042748 ●
12	90	32	12x40	1	RD	RH	042749 ●

**RPM:** Wood/wood derived material:  $n = 16000 - 24000 \text{ min}^{-1}$

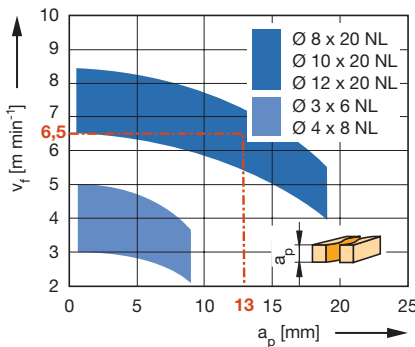
Plastics:  $n = 12000 - 18000 \text{ min}^{-1}$

**Workpiece material:** Duromers, plastomers, glulam (HPL), compound materials

**Operation:** Sizing

**Speed:**  $n = 16000 - 18000 \text{ min}^{-1}$

Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Softwood

**Operation:** Sizing

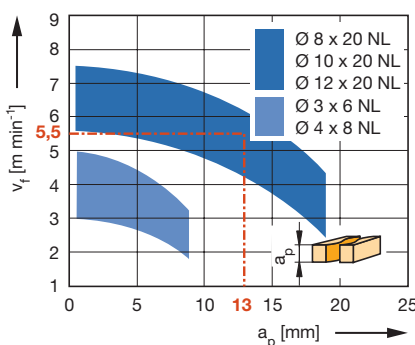
**Speed:**  $n = 18000 - 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Hardwood = 0.9;

Machining across grain = 0.8;

Chipboard = 1.1





### Spiral finishing router cutter

#### Application:

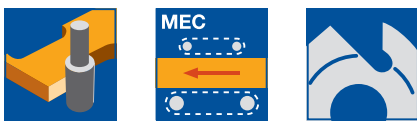
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality.

#### Machine:

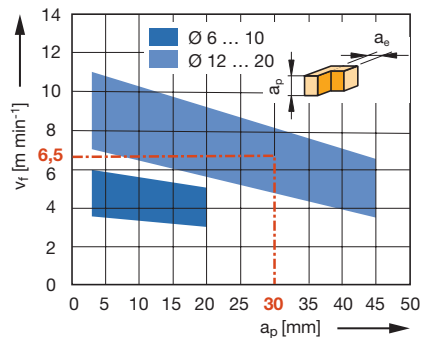
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Softwood

**Operation:** Jointing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Hardwood = 0.9;

Machining across grain = 0.7

#### Technical information:

Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Check twist direction for good top layer quality. Short design for increased stability and low vibration. Long design for larger material thickness at reduced feed speeds.

#### HW solid, Z 2, short design

WO 160 2 05

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
6	60	12	6x30	2	LD	RH	042457 ●
8	65	20	8x30	2	RD	RH	042472 ●
10	70	25	10x40	2	RD	RH	042458 ●
10	70	25	10x40	2	LD	RH	042459 ●
12	70	25	12x40	2	RD	RH	042758 ●
12	70	25	12x40	2	LD	RH	042760 ●
16	100	40	16x50	2	RD	RH	042761 ●
16	100	40	16x50	2	LD	RH	042763 ●

#### HW solid, Z 2, long design

WO 160 2 05

D	D	GL	GL	NL	NL	S	S	Z	Twist	DRI	ID
mm	in	mm	in	mm	in	mm	in				
12		80		35		12x40		2	RD	RH	042765 ●
12.7	1/2"	76.2	3"	31.8	1 1/4"	12.7x40	1/2"x1 1/2"	2	LD	RH	240510 ●
12.7	1/2"	88.9	3 1/2"	31.8	1 1/4"	12.7x40	1/2"x1 1/2"	2	LD	RH	240511 ●

**RPM:**  $n = 16000 - 24000 \text{ min}^{-1}$



### Spiral finishing router cutter

#### Application:

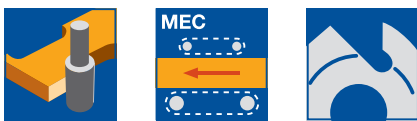
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality. Z 3 design for high feed speeds.

#### Machine:

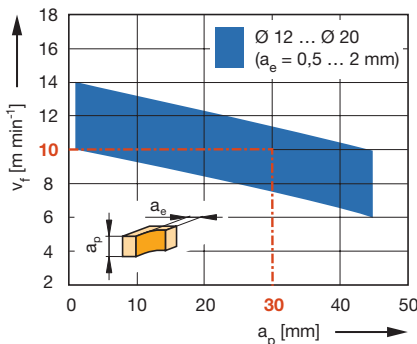
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Softwood

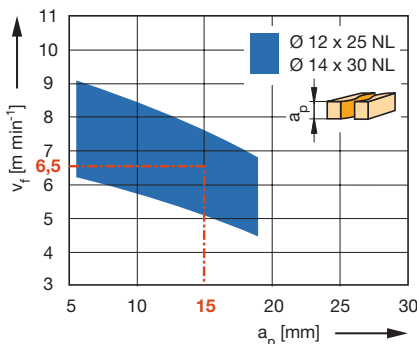
**Operation:** Jointing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Hardwood = 0.9;

Machining across grain = 0.7



**Workpiece material:** Duromers, laminated materials (HPL, CPL)

**Operation:** Sizing

**Speed:**  $n = 14000 - 18000 \text{ min}^{-1}$

#### Technical information:

Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Check twist direction for good top layer quality. Short design for increased stability and low vibration. Long design for larger material thickness at reduced feed speeds.

#### HW solid, Z 3, short design

WO 160 2 05

D	GL	NL	S	Z	Twist	ID	ID
mm	mm	mm	mm			LH	RH
12	70	25	12x40	3	LD		042486 ●
12	70	25	12x40	3	RD	042534 ●	042487 ●
16	100	40	16x50	3	RD		042488 ●
16	100	40	16x50	3	LD		042489 ●

#### HW solid, Z 3, long design

WO 160 2 05

D	GL	NL	S	Z	Twist	ID	ID
mm	mm	mm	mm			LH	RH
8	65	25	8x30	3	LD		042490 ●
12	80	35	12x40	3	RD		042460 ●
14	110	50	14x55	3	RD		042462 ●
16	110	55	16x55	3	RD		042464 ●
16	110	55	16x55	3	LD	042473 ●	042465 ●
20	120	60	20x55	3	RD		042466 ●
20	120	60	20x55	3	LD	042468 ●	042467 ●
20	130	75	20x50	3	RD		042549 ●

**RPM:**  $n = 16000 - 24000 \text{ min}^{-1}$





### Spiral finishing router cutter Marathon

#### Application:

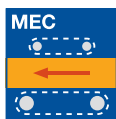
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality. Z 3 design for high feed speeds.

#### Machine:

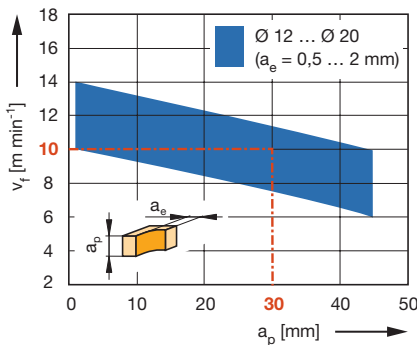
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### Technical information:

Marathon coating for increased performance time and reduced resin build up. Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Mirror finished cutting area ideal for machining thermoplastics.

#### HW solid, Z 3

WO 160 2 10

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
12	80	35	12x40	3	RD	RH	042790 ●
14	110	50	14x55	3	RD	RH	042791 ●
16	110	55	16x55	3	RD	RH	042792 ●
20	120	60	20x55	3	RD	RH	042793 ●
20	130	75	20x50	3	RD	RH	042794 ●

RPM:  $n = 16000 - 24000 \text{ min}^{-1}$

**Workpiece material:** Softwood

**Operation:** Jointing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Hardwood = 0.9;

Machining across grain = 0.7

## 5. Routing

### 5.1 Sizing and grooving

#### 5.1.2 Shank cutters HW-solid spiral design



#### Spiral finishing router cutter alternate twist angle

##### Application:

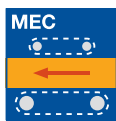
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides.

##### Machine:

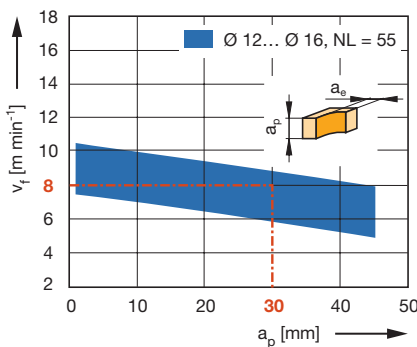
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).



Feed speed  $v_f$  depending on cutting depth  $a_p$



##### Technical information:

Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Alternate twist for tear-free cut edges on both sides. Z 1+1 design, suited for solid wood up to 50 mm thickness with roughing cut or 30 mm thickness without roughing cut.

##### HW solid, Z 1+1

WO 160 2 06

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
10	70	25	10x40	RH	042511 ●
12	80	35	12x40	RH	042509 ●
16	110	55	16x50	RH	042543 ●

RPM:  $n = 16000 - 20000 \text{ min}^{-1}$

**Workpiece material:** Softwood

**Operation:** Jointing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :**

Hardwood = 0.9;

Machining across grain = 0.7



#### Spiral finishing router cutter alternate twist angle

##### Application:

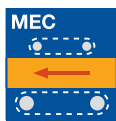
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides.

##### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).



##### Technical information:

Ideally used after roughing cutters, finish cut allowance approx. 1-2 mm. Alternate twist for tear-free cut edges on both sides. Design for coated chipboard material and fibre material, glulam, abrasive materials and compound materials with aluminium top layer.

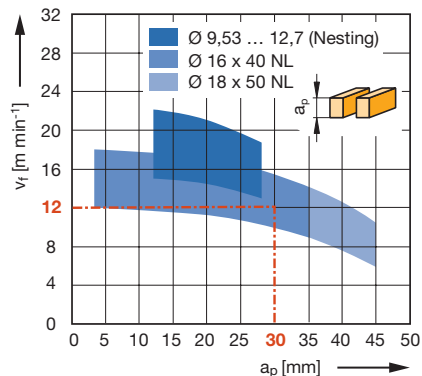
##### HW solid, Z 2+2, for abrasive materials

WO 160 2 06

D	D	GL	GL	NL	NL	S	S		DRI	ID
mm	in	mm	in	mm	in	mm	in			
12		70		25		12x40			RH	042536 ●
16		100		40		16x50			RH	042537 ●
18		100		50		18x50			RH	042538 ●
9.53	3/8"	76.2	3"	28.6	1 1/8"	9.53x40	3/8"x1 1/2"		RH	240516 ●
12.7	1/2"	88.7	3 1/2"	38.1	1 1/2"	12.7x40	1/2"x1 1/2"		RH	240517 ●

RPM:  $n = 16000 - 24000 \text{ min}^{-1}$

Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated and veneered chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor  $v_f$ :** MDF = 0.8;

Machining across grain = 0.7



#### Spiral finishing router cutter alternate twist angle

##### Application:

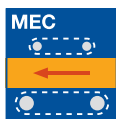
Router cutter for sizing, grooving and finish cutting. For high demands on finish quality and tear-free cut edges on both sides.

##### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.), decorative laminates (HPL-compact laminate, Trespa etc.).



##### Technical information:

Alternate twist for tear-free cutting edges on both sides. Especially suitable to cut coated chip and fibre boards, glulam, abrasive materials as well as composite materials with aluminium top layer.

##### HW solid, Z 2+2, Nesting types

WO 160 2 06

D	D	GL	GL	NL	NL	S	S	$a_{p \min}$	DRI	ID
mm	in	mm	in	mm	in	mm	in	mm		
9.53	3/8"	76.2	3"	23	7/8"	9.53x40	3/8"x1 1/2"	5.5	RH	240518 ●
9.53	3/8"	76.2	3"	28.6	1 1/8"	9.53x40	3/8"x1 1/2"	7	RH	240503 ●
10		75		28		10x40		8	RH	240530 ●
12.7	1/2"	76.2	3"	32	1 1/4"	12.7x40	1/2"x1 1/2"	5	RH	240504 ●
12.7	1/2"	76.2	3"	32	1 1/4"	12.7x40	1/2"x1 1/2"	6	RH	240505 ●
12.7	1/2"	88.9	3 1/2"	34.9	1 3/8"	12.7x40	1/2"x1 1/2"	6	RH	240506 ●
12.7	1/2"	101.6	4"	43	1 5/8"	12.7x40	3/8"x1 5/8"	20	RH	240507 ●

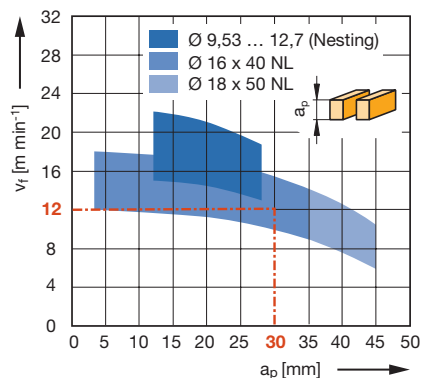
##### HW solid, Z 3+3, Nesting types

WO 160 2 06

D	D	GL	GL	NL	NL	S	S	$a_{p \min}$	DRI	ID
mm	in	mm	in	mm	in	mm	in	mm		
9.53	3/8"	76.2	3"	23	7/8"	9.53x40	3/8"x1 1/2"	6	RH	240508 ●
10		70		24		10x40		8	RH	042797 ●

RPM:  $n = 16000 - 24000 \text{ min}^{-1}$

Feed speed  $v_f$  depending on cutting depth  $a_p$



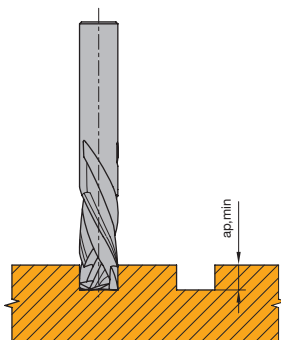
**Workpiece material:** Plastic coated and veneered chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor  $v_f$ :** MDF = 0.8;

Machining across grain = 0.7



Minimum grooving depth  $a_{p \min}$  for tear-free cut

## 5. Routing

### 5.1 Sizing and grooving

#### 5.1.2 Shank cutters HW-solid spiral design



#### Grooving cutter Lamello® Clamex® P-System®

##### Application:

Router cutter for machining a profile slot for Lamello® Clamex® P-System® connectors.

##### Machine:

Stationary routers with CNC control, machining centres, especially machines with 5 axes technology or with comparable aggregates to swivel cutting tools.

##### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., softwood and hardwood, glued wood and laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Solid tungsten carbide. Marathon-TDC coating for increased performance times. Alternate twist for tear-free cutting edges.

##### Z 2+2

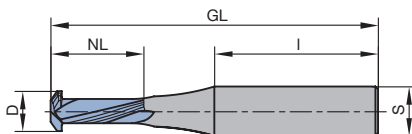
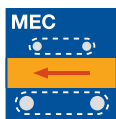
WO 531 2

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
9.8	80	23	12x40	RH	039161 ●

**RPM:**  $n_{\max} = 24000 \text{ min}^{-1}$

Boring bit for boring an access hole D = 6 mm: ID **034116**.

Grooving cutter for CNC: ID **090018**.



##### Recommendation for application:

##### RPM:

$n = 18000 - 24000 \text{ min}^{-1}$

##### Feed rate:

$v_f = 6 - 8 \text{ m min}^{-1}$  chipboard/MDF

$v_f = 4 - 6 \text{ m min}^{-1}$  solid wood/plywood

## 5. Routing

### 5.1 Sizing and grooving 5.1.3 Shank cutters DP



#### Router cutter Diamaster PRO

##### Application:

Router for sizing and grooving with continuous cutting edge.

##### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

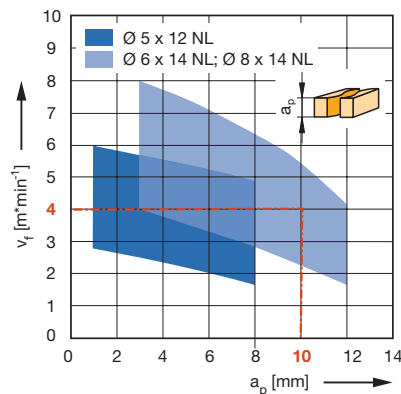
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, laminated materials (HPL-compact laminate, Trespa, multiplex plywood), NF-metals.

##### Technical information:

Solid tungsten carbide tool body for increased stability and smooth running. DP face edge suitable for plunging. Slightly positive shear angle for improved chip removal when ramp plunging. Axial infeed for grooving and sizing maximum 1.0 - 1.5 x D. Resharpenable up to 3 times with normal wear.



Feed speed  $v_f$  depending on cutting depth  $a_p$

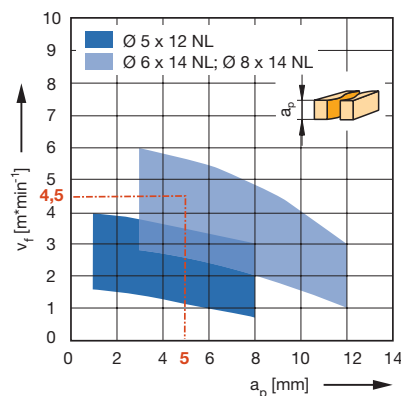


**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**RPM:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8; uncoated chipboard = 1.1



##### DP, Z 1

WO 120 2 50

D mm	GL mm	NL mm	S mm	Z	DRI	ID
5	60	12	8x35	1	RH	<b>191086 ●</b>
6	60	14	8x35	1	RH	<b>191087 ●</b>
8	55	10	8x35	1 (0°)	RH	<b>191107 ●</b>
8	60	14	8x35	1	RH	<b>191088 ●</b>

**RPM:**  $n = 18000 - 24000 \text{ min}^{-1}$

**Workpiece material:** Thermoplastics, compound materials

**Operation:** Sizing

**RPM:**  $n = 18000 \text{ min}^{-1}$

● available ex stock  
□ available at short notice  
Instruction manual visit [www.leitz.org](http://www.leitz.org)

## 5. Routing

### 5.1 Sizing and grooving

#### 5.1.3 Shank cutters DP



#### Router cutter Diamaster PRO

##### Application:

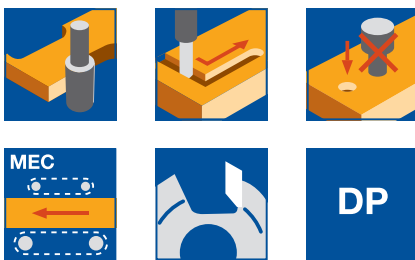
Router cutter for sizing and grooving with continuous cutting edge. Particularly suitable for machining MDF with direct lacquering or foil coating of the machined edges.

##### Machine:

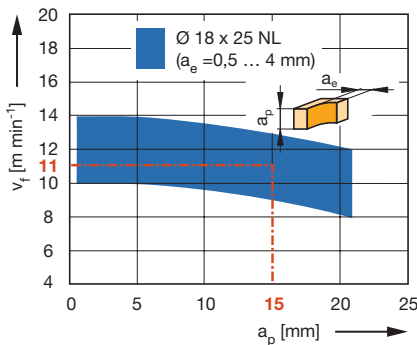
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, laminated materials (HPL-compact laminate, Trespa, multiplex plywood).



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.9;

Veneer across grain = 0.7

##### Technical information:

Negative shear angle (only for ID **091158**) for tear-free edges during grooving and to support the workpiece clamping of smaller parts. Resharpenable 3 to 5 times with normal wear. Maximum chip removal 4 mm; roughing cut required for higher chip removal.

##### DP, Z 2

WO 140 2 50

D	GL	NL	S	Z	DRI	ID
mm	mm	mm	mm			
10	70	12	12x40	2	RH	<b>091158</b> ●
18	90	25	16x50	2	RH	<b>091190</b> ●

**RPM:**  $n = 16000 - 24000 \text{ min}^{-1}$





### Router cutter Diamaster PRO

#### Application:

Router for sizing and grooving with continuous cutting edge.

#### Machine:

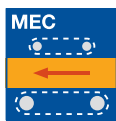
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

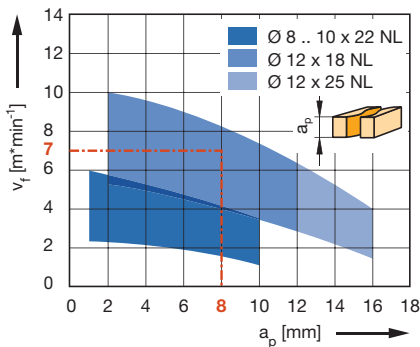
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, laminated materials (HPL-compact laminate, Trespa, multiplex plywood), NF-metals.

#### Technical information:

Solid tungsten carbide tool body for increased stability and smooth running. DP face edge suitable for ramp plunging. Slightly positive shear angle for improved chip removal when plunging. From D = 12 mm on with full size DP plunging edge. Axial infeed for grooving and sizing maximum 1.0 - 1.5 x D. Resharpenable 2 to 3 times with normal wear.



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### DP, Z 2

WO 120 2 50

D mm	GL mm	NL mm	S mm	Z	DRI	ID
8	65	15	12x35	2	RH	191108 ●
8	70	22	12x40	2	RH	191089 ●
10	70	22	12x40	2	RH	191090 ●
12	75	18	16x50	2	RH	191091 ●
12	85	25	16x50	2	RH	191092 ●

RPM:  $n = 18000 - 24000 \text{ min}^{-1}$

**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**RPM:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Uncoated chipboard = 1.1



### Router cutter Diamaster PLUS

#### Application:

Router cutter for sizing and grooving with seamless cut. Particularly suitable for machining MDF with direct lacquering or foil coating of the machined edges

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

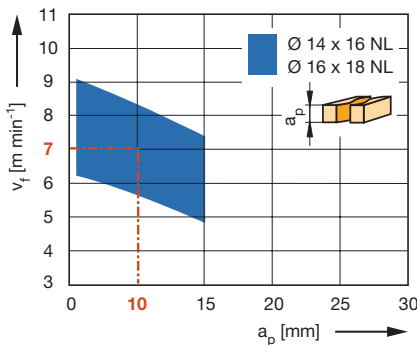
Hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, laminated materials (HPL-compact laminate, Trespa, multiplex plywood).

#### Technical information:

Negative shear angle for tear-free edges during grooving and to support the workpiece clamping of smaller parts. Resharpenable 5 to 8 times with normal wear. Short and stable tool design ideal for grooving and sizing of abrasive and hard to machine materials (HPL, Trespa, GFRP, CFRP etc.).



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Duromers, decorative laminates (HPL, CPL), fibre reinforced plastics

**Operation:** Sizing

**Speed:**  $n = 12000 - 18000 \text{ min}^{-1}$

#### DP, Z 2

WO 120 2 60

D	GL	NL	S	Z	DRI	ID
mm	mm	mm	mm			
14	80	16	20x50	2	RH	<b>091157 ●</b>
16	80	18	20x50	2	RH	<b>091156 ●</b>

**RPM:** Wood derived materials:  $n = 16000 - 24000 \text{ min}^{-1}$

Plastics:  $n = 12000 - 18000 \text{ min}^{-1}$



### Router cutter Diamaster PLUS

#### Application:

Router for sizing and grooving with continuous cutting edge. Particularly suitable for machining MDF with direct lacquering or foil coating of the machined edges.

#### Machine:

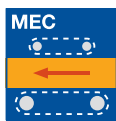
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

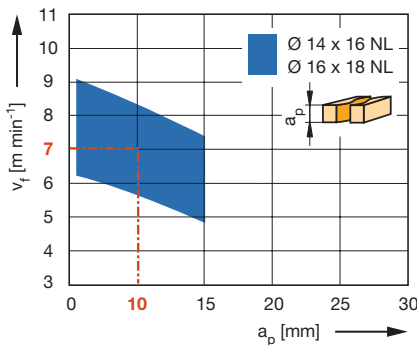
Hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, laminated materials (HPL-compact laminate, Trespa, multiplex plywood).

#### Technical information:

Alternate shear angle of the edges for neutral cutting. DP plunging edge. Resharpenable 5 to 8 times with normal wear. Short and stable tool design ideal for grooving and sizing of abrasive and hard to machine materials (HPL, Trespa, GFRP, CFRP etc.).



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Duromers, decorative laminates (HPL, CPL), fibre reinforced plastics

**Operation:** Sizing

**Speed:**  $n = 12000 - 18000 \text{ min}^{-1}$

#### DP, Z 2

WO 120 2

D	GL	NL	S	Z	DRI	ID
mm	mm	mm	mm			
14	80	16	20x50	2	RH	<b>191093 ●</b>
16	85	20	20x50	2	RH	<b>191094 ●</b>

**RPM:** Wood derived materials:  $n = 16000 - 24000 \text{ min}^{-1}$

Plastics:  $n = 12000 - 18000 \text{ min}^{-1}$



### Router cutter Diamaster PRO

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides. Suitable for small and medium batch quantities.

#### Machine:

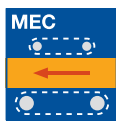
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

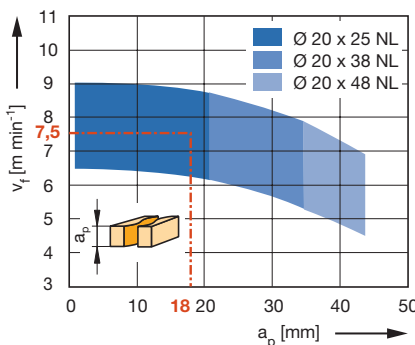
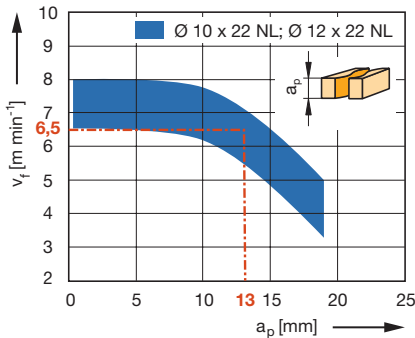
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.)

#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and tungsten carbide plunging tip. Resharpenable 3 to 5 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. Axial infeed for grooving and sizing maximum 1.0 - 1.8 x D.



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Uncoated chipboard = 1.1;

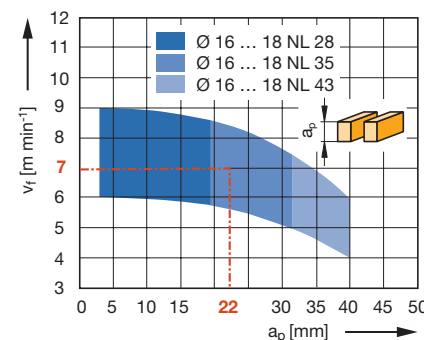
Veneer across grain = 0.7

#### DP, Z 1+1

WO 140 2 50

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
10	70	22	12x40		091264 ●
12	70	22	12x40		091265 ●
12	90	28	20x50		191095 ●
12	100	28	25x60		091266 ●
14	90	28	16x50		091267 ●
16	80	22	16x50		091268 ●
16	95	22	25x60		091269 ●
16	90	28	16x50	091271 ●	091270 ●
16	100	28	25x60		091272 ●
16	95	35	20x50		091273 ●
16	105	35	25x60		091274 ●
16	105	43	20x50		191096 ●
16	115	43	25x60	091276 ●	091275 ●
18	90	28	20x50		091277 ●
18	95	35	20x50		091278 ●
18	105	43	20x50	091281 ●	091280 ●
18	115	43	25x60		091282 ●
20	90	28	16x50		091283 ●
20	100	28	25x60	091285 ●	091284 ●
20	95	35	20x50		091286 ●
20	105	35	25x60		091287 ●
20	105	43	20x50	091289 ●	091288 ●
20	115	43	25x60		091290 ●
20	110	48	20x50	091292 ●	091291 ●
20	120	48	25x60	091294 ●	091293 ●
20	125	53	25x60		091295 ●
20	130	58	25x60		191041 ●

**RPM:**  $n = 18000 - 24000 \text{ min}^{-1}$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Veneer across grain = 0.7



### Router cutter Diamaster PRO

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides. Suitable for small and medium batch quantities.

#### Machine:

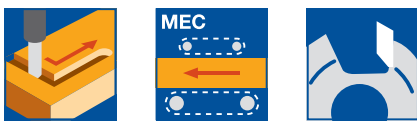
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

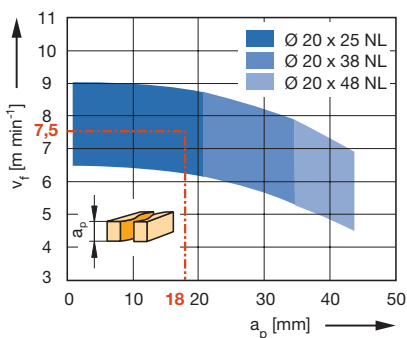
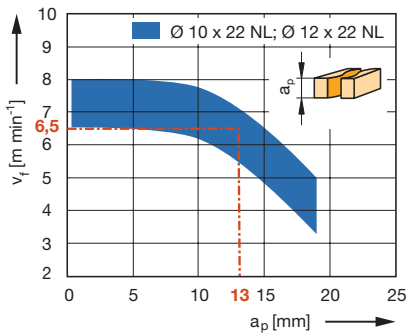
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and tungsten carbide plunging tip. Resharpenable 3 to 5 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. Axial infeed for grooving and sizing maximum  $1.0 - 1.8 \times D$ .



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### DP, Z 1+1, inch types

WO 140 2 50

D	D	GL	GL	NL	NL	S	S		DRI	ID
mm	in	mm	in	mm	in	mm	in			
12.7	1/2"	70	2 3/4"	22.23	7/8"	12.7x38	1/2" x 1 1/2"	RH	091296 ●	
12.7	1/2"	80	3 1/8"	35	1 3/8"	12.7x40	1/2" x 1 1/2"	RH	191065 ●	
19.05	3/4"	110	4 3/8"	48	1 7/8"	19.05x50	3/4" x 2"	RH	091297 ●	

RPM:  $n = 18000 - 24000 \text{ min}^{-1}$

**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Uncoated chipboard = 1.1;

Veneer across grain = 0.7



### Router cutter Diamaster PRO

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides. Suitable for medium batch quantities. Z 2+2 for increased feed speeds.

#### Machine:

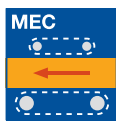
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

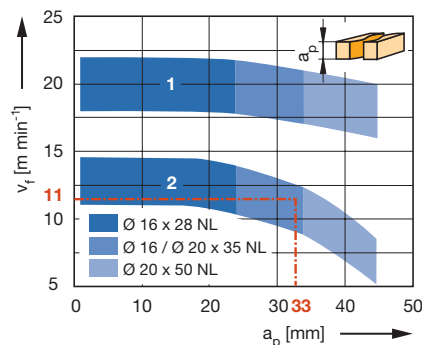
Spiral cutting edge arrangement with alternate shear angle and DP plunging tip. Resharpenable 3 to 5 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. Axial infeed for grooving and sizing maximum 1.0 - 1.8 x D.



Feed speed  $v_f$  depending on grooving depth  $a_p$

1 = Jointing cut  $a_e = 0.5 - 2$  mm

2 = Sizing cut



**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing, sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.6;  
Veneer across grain = 0.7

#### DP, Z 2+2

WO 140 2 50

D mm	GL mm	NL mm	S mm	ID LH	ID RH
14	90	35	16x50		191083 ●
16	90	28	20x50		191042 ●
16	95	35	20x50	191109 ●	191043 ●
16	105	45	20x50		191084 ●
18	115	55	20x50		191085 ●
20	95	35	20x50		191044 ●
20	105	35	25x60		191045 ●
20	110	50	20x50		191046 ●
20	120	50	25x60	191110 ●	191047 ●
20	125	58	25x55		191097 ●

**RPM:**  $n = 16000 - 24000 \text{ min}^{-1}$



### Router cutter Diamaster PRO

#### Application:

Router cutter for sizing and grooving (Nesting) at high feed speeds. For tear-free cut edges on both sides of the workpiece.

#### Machine:

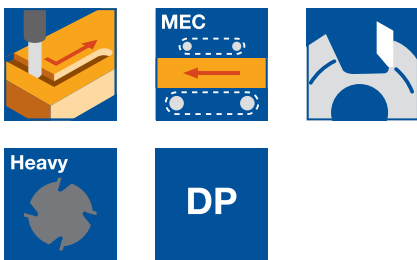
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

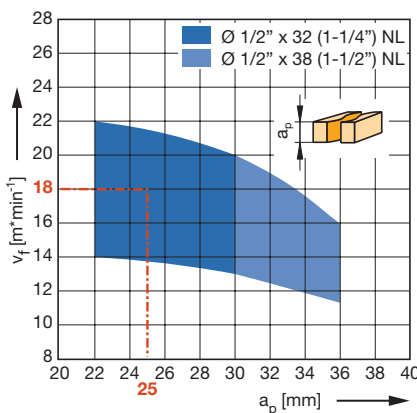
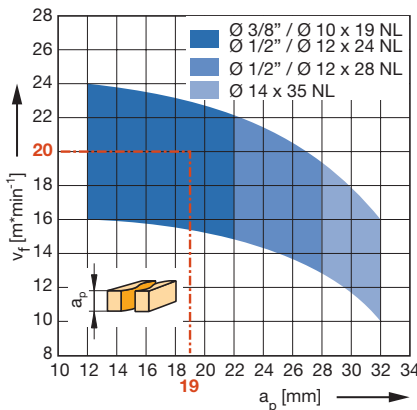
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and real - Z 2 over the complete cutting length, with DP plunging tip. Resharpenable up to 3 times with normal wear. Tool body made from high-tensile material. Important to follow the application data parameters.



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### DP, Z 2+2, Nesting

WO 140 2 50

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
10	65	19	10x40	RH	<b>191059 •</b>
12	70	24	12x42	RH	<b>191060 •</b>
12	75	28	12x42	RH	<b>191061 •</b>
14	90	35	16x50	RH	<b>191101 •</b>
16	105	45	20x50	RH	<b>191105 •</b>

#### DP, Z 2+2, Nesting, inch types

WO 140 2 50

D	D	GL	GL	NL	NL	S	S	DRI	ID
mm	in	mm	in	mm	in	mm	in		
9.53	3/8"	65	2 9/16"	19	3/4"	9.53x40	3/8" x 1 9/16"	RH	<b>191062 •</b>
12.7	1/2"	70	2 3/4"	24	15/16"	12.7x42	1/2" x 1 5/8"	RH	<b>191063 •</b>
12.7	1/2"	75	2 15/16"	28	1 1/8"	12.7x42	1/2" x 1 5/8"	RH	<b>191064 •</b>
12.7	1/2"	80	3 3/16"	32	1 1/4"	12.7x40	1/2" x 1 9/16"	RH	<b>191102 •</b>
12.7	1/2"	85	3 1/3"	38	1 1/2"	12.7x40	1/2" x 1 9/16"	RH	<b>191103 •</b>

RPM:  $n = 18000 - 24000 \text{ min}^{-1}$

#### Table of recommended workpiece thickness

Id.	NL	workpiece thickness
191059/191062	19	9 – 16 mm
191060/191063	24	13 – 20 (22) mm
191061/191064	28	19 – 25 mm
191102	32	22 – 28 (30) mm
191101	35	22 – 32 mm
191103	38	25 – 35 mm

**Workpiece material:** Chipboard, plastic coated

**Operation:** Sizing / Nesting

**RPM:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Chipboard uncoated = 1.1;

Veneer across the grain = 0.7;

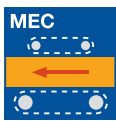
Pre-trimming MDF = 1.2



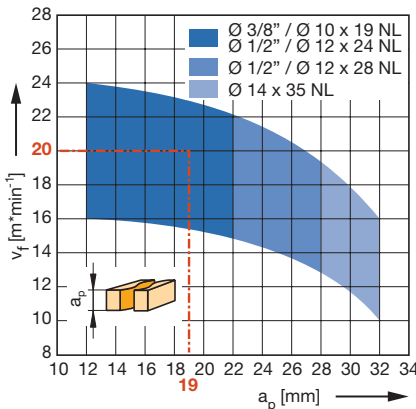
## 5. Routing

### 5.1 Sizing and grooving

#### 5.1.3 Shank cutters DP



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing / Nesting

**RPM:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Chipboard uncoated = 1.1;

Veneer across grain = 0.7;

Pre trimming MDF = 1.2

Table of recommended workpiece thickness

Id.	NL	workpiece thickness
191111	24	14 – 20 (22) mm
191112	28	19 – 25 mm

### Router cutter Diamaster PRO

#### Application:

Router cutter for sizing and grooving (Nesting) at high feed speeds. For tear free cut edges on both sides of the workpiece.

#### Machine:

Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

#### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

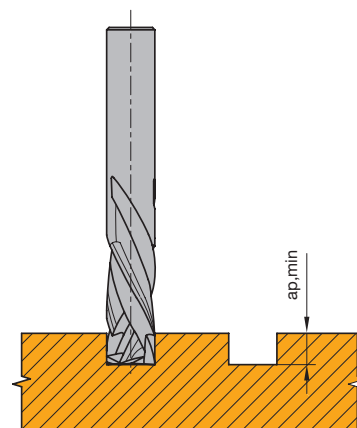
Spiral cutting edge arrangement with alternate shear angle and real - Z 2 over the complete cutting length, with DP plunging tip. Resharpenable up to 3 times with normal wear. Tool body made from high-tensile material. Important to follow the application data parameters. Tools with increased length of positive shear angle for optimized chip collection in the direction of the extraction hood – Leitz DFC®.

#### DP, Z 2+2, increased length of positive shear angle, Nesting application

WO 140 2 50

D	GL	NL	S	$a_{p \text{ min}}$	DRI	ID
mm	mm	mm	mm	mm		
12	70	24	12x42	14	RH	191111 ●
12	75	28	12x42	19	RH	191112 ●

**RPM:**  $n = 18000 - 24000 \text{ min}^{-1}$



Minimum grooving depth  $a_{p \text{ min}}$  for tear-free cut



### Router cutter Diamaster PRO<sup>3</sup>

#### Application:

Router cutter for sizing and grooving (Nesting) at high feed speeds. For tear-free cut edges on both sides of the workpiece.

#### Machine:

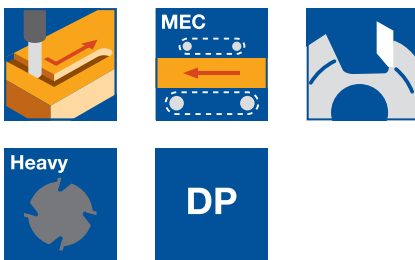
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

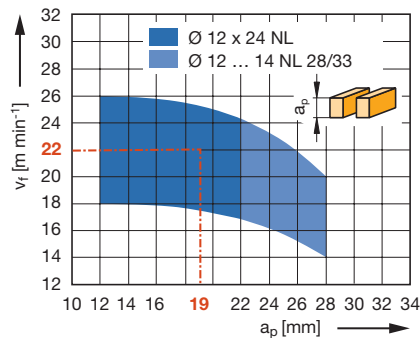
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and real - Z 3 over the complete cutting length, with DP plunging tip. Resharpenable up to 3 times with normal wear. Tool body made from high-tensile material. Important to follow the application data parameters.



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### DP, Z 3+3, Nesting

WO 140 2 50

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
12	65	19	12x42	RH	<b>191030 ●</b>
12	70	24	12x42	RH	<b>191031 ●</b>
12	75	28	12x42	RH	<b>191032 ●</b>
14	90	33	16x50	RH	<b>191033 ●</b>

#### DP, Z 3+3, Nesting, inch types

WO 140 2 50

D	D	GL	GL	NL	NL	S	S	DRI	ID
mm	in	mm	in	mm	in	mm	in		
12.7	1/2"	70	2 3/4"	24	15/16"	12.7x42	1/2" x 1 5/8"	RH	<b>191057 ●</b>
12.7	1/2"	75	2 15/16"	28	1 1/8"	12.7x42	1/2" x 1 5/8"	RH	<b>191058 ●</b>

**RPM:**  $n_{\max} = 24000 \text{ min}^{-1}$

**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing / Nesting

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

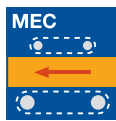
Uncoated chipboard = 1.1;

Veneer across grain = 0.7;

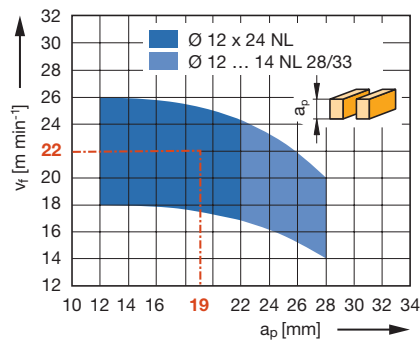
Pre trimming MDF = 1.2

#### Table of recommended workpiece thickness

Id.	NL	workpiece thickness
191030	19	9 – 16 mm
191031/191057	24	13 – 20 (22) mm
191032/191058	28	19 – 25 mm
191033	33	20 – 30 mm



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing / Nesting

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Uncoated chipboard = 1.1;

Veneer across grain = 0.7;

Pre trimming MDF = 1.2

Table of recommended workpiece thickness

Id.	NL	workpiece thickness
191113	24	14 – 20 (22) mm
191114	33	20 – 30 mm

### Router cutter Diamaster PRO<sup>3</sup>

#### Application:

Router cutter for sizing and grooving (Nesting) at high feed speeds. For tear free cut edges on both sides of the workpiece.

#### Machine:

Overhead routers with/without CNC control, machining centres, special routers with spindles for mounting shank tools.

#### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

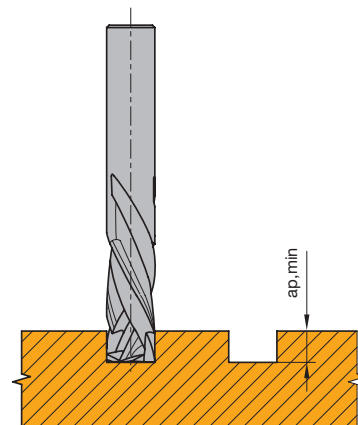
Spiral cutting edge arrangement with alternate shear angle and real - Z 3 over the complete cutting length, with DP plunging tip. Resharpenable up to 3 times with normal wear. Tool body made from high-tensile material. Important to follow the application data parameters. Tools with increased length of positive shear angle for optimized chip collection in the direction of the extraction hood – Leitz DFC®.

#### DP, Z 3+3, increased length of positive shear angle, Nesting application

WO 140 2 50

D	GL	NL	S	$a_{p \text{ min}}$	DRI	ID
mm	mm	mm	mm	mm		
12	70	24	12x42	14	RH	191113 ●
14	90	33	16x50	19	RH	191114 ●

RPM:  $n_{\text{max}} = 24000 \text{ min}^{-1}$



Minimum grooving depth  $a_{p \text{ min}}$  for tear-free cut



### Router cutter Diamaster PRO

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides of the workpiece. Suitable for right hand and left hand cutting (e.g. protective cutting) without tool change.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

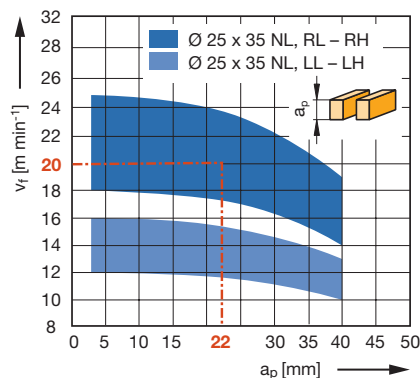
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., for tear-free edges on both sides of coated workpieces.

#### Technical information:

Spiral cutting edge arrangement with tungsten carbide plunging tip. Right hand rotation: Z 3+3, left hand rotation: Z 2+2. Resharpenable 3 to 5 times with normal wear. Right and left hand rotation in one tool (by adjusting the Z-axis and changing the direction of rotation).



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### Router cutter Diamaster PRO, Z 3+3 / Z 2+2

**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Uncoated chipboard = 1.1;

Veneer across grain = 0.7

#### DP, RH + LH combination tool

WO 140 2 50

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
25	120	24 + 24	25x50	LH, RH	<b>191034 ●</b>
25	145	35 + 35	25x55	LH, RH	<b>191020 ●</b>

**RPM:**  $n_{\max} = 24000 \text{ min}^{-1}$



### Router cutter Diamaster PLUS

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides.

#### Machine:

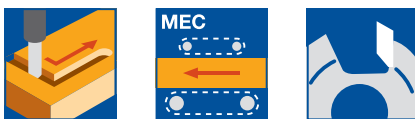
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

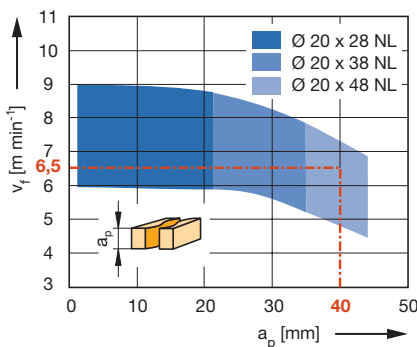
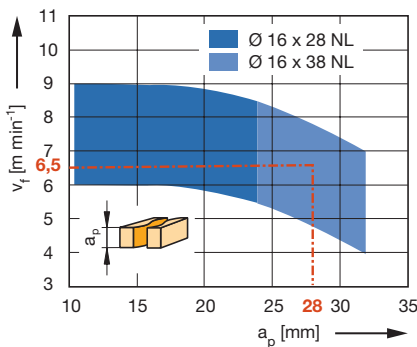
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., duromers, plastomers, laminated materials (HPL-compact laminate, Trespa, multiplex plywood).

#### Technical information:

Cutting edges with alternate shear angle and tungsten carbide plunging tip (ID **090174** with DP plunging edge). Resharpenable 5 to 8 times with normal wear. Cuts for painting in MDF require finishing with tools with continuous edges. Stable and rigid tips suitable for machining abrasive and hard to machine materials (HPL, Trespa, GFRP, CFRP etc.).



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

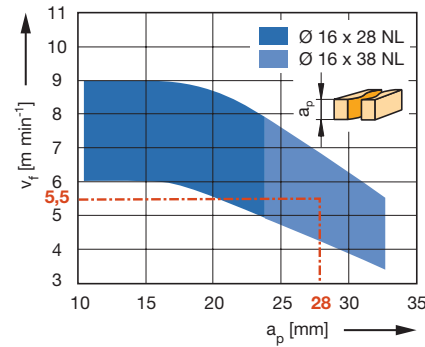
**Correction factor for  $v_f$ :** MDF = 0.8;  
Veneer across grain = 0.7

#### DP, Z 1+1

WO 140 2

D mm	GL mm	NL mm	S mm	DRI	ID
12	90	24	16x50	RH	<b>090174</b> ●
16	90	28	20x60	RH	<b>090188</b> ●
18	110	48	20x60	RH	<b>091101</b> ●
20	130	58	25x60	RH	<b>090167</b> ●

**RPM:**  $n = 16000 - 24000 \text{ min}^{-1}$



**Workpiece material:** Decorative laminates

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$



### Router cutter Diamaster QUATTRO

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides. Suitable for medium and large batch quantities. Z 2+2 for increased feed speeds.

#### Machine:

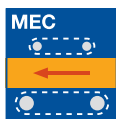
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

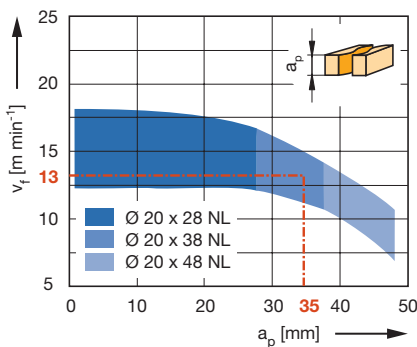
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and DP plunging tip (ID 091251, 091252, 091253 with tungsten carbide plunging tip). Resharpenable 5 to 8 times with normal wear. Cuts for painting in MDF require finishing with tools with continuous edges.



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### DP, Z 2+2

WO 140 2

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
20	90	28	20x50		091235 ●
20	110	48	20x50		091238 ●
20	110	38	25x60		091241 ●
20	120	48	25x60	091246 ●	091247 ●
25	110	38	25x60		091251 ●
25	120	48	25x60	091252 ●	091253 ●

RPM:  $n = 16000 - 24000 \text{ min}^{-1}$

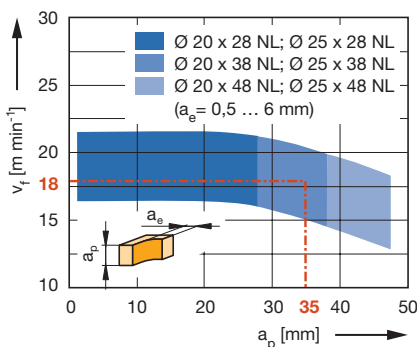
**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Paper coated = 0.8



**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.9;

Paper coated = 0.8;

Veneer across grain = 0.8



### Router cutter Diamaster PLUS, Z 3+3

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides. Suitable for large batch quantities. Z 3+3 at high feed speeds.

#### Machine:

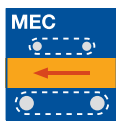
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

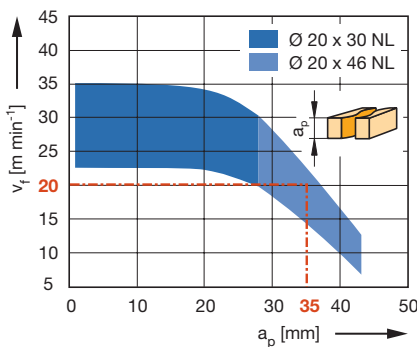
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.

#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and DP plunging tip. Resharpenable 8 to 12 times with normal wear. Cuts for painting in MDF require finishing with tools with continuous edges. Tools with negative twist support the tool clamping especially for small parts.



Feed speed  $v_f$  depending on cutting depth  $a_p$



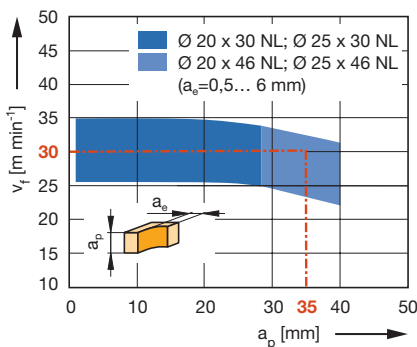
**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Paper coated = 0.8



#### DP, Z 3+3, with negative twist

WO 140 2

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
18	100	24	25x60		091204 ●
20	90	24	20x50		091207 ●
20	100	24	25x60		091209 ●
20	105	30	25x60	091170 ●	091171 ●
20	110	38	25x60		091211 ●
20	120	46	25x60		091174 ●
25	100	24	25x60		091213 ●
25	105	30	25x60	091176 ●	091177 ●
25	110	38	25x60	091214 ●	091215 ●
25	120	46	25x60	091179 ●	091180 ●

**RPM:**  $n = 16000 - 24000 \text{ min}^{-1}$

**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.9;

Paper coated = 0.8;

Veneer across grain = 0.8





### Router cutter Diamaster PLUS, Z 3+3

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides. Suitable for large batch quantities. Z 3+3 at high feed speeds.

#### Machine:

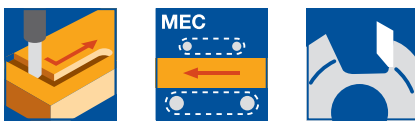
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

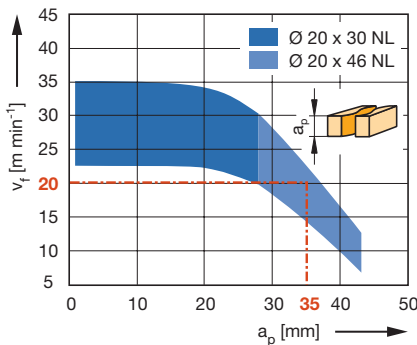
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.

#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and DP plunging tip. Resharpenable 8 to 12 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. Tools with positive twist for good chip removal into the extraction system - Leitz DFC®.



Feed speed  $v_f$  depending on cutting depth  $a_p$



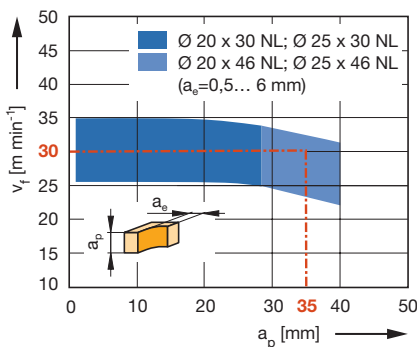
**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Paper coated = 0.8



#### DP, Z 3+3, with positive twist, DFC-design

WO 140 2

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
16	100	24	20x50		<b>091254 ●</b>
20	105	30	25x60		<b>191026 ●</b>
20	110	38	25x60		<b>191098 ●</b>
20	120	46	25x60		<b>191099 ●</b>
25	105	30	25x60		<b>191027 ●</b>
25	110	38	25x60		<b>091217 ●</b>
25	120	46	25x60	<b>091218 ●</b>	<b>091219 ●</b>

**RPM:**  $n = 16000 - 24000 \text{ min}^{-1}$

**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.9;

Paper coated = 0.8;

Veneer across grain = 0.8



### Router cutter Diamaster PLUS³, Z 3+3

#### Application:

Router cutter for sizing and grooving with increased performance time in engineered wood boards. For tear-free cut edges on both sides. Suitable for large batch quantities. Z 3+3 for high feed speeds.

#### Machine:

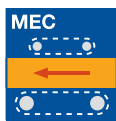
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

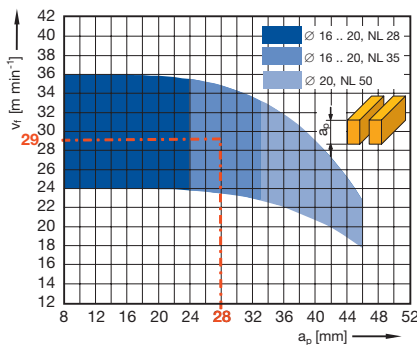
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and real - Z 3 over the complete cutting length. DP plunging tip. Resharpenable 8 to 12 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. Tools with negative twist support the tool clamping especially for small parts.



Feed speed  $v_f$  depending on cutting depth  $a_p$



#### DP, Z 3+3, with negative shear angle

WO 140 2

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
16	85	28	20x50		191048 ●
16	95	35	20x50	191050 ●	191049 ●
20	85	28	20x50		191051 ●
20	105	35	25x60	191053 ●	191052 ●
20	120	50	25x60		191054 ●

RPM:  $n = 18000 - 24000 \text{ min}^{-1}$

**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Chipboard, uncoated = 1.1;

Veneer across grain = 0.7;

Pre-cutting MDF = 1.2



#### Router cutter Diamaster PLUS³, Z 3+3

##### Application:

Router cutter for sizing and grooving with increased performance time in particle boards. For tear free cut edges on both sides. Suitable for large batch quantities. Z 3+3 for high feed speeds.

##### Machine:

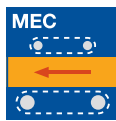
Overhead routers with/without CNC control, machining centres, special routers with spindles to mount shank tools.

##### Workpiece material:

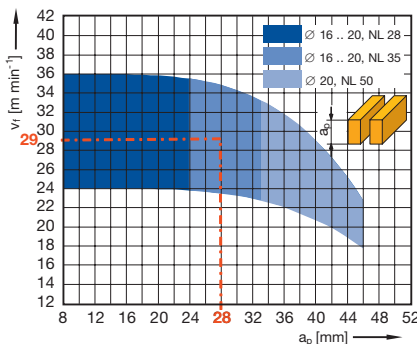
Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Spiral cutting edge arrangement with alternate shear angle and real - Z 3 over the complete cutting length. DP plunging tip. Resharpenable 8 to 12 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. Tools with increased length of positive shear angle for optimized chip collection in the direction of the extraction hood – Leitz DFC®.



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Chipboard, uncoated = 1.1;

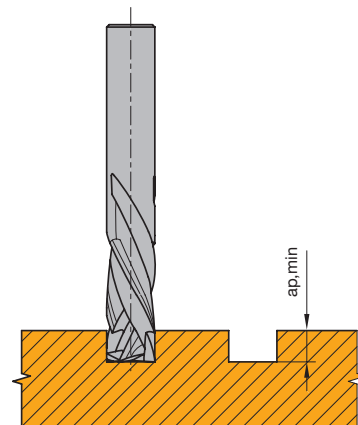
Veneer across grain = 0.7;

Pre-cutting MDF = 1.2

**DP, Z 3+3, increased length of positive shear angle, DFC design**  
WO 140 2

D mm	GL mm	NL mm	S mm	$a_{p \text{ min}}$ mm	DRI	ID
16	85	28	20x50	23	RH	191115 ●
20	105	35	25x60	27	RH	191116 ●

**RPM:**  $n = 18000 - 24000 \text{ min}^{-1}$



Minimum grooving depth  $a_{p \text{ min}}$  for tear-free cut



### Router cutter Diamaster PRO EdgeExpert

#### Application:

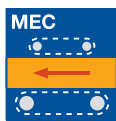
Routers for sizing and grooving with increased performance time in engineered wood boards. For tear-free cutting edges on both sides especially for sensitive and brittle decorative papers, laminating foils and veneers. Suitable for small and medium batch sizes.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



#### Technical information:

Spiral cutting edge arrangement with alternate shear angle and DP plunging tip. Enlarged shear angle for excellent edge quality for sensitive and brittle decorative papers, laminating foils and veneers. Resharpenable 2 to 4 times with normal wear. Cuts to be painted in MDF require finishing with tools with continuous edges. ID 191128 with a body made of vibration-damping alloy.

#### DP, Z 1+1

WO 140 2 50

D mm	GL mm	NL mm	S mm	DRI	ID
16	85	25	16x50	RH	191069 ●
16	95	35	20x50	RH	191070 ●

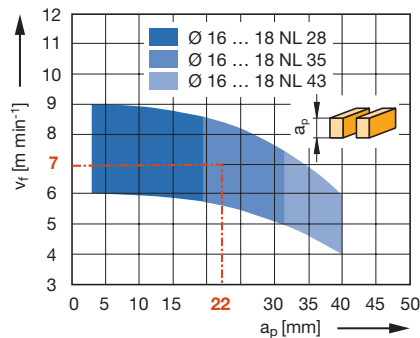
#### DP, Z 2+2

WO 140 2 50

D mm	GL mm	NL mm	S mm	DRI	ID
14	90	28	16x50	RH	191128 ●

RPM:  $n = 18000 - 24000 \text{ min}^{-1}$

Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Veneer across grain = 0.7;

Extremely sensitive decors = 0.7 - 0.8



#### Router cutter Diamaster QUATTRO EdgeExpert

##### Application:

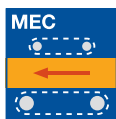
Routers for sizing and grooving with increased performance time in engineered wood boards. For tear-free cutting edges on both sides especially for sensitive and brittle decorative papers, laminating foils and veneers. Suitable for medium and large batch sizes. Z 2+2 for increased feed rates.

##### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



##### Technical information:

Spiral cutting edge arrangement with alternate shear angle and DP plunging tip. Enlarged shear angle for excellent edge quality for sensitive and brittle decorative papers, laminating foils and veneers. Resharpenable 4 to 6 times with normal wear. Precutting the workpieces is recommended. Cuts to be painted in MDF require finishing with tools with continuous edges.

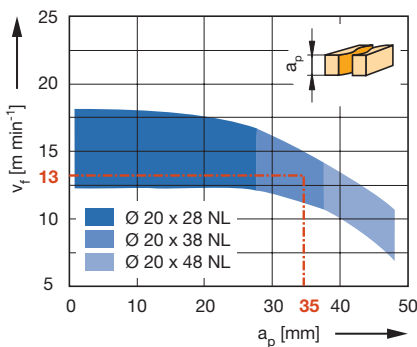
##### DP, Z 2+2

WO 140 2

D mm	GL mm	NL mm	S mm	DRI	ID
20	90	32	20x50	RH	191071 ●
20	120	48	25x60	RH	191072 ●

RPM:  $n = 18000 - 24000 \text{ min}^{-1}$

Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Sizing

**Speed:**  $n = 18000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Paper coated = 0.8



### Router cutter Diamaster PLUS³ EdgeExpert, Z 3+3

#### Application:

Routers for sizing and grooving with increased performance time in engineered wood boards. For tear-free cutting edges on both sides especially for sensitive and brittle decorative papers, laminating foils and veneers. Suitable for very large batch sizes. Z 3+3 for increased feed rates.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

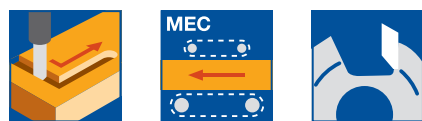
Spiral cutting edge arrangement with alternate shear angle and DP plunging tip. Enlarged shear angle for excellent edge quality for sensitive and brittle decorative papers, laminating foils and veneers. Resharpenable 5 to 8 times with normal wear. Precutting the workpieces is recommended. Especially suitable on CNC machining centres with laser edgebanding technology. Cuts to be painted in MDF require finishing with tools with continuous edges.

#### DP, Z 3+3, symmetric edge arrangement

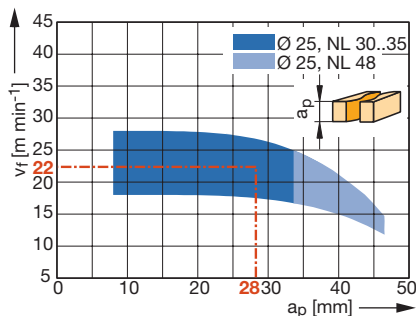
WO 140 2

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
25	105	30	25x60	RH	<b>191073 ●</b>
25	105	35	25x55	RH	<b>191074 ●</b>
25	120	48	25x60	RH	<b>191075 ●</b>

RPM:  $n = 18000 - 24000 \text{ min}^{-1}$



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

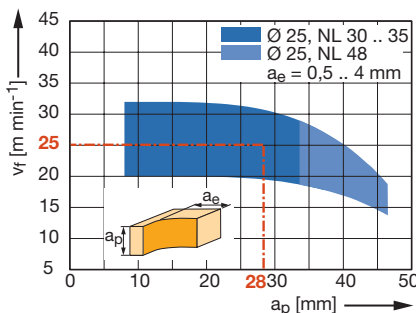
**Operation:** Sizing

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Veneer across grain = 0.7;

Extremely sensitive decors = 0.7 - 0.8



**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing

**Speed:**  $n = 24000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.8;

Veneer across grain = 0.7;

Extremely sensitive decors = 0.7 - 0.8



### Slot mortising bits

#### Application:

Router cutter for cutting tear-free longitudinal slots with stepwise infeed.

#### Machine:

Special routers with reciprocating spindles.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

For softwood and hardwood. Suitable for right hand and left hand rotation, tools resharpenable on the face side. Constant diameter after sharpening.

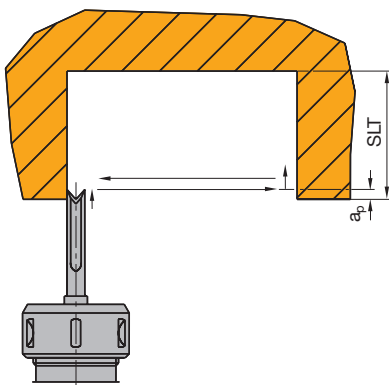


#### HS, Z 2

WB 510 0

D	GL	S	SLT	QAL	ID
mm	mm	mm	mm		
6	90	13x40	38	HS	037020 ●
8	95	13x40	42	HS	037022 ●
10	105	13x40	50	HS	037024 ●
12	115	13x40	60	HS	037026 ●

RPM:  $n = 4500 - 9000 \text{ min}^{-1}$



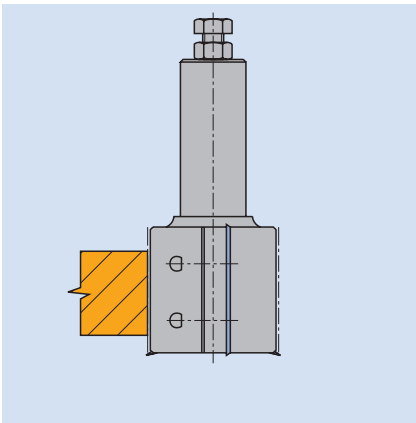
Application example of cutting slots  
 $a_p = 0.8 \text{ mm}$  (reciprocating movement)



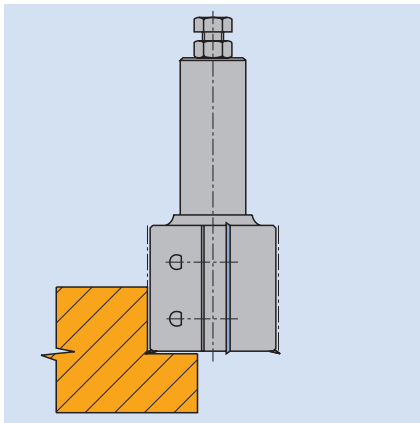
## 5. Routing

### 5.2 Jointing, rebating and bevelling

<b>Working step/Application</b>	Jointing, rebating and bevelling.
<b>Workpiece material</b> <b>[recommended cutting material]</b>	Softwood and hardwood [HW]. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. [HW, DP]. Plywood [HW, DP]. Duromers [HW, DP]. Plastomers [HW, DP]. Solid surface material (Corian, Varicor etc.) [HW, DP].
<b>Machine</b>	Stationary routers with/without CNC control. Milling machines with spindles to mount shank tools.
<b>Operation</b>	For conventional and climb cut operations, limited chip removal.

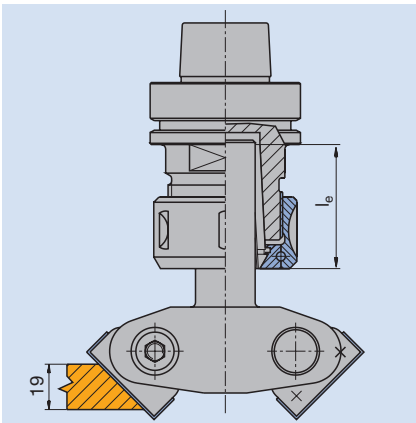


Jointing

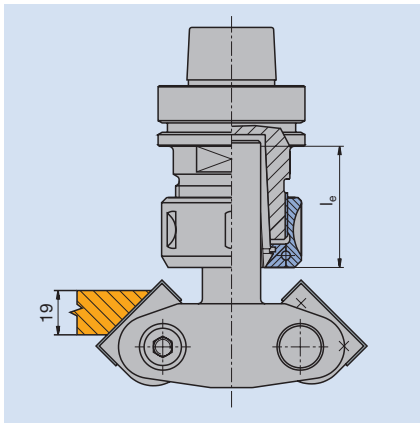


Rebating

#### Bevelling with adjustable bevel cutterhead



Bevelling top edge



Bevelling bottom edge

**Note:**

When bevelling from below, the minimum shank clamping length  $l_e$  must be observed. Under no circumstances must the tool be clamped at a shorter length.

Shank d x e	$l_e$ min [mm]
20 x 50	40
25 x 60	45

d = Shank diameter  
e = Shank length

#### Application parameters

#### RPM/feed speed

The recommended RPM and feed speeds are detailed in the diagrams next the tool tables.

#### Information

Smooth cutting results can only be achieved with tools having a continuous cutting edge. Spurs are required when rebating solid wood.

#### Workpiece clamping

Sufficient workpiece clamping is very important on stationary machines.

Insufficient clamping can reduce both the cut quality and tool life considerably. Panels can be held in place with vacuum clamping, but sometimes additional mechanical clamping is required.

Small and arched workpieces in particular require special jigs or clamping devices which must be made by the customer or sourced from specialist suppliers.



### Copy shaping cutterhead - HeliCut 15

#### Application:

For pre-cutting, jointing and copy shaping of large cutting depths, along and across to the fibre direction. For copy shaping of arched workpieces with template, ball bearing and guide ring, as well as for the application on CNC controlled stationary routers e.g. joinery machines, window manufacturing plants.

#### Machine:

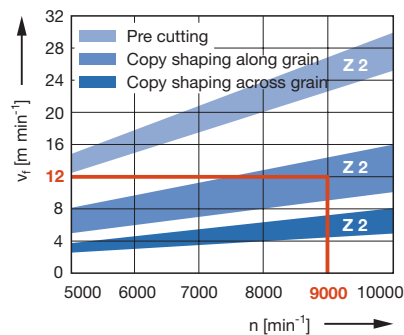
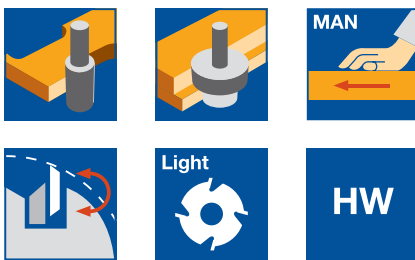
Spindle moulders and profile milling machines, double-end tenoner, stationary routers with/without CNC control.

#### Workpiece material:

Softwood and hardwood, glulam and laminated wood.

#### Technical information:

Noise reduced design with staggered knives, applicable for MAN and MEC. Mountable on clamping arbor. Also applicable for rebating. Application of the same knives as peripheral knife and spur. The cutting edges of the HW knives are numbered. No clamping wedges, direct tangential knife clamping thus easy handling of the knife change without further setting gauges. By default mounted with HW turnblade knives ID **009543**.



**Feed speed  $v_f$  depending on the number of teeth  $Z$  and speed  $n$  for solid wood (pre trimming and copy shaping)**

**Example for tool diameter 125 mm:**

$n = 9000 \text{ min}^{-1}$

$Z = 2$

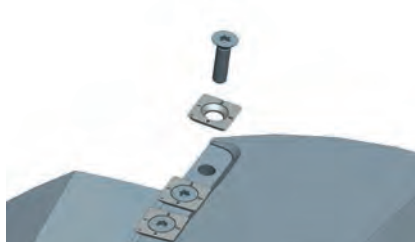
Application: copy shaping along the grain

$v_f = 12 \text{ m min}^{-1}$

#### Order example:

Tool set ID **132737** mounted on arbor ID **042951**, HSK-F 63 (A = 80 mm).

When giving the arbor ID observe the required clamping diameter.



### Copy shaping cutterhead - HeliCut 15

SL 499 1, WW 230 1 07

Tool Type	ABM mm	QAL	AM PCS	Z	V	ID
Cutterhead	60x81,5x20	HW-MF	16	2	2	<b>132600</b> ●
Cutterhead mounted on arbor	1-part	HW	16	2	2	<b>132736</b> □
Cutterhead	80x81,5x30	HW-MF	16	2	2	<b>132608</b> ●
Cutterhead mounted on arbor	1-part	HW	16	2	2	<b>132737</b> □
Cutterhead	125x93,7x30	HW-MF	20	2	2+2	<b>132604</b> ●
Cutterhead mounted on arbor	1-part	HW	20	2	2+2	<b>132738</b> □
Cutterhead	125x116,6x30	HW-MF	24	2	2+2	<b>132605</b> ●
Cutterhead mounted on arbor	1-part	HW	24	2	2+2	<b>132739</b> □

**RPM:** D 60 mm:  $n_{\max} = 20000 \text{ min}^{-1}$   
D 80 mm:  $n_{\max} = 18000 \text{ min}^{-1}$   
D 125 mm:  $n_{\max} = 12000 \text{ min}^{-1}$

More dimensions on request.

#### Spare knives:

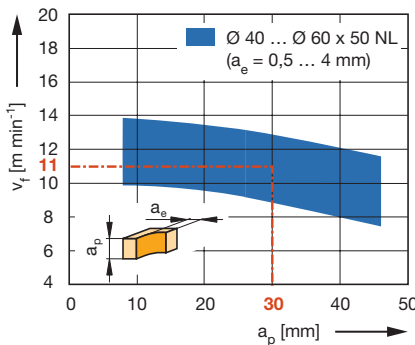
BEZ	ABM mm	QAL	BEM	VE PCS	ID
Turnblade knife	15x15x2,5	HW-MF	HeliCut 15	10	<b>009543</b> ●
Turnblade knife	15x15x2,5	HW	HeliCut 15	10	<b>009549</b> ●

#### Spare parts:

BEZ	ABM mm	for D mm	ID
Countersink screw, Torx® 20	M5x12	60	<b>007898</b> ●
Countersink screw, Torx® 20	M5x14.2-8.8	80	<b>007394</b> ●
Countersink screw, Torx® 20	M5x18	125	<b>114030</b> ●
Torx® key	Torx® 20		<b>006091</b> ●



Feed speed  $v_f$  depending on cutting depth  $a_p$



**Workpiece material:** Plastic coated chipboard

**Operation:** Jointing

**Speed:**  $n = 16000 \text{ min}^{-1}$

**Correction factor for  $v_f$ :** MDF = 0.9;

Paper coated = 0.8;

Machining across grain = 0.7

### Turnblade jointing / rebating cutterhead

#### Application:

For jointing and rebating with constant tool diameter.

#### Machine:

Stationary routers with/without CNC control, machining centres.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

HW turnblades Z 2 with straight cut for offset-free areas on pre-cut workpieces or on workpieces sized with roughing cutters. Mounted spurs especially for the production of tear-free rebates in softwood and hardwood. Smooth running through closed, round shape of the tool body.

#### HW, Z 2 / V 2

WL 402 1

D	GL	SB	S	ID
mm	mm	mm	mm	
40	120	50	25x60	<b>039235 ●</b>
50	120	50	25x60	<b>039239 ●</b>
60	113	50	25x60	<b>039243 ●</b>

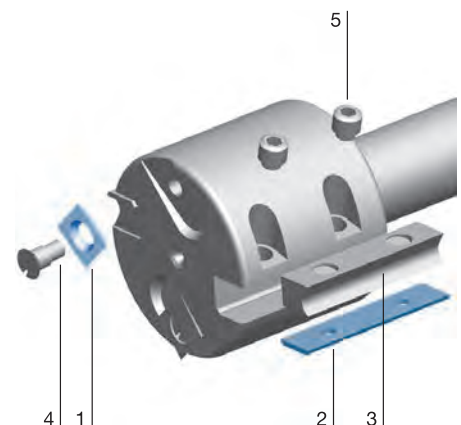
**RPM:**  $n_{\max} = 18000 \text{ min}^{-1}$

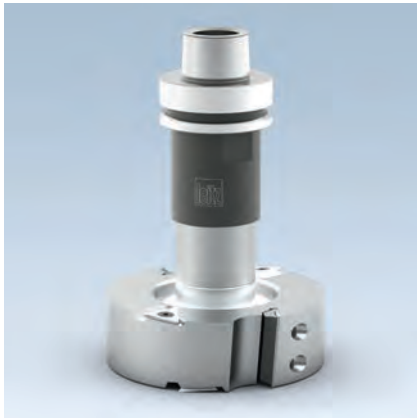
#### Spare knives:

Part-no.	BEZ	ABM	QAL	VE	ID
		mm		PCS	
1	Turnblade spur VS1	14x14x2	HW-F	10	<b>005099 ●</b>
2	Turnblade knife	50x12x1.5	HW-05F	10	<b>005086 ●</b>

#### Spare parts:

Part-no.	BEZ	ABM	for D	ID
		mm	mm	
3	Clamping wedge	48x11.6x9		<b>009871 ●</b>
4	Screw with slot	M5x12		<b>005744 ●</b>
5	Allen screw	M8x8	40/50	<b>006245 ●</b>
5	Allen screw	M8x14	60	<b>006073 ●</b>
	Allen key	SW 4		<b>005445 ●</b>





### Turnblade jointing / rebating cutterhead

#### Application:

Optimized for rebating, jointing and grooving with and against feed.

#### Machine:

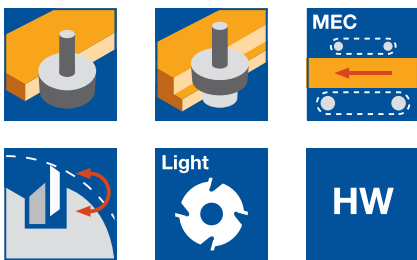
Stationary routers with/without CNC control, CNC machining centres.

#### Workpiece material:

Softwood and hardwood, compound materials of solid wood and wood derived materials, uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Cutterhead with turnblades and alternate shear angle, righthand rotation. Tool body in lightweight aluminium for a better dynamic situation.



#### HW, Z 2 / V 2

SL 199 2, SW 500 2

Tool Type	QAL	Z	V	ID
Cutterhead with spacers	HW	2	2	126039 ●
Cutterhead mounted on arbor	HW	2	2	426080 □

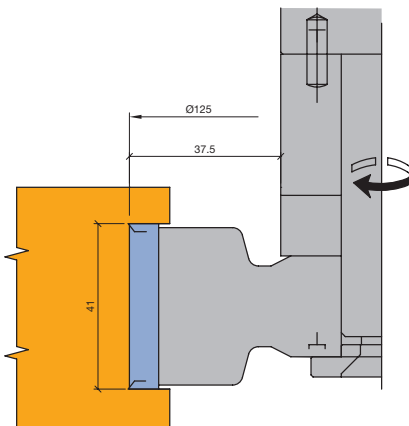
RPM:  $n_{\max} = 13700 \text{ min}^{-1}$

#### Spare knives:

BEZ	ABM	ID
	mm	
Turnblade knife	40x8x1.5	005074 ●
Turnblade spur VS2	19x19x2	005115 ●

#### Spare parts:

BEZ	ABM	ID
	mm	
Clamping wedge	38x18.75x8.27	009675 ●
Countersink screw, Torx® 20	M5x8.5	007808 ●
Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
Cylindrical screw with ISK	M5x80	007097 ●
Torx® key	Torx® 20	117503 ●
Torx® key	Torx® 25	117504 ●
Allen key	SW 4, L 100	005451 ●



#### Order example:

Tool set ID **426080** mounted on arbor ID **042847**, HSK-F 63 (A = 80 mm).  
When ordering choose arbors with d = 20 mm and clamping length 70 mm.



### Turnblade jointing / rebating cutterhead

#### Application:

Optimized for rebating, jointing and grooving with and against feed.

#### Machine:

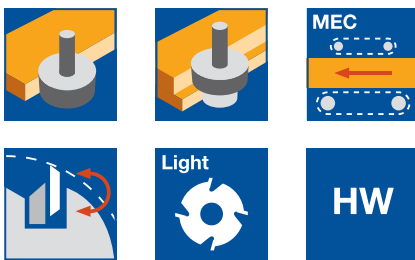
Stationary routers with/without CNC control, CNC machining centres.

#### Workpiece material:

Softwood and hardwood, compound materials of solid wood and wood derived materials, uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Cutterhead with turnblades and alternate shear angle, righthand rotation. Knife seatings for grooving and edging knives for seal groove and edge roundings. Tool body in lightweight aluminium for a better dynamic situation.



#### HW, Z 2 / V 2, with seatings for edging knives

SL 499 2, SW 530 2

Tool Type	QAL	Z	V	ID
Cutterhead with spacers	HW	2	2	126040 ●
Cutterhead mounted on arbor	HW	2	2	426081 □

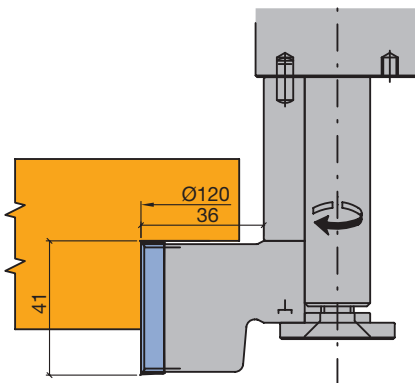
RPM:  $n_{\max} = 14300 \text{ min}^{-1}$

#### Spare knives:

BEZ	ABM	R	FAW	ID
	mm	mm	°	
Turnblade knife	40x8x1.5			005074 ●
Turnblade spur VS2	19x19x2			005115 ●
Edging knife	KM 11/0		45°	008268 ●
Edging knife	KM 12/3	2		008307 ●
Turnblade grooving knife NA5	35.2x15x5			008318 ●
Turnblade grooving knife NA4	35.2x15x4			008317 ●

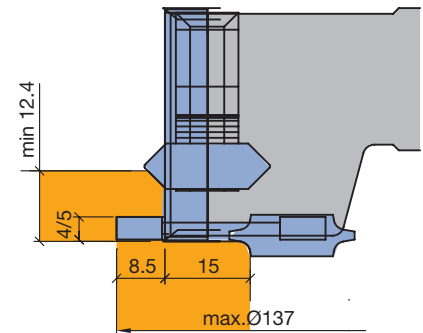
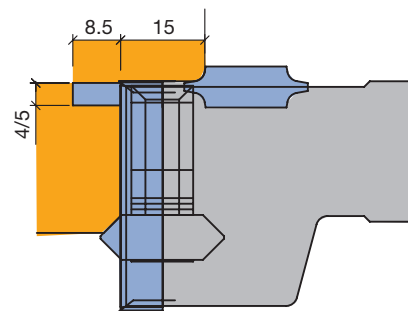
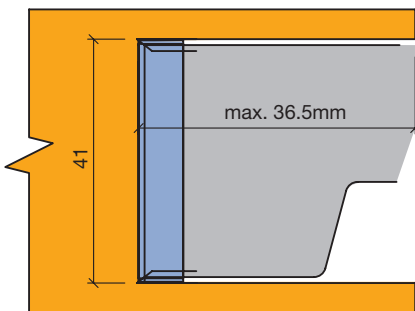
#### Spare parts:

BEZ	BEM	ABM	ID
		mm	
Set of spacers	for groove/edge knives	12.9x20x6.1	028565 ●
Spacer	for groove/edge knives	13/6.1x3	028185 ●
Spacer	for groove/edge knives	13/6.1x1	028037 ●
Countersink screw, Torx® 20	for groove/edge knives	M6x40	006090 ●
Countersink screw, Torx® 20	for groove/edge knives	M6x14	006085 ●
Clamping wedge		38x18.75x8.27	009675 ●
Countersink screw, Torx® 20	for spurs	M5x8.5	007808 ●
Clamping screw w. disc, Torx® 25		M6x18.5	007442 ●
Cylindrical screw with ISK		M5x80	007097 ●
Torx® key		Torx® 20	117503 ●
Torx® key		Torx® 25	117504 ●
Allen key		SW 4, L 100	005451 ●



#### Order example:

Tool set ID **426081** mounted on arbor ID **042847**, HSK-F 63 (A = 80 mm). When ordering choose arbors with d = 20 mm and clamping length 70 mm.





### Jointing cutterhead set with edging knives

#### Application:

For jointing and rounding or bevelling narrow edges with a constant tool diameter.

#### Machine:

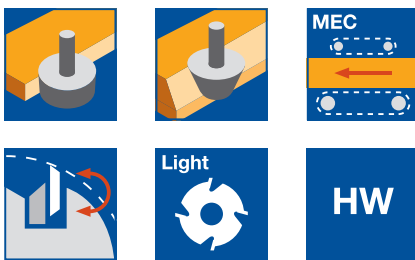
Stationary routers with/without CNC control, machining centres.

#### Workpiece material:

Softwood and hardwood, compound materials of solid wood and wood derived materials, uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Tungsten carbide turnblade knives Z 2 with shear angles. Narrow edge profiling with edging knives mounted on both sides of tool. Smooth running due to closed, round tool body.



#### HW, Z 2, with seatings for edging knives

SL 299 2, SW 510 2

Tool Type	ABM mm	QAL	Z	ID
Tool set without arbor, with spacer	85x50x20.1-part	HW	2	<b>125038</b> ●
Tool set mounted on arbor	1-part.HD40	HW	2	<b>426000</b> □
Tool set without arbor, with spacer	110x100x28x30	HW	2	<b>411179</b> ●
Tool set mounted on arbor	1-part	HW	2	<b>426085</b> □

RPM: D 85 mm:  $n_{\max} = 17900 \text{ min}^{-1}$

D 110 mm:  $n_{\max} = 15600 \text{ min}^{-1}$

Unless stated otherwise, tools are right hand rotation.

Cutter arbor see section Clamping Systems.

#### Spare knives:

BEZ	ABM mm	QAL	R mm	FAW °	VE PCS	ID
Turnblade knife	50x8x1.5	HW-05			10	<b>005402</b> ●
Turnblade knife	100x8x1.5	HW-05				<b>005405</b> ●
Edging knife	KM 12/4	HW-F	1.5			<b>008272</b> ●
Edging knife	KM 12/3	HW-F	2			<b>008307</b> ●
Edging knife	KM 12/0	HW-F	3			<b>008270</b> ●
Edging knife	KM 15/0	HW-F	3			<b>008275</b> ●
Edging knife	KM 12/1	HW-F	3			<b>008271</b> ●
Edging knife	KM 11/0	HW-F		45°		<b>008268</b> ●

#### Spare parts:

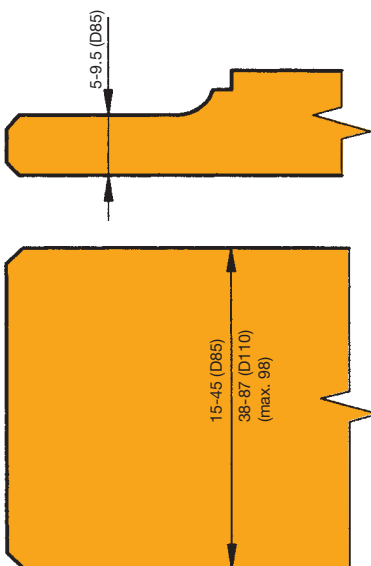
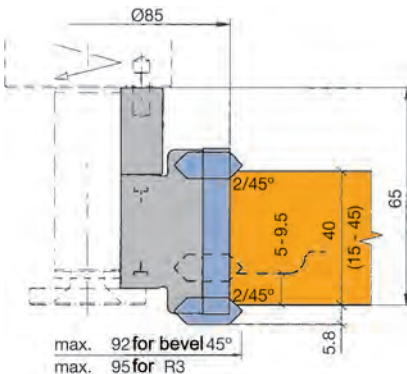
BEZ	ABM mm	ID
Clamping wedge	48x18.75x8.27	<b>009677</b> ●
Clamping wedge	98x18.75x8.27	<b>009681</b> ●
Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442</b> ●
Countersink screw, Torx® 20	M6x35	<b>007098</b> ●
Torx® key	Torx® 20	<b>117503</b> ●
Torx® key	Torx® 25	<b>117504</b> ●
Magnetic setting gauge	0.3/0.8	<b>005376</b> ●

#### Order example:

Tool set ID **426000** mounted on arbor ID **041125**, shank 25x60 mm.

When ordering, choose arbors with d = 20 mm and clamping length 55 mm.

#### Examples

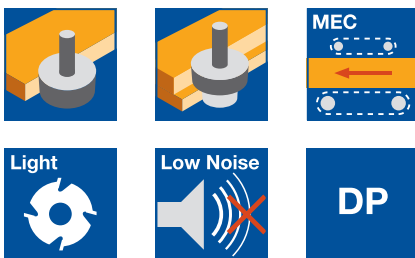




## 5. Routing

### 5.2 Jointing, rebating and bevelling

#### 5.2.1 Jointing and rebating tools



#### Jointing and rebating cutterhead WhisperCut

##### Application:

For tear-free and low noise jointing of the cutting surface.

##### Machine:

Stationary routers with/without CNC control, machining centres.

##### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, paper coated, fibre reinforced plastics (GFRP, CFRP etc.).

##### Technical information:

Cutterhead with DP knives with alternate shear angle for tear-free jointing edges and cutting surfaces. Noise reduced design with noise reduction of up to 5 dB(A) and highly efficient chip collection (>95%) by DFC. Significant weight reduction through lightweight aluminium tool body. Several times applicable through exchangeable knives. 0.6 mm reshaping area.

##### Diamaster WhisperCut jointing cutterhead

WM 230 2 01, WP 299 2

Tool Type	ABM mm	QAL	Z	ID
Cutterhead	70x33x20	DP	2/2/2	<b>192273</b> ●
Cutterhead mounted on arbor	1-part/HD28	DP	2/2/2	<b>192274</b> □

##### Application:

For tear-free and low noise rebating of the cutting surface.

##### Technical information:

Cutterhead with DP knives. For Tear-free rebates due to optimised knife arrangement with shear angle and separate bottom tip (spurs). Not suitable for jointing. Several times applicable through exchangeable knives.

Noise reduced design with noise reduction of up to 5 dB(A) and highly efficient chip collection (>95%) by DFC. Significant weight reduction through lightweight aluminium tool body.

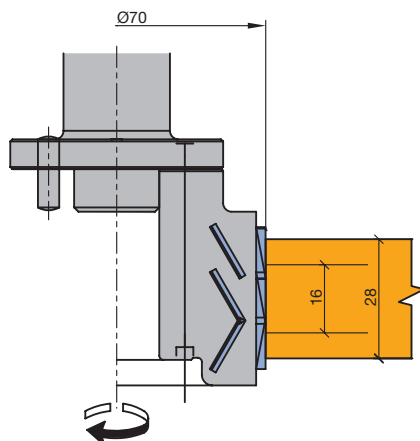
##### Diamaster WhisperCut rebating cutterhead

WM 430 2 01, WP 499 2

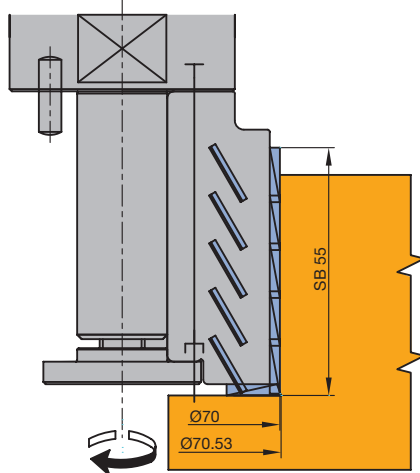
Tool Type	ABM mm	QAL	Z	ID
Cutterhead	70.53x55x20	DP	3x5	<b>192275</b> ●
Cutterhead mounted on arbor	D70.53/SB55	DP	3x5	<b>192276</b> □

Unless stated otherwise, tools are right hand rotation.

Cutter arbor see section Clamping Systems.



Diamaster WhisperCut jointing cutterhead



Diamaster WhisperCut rebating cutterhead

##### Order example:

Tool set ID **192274** mounted on arbor

ID **041126**, shank 25x60 mm.

In case of order select arbors with d = 20 mm and biggest clamping length of the respective type.

## 5. Routing

### 5.2 Jointing, rebating and bevelling

#### 5.2.1 Jointing and rebating tools



#### Jointing and rebating cutterhead WhisperCut EdgeExpert

##### Application:

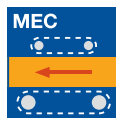
Optimized for noise reduced rebating and jointing particularly for sensitive decorative papers, foil coatings and veneers.

##### Machine:

Stationary routers with/without CNC control, machining centres.

##### Workpiece material:

Chip and fibre boards (MDF etc.) raw, veneered, painted and coated; especially for plastic, paper, HPL and anti-fingerprint coatings. Also suitable for surfaces in mat, high gloss or with relief structures.



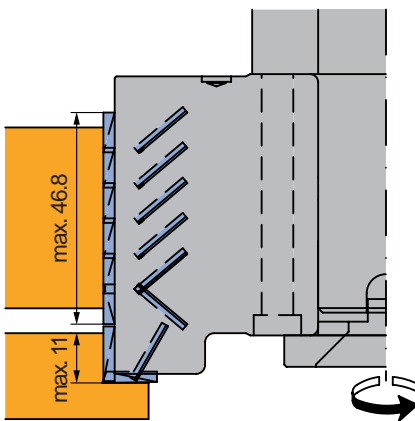
##### Technical information:

DP tipped cutterhead with alternate shear angle for tear-free jointing edges and cutting surface. With rebating knife for tear-free rebating edges (up to 11 mm rebating width). Increased shear angle for excellent edge quality on sensitive decorative papers, foil coatings and veneers. Noise reduced design with up to 5 dB(A) noise reduction. Significant weight reduction by using an aluminium alloy tool body. Carrier body for multiple use with exchangeable throw-away knives (not resharpenable).

##### Diamaster WhisperCut EdgeExpert

WP 299 2

Tool Type	ABM mm	QAL	Z	DRI	ID
Cutterhead mounted on arbor HSK-F 63	D125/SB59,8	DP	2/2	LH	<b>192310</b> □



Diamaster WhisperCut EdgeExpert  
jointing and rebating cutterhead



#### Variable angle cutterhead - turnblade design

##### Application:

For jointing and bevelling with adjustable bevel angle.

##### Machine:

Stationary routers with/without CNC control, machining centres.

##### Workpiece material:

Softwood and hardwood, laminated veneer lumber, plastomers, limited suitable for MDF and chipboard (uncoated or coated).

##### Technical information:

Knife holder swivelling adjustable from 0 - 90°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Free of marks cutting result due to 1-part, continuous cutting edge. Economical due to changeable tungsten carbide turnblades with two cutting edges. Optimized gullet design for improved chip removal.



##### Turnblade, adjustable bevel angle

WP 341 1 01

D	SB	S	DRI	ID
mm	mm	mm		
120	50	25x60	RH	042864 ●
120	50	20x50	RH	042865 □

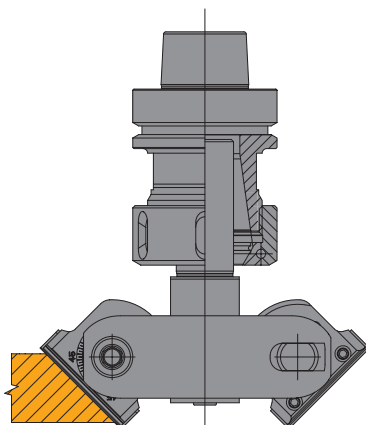
RPM:  $n_{\max} = 11000 \text{ min}^{-1}$

##### Spare knives:

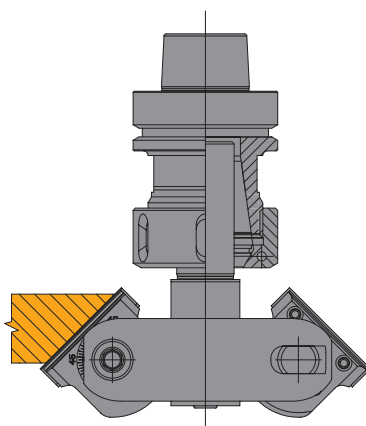
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
1	Turnblade knife	50x12x1.5	HW-05F	10	005086 ●

##### Spare parts:

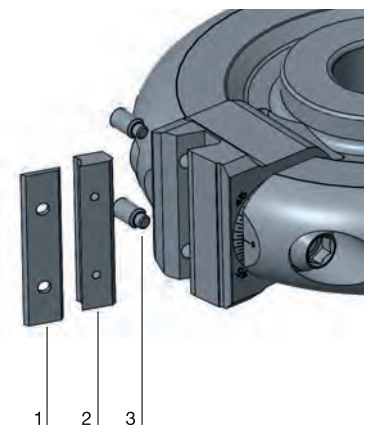
Part-no.	BEZ	ABM mm	ID
2	Clamping wedge with pin	48x10.88x6	009766 ●
3	Allen screw	M6x12	006035 ●
	Allen key	SW 3	005433 ●
	Allen key	SW 8, L 100	005437 ●
	Setting gauge for knives	80x12x9.5	005352 ●



Bevelling from above



Bevelling from below





### Variable angle cutterhead - HeliCut

#### Application:

For jointing and bevelling with adjustable bevel angle.

#### Machine:

Stationary routers with/without CNC control, machining centres.

#### Workpiece material:

Softwood and hardwood, laminated veneer lumber, plastomers, technical foams (XPS, PU), limited suitable for MDF and chipboard (uncoated or coated).

#### Technical information:

Knife holder can be swivelled steplessly on both sides from 0 - 65°. Quick and easy adjustment of conventional angles (15°, 30°, 45°, 60°) due to additional locking positions in 15° steps. Design with divided cutting edges and optimized gullet areas for low-noise working with low cutting pressure even at high cutting performance. Workpiece edges free of tear-out on both sides even in critical materials due to alternating shear angle. Cutting edges with particularly precise geometry and polishing for long tool life and machining of „soft“ materials. Economical due to partially exchangeable solid carbide blades with 4 cutting chamfers.

#### HeliCut, adjustable bevel angle

WP 341 1 01

D	SB	S	DRI	ID
mm	mm	mm		
120	55	25x60	RH	<b>042859 ●</b>
120	55	20x50	RH	<b>042863 □</b>

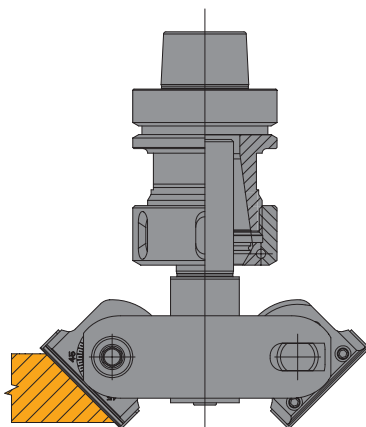
RPM:  $n_{\max} = 11000 \text{ min}^{-1}$

#### Spare knives:

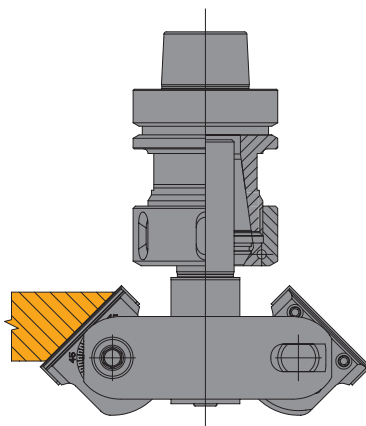
Part-no.	BEZ	ABM	ID
		mm	
1	Turnblade knife	15x15x2.5	<b>009543 ●</b>

#### Spare parts:

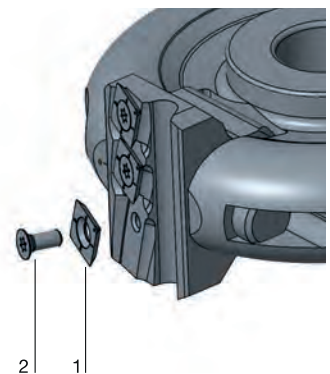
Part-no.	BEZ	ABM	ID
2	Countersink screw, Torx® 20	M5x12	<b>007898 ●</b>
	Torx® key	Torx® 20	<b>006091 ●</b>
	Allen key	SW 8, L 100	<b>005437 ●</b>



Bevelling from above



Bevelling from below





### Variable angle cutterhead - WhisperCut

#### Application:

For jointing and bevelling with adjustable bevel angle.

#### Machine:

Stationary routers with/without CNC control, machining centres.

#### Workpiece material:

Hardwood, chip and fibre board (chipboard, MDF, HDF etc.), plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), solid surface material (Corian, Varicor etc.), fibre reinforced plastics (GRP, CFRP).

#### Technical information:

Knife holder swivelling adjustable from 0 - 65°. Quick and easy angle adjustment of common angles (15°, 30°, 45°, 60°) by additional locking positions in 15° steps. Workpiece edges tear-free on both sides due to alternatinv shear angle. Economical due to partial change of diamond cutting edges. Noice reduced design with optimized gullet design for improved chip removal.

#### WhisperCut, adjustable bevel angle

WP 341 1 01

D	SB	S	DRI	ID
mm	mm	mm		
120	55	25x60	RH	042860 ●
120	55	20x50	RH	042866 □

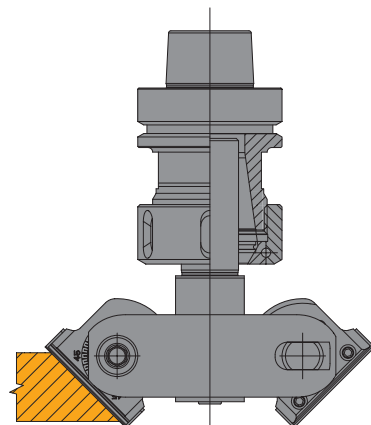
RPM:  $n_{\max} = 11000 \text{ min}^{-1}$

#### Spare knives:

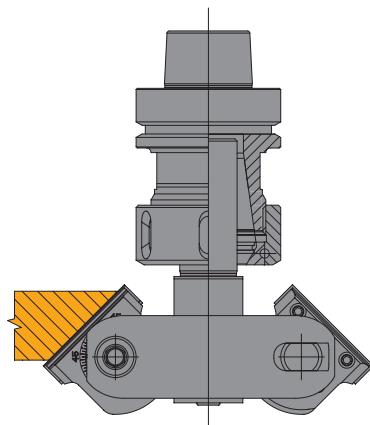
Part-no.	BEZ	ABM	ID
		mm	
1	WhisperCut-knife SB14	14x14.2x4.3	091074 ●

#### Spare parts:

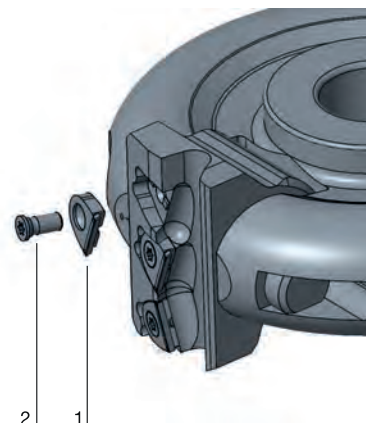
Part-no.	BEZ	ABM	ID
		mm	
2	Countersink screw, Torx®	M5x11.5	007899 ●
	20/59°		
	Torx® key	Torx® 20	006091 ●
	Allen key	SW 8, L 100	005437 ●



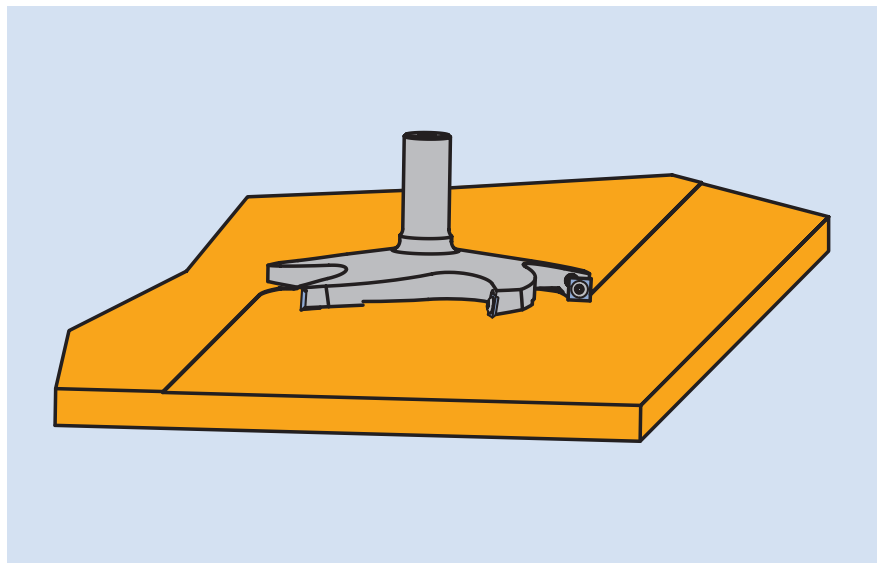
Bevelling from above



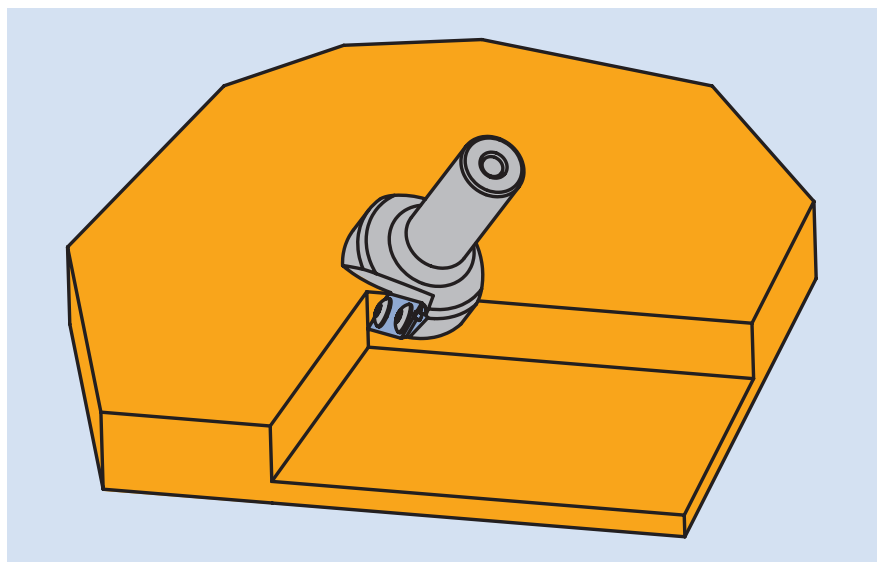
Bevelling from below



<b>Working step/Application</b>	Face milling, finish cutting.
<b>Workpiece material</b> <b>[recommended cutting material]</b>	Softwood and hardwood [HW]. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. [HW, DP]. Duromers [HW, DP]. Plastomers [HW, DP]. Solid surface material (Corian, Varicor etc.) [HW, DP].
<b>Machine</b>	Stationary routers with/without CNC control. Milling machines with spindles to mount shank tools.
<b>Operation</b>	For conventional and climb cut operations, limited chip removal.



Face milling



Finish cutting

#### Application parameters

#### RPM/feed speed

The recommended RPM and feed speeds are detailed in the diagrams next the tool tables.

#### Information

Smooth cutting results can only be achieved with tools having a continuous cutting edge.  
In order to obtain a score-free finish during face milling, the machine spindle must be exactly vertical to the machine table. The larger the diameter of the planing cutter, the higher the risk of scoring and tool marks on the workpiece surface due to angular misalignment.

#### Workpiece clamping

Sufficient workpiece clamping is very important on stationary machines.

Insufficient clamping can reduce both the cut quality and tool life considerably. Panels can be held in place with vacuum clamping, but sometimes additional mechanical clamping is required.

Small and arched workpieces in particular require special jigs or clamping devices which must be made by the customer or sourced from specialist suppliers.





### Planing cutter - turnblade design HeliPlan

#### Application:

For surface planing of large workpieces and for cutting wide rebates in one operation.

#### Machine:

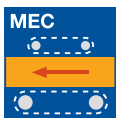
Stationary routers with/without CNC control, machining centres.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.).

#### Technical information:

Cutting edge with shear angle; reversible and replaceable knives. D 135 and D 180 particularly suitable for planing MDF spoilboards in nesting applications. Excellent cutting result through optimized cutting geometry.



#### HW, Z 3, Z 4, Z 5

WL 400 2 01

D	GL	NL	S	Z	$n_{max}$	DRI	ID
mm	mm	mm	mm		$min^{-1}$		
80	90	15	20x50	3	14000	RH	041554 ●
80	100	15	25x60	3	14000	RH	041555 ●
135	90	15	25x60	4	10000	RH	041556 ●
180	90	15	25x60	5	8400	RH	041557 ●

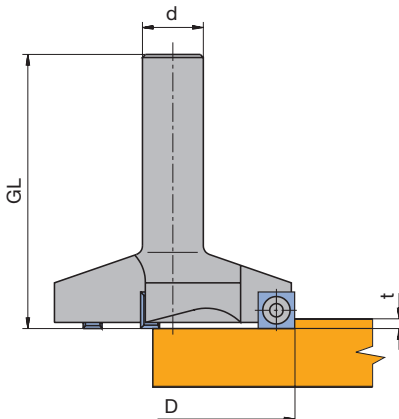
#### Spare knives:

BEZ	ABM	QAL	VE	ID
	mm		PCS	
Turnblade knife	15x15x2.5	HW	10	009535 ●

#### Spare parts:

BEZ	ABM	ID
	mm	
Countersink screw, Torx® 20	M5x9	114049 ●
Torx® key	Torx® 20	006091 ●

Example



$t = 0.5 - 10 \text{ mm}$

Surface planing of MDF spoilboards in nesting applications:

$t = 0.5 - 1.5 \text{ mm}$

ID **041557**  $n = 8400 \text{ min}^{-1}$

$v_f = 25 - 40 \text{ m min}^{-1}$



#### Turnblade finishing cutter, Z 1

##### Application:

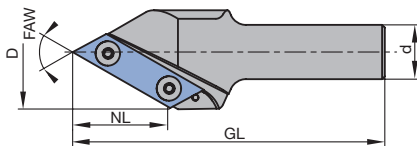
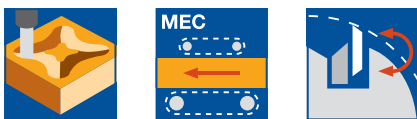
For machining V-groove profiles and for multi-purpose carving operations (decorative groove, 90° corner etc.).

##### Machine:

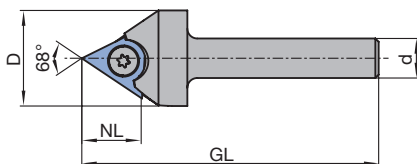
Stationary routers with/without CNC-control, milling machines with spindles to mount shank tools.

##### Workpiece material:

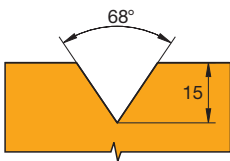
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



V-groove cutter



V-groove cutter 68° (ID 042932)



V-groove cutter in turnblade design with point 68° (ID 042932)

##### Technical information:

Cutterhead with exchangeable turnblades. 2 or 3 (ID 042932) performance times through turning the knife. Extra long design (ID 042937) particularly suitable for carving operations on 5-axes machines.

##### HW, Z 1

WL 300 2

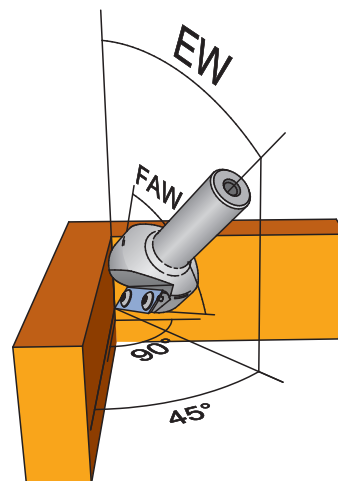
D	GL	NL	S	FAW	Z	P	DRI	ID
mm	mm	mm	mm	°				
29	90	18	12x58	68°	1	1	RH	042932 ●
35	125	42	20x50	45°	1	2	RH	042933 ●
42	115	35	20x50	60°	1	3	RH	042934 ●
42	180	35	20x50	60°	1	3	RH	042937 ●
54	100	27	20x50	90°	1	4	RH	042935 ●
54	100	27	20x50	91°	1	5	RH	042936 ●

##### Spare knives:

BEZ	ABM	P	QAL	ID
	mm			
Turnblade knife triangular	19x19x2	1	HW	009528 ●
Turnblade knife	59x12x1.5	2	HW	602503 ●
Turnblade knife	49x12x1.5	3	HW	602502 ●
Turnblade knife	39x12x1.5	4/5	HW	602501 ●

##### Spare parts:

BEZ	ABM	P	ID
	mm		
Countersink screw, Torx® 20	M5x5	1	007445 ●
Oval head screw Torx® 15	M4x5	2-5	007038 ●
Torx® key	Torx® 20	1	117520 ●
Torx® key	Torx® 15	2-5	005457 ●



Determination of the adjustment angle EW depending on the bevel angle FAW while finish cutting 90° internal corners.

FAW	EW
45°	= 32.77°
60°	= 45.00°
68°	= 52.26°

## 5. Routing

### 5.3 Face milling and finishing 5.3.2 V-groove and finishing cutters



#### DP V-grooving cutter for composite panels

##### Application:

Routers for cutting V-grooves in composite panels for folding works.

##### Machine:

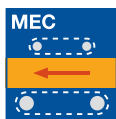
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Composite panels based on thermoplastic cores with aluminium coverage on both sides (e.g. Alucobond®, Dibond® etc.).

##### Technical information:

DP edge with shear angle. Resharpenable 3 to 5 times with normal wear.



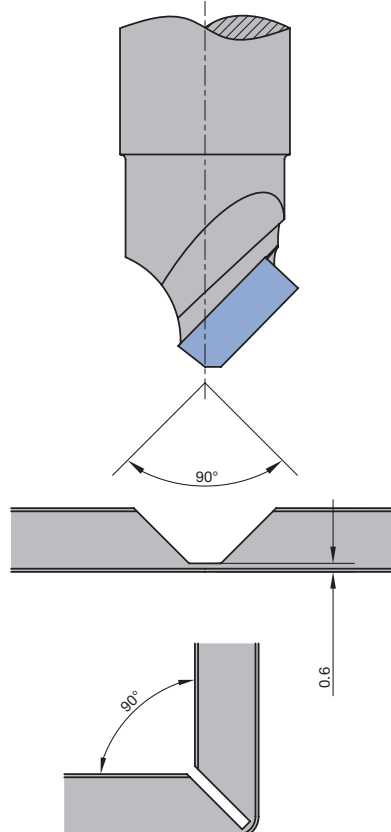
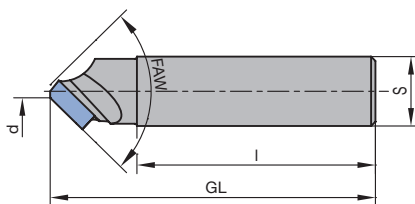
##### DP, Z 1

WO 311 2

D	d	NL	S	FAW	DRI	ID
mm	mm	mm	mm	°		
18	3	7.5	16x55	90°	RH	<b>191100</b>
20	2	3.7	16x55	135°	RH	<b>191106</b>

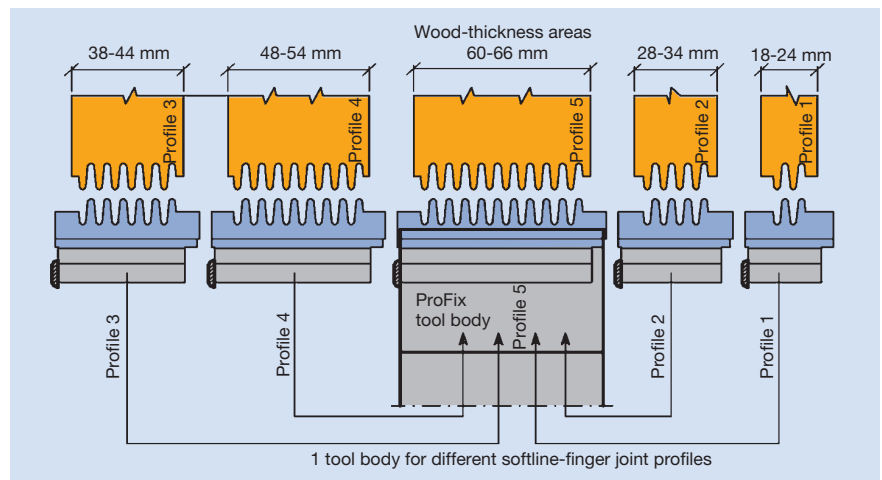
**RPM:**  $n = 18000 - 24000 \text{ min}^{-1}$

##### Application example:



Production of folding corners on composite panels.

ProFix F cutterhead PF 25-15°



#### Working step/Application

For machining self-locking longitudinal joints for exactly measured workpieces, e.g. constructional finger joints, window and door profiles, mitred frames, arched joints, stair, furniture and shelf parts.

#### Cutting material

HS, HW (quality according to machined material).

#### Machine

Stationary routers with/without CNC, milling machines with spindles to mount tools with bore.

#### Tool design

ProFix tool body with bore for mounting on arbors. For ProFix finger joint knives without shear angle and with straight clearance.

#### RPM

$D_0$  = diameter of the tool body

$D_0 = 80 \text{ mm}$ ,  $n_{\text{max}} = 11000 \text{ min}^{-1}$ .

$D_0 = 100 \text{ mm}$ ,  $n_{\text{max}} = 9000 \text{ min}^{-1}$ .

#### Resharpener area

PF 25 = 4.5 mm.

#### Number of teeth/Cutting with

Z 2, SB max. = 80 mm.

#### Feed speed

Depends on the RPM, maximum  $18 \text{ m min}^{-1}$ .

	$f_z [\text{mm}]$
Softwood	0.30 – 0.40
Hardwood	0.40 – 0.50

$$v_f = f_z \cdot n \cdot Z / 1000$$

## 5. Routing

### 5.4 Profiling

#### 5.4.1 Finger joints

##### Technical features

Tool body for resharpenable HS- or HW profile knives. Constant profile/diameter after resharpening. New and resharpened knives are always positioned and clamped at constant diameter by the ProFix clamping system.

- Form and force knife clamping.
- Knife clamping screws positioned behind the cutting edge, and in the dust protected area.
- One tool body can be used for different finger and glue joint profiles of different cutting widths.
- PF 25 with profile depth 25 mm.

##### General information

- Simple and exact knife replacement.
- No setting gauges required.
- Constant profile/diameter (no correction to the machine settings required).
- Ready for use immediately after knife replacement, even on the machine.
- Basic clearance 0.5 mm without side clearance.
- Exact fitting to the workpiece by height adjusting the position of the profile to the middle of the wood (profile symmetry =  $HD/2$ ).



### Profile cutterhead set - multi-purpose glue joint profile

#### Application:

For cutting longitudinal joints for dimensionally stable construction parts, windows and doors e.g. round arched joints, stairs and frame construction parts.

#### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, modified timber for window construction, compound materials of solid wood and wood derived material, uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

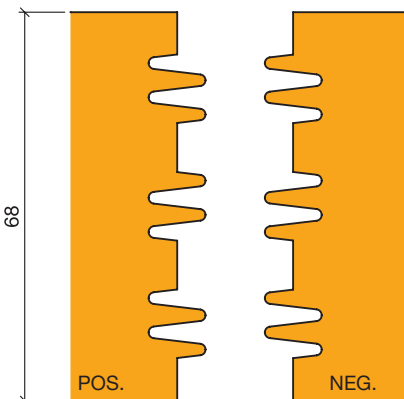
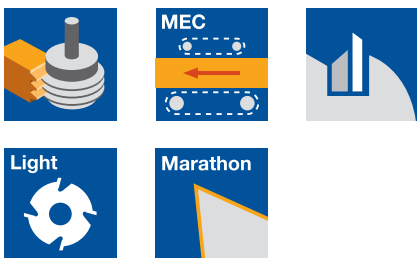
Variable wood thickness (56/56/60/68/78/90/92/106/110 mm) through cutting processes in several passes (profile splitting).

#### ZL 10 mm, HD 56 - 110 mm

SG 599 2 53

Tool Type	DRI	Z	ID
Glue joint cutter set, positive and negative	RH	2	953576 □

RPM:  $n_{\max} = 12700 \text{ min}^{-1}$



Positive and negative glue joint profile, combined in one tool

#### Single tools

WE 600 2 53

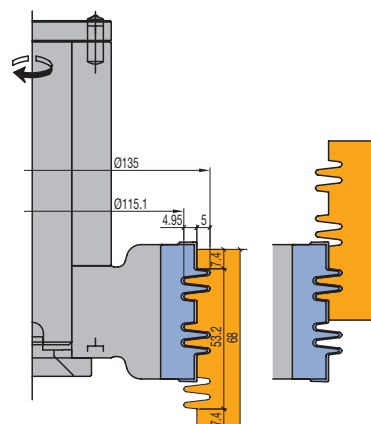
Tool Type	ABM mm	Z	ID
Profile cutterhead	135x53x30	2	414300 ●

#### Spare knives:

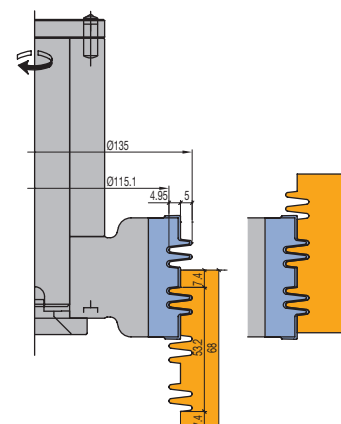
BEZ	ABM mm	QAL	ID
ProfilCut Q knife	53x20.5x2.4	MC	413532

#### Spare parts:

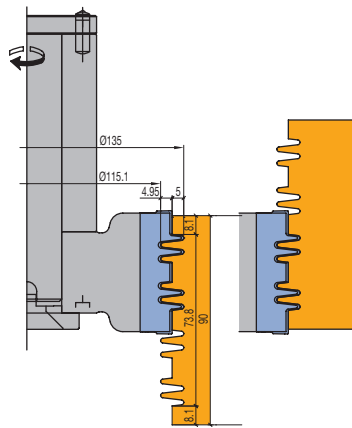
BEZ	ABM mm	ID
Clamping wedge profiled	48x18x8.27	629291
Clamping screw w. disc, Torx® 25	M6x18.5	007442 ●
Torx® key	Torx® 25	117504 ●



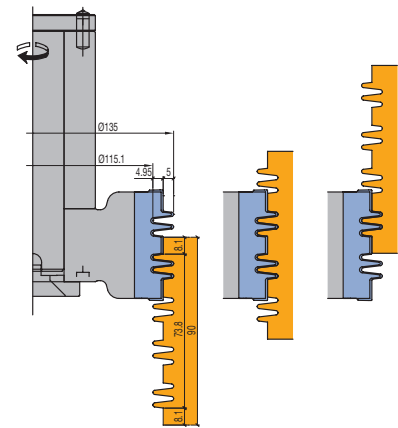
Glue joint profile positive, wood thickness 68 mm



Glue joint profile negative, wood thickness 68 mm



Glue joint profile positive, wood thickness 90 mm



Glue joint profile negative, wood thickness 90 mm

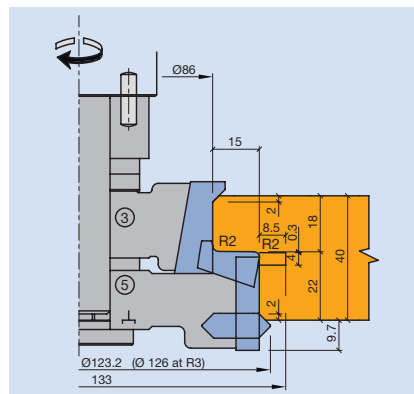


## 5. Routing

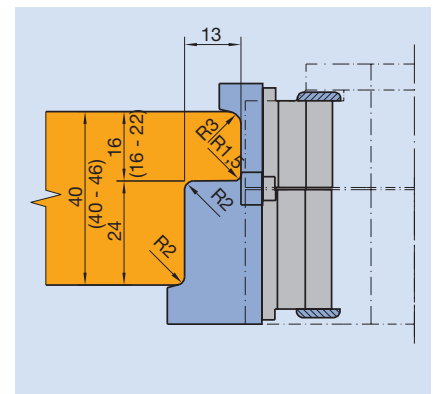
### 5.4 Profiling 5.4.2 Tools for internal doors

<b>Working step/Application</b>	Profiling and rebating of internal doors.
<b>Workpiece material</b>	Softwood, hardwoods glulam, HDF coated or veneered.
<b>Machine</b>	Stationary routers and machining centres.
<b>Profile cutterset for profiling and rebating internal doors Z 2</b>	
<b>Important ordering data</b>	With adjustable cuttersets the depth of the rebate is set by the profile → see profiles below. The same tool can machine doors of different thickness, but the rebate depth is constant.

#### Profile examples



**ID 426093**  
Rebate depth 15 mm  
Rebate width 22 mm  
Turnblade knife tool set



**ID 023538 – P 1**  
Rebate depth 13 mm  
Rebate width 24 mm  
ProFix tool set



#### Profile cutterhead set ProfilCut Q - door processing

##### Application:

For profiling and rebating internal single rebate doors, rebate depth 15 mm.

##### Machine:

Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

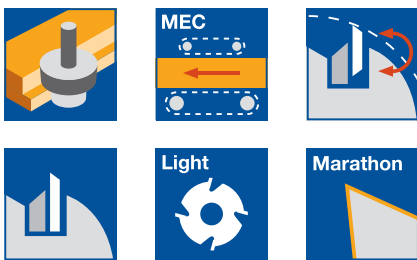
Softwood and hardwood, compound materials of solid wood and wood derived materials, uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Variable profile overlap by exchange profile edging knives.

Adjustable rebate dimensions: rebate width 22 mm, rebate depth 15 mm.

Seal groove profile by mounting grooving knives SB 4 mm. Constant tool diameter.



##### Single rebate 15 mm

SE 540 2 53, SG 599 2 53, WE 500 2 53

Tool Type	ABM mm	Tool no.	Z	ID
Profile cutterhead	104x30x20	3	2	<b>125270</b>
Profile cutterhead	126.2x35x20	5	2	<b>125271</b>
Tooling set with spacers, without arbor	126.2,d20,2-part	3/5	2	<b>126067</b>
Tool set mounted on arbor	D <sub>0</sub> =96;D=126.2; 2-part	3/5	2	<b>426093</b>

**RPM:**  $n_{max} = 13600 \text{ min}^{-1}$

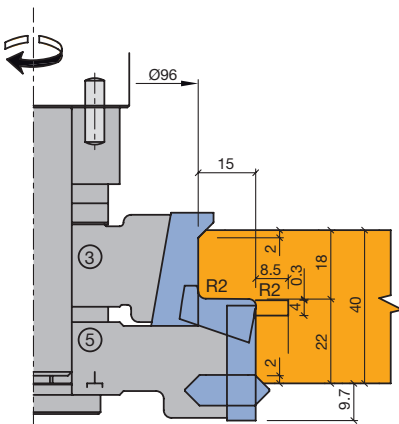
Unless stated otherwise, tools are right hand rotation.

Cutter arbor see section Clamping Systems.

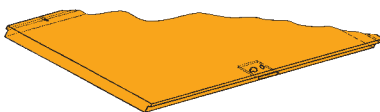
##### Spare knives:

Part- no.	BEZ	ABM mm	Tool no.	R mm	FAW °	QAL	VE PCS	ID
1	ProfilCut Q knife	30.2x14.1x2	3		45°	MC		<b>619334</b>
1	ProfilCut Q knife	30.2x14.2x2	3	1.5		MC		<b>619335</b>
1	ProfilCut Q knife	30.2x14.21x2	3	2		MC		<b>619336</b>
1	ProfilCut Q knife	30.2x14.22x2	3	3		MC		<b>619337</b>
1	ProfilCut Q knife	30.2x15.3x2	3	4		MC		<b>619338</b>
1	ProfilCut Q knife	30.2x15.31x2	3	5		MC		<b>619339</b>
1	ProfilCut Q knife, flute	30.2x14.1x2	3	3		MC		<b>619340</b>
1	ProfilCut Q knife	20.1x12.61x2	5	2		MC		<b>413046</b>
2	Turnblade knife	30x8x1.5	5			HW-05	10	<b>005059</b> ●
3	Edging knife	KM 11/0	5		45°	HW-F		<b>008268</b> ●
4	Turnblade grooving knife	35.2x15x4	5			HW-F		<b>008317</b> ●

NA4



Example



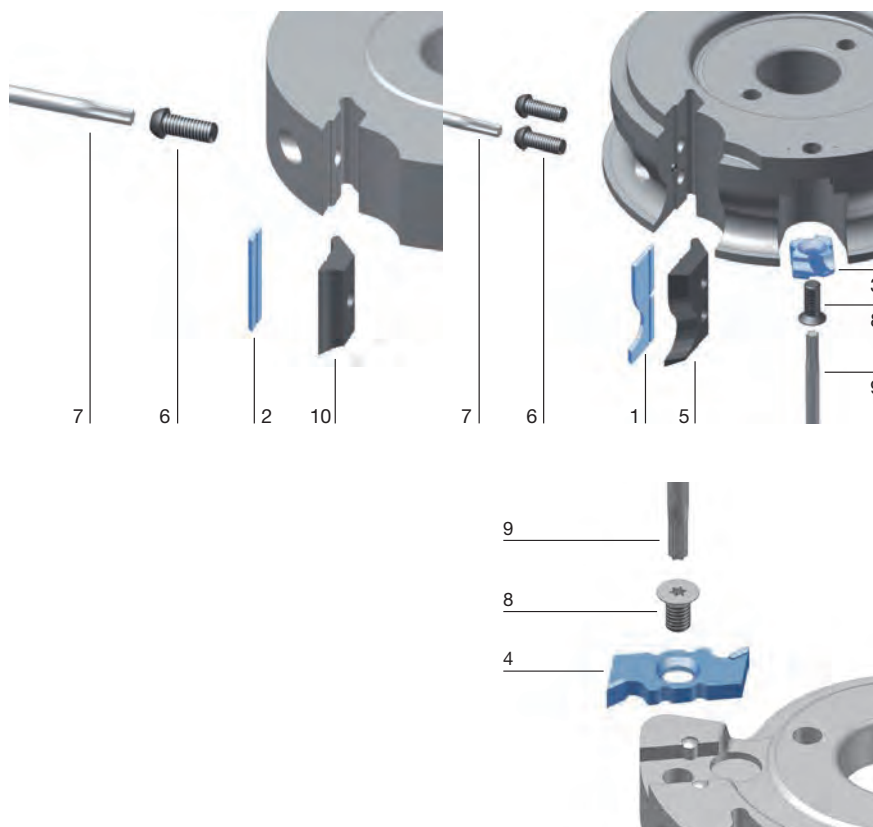
ID **008270** = R 3 ID **008275** = R 3  
ID **008307** = R 2  
ID **008272** = R 1.5



ID **008271** = R 3

#### Spare parts:

Part-no.	BEZ	ABM	Tool no.	ID
		mm		
5	Clamping wedge ProfilCut Q	28x20x8.27	3	629208
5	Clamping wedge profiled	18x24.9x8.27	5	629268
6	Clamping screw w. disc, Torx® 25	M6x18.5		007442 ●
7	Torx® key	Torx® 25		117504 ●
8	Countersink screw, Torx® 20	M6x0.5x4.9		006243 ●
9	Torx® key	Torx® 20		117503 ●
10	Clamping wedge	28x18.75x8.27	5	009673 ●
	Magnetic setting gauge	0.3/0.8		005376 ●



## 5. Routing

### 5.4 Profiling

#### 5.4.3 Tools for furniture and interior construction

**Working step/Application**

Panel raising profiles.

**Workpiece material**

Softwood, hardwood and composite materials (HDF coated or veneered).

**Machine**

Stationary routers and machining centres.

**Panel raising profile  
cutterset Z 2/2**

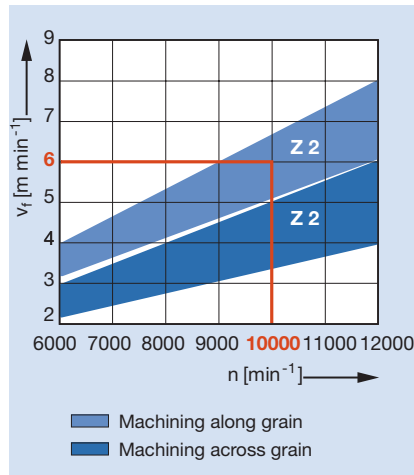
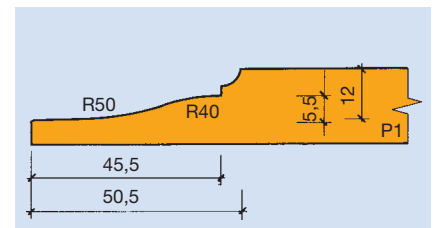
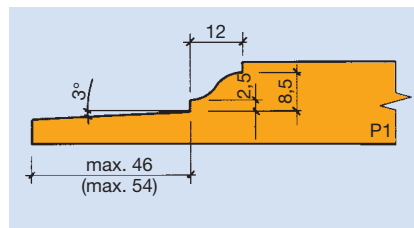


Diagram to determine feed speed  $v_f$  depending on RPM and direction of cut when machining solid wood panels (panel raising).

**Profile examples**





### Profile cutterhead set ProfilCut Q - Panel raising

#### Application:

For panel raising profiles for framed doors, ceilings, wall coverings etc.

#### Machine:

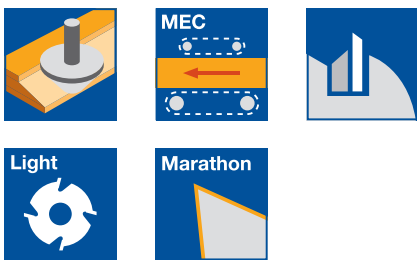
Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Panel edge jointing by mounting an additional jointing cutterhead ID **041221**. Cutterhead with changeable knives and shear angle.



#### Panel raising depth max. 49 mm

SG 599 2 53, TR 811 0, WE 550 2 53

Tool Type	ABM mm	Z	$n_{\max}$ $\text{min}^{-1}$	ID
Cutterhead	132x43x20	2	11600	<b>125273</b>
Cover plate	46x9.5x20			<b>007925</b>
Cutterhead mounted on arbor	1-part			<b>426095</b>

Unless stated otherwise, tools are right hand rotation.

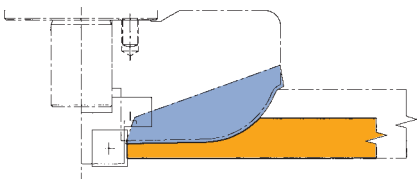
Cutter arbor see section Clamping Systems.

#### Spare knives:

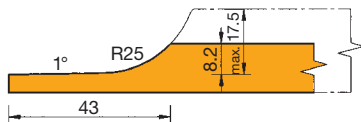
Part-no.	BEZ	ABM mm	QAL	VE PCS	ID
	Turnblade knife	12x12x1.5	HW-05F	10	<b>005081 •</b>
1	ProfilCut Q knife	60x20.47x2	MC		<b>619343</b>

#### Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	57x28.97x7.25	<b>629255</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442 •</b>
4	Torx® key	Torx® 25	<b>117504 •</b>
	Oval head screw Torx® 15	M4x6	<b>006225 •</b>
	Torx® key	Torx® 15	<b>117507 •</b>



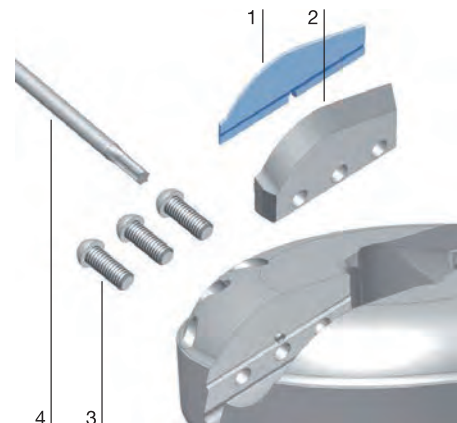
Example



#### Jointing

WW 200 2 NN

Tool Type	ABM mm	QAL	Z	ID
Jointing cutterhead	30/46x12/22.5x20	HW	2	<b>041221</b>





## Profile cutterhead set ProfilCut Q - Panel raising

### Application:

For panel raising profiles for framed doors, ceilings, wall coverings etc.

### Machine:

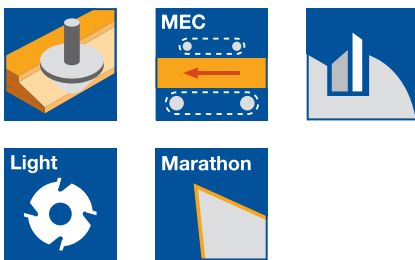
Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

### Workpiece material:

Softwood and hardwood.

### Technical information:

Panel edge jointing by mounting an additional jointing cutterhead ID **041221**. Cutterhead with changeable knives and shear angle. Profile can be changed by replacing the knives.



### Panel raising depth max. 40 / 50 mm with/without jointing

SG 599 2 53, TR 811 0, WE 550 2 53

Tool Type	P	ABM mm	QAL	Z	$n_{\max}$ min <sup>-1</sup>	ID
Cutterhead	1	110x40/40x20	MC	2	13800	<b>125274</b> ●
Cover plate		46x9.5x20				<b>007925</b>
Cutterhead mounted on arbor		1-part	MC			<b>426096</b> □

Unless stated otherwise, tools are right hand rotation.

Cutter arbor see section Clamping Systems.

### Spare knives:

Part-no.	BEZ	P	ABM mm	QAL	VE PCS	ID
1	Turnblade knife		12x12x1.5	HW-05F	10	<b>005081</b> ●
1	ProfilCut Q knife	1	50x14.5x2	MC		<b>619344</b>
1	ProfilCut Q knife	2	50x14.56x2	MC		<b>619345</b>

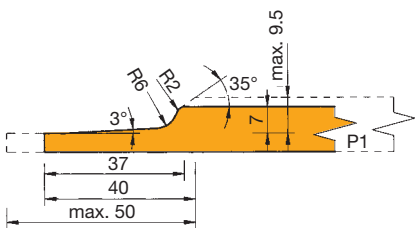
### Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge profiled	47x23x7.25	<b>629256</b>
3	Clamping screw w. disc, Torx® 25	M6x18.5	<b>007442</b> ●
4	Torx® key	Torx® 25	<b>117504</b> ●
	Oval head screw Torx® 15	M4x6	<b>006225</b> ●
	Torx® key	Torx® 15	<b>117507</b> ●

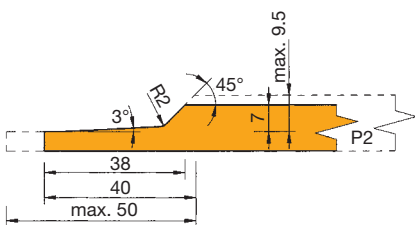
### Jointing

WW 200 2 NN

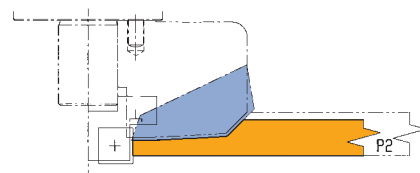
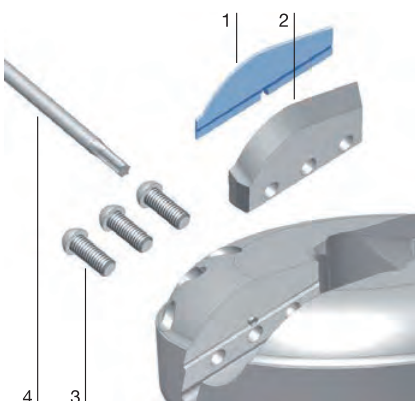
Tool Type	ABM mm	QAL	Z	ID
Jointing cutterhead	30/46x12/22.5x20	HW	2	<b>041221</b>



P1



P2



Example



### Profile cutterhead set ProfilCut Q - Panel raising

#### Application:

For panel raising profiles for framed doors, ceilings, wall coverings etc.

#### Machine:

Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Panel edge jointing by mounting an additional jointing cutterhead ID **041221**. Cutterhead with changeable knives and shear angle. Profile can be changed by replacing the knives.

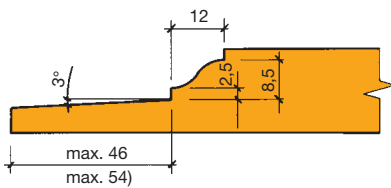
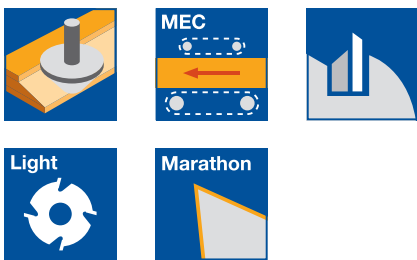
#### Panel raising depth max. 54 mm

SG 599 2 53, TR 811 0, WE 550 2 53

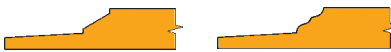
Tool Type	P	ABM mm	QAL	Z	n <sub>max</sub> min <sup>-1</sup>	ID
Cutterhead	1	124x20/36x20	MC	2/2	12300	<b>125275</b>
Cover plate		46x9.5x20				<b>007925</b>
Cutterhead mounted on arbor	1	1-part	MC	2/2	12300	<b>426097</b>

Unless stated otherwise, tools are right hand rotation with profile P1.

Cutter arbor see section Clamping Systems.



P1



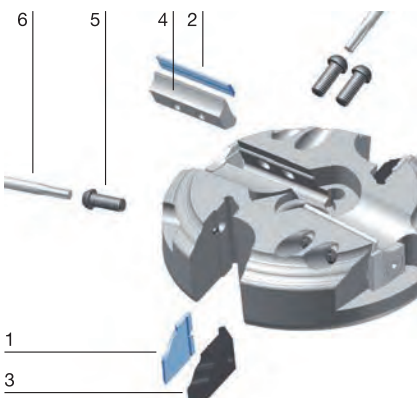
P2

P3



P4

P5



#### Spare knives:

Part-no.	BEZ	P	ABM mm	QAL	VE PCS	ID
	Turnblade knife		12x12x1.5	HW-05F	10	<b>005081 •</b>
1	ProfilCut Q knife	1	20x27x2	MC		<b>619346</b>
1	ProfilCut Q knife	2	20x27x2	MC		<b>619347</b>
1	ProfilCut Q knife	3	20x27x2	MC		<b>619348</b>
1	ProfilCut Q knife	4	20x27x2	MC		<b>619349</b>
1	ProfilCut Q knife	5	20x27x2	MC		<b>619350</b>
2	Turnblade knife		40x8x1.5	HW-30F	10	<b>005074 •</b>

#### Spare parts:

Part-no.	BEZ	P	ABM mm	ID
3	Clamping wedge profiled	1-5	18x37.46x8.27	<b>629257</b>
4	Clamping wedge		37x16.8x7.25	<b>009577 •</b>
5	Clamping screw w. disc, Torx® 25		M6x18.5	<b>007442 •</b>
6	Torx® key		Torx® 25	<b>117504 •</b>
	Oval head screw Torx® 15		M4x6	<b>006225 •</b>
	Torx® key		Torx® 15	<b>117507 •</b>
	Cover plate		46x9.5x20	<b>007925</b>

#### Jointing

WW 200 2 NN

Tool Type	ABM mm	QAL	Z	ID
Jointing cutterhead	30/46x12/22.5x20	HW	2	<b>041221</b>





### Profile cutterhead set ProfilCut Q - Panel raising

#### Application:

For panel raising profiles for framed doors, ceilings, wall coverings etc.

#### Machine:

Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

Panel edge jointing by mounting an additional jointing cutterhead ID **041221**. Cutterhead with changeable knives and shear angle. Profile can be changed by replacing the knives.

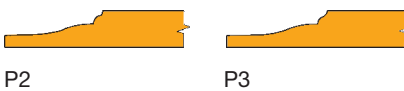
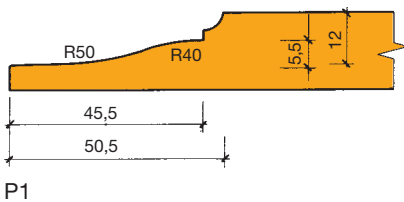
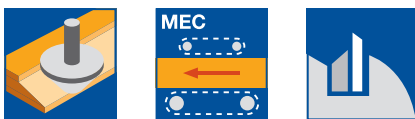
#### Panel raising depth max. 50 mm

SG 599 2 53, TR 811 0, WE 550 2 53

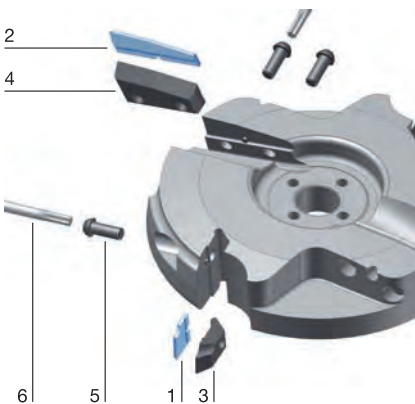
Tool Type	P	ABM mm	QAL	Z	n <sub>max</sub> min <sup>-1</sup>	ID
Cutterhead	1	131x20/36x20	MC	2/2	11600	<b>125276</b>
Cover plate		46x9.5x20				<b>007925</b>
Cutterhead mounted on arbor	1	1-part	MC	2/2	11600	<b>426098</b>

Unless stated otherwise, tools are right hand rotation with profile P1.

Cutter arbor see section Clamping Systems.



Profile examples



#### Spare knives:

Part-no.	BEZ	P	ABM mm	QAL	VE PCS	ID
	Turnblade knife		12x12x1.5	HW-05F	10	<b>005081 •</b>
1	ProfilCut Q knife	1	20x16x2	MC		<b>619351</b>
1	ProfilCut Q knife	2	20x16x2	MC		<b>619352</b>
1	ProfilCut Q knife	3	20x16x2	MC		<b>619353</b>
1	ProfilCut Q knife	4	20x16x2	MC		<b>619354</b>
1	ProfilCut Q knife	5	20x16x2	MC		<b>619355</b>
2	ProfilCut Q knife (pan.raised)		50x11.68x2	MC		<b>619356</b>

#### Spare parts:

Part-no.	BEZ	P	ABM mm	ID
3	Clamping wedge profiled	1-5	18x26.46x8.27 (P1-5)	<b>629258</b>
4	Clamping wedge profiled		47x20.18x7.25 (raised panel)	<b>629259</b>
5	Clamping screw w. disc, Torx® 25		M6x18.5	<b>007442 •</b>
6	Torx® key		Torx® 25	<b>117504 •</b>
	Oval head screw Torx® 15		M4x6	<b>006225 •</b>
	Cover plate		46x9.5x20	<b>007925</b>

#### Jointing

WW 200 2 NN

Tool Type	ABM mm	QAL	Z	ID
Jointing cutterhead	30/46x12/22.5x20	HW	2	<b>041221</b>



### Profile cutterhead set ProfilCut Q - Door frame

#### Application:

For profiles and counter profiles in solid wood frame furniture doors.

#### Machine:

Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood.

#### Technical information:

3 tools with 5 profiles for single side profiled frames and inserted or beaded panels. Additional profiles by remounting the single tools.



#### Frame profile one side, 12 mm tongue

AG 341 2 53, SE 640 2 53

Tool Type	Tool no.	Z	$n_{\max}$ $\text{min}^{-1}$	ID
Profile set	1	2	14500	<b>126068</b>
Counter profile set	2/3	2/2	14500	<b>126069</b>
Tool set profile and counter profile mounted on arbor				<b>426099</b>

#### Frame profile one side, 12 mm rebate

AG 341 2 53, SE 640 2 53

Tool Type	Tool no.	Z	$n_{\max}$ $\text{min}^{-1}$	ID
Profile set	1/3	2/2	14500	<b>126070</b>
Counter profile set	2/4	2/2	14500	<b>126071</b>
Tool set profile and counter profile mounted on arbor				<b>426100</b>

#### Frame profile one side, 6 mm tongue

AG 341 2 53, SE 640 2 53

Tool Type	Tool no.	Z	$n_{\max}$ $\text{min}^{-1}$	ID
Profile set	1/5	2/2	14500	<b>126072</b>
Counter profile set	2/5	2/2	14500	<b>126073</b>
Tool set profile and counter profile mounted on arbor				<b>426101</b>

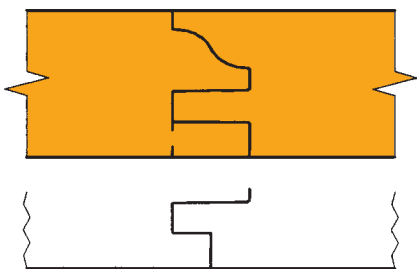
#### Single tools

WE 500 2 53, WW 210 2, WW 410 2 NN

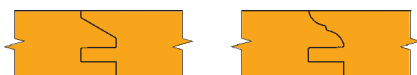
Tool Type	ABM mm	Tool no.	Z	ID
Profile cutterhead	109.1x30x20	1	2	<b>125277</b>
Profile cutterhead	109.0x20x20	2	2	<b>125278</b>
Rebating cutterhead	109.0x15x20	3	Z2/V2	<b>023970</b>
Jointing cutterhead	85x15x20	4	2	<b>023971</b>
Rebating cutterhead	97x15x20	5	Z2/V2	<b>023972</b>

Cutter arbor see section Clamping Systems.

Tools supplied with profile 1 unless ordered otherwise.



P1



P2

P3



P4

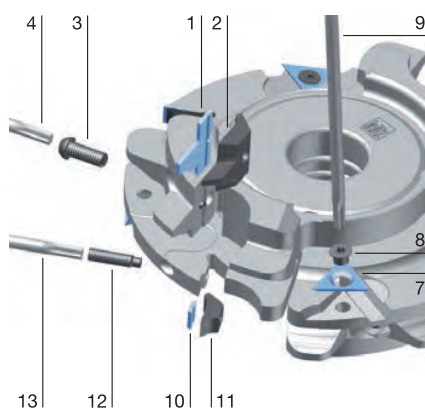
P5

Profile examples

## 5. Routing

## 5.4 Profiling

### 5.4.3 Tools for furniture and interior construction

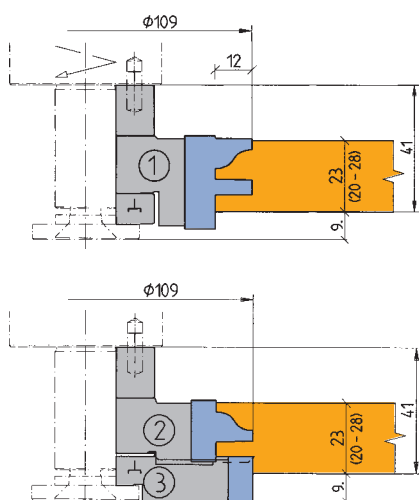
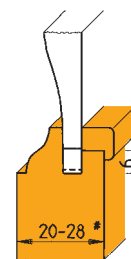
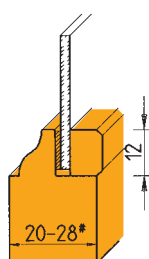
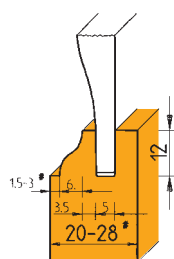


#### Spare knives:

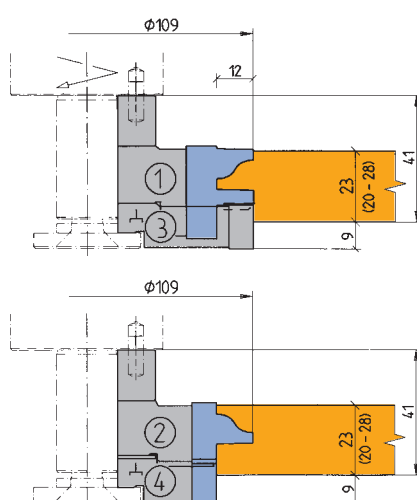
Part-no.	BEZ	ABM mm	P	Tool no.	QAL	VE PCS	ID
1	ProfilCut Q knife	30x23.2x2	1	1	MC		619357
1	ProfilCut Q knife	30x23.2x2	2	1	MC		619358
1	ProfilCut Q knife	30x23.2x2	3	1	MC		619359
1	ProfilCut Q knife	30x23.2x2	4	1	MC		619360
1	ProfilCut Q knife	30x23.2x2	5	1	MC		619361
1	ProfilCut Q knife	20x23x2	1	2	MC		619362
1	ProfilCut Q knife	20x23x2	2	2	MC		619363
1	ProfilCut Q knife	20x23x2	3	2	MC		619364
1	ProfilCut Q knife	20x23x2	4	2	MC		619365
1	ProfilCut Q knife	20x23x2	5	2	MC		619366
7	Turnblade spur VS2	19x19x2		3/5	HW-F	10	005115 ●
10	Turnblade knife	14.7x8x1.5		3-5	HW-30F	10	005070 ●

#### Spare parts:

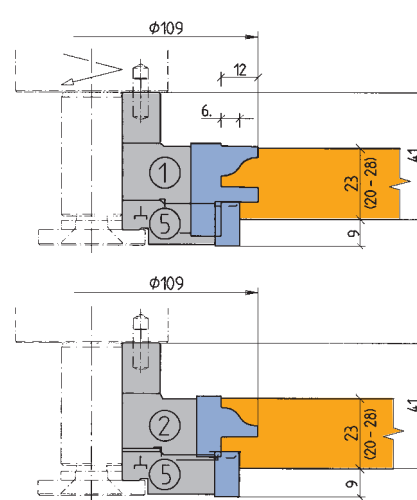
Part-no.	BEZ	ABM mm	P	Tool no.	ID
2	Clamping wedge profiled	28x29x8.27	1-5	1	629260
2	Clamping wedge profiled	18x29x8.27	1-5	2	629261
3	Clamping screw w. disc, Torx®	M6x18.5			007442 ●
4	Torx® key	Torx® 25			117504 ●
8	Countersink screw, Torx® 20	M5x8.5			007808 ●
9	Torx® key	Torx® 20			117503 ●
11	Clamping wedge	13x18.75x8.27		3-5	009670 ●
	Magnetic setting gauge	0.3/0.8			005376 ●



Tongue 12 mm, inserted panel



Rebate 12 mm, beaded panels



Tongue 6 mm, inserted and beaded panels



#### Profile cutterhead set ProfilCut Q - Door frame

##### Application:

For profiles and counter profiles in solid wood frame furniture doors.

##### Machine:

Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

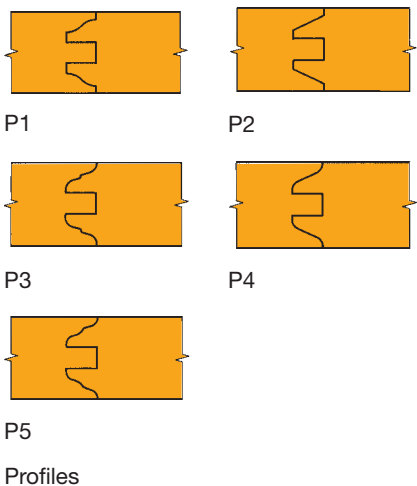
Tools with 5 profiles for double sided profiled frames and inserted or beaded panels. Additional tools available for changing from frames with profiles on both sides to frames with profiles on one side.



##### Frame profile two sides, 15 mm tongue

AG 341 2 53, SE 640 2 53

Tool Type	Tool no.	Z	$n_{\max}$ min <sup>-1</sup>	ID
Profile set	1/2/3	Z2/V2	13200	<b>126074</b>
Counter profile set	1/3	Z2	13200	<b>126075</b>
Tool set profile and counter profile mounted on arbor				<b>426102</b>



##### Frame profile one side, 15 mm rebate

AG 341 2 53, SE 640 2 53

Tool Type	Tool no.	Z	$n_{\max}$ min <sup>-1</sup>	ID
Profile set	3/5	Z2/V2	13200	<b>126076</b>
Counter profile set	1/4	Z2	13200	<b>126077</b>
Tool set profile and counter profile mounted on arbor				<b>426103</b>

##### Frame profile two sides, 15 mm tongue, profile and counter profile

SE 640 2 53, SG 699 2 53

Tool Type	Tool no.	Z	$n_{\max}$ min <sup>-1</sup>	ID
Profile and counter profile set	3/1/2/3	Z2/V2	13200	<b>126078</b>
Tool set profile and counter profile mounted on arbor				<b>426104</b>

##### Additional tool (conversion from tongue 15 mm to rebate 15 mm)

WW 211 2, WW 410 2 NN

Tool Type	Tool no.	Z	$n_{\max}$ min <sup>-1</sup>	ID
Profile	5	Z2/V2	13200	<b>125032</b>
Counter profile	4	2	13200	<b>023085 ●</b>

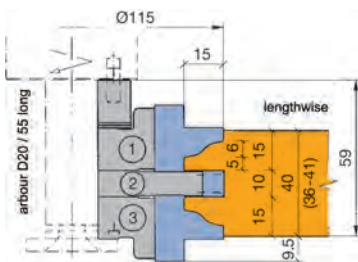
Cutter arbor see section Clamping Systems.

##### Wood thickness:

Frame profile two sides HD 36 - 41 mm

Frame profile one side HD 20 - 49 mm

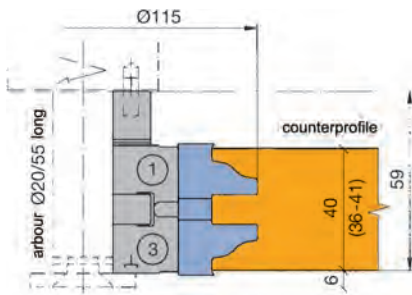
Frame profiled on two sides - longitudinal profile



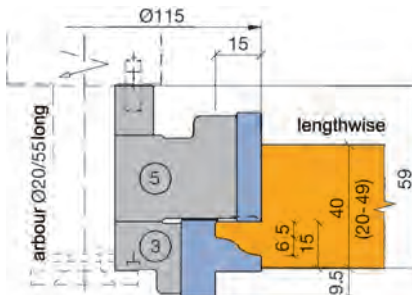
## 5. Routing

### 5.4 Profiling

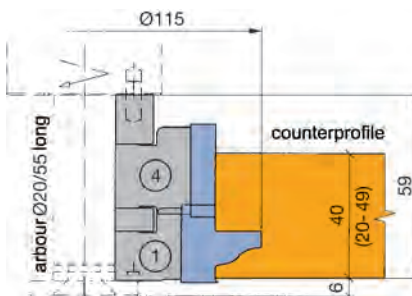
#### 5.4.3 Tools for furniture and interior construction



Frame profiled on two sides - counter profile



Frame profiled on one side - longitudinal profile



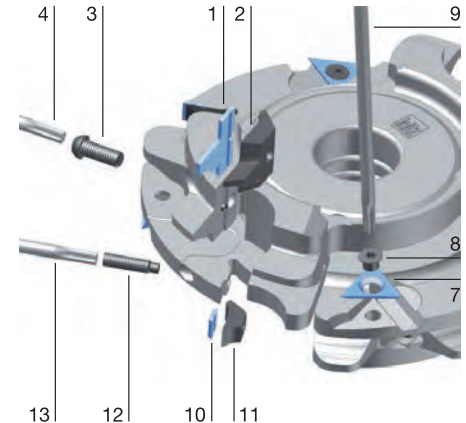
Frame profiled on one side - counter profile

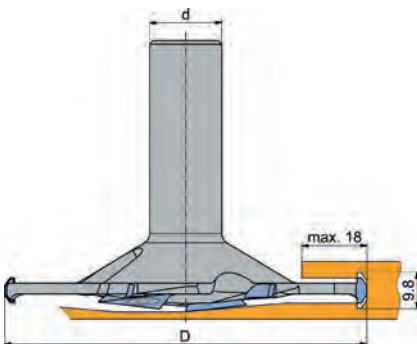
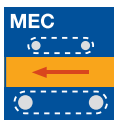
#### Spare knives:

Part-no.	BEZ	ABM mm	P	Tool no.	QAL	VE PCS	ID
1	ProfilCut Q knife	25x27x2	1	3	MC		619291
1	ProfilCut Q knife	25x27x2	2	3	MC		619292
1	ProfilCut Q knife	25x27x2	3	3	MC		619293
1	ProfilCut Q knife	25x27x2	4	3	MC		619294
1	ProfilCut Q knife	25x27x2	5	3	MC		619295
1	ProfilCut Q knife	25x27x2	1	1	MC		619296
1	ProfilCut Q knife	25x27x2	2	1	MC		619297
1	ProfilCut Q knife	25x27x2	3	1	MC		619298
1	ProfilCut Q knife	25x27x2	4	1	MC		619299
1	ProfilCut Q knife	25x27x2	5	1	MC		619300
7	Turnblade spur VS2	19x19x2		2	HW-F	10	005115 ●
10	Turnblade knife	9.7x8x1.5		5	HW-30F	10	005197 ●
10	Turnblade knife	35x8x1.5		4	HW-30F	10	005073 ●
10	Turnblade knife	30x8x1.5		2/5	HW-30F	10	005072 ●

#### Spare parts:

Part-no.	BEZ	ABM mm	Tool no.	ID
2	Clamping wedge profiled	23x30x8.27	3	629237
2	Clamping wedge profiled	23x30x8.27	1	629238
3	Clamping screw w. disc, Torx® 25	M6x18.5		007442 ●
4	Torx® key	Torx® 25		117504 ●
8	Countersink screw, Torx® 20	M6x0.5x4.9		006243 ●
9	Torx® key	Torx® 20		117503 ●
11	Clamping wedge	9x18.75x8.27	2	009764 ●
11	Clamping wedge	28x18.75x8.27	4	009673 ●
11	Clamping wedge	33x18.75x8.27	5	009674 ●
12	Allen screw with shank, Torx® 15	M5x20		007380 ●
13	Torx® key	Torx® 15		117507 ●
	Magnetic setting gauge	0.3/0.8		005376 ●





Profile cutter for Clamex® P-System® connector

#### Profile cutter Lamello® Clamex® P-System®

##### Application:

Router for milling the profile groove for Lamello® Clamex® P-System® connectors on nesting machines made by Holz-Her.

##### Machine:

Routing machines with CNC control, machining centres.

##### Workpiece material:

Chipboard and fibre materials (chipboard, MDF, HF etc.), raw, plastic-coated, veneered etc., glued wood and laminated wood (plywood, Multiplex etc.).

##### Technical information:

Profile and basic cutting edges in PCD, boring edges in reversible knife design with diamond coating. For use exclusively on Holz-Her machines with existing software module (subject to licence). Not resharpenable.

##### Z 2+2 / 1+1

WO 532 2

D mm	GL mm	NL mm	S mm	DRI	ID
100.4	75	7	20x53	RH	<b>191127 ●</b>

**RPM:**  $n_{\max} = 18000 \text{ min}^{-1}$

Drill for access hole D = 6 mm: ID 034116.

##### Spare knives:

BEZ	ABM mm	QAL	ID
Turnblade spur	19x19x2	DP*	<b>006607 ●</b>

DP\* = Diamond coating

##### Spare parts:

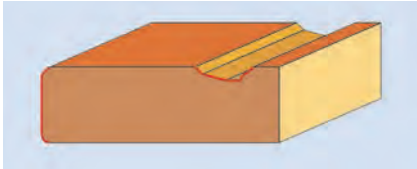
BEZ	ABM mm	ID
Countersink screw Torx® 20	M5x6	<b>114050 ●</b>
Torx® key	Torx® 20	<b>117520 ●</b>



## 5. Routing

### 5.4 Profiling

#### 5.4.4 Tools for multi-purpose profiles

<b>Working step/Application</b>	Profiling (jointing, bevelling, rounding, panel raising and decorative grooves).
<b>Workpiece material [recommended cutting material]</b>	Softwood and hardwood [HS, HW]. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. [HW]. Plywood [HW]. Duromers [HW]. Plastomers [HS, HW]. Solid surface material (Corian, Varicor etc.) [HW]. Decorative laminates (HPL-compact laminate, Trespa etc.) [HW]. Non-ferrous metal (Aluminium, copper etc.) [HS, HW].
<b>Machine</b>	Stationary routers with/without CNC control, CNC machining centres. Milling machines with spindles to mount shank tools.
<b>Operation</b>	For conventional and climb cut operations.
<b>Recommendation</b>	Solid wood along grain: climb cut. Solid wood across grain: conventional cut.
<b>Technical features</b>	Cutterhead with replaceable and shapeable knives or ProfilCut Q system cutterheads for machining panels and decorative grooves.
	
Example	

Application parameters

RPM/feeds

Recommended cutting speeds  $v_c$  and chip load  $f_z$  for multi-purpose cutterheads.

	Cutterhead HS $v_c$ [m/s]	Cutterhead HW $v_c$ [m/s]
Softwood	50 – 80	60 – 90
Hardwood	40 – 60	50 – 80
Chipboard/MDF	–	60 – 80
Plywood	–	60 – 80
Plastic coated board	–	40 – 60

	Cutterhead HS/HW $f_z$ [mm]
Solid wood along grain	0.3 – 0.5
Solid wood across grain	0.25 – 0.35
Chipboard/MDF	0.3 – 0.5
Plywood	0.25 – 0.35

Calculation formula:  $v_f = f_z \cdot n \cdot Z / 1000$

<b>Workpiece clamping</b>	<p>Sufficient workpiece clamping is very important on stationary machines.</p> <p>Insufficient clamping can reduce both the cut quality and tool life considerably. Panels can be held in place with vacuum clamping, but sometimes additional mechanical clamping is required.</p> <p>Small and arched workpieces in particular require special jigs or clamping devices which must be made by the customer or sourced from specialist suppliers.</p>
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#### Profile cutterhead set ProfilCut Q

##### Application:

Multi-purpose tool set for bevelling and rounding, optional jointing of the workpiece edge.

##### Machine:

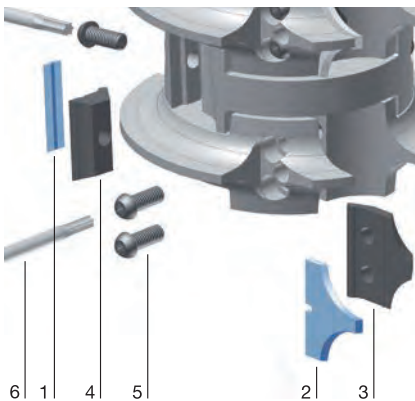
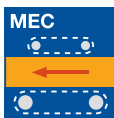
Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

By combining jointing and bevelling or rounding cutterheads several different profiles and wood thicknesses can be covered. Different radii or bevel profile knives can be mounted in one cutterhead.



##### Jointing, rounding or bevelling tool

SG 599 2 53

Tool Type	R mm	BEM	$n_{\max}$ $\text{min}^{-1}$	ID
Rounding		No. of tools 1	12000	<b>426105</b> □
Jointing rounding		No. of tools 2	12000	<b>426106</b> □
Rounding jointing rounding	3-8	No. of tools 3	12000	<b>426107</b> □
Rounding jointing rounding	3-8	No. of tools 3	12000	<b>426108</b> □
	10-15			
Rounding rounding	3-8	No. of tools 2	12000	<b>426109</b> □
	10-15			

##### Spare knives:

Part- no.	BEZ	ABM mm	Tool no.	R mm	FAW °	QAL	VE PCS	ID
1	Turnblade knife	14.7x8x1.5	6			HW-30F	10	<b>005070</b> ●
1	Turnblade knife	19.7x8x1.5	3			HW-30F	10	<b>005071</b> ●
1	Turnblade knife	30x8x1.5	4			HW-30F	10	<b>005072</b> ●
1	Turnblade knife	40x8x1.5	5			HW-30F	10	<b>005074</b> ●
1	Turnblade knife	50x8x1.5	7			HW-30F	10	<b>005075</b> ●
2	ProfilCut Q knife	20x18x2	1	3		MC		<b>619246</b>
2	ProfilCut Q knife	20x18x2	1	4		MC		<b>619247</b>
2	ProfilCut Q knife	20x18x2	1	5		MC		<b>619248</b>
2	ProfilCut Q knife	20x18x2	1	6		MC		<b>619249</b>
2	ProfilCut Q knife	20x18x2	1	7		MC		<b>619250</b>
2	ProfilCut Q knife	20x18x2	1	8		MC		<b>619251</b>
2	ProfilCut Q knife	20x18x2	1	5	45°	MC		<b>619253</b>
2	ProfilCut Q knife	35x25.2x2	2	10		MC		<b>619384</b>
2	ProfilCut Q knife	35x25.2x2	2	11		MC		<b>619385</b>
2	ProfilCut Q knife	35x25.2x2	2	12		MC		<b>619386</b>
2	ProfilCut Q knife	35x25.2x2	2	13		MC		<b>619387</b>
2	ProfilCut Q knife	35x25.2x2	2	14		MC		<b>619388</b>
2	ProfilCut Q knife	35x25.2x2	2	15		MC		<b>619389</b>
2	ProfilCut Q knife	35x25.2x2	2	9	45°	MC		<b>619390</b>

##### Spare parts:

Part- no.	BEZ	ABM mm	Tool no.	ID
3	Clamping wedge	18x22x8.27	1	<b>629231</b>
3	Clamping wedge	33x29x8.27	2	<b>629265</b>
4	Clamping wedge	18x18.75x8.27	3	<b>009671</b> ●
4	Clamping wedge	28x18.75x8.27	4	<b>009673</b> ●
4	Clamping wedge	38x18.75x8.27	5	<b>009675</b> ●
4	Clamping wedge	13x18.75x8.27	6	<b>009670</b> ●
4	Clamping wedge	48x18.75x8.27	7	<b>009677</b> ●
5	Clamping screw w. disc, Torx® 25	M6x18.5		<b>007442</b> ●
6	Torx® key	Torx® 25		<b>117504</b> ●
	Allen key	SW 4		<b>005445</b> ●

Part nos. 1 and 2 - ProfilCut Q and turnblade knives - see detailed information on the following pages.

## 5. Routing

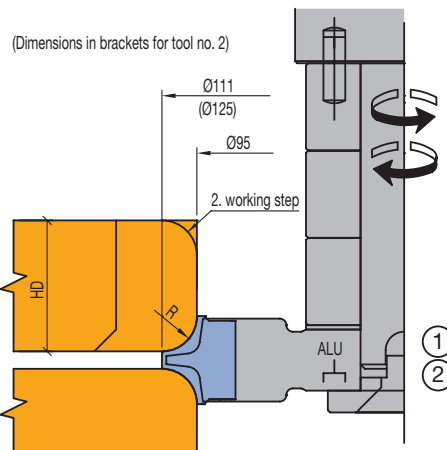
### 5.4 Profiling

#### 5.4.4 Tools for multi-purpose profiles

##### ID. 426105

Order example:

- Combination ID 426105
- Profile description top down RL
- RL R5
- Cutter arbor from Lexicon / Larbor length 70mm / Larbor Ø 20mm



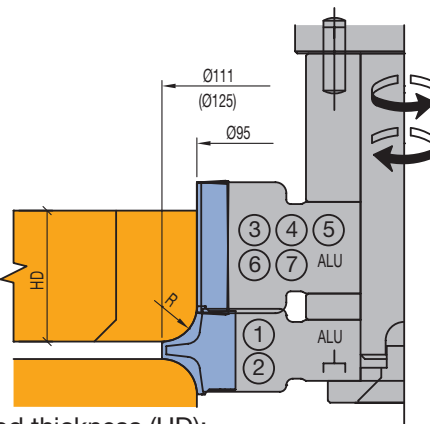
##### Spacers / tool weight

Tool No.	①	②
Spacer "X"	3x20.0 1x1.0	2x20.0 1x5.0 1x1.0
Weight (without cutter arbor)	0.8 kg	1.0 kg

##### ID. 426106

Order example:

- Combination ID 426106
- Profile description top down RL
- jointingSB20/R5
- Cutter arbor from Lexicon / Larbor length 70mm / Larbor Ø 20mm



##### Wood thickness (HD):

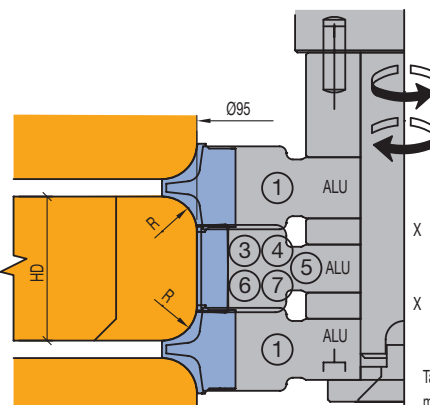
Table value for bevel knives:  $R = 5 (9) \times 45^\circ$

Tool-combination	① ③	① ④	① ⑤	① ⑥	① ⑦	② ③	② ④	② ⑤	② ⑥	② ⑦
max. wood thickness	19 + R	29 + R	39 + R	14 + R	49 + R	19 + R	29 + R	39 + R	14 + R	49 + R
min. wood thickness	-	-	-	-	-	-	-	-	-	-
Spacer set "X"	50.0	40.0	30.0	55.0	20.0	35.0	25.0	15.0	40.0	5.0
Weight (without cutter arbor)	0.9 kg	1.0 kg	1.0 kg	1.1 kg	1.1 kg	1.1 kg	1.1 kg	1.2 kg	1.2 kg	1.2 kg

##### ID. 426107

Order example:

- Combination ID 426107
- Profile description top down RL
- R5/jointingSB20/R5
- Cutter arbor from Lexicon / Larbor length 70mm / Larbor Ø 20mm



At clamping height 75 mm no combination of tool no. ② is possible.

Table value for bevel knives:  
min. wood thickness are with bevel  $5 (9) \times 45^\circ$  calculated

Tool-combination	① ③ ①	① ④ ①	① ⑤ ①	① ⑥ ①	① ⑦ ①
max. wood thickness	17 + R + R	27 + R + R	37 + R + R	13 + R + R	47 + R + R (but max. 57)
min. wood thickness	21	31	41	16	51
Spacer set "X"	2x18.0	2x13.0	2x8.0	2x20.5	2x3.0
Weight (without cutter arbor)	1.0 kg	1.0 kg	1.1 kg	1.1 kg	1.1 kg

## 5. Routing

### 5.4 Profiling

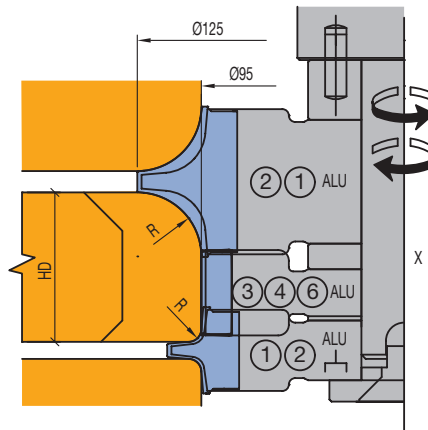
#### 5.4.4 Tools for multi-purpose profiles



#### ID. 426108

Order example:

- Combination ID 426108
- Profile description top down RL
- R12/jointingSB20/R5
- Cutter arbor from Lexicon / Larbor length 70mm / Larbor Ø 20mm



At clamping height 75 mm no combination of tool no. ② and ② or ⑤ and ⑦ is possible.  
For combination no. ① and ① see ID 426107

Tool-combination	① ③ ②	① ④ ②	① ⑥ ②
max. wood thickness	17 + R + R	27 + R + R	13 + R + R
min. wood thickness	28	38	23
Spacer set "X"	2x10.5	2x5.5	2x13.0
Weight (without cutter arbor)	1.2 kg	1.3 kg	1.3 kg

Table value for bevel knives:  
min. wood thickness are with bevel

R = 5 (9) x 45°

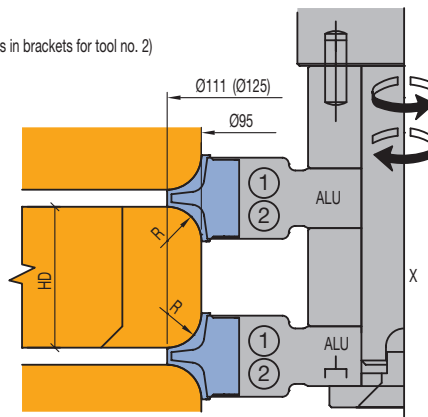
5 (9) x 45° calculated

#### ID. 426109

Order example:

- Combination ID 426109
- Profile description top down RL
- R5/R5
- Cutter arbor from Lexicon / Larbor length 70mm / Larbor Ø 20mm

(Dimensions in brackets for tool no. 2)

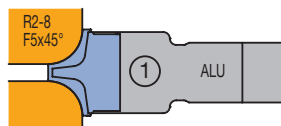


Tool-combination	① ①	② ②	① ②
max. wood thickness	57	41	49
min. wood thickness	R + R but min. 10	R + R but min. 24	R + R but min. 17
Spacer set "X"	47	17	32
Weight (without cutter arbor)	0.9 kg	1.3 kg	1.1 kg

Table value for bevel knives:  
min. wood thickness are with bevel

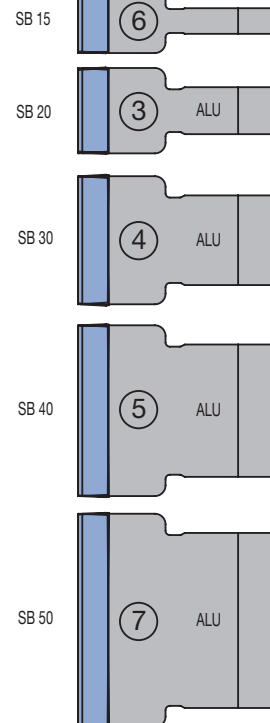
R = 5 (9) x 45°

5 (9) x 45° calculated



Spare part:  
Clamping wedge 629231

WZ 125377 ME 619245	R2	WZ 125282 ME 619249	R6
WZ 125279 ME 619246	R3	WZ 125283 ME 619250	R7
WZ 125280 ME 619247	R4	WZ 125284 ME 619251	R8
WZ 125281 ME 619248	R5	WZ 125285 ME 619253	F5x45°



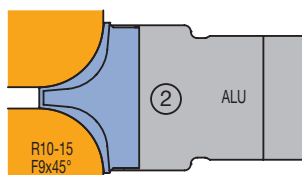
WZ 125302  
ME 5070  
(VE 10 pcs.)  
Wedge 9670

WZ 125299  
ME 5071  
(VE 10 pcs.)  
Wedge 9671

WZ 125300  
ME 5072  
(VE 10 pcs.)  
Wedge 9673

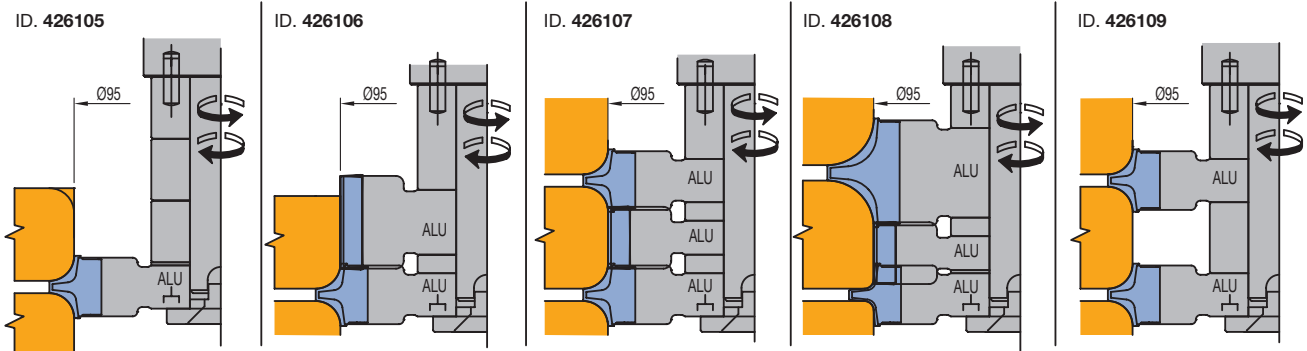
WZ 125301  
ME 5074  
(VE 10 pcs.)  
Wedge 9675

WZ 125303  
ME 5075  
(VE 10 pcs.)  
Wedge 9677



Spare part:  
Clamping wedge 629265

WZ 125286 ME 619384	R10	WZ 125290 ME 619388	R14
WZ 125287 ME 619385	R11	WZ 125291 ME 619389	R15
WZ 125288 ME 619386	R12	WZ 125292 ME 619390	F9x45°
WZ 125289 ME 619387	R13		





### Profile cutterhead - radii / bevel profile

#### Application:

For rounding workpieces with different radii or 45° bevelling.

#### Machine:

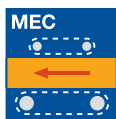
Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.).

#### Technical information:

Multi-purpose use on top or bottom of workpiece up to HD approx. 35 mm. Suitable for cutting narrow internal radii on workpieces. One tool body can be used for radii from 2 to 5 mm and 45° bevels.



#### Cutterhead with set of radius profile knives

AG 740 2

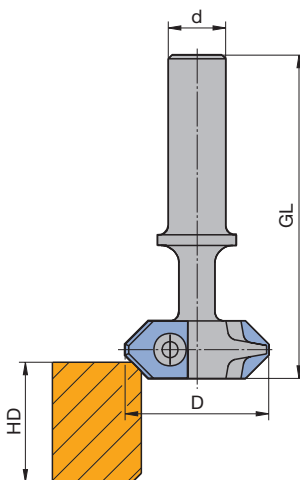
Tool Type	D mm	S mm	Z	DRI	ID
1 tool body + 2 pcs. R2, R3, R4, R5 knives each in wooden box	40	16x60	2	RH	<b>043105 ●</b>

#### Spare knives:

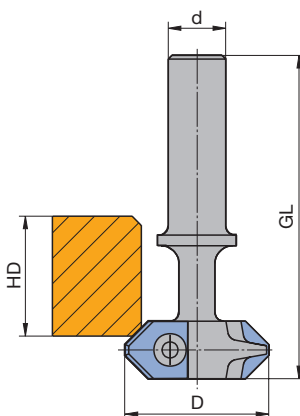
BEZ	ABM mm	QAL	R mm	FAW °	ID
Exchange knife	16x17.5x2	HW	2.0		<b>005132 ●</b>
Exchange knife	16x17.5x2	HW	3.0		<b>005133 ●</b>
Exchange knife	16x17.5x2	HW	4.0		<b>005134 ●</b>
Exchange knife	16x17.5x2	HW	5.0		<b>005135 ●</b>
Exchange knife	16x17.5x2	HW		45°	<b>009525 ●</b>

#### Spare parts:

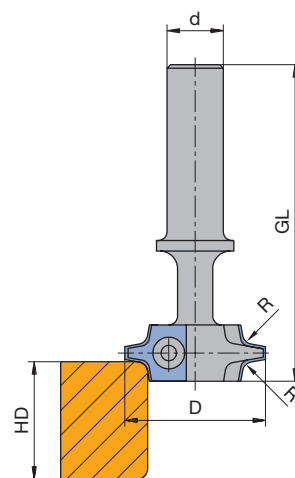
BEZ	ABM mm	ID
Oval head screw Torx® 15	M4x6	<b>006225 ●</b>
Torx® key	Torx® 15	<b>005457 ●</b>



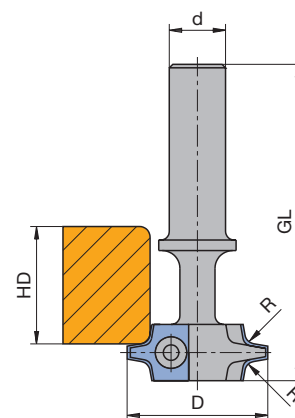
Machining chamfers on the top side of the workpiece



Machining chamfers on the bottom side of the workpiece



Machining radius on the top side of the workpiece



Machining radius on the bottom side of the workpiece



### Multi-purpose profile cutterhead, Z 1

#### Application:

For cutting decorative grooves and internal profiles.

#### Machine:

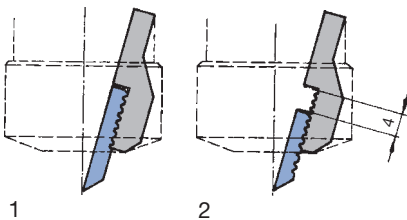
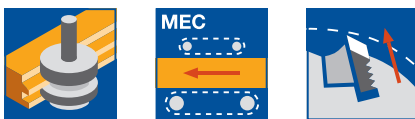
Stationary routers with/without CNC-control, milling machines with spindles to mount shank tools.

#### Workpiece material:

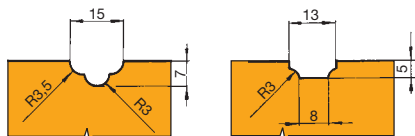
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Cutterhead with resharpenable profile knife. Form fit, play free knife mounting by precise serration. Different profiles in one tool body. Special profiles can be ground into the blank knife on request and available with DP tipping for long performance time in wood derived materials.

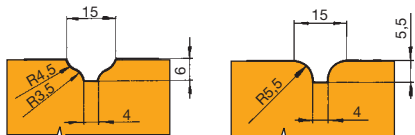


1 = Knife as new  
2 = Maximum adjustment of resharpened knife



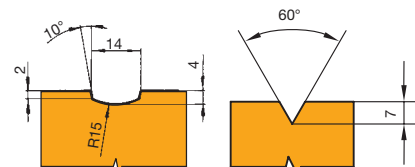
P1

P2



P3

P4



P5

P6

Profile examples

#### For profiles, Z 1, cutting in end grain

WP 500 1

D mm	GL mm	SB mm	S mm	Z	DRI	ID
15	88.5	7	16x50	1	RH	042930 ●

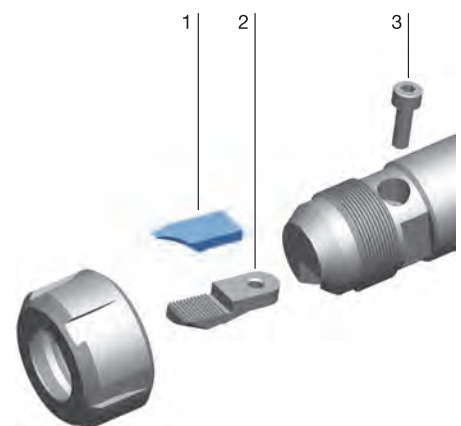
Sales unit consisting of cutterhead with clamping wedge and nut without HW knife blank.

#### Spare knives:

Part-no.	BEZ	P	ABM mm	QAL	ID
1	Profile knife	1	20.7x9x3	HW	006945 ●
1	Profile knife	2	20.7x9x3	HW	006946 ●
1	Profile knife	3	20.7x9x3	HW	006947 ●
1	Profile knife	4	20.7x9x3	HW	006948 ●
1	Profile knife	5	20.7x9x3	HW	006949 ●
1	Profile knife V-groove	6 (60°)	20.7x9x3	HW	006950 ●
1	Back serrated blank		9x21.7x3	HW	007490 ●

#### Spare parts:

Part-no.	BEZ	ABM mm	ID
2	Clamping wedge with back serration	9x27.4x7	009584 ●
3	Cylindrical screw with ISK	M4x16	005847 ●
	Sickle spanner	34/36	005498 ●
	Allen key	SW 3	005433 ●





#### Multi-purpose profile cutterhead, Z 2

##### Application:

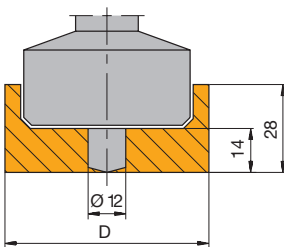
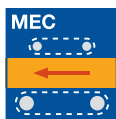
For cutting decorative grooves, internal profiles and combined external and internal profiles.

##### Machine:

Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



Profile area

##### Technical information:

Cutterhead with profiled changeable knives. One knife with centre cutting design. Knives with shear angle. Different profiles possible in one tool body. Special profiles ground into blank knives and backing plates on request. Use cutterhead WP 500 1 for smaller decorative groove profiles ( $d < 15$  mm).

##### For profiles, Z 2, cutting in end grain

WG 502 2 01

D	GL	SB	S	Z	DRI	ID
mm	mm	mm	mm			
65	95	14 - 28	16x50	2	RH	042872 ●
65	95	14 - 28	20x50	2	RH	042873 ●
65	105	14 - 28	25x60	2	RH	042870 ●

Sales unit consisting of cutterhead with clamping wedge but without profiled HW knives and backing plates. Tip with 1 replaceable profile knife and backing plate each, version A and 1 replaceable profile knife and backing plate each, version B.

##### Minimum order quantity:

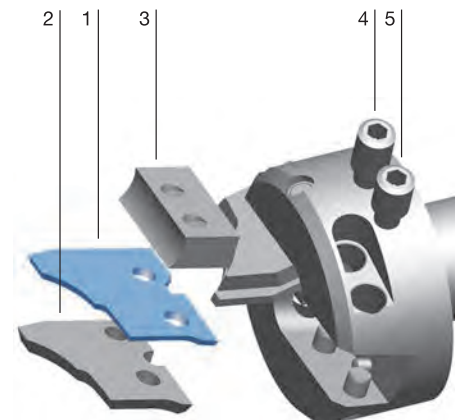
Replaceable profile knife: 6 pcs. each A and B

Backing plates: 1 pc. each A and B

Profile examples see next page.

##### Spare parts:

Part-no.	BEZ	ABM	QAL	ID
		mm		
1	Blank knife	35.5x30.5x2	HW	007488 ●
1	Blank knife	35.5x30.5x2	HW	007489 ●
2	Backing plate A	34x28x4		007923 ●
2	Backing plate B	34x28x4		007924 ●
3	Clamping wedge	25x15x8		009969 ●
4	Allen screw	M8x16		006042 ●
5	Allen screw	M8x14		006073 ●
	Allen key	SW 4		005445 ●





#### Sets of profile knives and backing plates

AT 103 0, AT 199 0

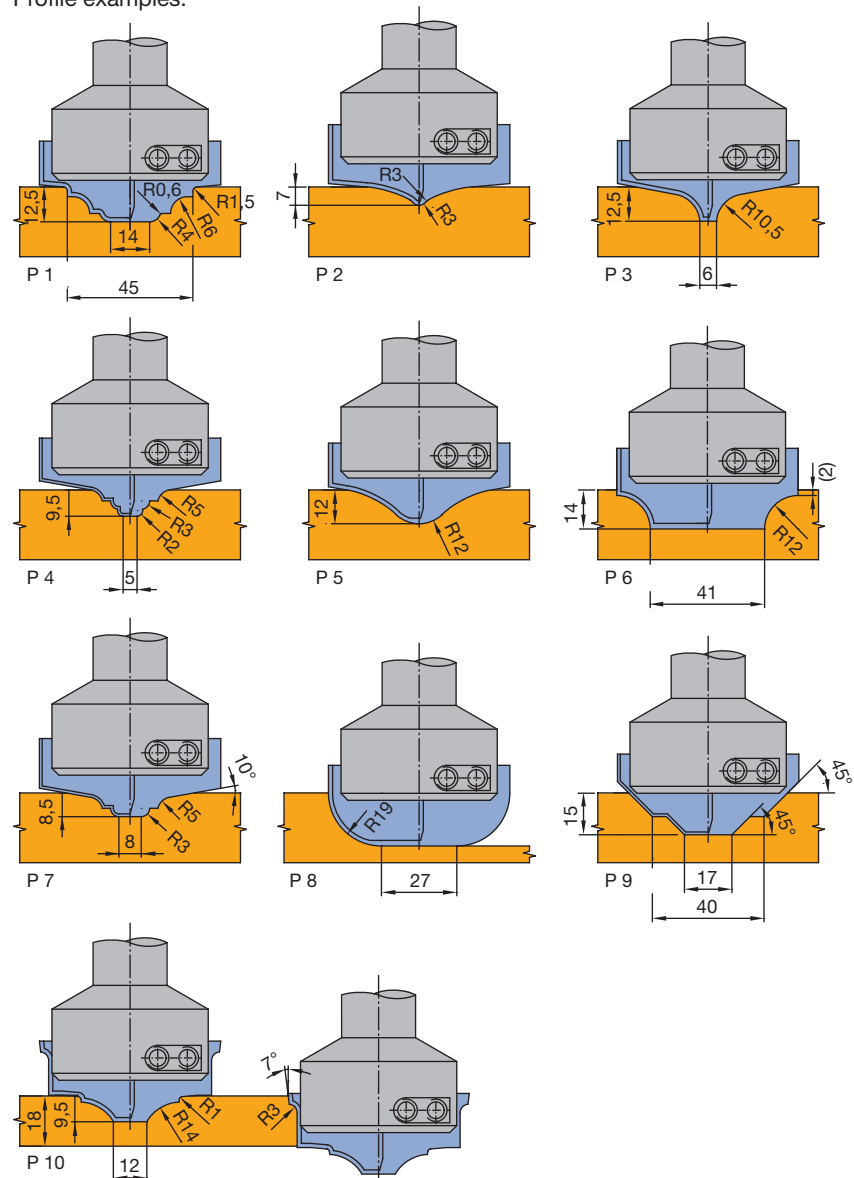
P	ID	ID
	Set of backing plates	Set of profile knives
1	692200 <input type="checkbox"/>	692000 <input type="checkbox"/>
2	692201 <input type="checkbox"/>	692001 <input type="checkbox"/>
3	692202 <input type="checkbox"/>	692002 <input type="checkbox"/>
4	692203 <input type="checkbox"/>	692003 <input type="checkbox"/>
5	692204 <input type="checkbox"/>	692004 <input type="checkbox"/>
6	692205 <input type="checkbox"/>	692005 <input type="checkbox"/>
7	692206 <input type="checkbox"/>	692006 <input type="checkbox"/>
8	692207 <input type="checkbox"/>	692007 <input type="checkbox"/>
9	692208 <input type="checkbox"/>	692008 <input type="checkbox"/>
10	692209 <input type="checkbox"/>	692009 <input type="checkbox"/>

Set of profile knives consisting of 1 profile knife design A and B each.

Set of backing plates consisting of 1 backing plate design A and B each.

Minimum order quantity: set of profile knives: 6 pcs., set of backing plates: 1 pc.

Profile examples:



## 5. Routing

### 5.4 Profiling

#### 5.4.4 Tools for multi-purpose profiles



#### Router cutter - Profildiamaster ball nose

##### Application:

Routers to cut radius profiles in panels for furniture and interior construction.

##### Machine:

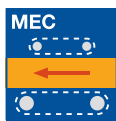
Stationary routers with/without CNC control, machining centres, milling machines with spindles to mount shank tools.

##### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.

##### Technical information:

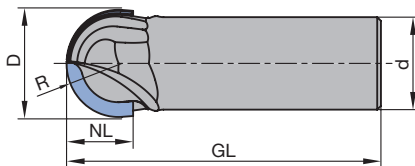
DP profile edges with shear angle. Resharpenable 3 to 5 times with normal wear.



##### DP, Z 2

WO 531 2 51

D	GL	NL	S	R	DRI	ID
mm	mm	mm	mm	mm		
20	75	12	20x55	10	RH	<b>191035</b>
20	80	12	25x60	10	RH	<b>191036</b>
30	80	18	20x55	15	RH	<b>191037</b>
30	85	18	25x60	15	RH	<b>191038</b>
40	90	24	20x55	20	RH	<b>191039</b>
40	95	24	25x60	20	RH	<b>191040</b>

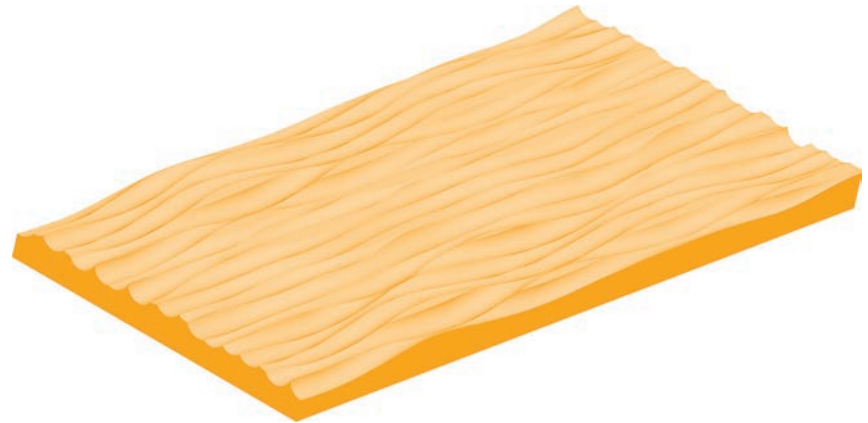


**RPM:** n = 18000 - 24000 min<sup>-1</sup>

Other profiles on request.

##### Application example:

MDF wall covering or MDF furniture part

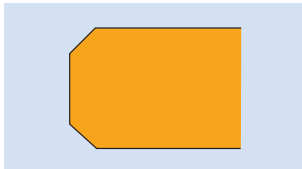


## 5. Routing

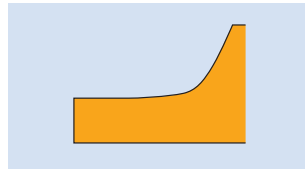
### 5.4 Profiling

#### 5.4.5 Tools for special profiles

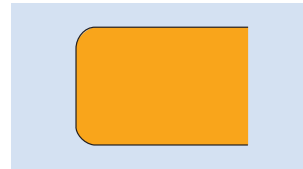
<b>Working step/Application</b>	Profiling.
<b>Workpiece material [recommended cutting material]</b>	Softwood and hardwood [HS, HW]. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. [HW, DP]. Plywood [HW, DP]. Duromers [HW, DP]. Plastomers [HS, HW, DP]. Solid surface material (Corian, Varicor etc.) [HW, DP]. Decorative laminates (HPL-compact laminate, Trespa etc.) [HW, DP]. Non-ferrous metal (Aluminium, copper etc.) [HS, HW, DP].
<b>Machine</b>	Stationary routers with/without CNC control. Milling machines with spindles to mount shank tools.
<b>Operation</b>	For conventional and climb cut operations, limited chip removal.
<b>Technical features</b>	Profile shank cutters can be produced for the following profiles:



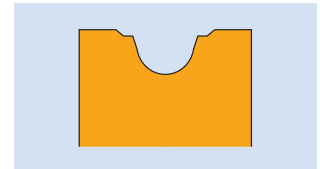
Bevelling



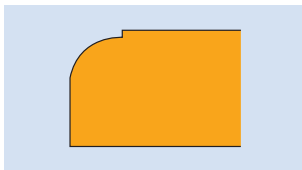
Panel raising



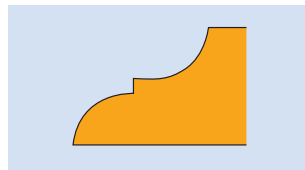
Edges with radii



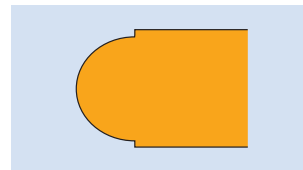
Decorative grooves



Quarter round



Other special profiles



Half round

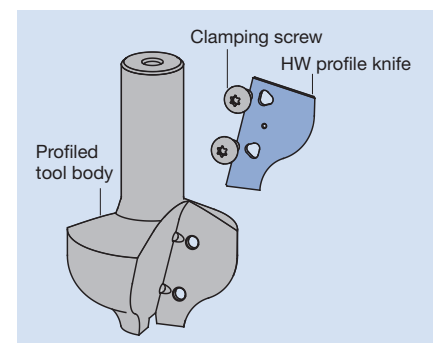
<b>VariForm</b>	Profile cutterhead with shank for blank knives on profiled tool body or blank knives with backing plates
-----------------	--



VariForm profile cutterhead with blank knives and backing plates

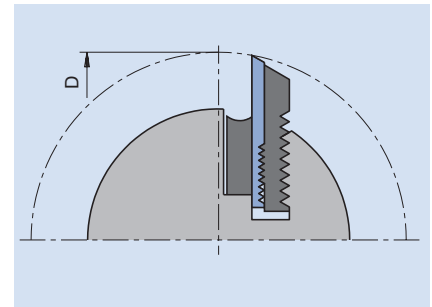
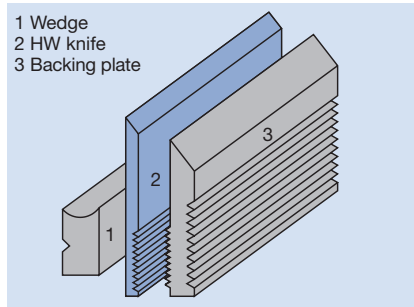
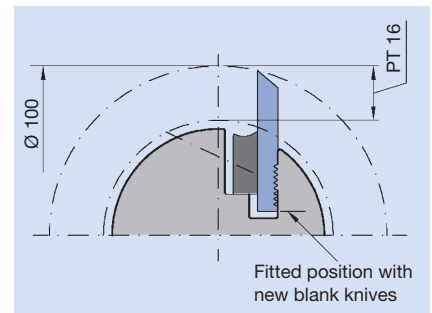
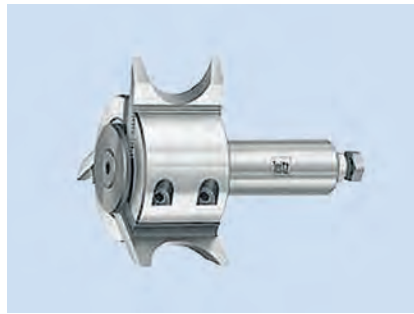


VariForm profile cutterhead with profiled tool body.



Profiling of the knives, backing plates and tool body by Leitz service.

##### Profile cutterhead with shank for serrated back blank knives



Existing profile cutterheads can use the Micro-system set.

##### Tipped profile shank cutter



Tipped profile shank cutters can be supplied in various designs. Available with HS, HW and DP cutting materials and produced to customer requirements. Designs with Z 1 - Z 5, with or without shear angle, Z 1/1 - Z 3/3 with alternate shear angles and with or without plunging tip. Further information available from your nearest Leitz subsidiary or agency.



### Profile cutterhead VariForm with backing plates

#### Application:

For cutting different profiles. Profile can be changed by replacing profile knives and backing plates.

#### Machine:

Stationary routers with/without CNC control, milling machines with spindles to mount shank tools.

#### Workpiece material:

Softwood and hardwood (HW-30F), chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.) (HW-10F).

#### Technical information:

Three point knife clamping for high precision and safety. Economic, resharpenable 3 to 4 times. Modular system: use the same profile knives in different tool bodies on different machines.

#### Tool body, mech. feed, Z 2

TU 531 2

D	TD	SB	S	PT <sub>max</sub>	DRI	ID
mm	mm	mm	mm	mm		
110	76	40/45	25x60	15	RH	<b>135400 ●</b>
110	76	50/60	25x60	15	RH	<b>135401 ●</b>

**RPM:**  $n_{\max} = 12000 \text{ min}^{-1}$

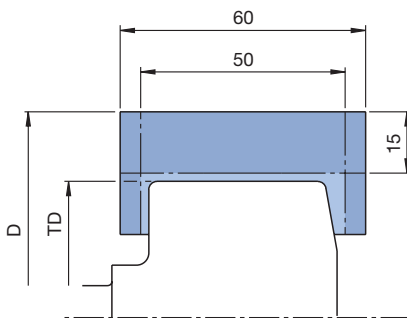
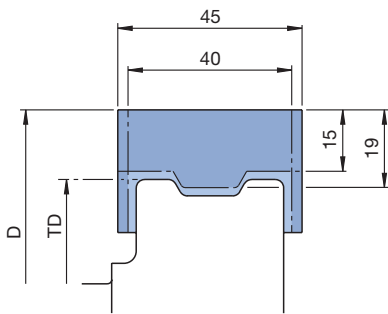
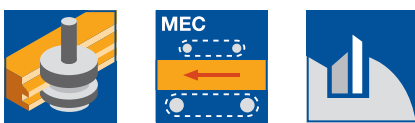
Supplied with clamping wedges, but without backing plates and knives.

#### Spare knives:

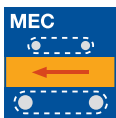
BEZ	H	SB	PT <sub>max</sub>	ID	ID
	mm	mm	mm	HW-10F	HW-30F
Blank knife VariForm	40	40	15	<b>636227 ●</b>	<b>636240 ●</b>
Blank knife VariForm	40	45	15	<b>636231 ●</b>	<b>636244 ●</b>
Blank knife VariForm	40	50	15	<b>636284 ●</b>	<b>636272 ●</b>
Blank knife VariForm	40	60	15	<b>636288 ●</b>	<b>636276 ●</b>

#### Spare parts:

Tool Type	ABM	H	for SB	PT <sub>max</sub>	ID
	mm	mm	mm	mm	
Backing plate	for knives 40x40x2.1	40	40	15	<b>645000 ●</b>
Backing plate	for knives 45x40x2.1	40	45	15	<b>645001 ●</b>
Backing plate	for knives 50x40x2.1	40	50	15	<b>645002 ●</b>
Backing plate	for knives 60x40x2.1	40	60	15	<b>645003 ●</b>
Clamping wedge	36x13.5x26		40/45		<b>009761 ●</b>
Clamping wedge	44x13.5x26		50/60		<b>009762 ●</b>
Allen screw	M10x12				<b>006044 ●</b>
Key	SW 5, L100				<b>117506 ●</b>



Profile area



#### Cutting material recommendation:

	HS	HW-30 F	HW-10 F
Softwood	◆	◆	
Hardwood		◆	◆
Glulam		◇	◆
Chipboard			◆
MDF		◆	◆
Solid surface materials			◆
HPL			◆
◆ suitable			
◇ partly suitable			

### Profile cutterheads for serrated back blank knives

#### Application:

For cutting different profiles.

#### Machine:

Routing machine with/without CNC control, special routers with spindles to hold shank tools.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., gluelam (plywood, etc.).

#### Technical information:

High precision knife clamping through back serrated knives. Wide range of different cutting materials to suit the workpiece material.

#### Z 2

WP 510 2 01

D	TD	SB	GL	S	Z	DRI	n <sub>max</sub>	ID
mm	mm	mm	mm	mm			min <sup>-1</sup>	
100	63	40	108	25x60	2	RH	12000	042898 ●

Sales unit consisting of cutterhead and clamping system, but without knives.

#### Blank knives HS

AT 103 0 28

SB	H	DIK	PT	SET	QAL	ID
mm	mm	mm	mm	PCS		
40	41.5	6	15	2	HS	697545 ●

#### Spare parts:

BEZ	ABM	ID
	mm	
Clamping wedge	39x18.5x7.2	009970 ●
Allen screw	M8x14	006073 ●
Allen key	SW 4, L 71	005468 ●

#### Blank knives / support plates Powerknife System PKS

AT 103 0 35, AT 107 0 35

SB	H	DIK	PT	SET	QAL	ID	ID
mm	mm	mm	mm	PCS		Blank knife	Blank knife + support plate
40	42.5	3	15	2	HW-10F	698006	698106
40	42.5	3	15	2	HW-30F	698001	698101

#### Spare parts:

BEZ	ABM	ID
	mm	
Clamping wedge MS	39x18x6	009771 ●
Allen screw	M8x14	006073 ●
Allen key	SW 4, L 71	005468 ●

<b>Working step/Application</b>	Sizing, jointing, grooving and profiling.														
<b>Workpiece material</b> <b>[recommended cutting material]</b>	Softwood and hardwood [HS, HW]. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. [HW]. Plywood [HW]. Duromers [HW, DP]. Plastomers [HS, HW]. Solid surface material (Corian, Varicor etc.) [HW]. Composite panels (Alucobond®, Dibond® etc.) [HW].														
<b>Machine</b>	Portable routers														
<b>Operation</b>	Conventional cut, limited chip removal.														
<b>Technical features</b>	Tools for portable routers are:  Straight routers: HS solid HW tipped HW solid HW turnblade DP tipped (Only for special applications with known workpieces).  Profile routers: HW tipped DP tipped (Only for special applications with known workpieces).														
<b>Application parameters</b>	<p><b>RPM</b> Recommended RPM for routing and boring tools on portable router machines:</p> <table border="1"> <thead> <tr> <th></th><th>Recommended RPM n [min<sup>-1</sup>]</th></tr> </thead> <tbody> <tr> <td>Dowel drill</td><td>3000 – 9000</td></tr> <tr> <td>Hinge drill</td><td>3000 – 9000</td></tr> <tr> <td>Router cutter with cylindrical shank</td><td>18000 – 30000</td></tr> <tr> <td>Router cutter with internally thread shank</td><td>16000 – 24000</td></tr> <tr> <td>Turnblade router cutter WL 101 1</td><td>16000 – 18000</td></tr> <tr> <td>Profile cutters HW tipped</td><td>18000 – 27000</td></tr> </tbody> </table> <p>The RPM speeds marked on the shank are mandatory.</p>		Recommended RPM n [min <sup>-1</sup> ]	Dowel drill	3000 – 9000	Hinge drill	3000 – 9000	Router cutter with cylindrical shank	18000 – 30000	Router cutter with internally thread shank	16000 – 24000	Turnblade router cutter WL 101 1	16000 – 18000	Profile cutters HW tipped	18000 – 27000
	Recommended RPM n [min <sup>-1</sup> ]														
Dowel drill	3000 – 9000														
Hinge drill	3000 – 9000														
Router cutter with cylindrical shank	18000 – 30000														
Router cutter with internally thread shank	16000 – 24000														
Turnblade router cutter WL 101 1	16000 – 18000														
Profile cutters HW tipped	18000 – 27000														
<b>Feed</b>	The manual feed speed of portable routers depends on the required cut quality and machine load. To ensure proper intended use of portable router bits it is only allowed to machine in conventional cut. Climb cut is not permissible.														
<b>Machining method</b>	Portable routers are usually used either with guide bearings or templates when producing components in batches. Router cutters with guide bearings are suitable for additional machining operations on part finished components. Tools without guide bearings are generally used with either a side stop or a guide rail system.														





#### Grooving cutters, shank 8 mm

##### Application:

Router cutter for sizing and grooving.

##### Machine:

Portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Straight cut, ground on end or with tungsten carbide plunging tip.



##### HW solid, Z 2

WO 120 1 16

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
3	45	6	8x30	HW solid	RH	072612 □
4	45	10	8x30	HW solid	RH	072608 □
5	45	12	8x30	HW solid	RH	072613 □
6	55	14	8x40	HW solid	RH	041984 ●
7	55	17	8x30	HW solid	RH	041958 ●
8	55	20	8x30	HW solid	RH	041985 ●
8	60	30	8x30	HW solid	RH	072650 □

##### HW, Z 2, short version

WO 120 1 09, WO 120 1 10

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
9	55	25	8x30	HW	RH	040304 ●
10	60	20	8x40	HW	RH	040440 ●
10	60	25	8x30	HW	RH	072614 □
11	60	20	8x40	HW	RH	040441 ●
12	60	20	8x40	HW	RH	072368 ●
13	60	20	8x40	HW	RH	072369 ●
14	60	20	8x40	HW	RH	072370 ●
15	60	20	8x40	HW	RH	072371 ●
16	70	20	8x50	HW	RH	072372 ●
18	60	20	8x40	HW	RH	072374 □
19	60	20	8x40	HW	RH	072376 □
20	60	20	8x50	HW	RH	072377 ●
22	60	20	8x50	HW	RH	072379 ●
24	60	20	8x40	HW	RH	072380 ●
25	60	20	8x40	HW	RH	072381 ●
30	60	20	8x40	HW	RH	072382 ●

##### HW, Z 2, long version

WO 120 1 10

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
10	60	30	8x30	HW	RH	072651 □
12	60	30	8x30	HW	RH	072652 □
16	65	30	8x35	HW	RH	072373 ●
18	60	30	8x30	HW	RH	072375 ●
20	60	30	8x30	HW	RH	072378 ●

RPM: n = 18000 - 30000 min<sup>-1</sup>



#### Grooving cutter, shank 12 mm

##### Application:

Router cutter for sizing and grooving. Grooving operation for automatic door seals.

##### Machine:

Portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Straight cut, tungsten carbide plunging tip (only WO 120 1 10). Long version for increased cutting depth (recommended in several steps).



##### HW, Z 2

WO 120 1 01, WO 120 1 10

D mm	GL mm	NL mm	S mm	DRI	ID
10	90	35	12x40	RH	<b>072495</b> ●
12	90	40	12x40	RH	<b>072496</b> ●
13.2	85	35	12x40	RH	<b>072741</b> □
14	85	40	12x40	RH	<b>072104</b> □
14	100	50	12x40	RH	<b>072233</b> ●
15	85	35	12x40	RH	<b>072742</b> □
16	90	45	12x40	RH	<b>072105</b> ●
16	100	60	12x40	RH	<b>072234</b> ●
18	90	45	12x40	RH	<b>072106</b> ●
20	90	45	12x40	RH	<b>072107</b> ●
22	90	45	12x40	RH	<b>072108</b> ●
24	90	45	12x40	RH	<b>072109</b> ●
30	90	35	12x40	RH	<b>072498</b> ●

**RPM:** n = 18000 - 30000 min<sup>-1</sup>

Table for selection of grooving cutter depending on door seal:

Door seal	Width mm	Depth mm	ID
Doppeldicht	12	40	<b>072496</b>
Kältefeind	12	40	<b>072496</b>
Planet HS	13,1	30	<b>072741</b>
Schall-Ex L	14,8	32	<b>072742</b>
Schall-Ex RD	14,8	28	<b>072742</b>
Schall-Ex Ultra	19,7	30	<b>072107</b>

## 5. Routing

### 5.5 Portable routers

#### 5.5.1 Tools for sizing and grooving



#### Grooving cutter with internal threaded shank

##### Application:

Router cutter for sizing and grooving.

##### Machine:

Portable routers. M10: Scheer, M12: DeWalt (former ELU).

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Straight cut, ground on end or tungsten carbide plunging tip.

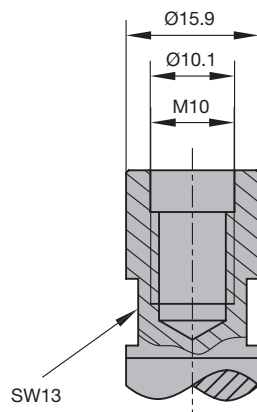


##### HW, Z 2

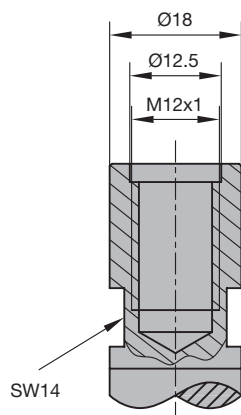
WO 120 1 06, WO 120 1 11, WO 120 1 12

D	GL	NL	S	QAL	DRI	ID
mm	mm	mm	mm			
10	67	35	M10	HW	RH	042050 ●
12	70	40	M12	HW	RH	040082 ●
16	75	45	M12	HW	RH	040084 ●
20	60	25	M12	HW	RH	039942 ●

RPM: n = 16000 - 24000 min<sup>-1</sup>



Threaded shank M10



Threaded shank M12x1



### Spiral grooving cutter HS

**Application:**

Router cutter for sizing and grooving.

**Machine:**

Portable routers.

**Workpiece material:**

Softwood and hardwood. Thermoplastics.

**Technical information:**

HS solid, spiral edges, ground plunging edge.

**HS, Z 2**

WO 160 1

D	GL	NL	S	Z	Twist	DRI	ID
mm	mm	mm	mm				
6	50	21	8x25	2	RD	RH	<b>072766</b> <input type="checkbox"/>
8	50	19	8x30	2	RD	RH	<b>072391</b> <input type="checkbox"/>
10	60	30	8x30	2	RD	RH	<b>072393</b> <input type="checkbox"/>
12	52	20	8x30	2	RD	RH	<b>072185</b> <input type="checkbox"/>
14	52	20	8x30	2	RD	RH	<b>072186</b> <input type="checkbox"/>
16	52	20	8x30	2	RD	RH	<b>072187</b> <input type="checkbox"/>
18	57	25	8x30	2	RD	RH	<b>072188</b> <input type="checkbox"/>
20	57	25	8x30	2	RD	RH	<b>072189</b> <input type="checkbox"/>

RPM: n = 18000 - 30000 min<sup>-1</sup>



### Spiral grooving cutter HW

**Application:**

Router cutter for sizing and grooving.

**Machine:**

Portable routers.

**Workpiece material:**

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.). Thermoplastics. Solid surface material (Corian, Varicor etc.).

**Technical information:**

Solid tungsten carbide, spiral edges, ground plunging edge.

**HW, Z 2**

WO 160 1

D	GL	NL	S	QAL	Z	Twist	DRI	ID
mm	mm	mm	mm					
4	45	10	8x25	HW solid	2	RD	RH	<b>072615</b> <input type="checkbox"/>
6	50	21	8x30	HW solid	2	RD	RH	<b>072759</b> <input type="checkbox"/>
8	55	25	8x30	HW solid	2	RD	RH	<b>072397</b> <input type="checkbox"/>
10	60	30	8x30	HW solid	2	RD	RH	<b>072399</b> <input type="checkbox"/>

RPM: n = 18000 - 30000 min<sup>-1</sup>





### Turnblade router cutter

#### Application:

Router cutter for sizing and grooving to finish quality.

#### Machine:

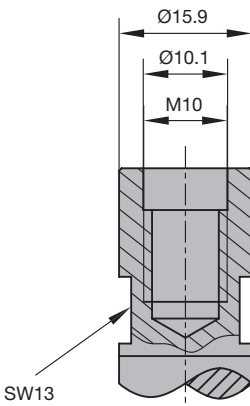
Portable routers. M10: Scheer, M12: DeWalt (former ELU).

#### Workpiece material:

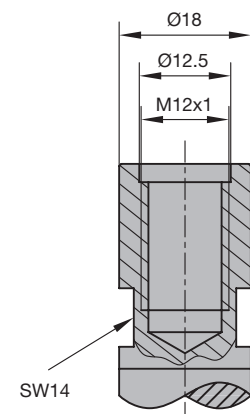
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), duromers, plastomers, solid surface material (Corian, Varicor etc.).

#### Technical information:

Straight cut with tungsten carbide plunging tip. For grooving with constant tool diameter. Knife tip designed for seamless cut. Teflon coated tool body to reduce resin and glue build up.



Threaded shank M10



Threaded shank M12x1

#### HW, Z 1+1, with plunging tip

WL 101 1

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
16	70	30	8x30	RH	<b>071050</b> □
18	70	30	8x30	RH	<b>071051</b> □
20	54	12	8x25	RH	<b>040824</b> ●
16	64	30	M10	RH	<b>040911</b> ●
20	64	30	M10	RH	<b>040915</b> ●
16	64	30	M12x1	RH	<b>040917</b> ●
18	64	30	M12x1	RH	<b>040919</b> ●
20	64	30	M12x1	RH	<b>040921</b> ●

**RPM:** n = 16000 - 18000 min<sup>-1</sup>

#### Spare knives:

BEZ	Knife	ABM	for D	QAL	VE	ID
		mm	mm		PCS	
Turnblade knife	Plunging tip	7.6x12x1.5	16 - 18	HW-05F	10	<b>005080</b> ●
Turnblade knife	Plunging tip	9x12x1.5	20	HW-05F	10	<b>005158</b> ●
Turnblade knife	Peripheral tip	12x12x1.5		HW-05F	10	<b>005081</b> ●
Turnblade knife	Peripheral tip	30x12x1.5		HW-05F	10	<b>005161</b> ●

#### Spare parts:

BEZ	Knife	ABM	for D	ID
		mm	mm	
Screw	Plunging tip	M3.5x4 (head D7)	16 - 20	<b>006068</b> ●
Screw	Peripheral tip	M3.5x4 (head D9)	16 - 20	<b>006226</b> ●
Torx® key		Torx® 15		<b>005457</b> ●

**Turnblade router cutter****Application:**

Router cutter for sizing and grooving to finish quality.

**Machine:**

Portable routers.

**Workpiece material:**

Softwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.

**Technical information:**

Tungsten carbide turnblade knife clamped by wedge. Design without plunging tip only suitable for ramp plunging. Design with plunging tip limited suitable for axial plunging.

**HW, Z 1, with plunging tip**

WL 100 1

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
14	107	45	12x40	RH	<b>041722 ●</b>

**HW, Z 1, without plunging tip**

WL 100 1

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
8	55	20	8x30	RH	<b>041622 ●</b>
10	60	25	8x30	RH	<b>041641 ●</b>
12	66	30	8x30	RH	<b>041665 ●</b>
14	66	30	8x30	RH	<b>041670 ●</b>

**RPM:** n = 16000 - 24000 min<sup>-1</sup>

**Spare knives:**

BEZ	ABM	for D	NL	QAL	VE	ID
	mm	mm	mm		PCS	
Turnblade knife	20x4.1x1.1	8 - 9	20	HW-05	10	<b>005186 ●</b>
Turnblade knife	25x5.5x1.1	10	25	HW-05	10	<b>005188 ●</b>
Turnblade knife	30x5.5x1.1	11 - 24	30	HW-05	10	<b>005189 ●</b>
Turnblade knife	50x5.5x1.1	14	50	HW-05	10	<b>005191 ●</b>

**Spare parts:**

BEZ	ABM	for D	NL	ID
	mm	mm	mm	
Clamping wedge	17.5x5.15x2.8	8 - 9	20	<b>009258 ●</b>
Clamping wedge	22.5x6.54x4	10	25	<b>009260 ●</b>
Clamping wedge	27.5x7.35x3.7	12 - 14	30	<b>009263 ●</b>
Clamping wedge with plunging tip	45x3.7x7.35	14	45	<b>009749 ●</b>
Countersink screw, Torx® 8	M2.5x5.7	8 - 11		<b>006231 ●</b>
Countersink screw, Torx® 8	M3x7.6	12 - 14		<b>006233 ●</b>
Countersink screw, Torx® 15	M4x11.5	16 - 20		<b>006234 ●</b>
Torx® key	Torx® 8, L=40			<b>006092 ●</b>
Torx® key	Torx® 15			<b>005457 ●</b>

## 5. Routing

### 5.5 Portable routers

#### 5.5.1 Tools for sizing and grooving



#### Panel pilot router cutter

##### Application:

Router cutter for edge trimming of protruding veneer or laminates and for plunging and cutting apertures into veneered or laminated panels.

##### Machine:

Portable routers.

##### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., glulam (HPL, CPL etc.).

##### Technical information:

Straight cut with V-point plunging tip.

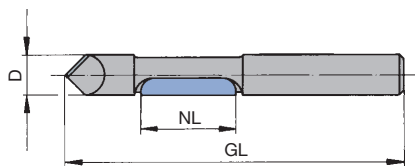


##### HW, Z 1, with guide pin

WO 250 0 01

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
6	65	19	6x27	RH	<b>039610 •</b>
8	65	19	8x30	RH	<b>041586 •</b>

**RPM:** n = 18000 - 30000 min<sup>-1</sup>



Panel pilot router cutter Z 1 with V-point plunging tip





### Grooving cutters

#### Application:

Router cutter for grooving panel edges.

#### Machine:

Portable routers.

#### Workpiece material:

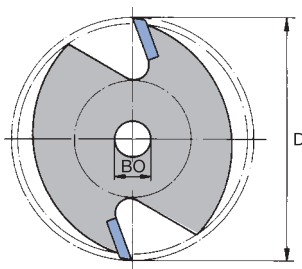
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### HW, Z 2, flat tooth, without arbor

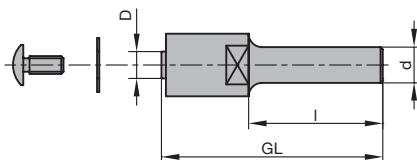
WK 200 3 01

D mm	BO mm	SB mm	ID
40	6	1.5	039644 ●
40	6	1.8	039648 ●
40	6	2	039652 ●
40	6	2.5	039660 ●
40	6	3	039668 ●
40	6	3.5	039672 ●
40	6	4	039676 ●
40	6	5	070653 ●

RPM:  $n = 12000 - 14000 \text{ min}^{-1}$



WK 200 3 01 grooving cutter Z 2



PM 100 0 Arbor

#### Application:

For fixing of grooving cutter WK 200 3 01 without ball bearing guide.

#### Arbor without ball bearing guide ring

PM 100 0

D mm	GL mm	S mm	DRI	ID
6	49	8x30	RH	072772 □

#### Spare parts:

BEZ	ABM mm	ID
Washer	6x12x0.5	116009 ●
Clamping screw, Torx® 15	M4x9	007887 ●
Torx® key	Torx® 15	005457 ●



### Edge trimming cutter

#### Application:

Router for edge trimming or chamfering of protruding veneer, laminates or edgeband materials. Tool guided on the workpiece by ball bearing guide ring.

#### Machine:

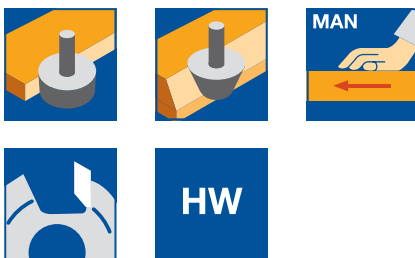
Portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Ball bearing guide ring for use with templates or guided by the workpiece edge.



#### Edge trimming cutter, HW, Z 2 with guide ring

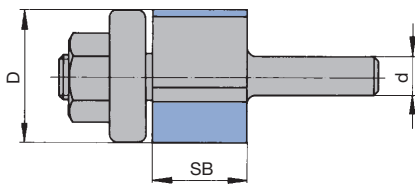
WO 203 1, WO 203 1 01

D	SB	S	BEM	DRI	ID
mm	mm	mm			
21	15	6x30	Guide ring on bottom	RH	039440 ●
12.7	25	8x30	Guide ring on bottom	RH	072509 □
19	25	8x30	Guide ring on shank side	RH	072572 □

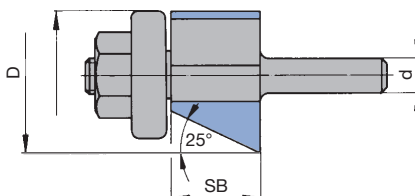
RPM:  $n = 18000 - 27000 \text{ min}^{-1}$

#### Spare parts:

BEZ	BEM	ABM	ID
		mm	
Ball bearing	to ID 072509	12.7x4.97x4.76	008088 ●
Ball bearing	to ID 072572	19.05x12.7x4.97	008105 ●
Ball bearing guide	to ID 039440	21x7.2x15.88	072157 ●



Edge trimming cutter with guide ring on bottom



Square bevel trimming cutter with guide ring on bottom

#### Square bevel trimming cutter, HW, Z 1+1 / bevel 45°

WO 314 1 01

D	D1	SB	S	FAW	DRI	ID
mm	mm	mm	mm	°		
24	18	11	8x30	45°	RH	070477 □

RPM:  $n = 18000 - 27000 \text{ min}^{-1}$

#### Spare parts:

BEZ	BEM	ABM	ID
		mm	
Ball bearing guide	to ID 070477	18x8x15.88	070828 ●



### Turnblade jointing / bevel cutter

#### Application:

Router cutter for edge trimming or bevelling on machines with copy shaping guide ring, side stop or guide rail systems.

#### Machine:

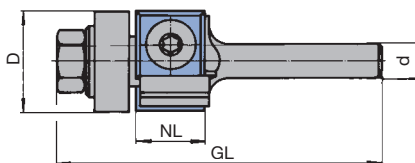
Portable routers.

#### Workpiece material:

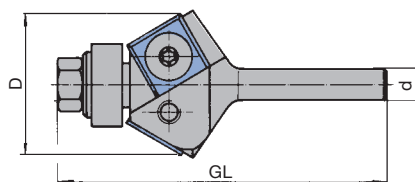
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Tools with ball bearing guide ring for use with templates or guided by the workpiece edge. Replaceable tungsten carbide turnblade knives.



WL 220 1/0°-jointing cutter with guide ring



WL 320 1/30°-bevel cutter with guide ring

#### HW, Z 2, with ball bearing guide ring

WL 220 1, WL 320 1

Class.	D mm	GL mm	NL mm	S mm	FAW °	DRI	ID
WL 220 1	19	52.7	12	8x30	0°	RH	072776 □
WL 220 1	19	64.5	20	8x30	0°	RH	040765 ●
WL 220 1	19	74.5	30	8x30	0°	RH	040774 ●
WL 320 1	27	60		8x30	45°	RH	072767 □

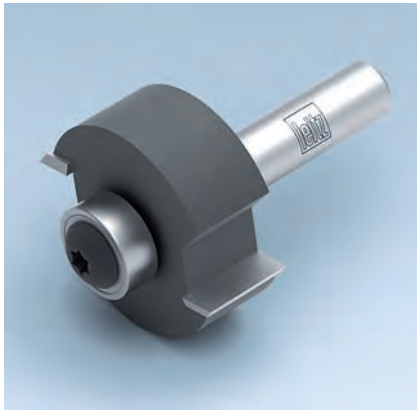
RPM: n = 18000 - 30000 min<sup>-1</sup>

#### Spare knives:

BEZ	Knife	BEM	ABM mm	QAL	VE PCS	ID
Turnblade knife	Peripheral tip	Bevel 45°	12x12x1.5	HW-05F	10	005081 ●
Turnblade knife	Peripheral tip		20x12x1.5	HW-05F	10	005083 ●
Turnblade knife	Peripheral tip		30x12x1.5	HW-05F	10	005084 ●

#### Spare parts:

BEZ	BEM	ABM mm	ID
Ball bearing	D19	19x6x6	008082 ●
Ball bearing	D27/45°	12.7x4.97x4.76	008088 ●
Nut	NL30	M6	005651 ●
Oval head screw Torx® 15	NL12	M4x5	007038 ●
Clamping screw, Torx® 15	NL12/45°	M4x9	007887 ●
Oval head screw Torx® 15	NL20/30	M4x6	006225 ●
Torx® key		Torx® 15	005457 ●



### Rebating cutter

**Application:**  
Router for cutting rebates.

**Machine:**  
Portable routers.

**Workpiece material:**  
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

**Technical information:**  
Straight cut, ball bearing guide ring. Variable rebating width by changing the guide rings.



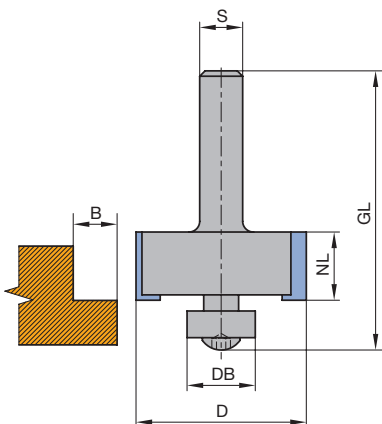
**HW, Z 2**  
WO 434 1

D	DB	GL	NL	S	QAL	DRI	ID
mm	mm	mm	mm	mm			
31.7	12.7	54	12.7	8x30	HW	RH	<b>072479 •</b>

**RPM:** n = 16000 - 22000 min<sup>-1</sup>

#### Spare parts:

BEZ	ABM	B	ID
	mm	mm	
Ball bearing	9.53x3.17x4.76	11	<b>008087 •</b>
Ball bearing	12.7x4.97x4.76	9.5	<b>008088 •</b>
Ball bearing guide	16x8x4.76	7.9	<b>072629 •</b>
Ball bearing guide	19x8x4.76	6.35	<b>072630 •</b>
Ball bearing guide	22x8x4.76	4.9	<b>072631 •</b>
Oval head screw Torx® 15	M4x8		<b>007407 •</b>
Torx® key	Torx® 15		<b>005457 •</b>



#### Note:

Variable rebating widths by changing the guide rings.

DB	9,53	12,7	16	19	22
B	11	9,5	7,9	6,35	4,9



### Turnblade rebating cutter

#### Application:

Router for cutting rebates.

#### Machine:

Portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Straight cut, ball bearing guide ring. Variable rebating width by changing the guide rings.



#### HW, Z 2, with set of ball bearing guide rings

AL 630 1

D	DB	GL	NL	S	QAL	DRI	ID
mm	mm	mm	mm	mm			
38	12.7	54	12.7	8x30	HW	RH	072521 □

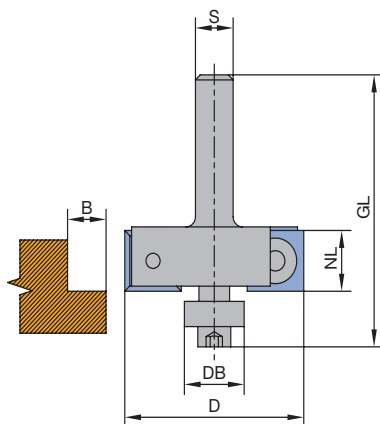
RPM: n = 18000 - 27000 min<sup>-1</sup>

#### Spare knives:

BEZ	ABM	QAL	ID
	mm		
Turnblade knife	12x12x1.5	HW-05F	005081 ●

#### Spare parts:

BEZ	ABM	B	ID
	mm	mm	
Ball bearing	9.53x3.17x4.76	11	008087 ●
Ball bearing	12.7x4.97x4.76	9.5	008088 ●
Ball bearing guide	16x8x4.76	7.9	072629 ●
Ball bearing guide	19x8x4.76	6.35	072630 ●
Ball bearing guide	22x8x4.76	4.9	072631 ●
Oval head screw Torx® 15	M4x8		007407 ●
Oval head screw Torx® 15	M4x6		006225 ●
Torx® key	Torx® 15		005457 ●



DB	9,53	12,7	16	19	22
B	14,2	12,6	11	9,5	8

#### Note:

Set of ball bearing guide rings consists of DB = 9.53 / 12.7 / 16 / 19 and 22 mm



### Quarter round cutter

#### Application:

Router cutter for rounding with template, guide ring, side stop or guide rail system.

#### Machine:

Portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Edges with shear angle, without plunging tip.

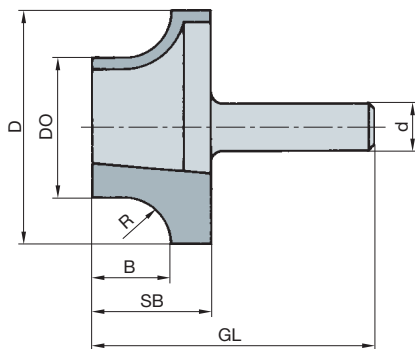


#### Quarter round cutter, HW, Z 2

WO 531 1 01

D	D <sub>0</sub>	SB	GL	S	R	DRI	ID
mm	mm	mm	mm	mm	mm		
17	11	10	41	8x30	3	RH	072429 ●
19	11	11	42	8x30	4	RH	072431 ●
21	11	12	43	8x30	5	RH	072433 ●
23	11	13	44	8x30	6	RH	072435 ●
27	11	15	45	8x30	8	RH	072437 ●

RPM: n = 18000 - 27000 min<sup>-1</sup>



Quarter round cutter Z 2



### Radius cutter

#### Application:

Router cutter for rounding over workpiece edges. Tool guided along workpiece by ball bearing guide.

#### Machine:

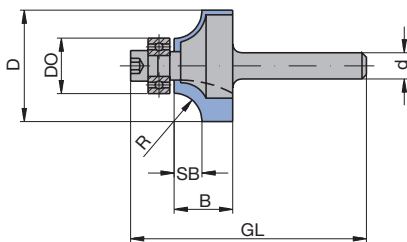
Portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Ball bearing guide ring on bottom for use with templates or guided by the workpiece edge.



Radius cutter

#### Radius cutter, HW, Z 2, shank 6 / 8 mm

WO 551 1

D	D <sub>0</sub>	GL	SB	B	S	R	DRI	ID
mm	mm	mm	mm	mm	mm	mm		
16.7	12.7	49	2	12	6x30	2	RH	072456 ●
18.7	12.7	50	3	7	6x30	3	RH	072458 ●
25.5	12.7	54	6	12	6x30	6.35	RH	072462 ●
17.1	12.7	49	2	12	8x30	2	RH	072636 ●
19.1	12.7	50	3	7	8x30	3	RH	072635 ●
22.7	12.7	52	5	9	8x30	5	RH	072634 ●
28.7	12.7	55	8	12	8x30	8	RH	072632 ●
31.7	12.7	56	9.5	16.5	8x30	9.5	RH	072637 □
42.7	12.7	62	15	22	8x30	15	RH	072639 □

RPM: n = 18000 - 27000 min<sup>-1</sup>

#### Radius cutter, HW, Z 2, shank 12 mm

WO 551 1

D	D <sub>0</sub>	GL	SB	B	S	R	DRI	ID
mm	mm	mm	mm	mm	mm	mm		
63	12.7	80	26	32	12x40	25	RH	072501 ●

RPM: n = 16000 - 22000 min<sup>-1</sup>

#### Spare parts:

BEZ	ABM	ID
	mm	
Ball bearing	12.7x4.97x4.76	008088 ●
Cap screw	M4x10	005846 ●





### Bevel cutter

#### Application:

Router cutter for bevelling workpiece edges. Tool guided along workpiece by ball bearing guide.

#### Machine:

Portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Ball bearing guide ring on bottom for use with templates or guided by the workpiece edge.

#### Bevel cutter, HW, Z 2, shank 8 mm

WO 314 1, WO 315 1

D	D <sub>0</sub>	GL	SB	FAW	S	DRI	ID
mm	mm	mm	mm	°	mm		
25.7	12.7	70	25.1	15°	8x30	RH	<b>072522</b> □
25	12.7	50.3	12	30°	8x30	RH	<b>072774</b> □
38.5	12.7	64.5	23	30°	8x30	RH	<b>072523</b> □
26	12.7	47.8	7	45°	8x30	RH	<b>072775</b> ●

#### Spare parts:

BEZ	ABM	for D <sub>0</sub>	ID
	mm	mm	
Ball bearing	12.7x4.97x4.76	12.7	<b>008088</b> ●
Ball bearing	15.88x5x6.35	15.88	<b>008081</b> ●
Cap screw	M4x10		<b>005846</b> ●

#### Bevel cutter, HW, Z 2, shank 12 mm

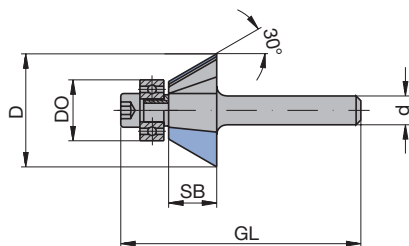
WO 315 1

D	D <sub>0</sub>	GL	SB	FAW	S	DRI	ID
mm	mm	mm	mm	°	mm		
55	12.7	76	20	45°	12x40	RH	<b>072517</b> ●

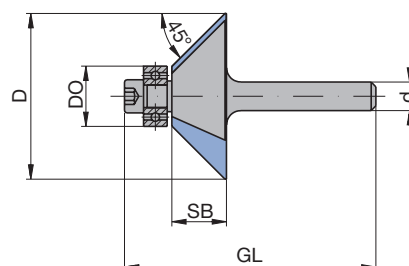
RPM: n = 18000 - 27000 min<sup>-1</sup>

#### Spare parts:

BEZ	ABM	for D <sub>0</sub>	ID
	mm	mm	
Ball bearing	12.7x4.97x4.76	12.7	<b>008088</b> ●
Cap screw	M4x10		<b>005846</b> ●



WO 314 1 02 bevel cutter 30°



WO 314 1 03 bevel cutter 45°



### Guttering mould cutter

#### Application:

Router cutter for cutting draining grooves and for copy shaping.

#### Machine:

Portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

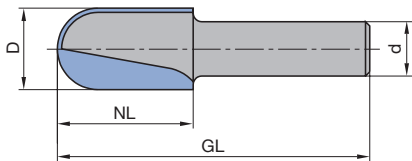
For use with separate guide rings and templates, side stop or guide rail system.



#### Guttering mould cutter, HW, Z 2, shank 8 mm

WO 531 1, WO 531 1 06

D	GL	NL	S	R	DRI	ID
mm	mm	mm	mm	mm		
8	38	8	8x30	4	RH	<b>041153</b> <input type="checkbox"/>
16	65	25	8x30	5	RH	<b>072616</b> <input type="checkbox"/>
12.7	40	10	8x30	6.35	RH	<b>072403</b> <input type="checkbox"/>
16	41	11	8x30	8	RH	<b>072405</b> <input type="checkbox"/>
19.4	41	11	8x30	9.7	RH	<b>072057</b> <input type="checkbox"/>
25.4	44	14	8x30	12.7	RH	<b>072058</b> <input type="checkbox"/>



Guttering mould cutter without guide ring

#### Guttering mould cutter, HW, Z 2, shank 12 mm

WO 531 1

D	GL	NL	S	R	DRI	ID
mm	mm	mm	mm	mm		
30	60	20	12x40	15	RH	<b>072222</b> <input type="checkbox"/>
40	65	25	12x40	20	RH	<b>072239</b> <input type="checkbox"/>

**RPM:** n = 18000 - 27000 min<sup>-1</sup>



#### Guttering mould cutter with guide ring

##### Application:

Router cutter for cutting draining grooves and for copy shaping.

##### Machine:

Portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Ball bearing guide ring on top, for use with templates or guide rail system.



#### Guttering mould cutter, HW, Z 2, with guide ring

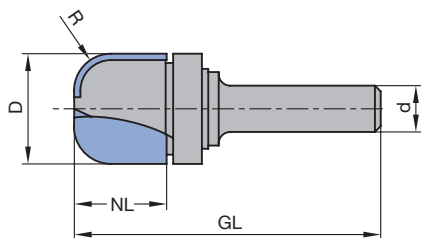
WO 551 1

D	GL	NL	S	R	DRI	ID
mm	mm	mm	mm	mm		
19	53	16	8x30	6.4	RH	<b>072617</b> □

RPM:  $n = 18000 - 27000 \text{ min}^{-1}$

##### Spare parts:

BEZ	ABM	ID
	mm	
Ball bearing	19.05x12.7x4.97	<b>008105</b> ●
Safety washer	12x1 DIN 471	<b>008419</b> ●



Guttering mould cutter with guide ring



### Guttering mould cutter with guide ring

#### Application:

Router for cutting cove moulds.

#### Machine:

Portable routers.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Cutting edges with shear angle, ball bearing guide ring on bottom for use with templates or guide rail system.



#### HW, Z 2

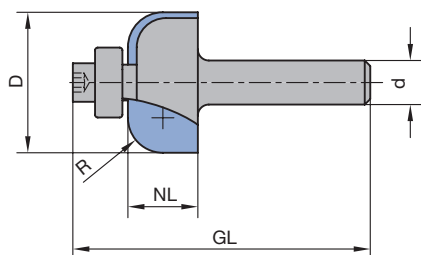
WO 551 1, WO 551 1 02

D	GL	NL	S	R	DRI	ID
mm	mm	mm	mm	mm		
25.5	54	12.7	8x30	6.35	RH	<b>072471</b> □
28.8	56	14	8x30	8	RH	<b>072473</b> □
31.7	56	14.3	8x30	9.5	RH	<b>072475</b> □
38.1	57	16	8x30	12.7	RH	<b>072477</b> □

RPM: n = 18000 - 27000 min<sup>-1</sup>

#### Spare parts:

BEZ	ABM	ID
	mm	
Ball bearing	12.7x4.97x4.76	<b>008088</b> ●
Cap screw	M4x10	<b>005846</b> ●



Guttering mould cutter with guide ring



### Dovetail cutter

#### Application:

Routers for dovetail joints.

#### Machine:

Portable routers.

#### Workpiece material:

Softwood and hardwood, laminated veneer lumber (plywood, multiplex plywood etc.).

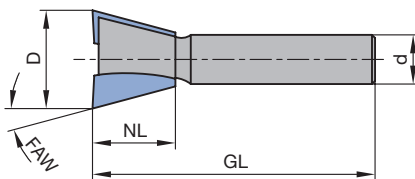
#### Technical information:

Cutting edges with shear angle. Design with spurs for increased cutting quality.

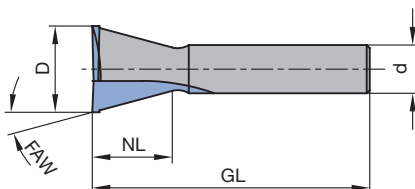
#### HS/HW, Z 2, shank 8 mm, without spurs

WO 610 1, WO 612 1

D mm	GL mm	NL mm	S mm	FAW °	QAL	DRI	ID
13.8	46	13.5	8x30	15°	HS	RH	<b>072757</b> □
20	49	17	8x30	15°	HS	RH	<b>072411</b> □
13.8	46	13.5	8x30	15°	HW	RH	<b>072758</b> □
16	46	13.5	8x30	15°	HW	RH	<b>072045</b> □
20	49	17	8x30	15°	HW	RH	<b>072417</b> □
14.3	50	16	8x30	10°	HW	RH	<b>072585</b> □
20	58	26	8x30	10°	HW	RH	<b>072583</b> □



Dovetail cutter without spurs



Dovetail cutter with spurs

#### HS/HW, Z 2, shank 8 mm, with spurs

WO 612 1

D mm	GL mm	NL mm	S mm	FAW °	QAL	DRI	ID
14.3	46	13.5	8x30	15°	HW	RH	<b>070361</b> □

RPM: n = 18000 - 27000 min<sup>-1</sup>

## 5. Routing

### 5.5 Portable routers 5.5.2 Tools for profiling



#### V-groove / engraving cutter

##### Application:

Routers for cutting V-grooves and engraving.

##### Machine:

Portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Cutting edges with shear angle. Z 1 suitable for fine engraving operations.



##### HS/HW, Z 1

WO 531 1

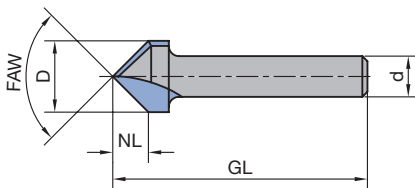
D	GL	NL	S	FAW	QAL	DRI	ID
mm	mm	mm	mm	°			
11	50	9.5	8x30	60°	HW	RH	<b>070562</b> □
11	55	9.5	8x30	60°	HS	RH	<b>070262</b> □

##### HS/HW, Z 2

WO 531 1

D	GL	NL	S	FAW	QAL	DRI	ID
mm	mm	mm	mm	°			
11	50	9.5	8x30	60°	HS	RH	<b>072421</b> □
14	50	7	8x30	90°	HS	RH	<b>072423</b> □
14	50	7	8x30	90°	HW	RH	<b>072425</b> □

**RPM:** n = 18000 - 27000 min<sup>-1</sup>



V-groove / engraving cutter

## 5. Routing

### 5.5 Portable routers 5.5.2 Tools for profiling



#### V-groove cutter for plasterboard

##### Application:

Router for cutting V-grooves in plasterboard for folding.

##### Machine:

Portable routers.

##### Workpiece material:

Plasterboard and gypsum fibre, softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Cutting edges with shear angle, flat point designed for folding.

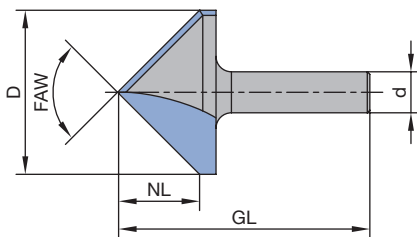


##### HW, Z 1 / Z 2

WO 531 1

D	GL	NL	S	FAW	QAL	Z	DRI	ID
mm	mm	mm	mm	°				
12.5	55	14	8x30	45°	HW	1	RH	<b>072618</b> □
32	49	16	8x30	90°	HW	2	RH	<b>070673</b> □

**RPM:** n = 18000 - 27000 min<sup>-1</sup>



V-groove cutter for plasterboard





### Profile cutter

**Application:**  
Router cutter for profiling.

**Machine:**  
Portable routers.

**Workpiece material:**  
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

**Technical information:**  
Cutting edges with shear angle. With guide ring for guiding along the workpiece edges. Finger pull cutter for cutting a covered grip rail on furniture fronts.



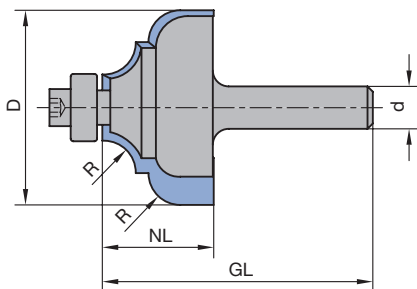
#### HW, Z 2, profile cutter, with guide ring

WO 551 1

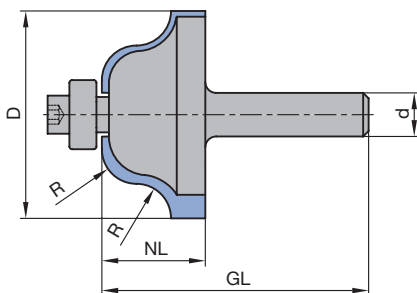
D	GL	NL	S	R	DRI	ID
mm	mm	mm	mm	mm		
36.7	61	21	8x30	6	RH	072511 □

#### Spare parts:

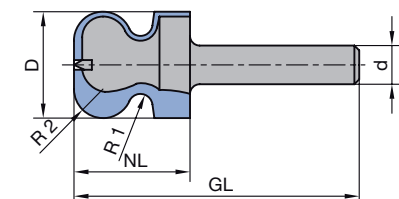
BEZ	ABM	ID
	mm	
Ball bearing	12.7x4.97x4.76	008088 ●
Cap screw	M4x10	005846 ●



Profile cutter with guide ring WO 551 1



Double radius cutter with guide ring WO 531 1



Finger pull cutter WO 532 1

#### HW, Z 2, double radius cutter, with guide ring

WO 551 1

D	GL	NL	S	R	DRI	ID
mm	mm	mm	mm	mm		
31.7	53	13	8x30	4	RH	072481 □
38.1	59	19	8x30	6.35	RH	072483 □

#### Spare parts:

BEZ	ABM	ID
	mm	
Ball bearing	12.7x4.97x4.76	008088 ●
Cap screw	M4x10	005846 ●

#### HW, Z 2, finger pull cutter

WO 532 1

D	GL	NL	S	R1	R2	DRI	ID
mm	mm	mm	mm	mm	mm		
22	59	16	8x30	2.5	6	RH	072624 □

**RPM:** n = 18000 - 27000 min<sup>-1</sup>

## 5. Routing

### 5.5 Portable routers 5.5.2 Tools for profiling



#### T-groove cutter

##### Application:

Router for cutting T-grooves and keyholes.

##### Machine:

Portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Straight cut.

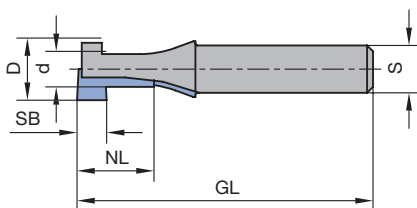


##### HW, Z 1

WO 120 1

D	d	SB	GL	NL	S	QAL	DRI	ID
mm	mm	mm	mm	mm	mm			
10.5	6.5	5	50	13	8x30	HW	RH	072526 □

RPM: n = 18000 - 27000 min<sup>-1</sup>



T-groove cutter

## 5. Routing

### 5.5 Portable routers 5.5.2 Tools for profiling



#### Glue joint cutter

**Application:**

Routers for cutting glue joint profiles.

**Machine:**

Portable routers.

**Workpiece material:**

Softwood and hardwood, laminated veneer lumber (plywood, multiplex plywood etc.).

**Technical information:**

Straight cut. Guide by side stop or guide rail system.

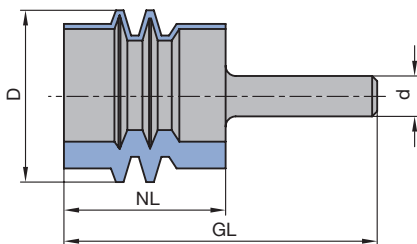
**HW, Z 2**

WO 631 1



D	GL	NL	HD	S	QAL	DRI	ID
mm	mm	mm	mm	mm			
34	62	32	30	8x30	HW	RH	072197 □

**RPM:** n = 18000 - 27000 min<sup>-1</sup>



Glue joint cutter

**Spiral grooving cutter****Application:**

Router for sizing and grooving.

**Machine:**

Portable routers.

**Workpiece material:**

Solid surface material (Corian, Varicor etc.).

**Technical information:**

Solid tungsten carbide design, spiral-shaped edges, ground plunging edge.

**HW, Z 2, spiral roughing/finishing cutter**

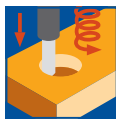
WO 160 2 04

D mm	GL mm	NL mm	S mm	Twist	DRI	ID
12	87	42	12x40	LD	RH	<b>072707</b> □

**HW, Z 2, spiral finishing cutter**

WO 160 2 05

D mm	GL mm	NL mm	S mm	Twist	DRI	ID
10	70	25	10x40	RD	RH	<b>042458</b> ●
12	70	25	12x40	RD	RH	<b>042758</b> ●
12	87	42	12x40	RD	RH	<b>072705</b> □

RPM: n = 18000 - 27000 min<sup>-1</sup>**Turnblade grooving cutter****Application:**

Router cutter for sizing and grooving.

**Machine:**

Portable routers.

**Workpiece material:**

Solid surface material (Corian, Varicor etc.).

**Technical information:**

Straight cut. Design with plunging tip limited suitable for axial plunging.

**HW, Z 1, with plunging tip**

WL 100 1

D mm	GL mm	NL mm	S mm	DRI	ID
14	107	45	12x40	RH	<b>041722</b> ●

RPM: n = 16000 - 24000 min<sup>-1</sup>**Spare knives:**

BEZ	ABM mm	NL mm	QAL	VE PCS	ID
Turnblade knife	50x5.5x1.1	50	HW-05	10	<b>005191</b> ●

**Spare parts:**

BEZ	ABM mm	ID
Clamping wedge with plunging tip	45x3.7x7.35	<b>009749</b> ●
Countersink screw, Torx® 8	M3x7.6	<b>006233</b> ●



#### Edge trimming cutter with guide ring

##### Application:

Router for trimming protrusions of glued solid surface material construction parts.

##### Machine:

Portable routers.

##### Workpiece material:

Solid surface material (Corian, Varicor etc.).

##### Technical information:

Straight cut. Plastic covered ball bearing guide ring for protection against marks on the workpiece.



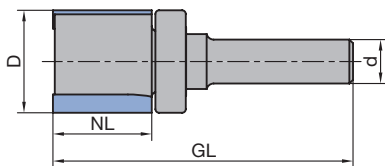
##### HW, Z 2, with guide ring on top

WO 203 1

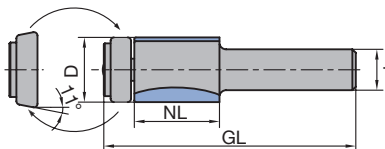
D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
28	80	25	12x40	RH	072697 □

##### Spare parts:

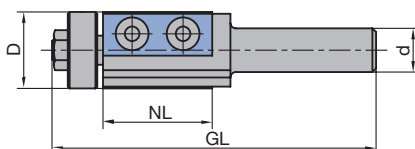
BEZ	ABM	ID
	mm	
Ball bearing guide	28x8.3x15	072712 ●



Edge trimming cutter with guide ring on top



Edge trimming cutter with guide ring on bottom



Turnblade edge trimming cutter with guide ring on bottom

##### HW, Z 2, with guide on bottom

AO 640 1

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
19	74	25	12x40	RH	072709 □

##### Spare parts:

BEZ	ABM	ID
	mm	
Ball bearing guide	19x8x4.76	072630 ●
Ball bearing guide	22x8x4.76/11°	072711 ●
Oval head screw Torx® 15	M4x8	007407 ●

##### HW turnblade, Z 2, with guide ring on bottom

WL 220 1

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
21	89	30	12x40	RH	072220 □

RPM:  $n = 18000 - 27000 \text{ min}^{-1}$

##### Spare knives:

BEZ	ABM	VE	ID
	mm	PCS	
Turnblade knife	30x12x1.5	10	005161 ●

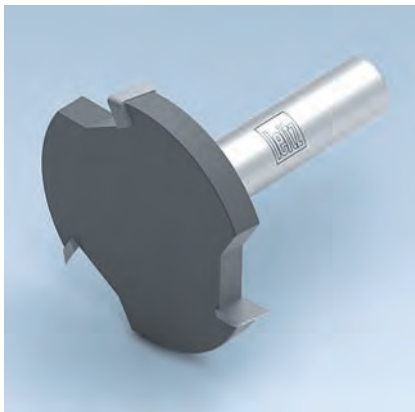
##### Spare parts:

BEZ	ABM	ID
	mm	
Ball bearing guide	15.88x21x8.1	072255 ●
Nut	M6	005651 ●
Oval head screw Torx® 15	M4x6	006225 ●
Torx® key	Torx® 15	005457 ●

## 5. Routing

### 5.5 Portable routers

#### 5.5.3 Tools for solid surface materials



#### Planing cutter

**Application:**

Router for cutting panel raising profiles.

**Machine:**

Portable routers.

**Workpiece material:**

Solid surface material (Corian, Varicor etc.).

**Technical information:**

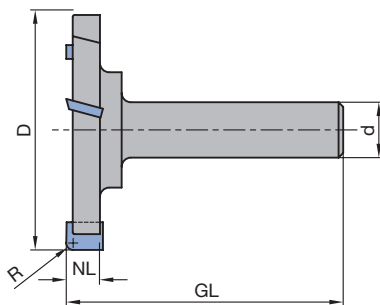
Optimised cutting geometry for clean planed surface. Also suitable for edge trimming of installed sinks of solid surface material.



**HW, Z 3**

WO 110 1

D	GL	NL	S	$n_{\max}$	DRI	ID
mm	mm	mm	mm	$\text{min}^{-1}$		
52	60	7.3	12x40	27000	RH	<b>072693</b> □



Planing cutter Z 3

## 5. Routing

### 5.5 Portable routers 5.5.4 Tools for composite panels



#### V-groove cutter for composite panels

##### Application:

Routers for cutting V-grooves in composite panels for folding operations.

##### Machine:

Portable routers.

##### Workpiece material:

Composite panels based on thermoplastic cores with aluminium coverage on both sides (e.g. Alucobond®, Dibond® etc.).

##### Technical information:

Stable edges, flat point for folding operations.



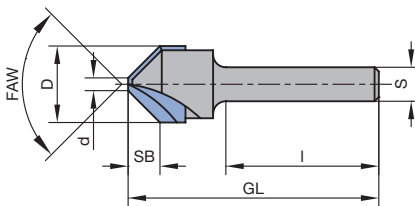
##### HW, Z 2

WO 531 2

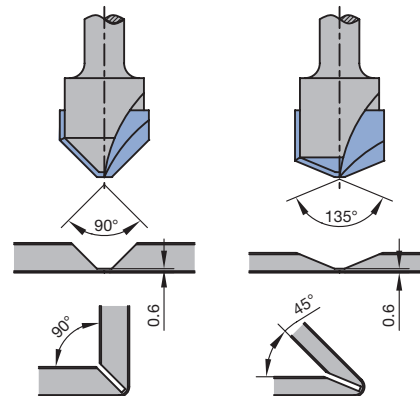
D	d	GL	NL	S	FAW	QAL	Z	DRI	ID
mm	mm	mm	mm	mm	°				
18	3	59	8	8x39	90°	HW	2	RH	070564 □
18	2	59	3.3	8x39	135°	HW	2	RH	070565 □

RPM: n = 18000 - 27000 min<sup>-1</sup>

##### Application example:



V-groove cutter for composite panels



Production of folding corners on composite panels



## 5. Routing

### 5.5 Portable routers 5.5.5 Drills for portable routers



#### Dowel drill, HW, Z 2 / V 2

##### Application:

For drilling blind holes, particularly dowel holes in furniture construction.

##### Machine:

Portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Spurs geometry with shear cut. Tool body with reduced diameter for minimum friction and feed force. Cylindrical shank without clamping flat.

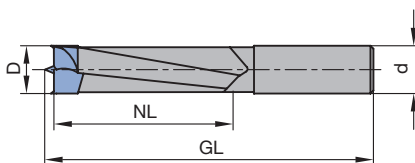


#### Dowel drill, HW, Z 2 / V 2

WB 101 0, WB 120 0

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
3	55	16	8x30	RH	<b>072597</b> <input type="checkbox"/>
5	60.5	30	8x27	RH	<b>072752</b> <input type="checkbox"/>
6	60.5	30	8x27	RH	<b>072753</b> <input type="checkbox"/>
8	60.5	30	8x27	RH	<b>072754</b> <input type="checkbox"/>
10	60.5	30	8x27	RH	<b>072755</b> <input type="checkbox"/>

**RPM:** n = 3000 - 9000 min<sup>-1</sup>



Dowel drill Z 2 / V 2

## 5. Routing

### 5.5 Portable routers 5.5.5 Drills for portable routers



#### Through-hole drill, HW, Z 2

##### Application:

For drilling through holes in furniture construction.

##### Machine:

Portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Conical tip design for tear-free through-holes. Tool body with reduced diameter for minimum friction and feed force. Cylindrical shank without clamping flat.

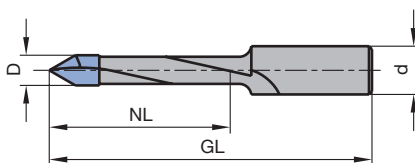


#### Through-hole drill, HW, Z 2

WB 101 0

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
5	60.5	30	8x27	RH	<b>072756</b> □

**RPM:** n = 3000 - 9000 min<sup>-1</sup>



Through hole drill Z 2

## 5. Routing

### 5.5 Portable routers 5.5.5 Drills for portable routers



#### Hinge boring bit

##### Application:

For drilling hinge holes in furniture construction.

##### Machine:

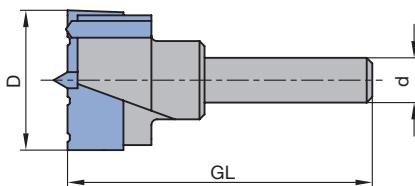
Portable routers.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Good centering in solid wood by centre point. Minimised friction by relief ground spurs and raker edge with chip breakers. Cylindrical shank without clamping flat.



Hinge boring bit Z 2 / V 2

#### HW, Z 2 / V 2

WB 310 0

D	GL	S	DRI	ID
mm	mm	mm		
15	54.5	8x30	RH	<b>034660</b> <input type="checkbox"/>
18	54.5	8x30	RH	<b>072596</b> <input type="checkbox"/>
20	54.5	8x30	RH	<b>072012</b> <input type="checkbox"/>
22	54.5	8x30	RH	<b>072740</b> <input type="checkbox"/>
25	54.5	8x30	RH	<b>034656</b> <input type="checkbox"/>
26	54.5	8x30	RH	<b>034658</b> <input type="checkbox"/>
30	54.5	8x30	RH	<b>034657</b> <input type="checkbox"/>
34	54.5	8x30	RH	<b>072196</b> <input type="checkbox"/>
35	54.5	8x30	RH	<b>034659</b> <input type="checkbox"/>

**RPM:** n = 3000 - 9000 min<sup>-1</sup>

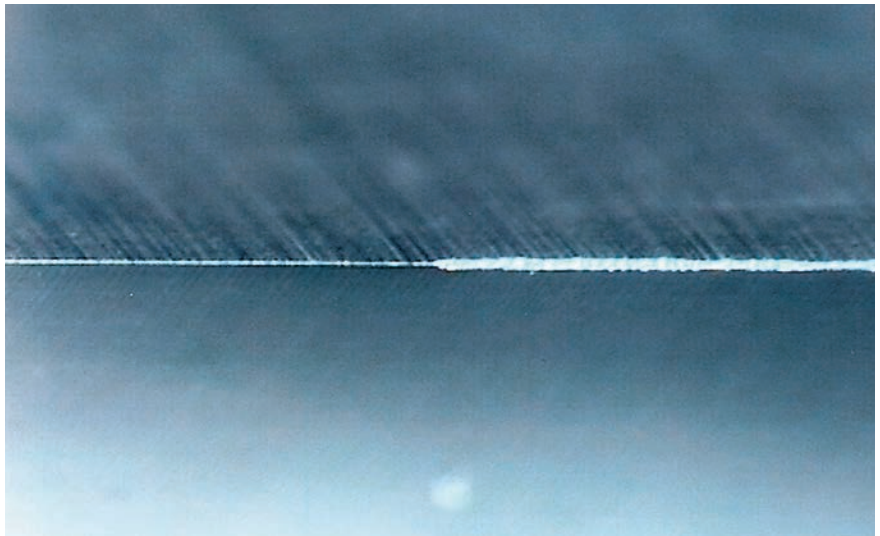
Problem	Possible cause	Action
<b>Chatter marks</b> <b>Loud cutting noise</b>	– Wrong removal rate	Adjust feed speed and RPM for cutting depth to the chart on the product page. If necessary, machine the cutting depth in 2 steps or precut with roughing router cutter.
	– Incorrectly adjusted tool dimensions	Use a more solid tool with largest possible shank and tool diameters and short working length. Select tool with staggered or spiral cutting edges.
	– Vibrations of the tool spindle system	Note minimum shank clamping length. $l_{e \min} = 2 \times \text{shank diameter}$ . Do not machine with long or secondary chucks. Use short chucks (PM 320 0 53) or shrink clamping devices. Check and, if necessary, repair machine guides and motor bearings.
	– Insufficient clamping of workpiece	Increase vacuum clamping. Clamp waste. Improve workpiece clamping by mechanical clamping, friction or fastening with screws.
<b>Marks on the workpiece from tools with staggered cutting edges</b>  <b>Note:</b> Tools with staggered cutting edges cannot produce surfaces free of marks due to minor tolerances in concentricity. In MDF and solid wood, concentricity inaccuracies of 0.03 mm are visible.	– Errors in concentric running of clamping chuck, motor spindle or tool	To identify cause, turn tool 90° in the chuck and cut again: A change in the marks on the workpiece point to chuck error. Most accurate concentricity is achieved using hydro chucks or shrink chucks. Constant cutter marks point to a defective tool which should be repaired or exchanged.
	– Unstable spindle bearing	Select short chucks. Do not use extension pieces.
<b>Tool breakage of shank cutters</b>	– Cutting depth or feed speed too high	Adjust application data to chart on the product page.
	– Wrong tool clamping	Note minimum shank clamping length. $l_{e \min} = 2 \times \text{shank diameter}$ . Do not machine with long or extension chucks. Use short chucks (PM 320 0 53) or shrink-clamping chucks.
	– Incorrectly adjusted tool dimensions	Use a more solid tool with the largest possible shank and tool diameters and shortest working length. Select tool with staggered or spiral cutting edges.
	– Inadequate tool clamping (critical with solid HW tools)	Check chuck clamping area for burrs or dirt.
	– Damage from loose waste pieces	Clamp waste pieces. Hog small pieces when shaping.
	– Machine vibrations	Check machine guide and motor bearings. Check balance of clamping chuck.
<b>Cutting edge breakages on DP (DIA) router bits</b>	– Vibrations of tool spindle	Check balance, contamination and concentricity of the clamping chuck.
	– Vibrations at the workpiece due to insufficient support	Clamp tool as close as possible to the profile. Make vacuum clamping areas as large as possible. Clamp waste pieces.

### Continuous wear of cutting edges

Mechanical abrasion causes continuous wear of the cutting edge when machining largely uniform materials.

The degree of permissible wear is determined by the required machined quality. As a standard the width of wear VB of 0.2 up to maximum 0.3 mm should not be exceeded.

Tipped tools must be resharpened in good time to ensure the economic efficiency of the tool.



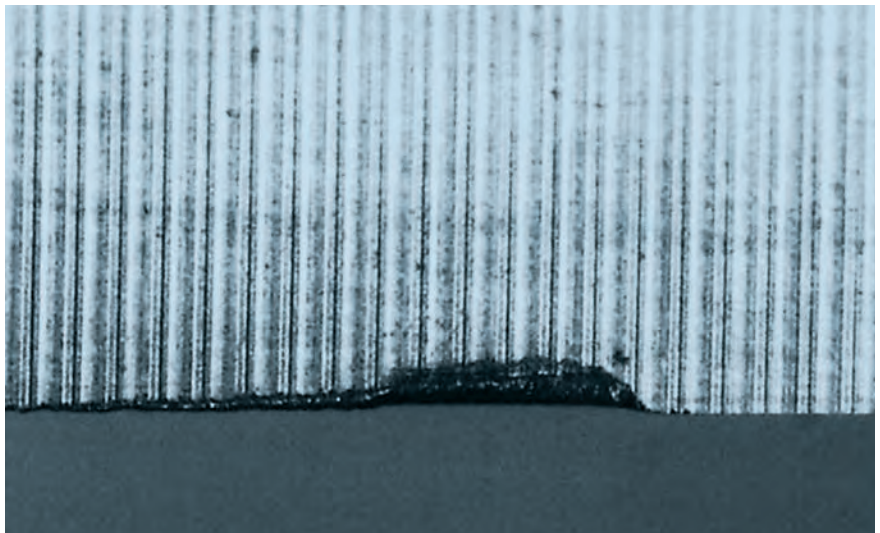
Normal cutting edge wear after machining of spruce.

### Local cutting edge wear

Irregular cutting edge wear is caused when machining non-uniform panel materials (e.g. coated chipboard or laminate floors).

The highest abrasion occurs in the area of more densely pressed surface layers with higher sand content. This local abrasion defines the quality of the machined edge and determines the end of the tool life.

If the machining situation allows axial adjustment tool, a sharp section of cutting edge can be used to machine the edge, increasing the tool performance time.

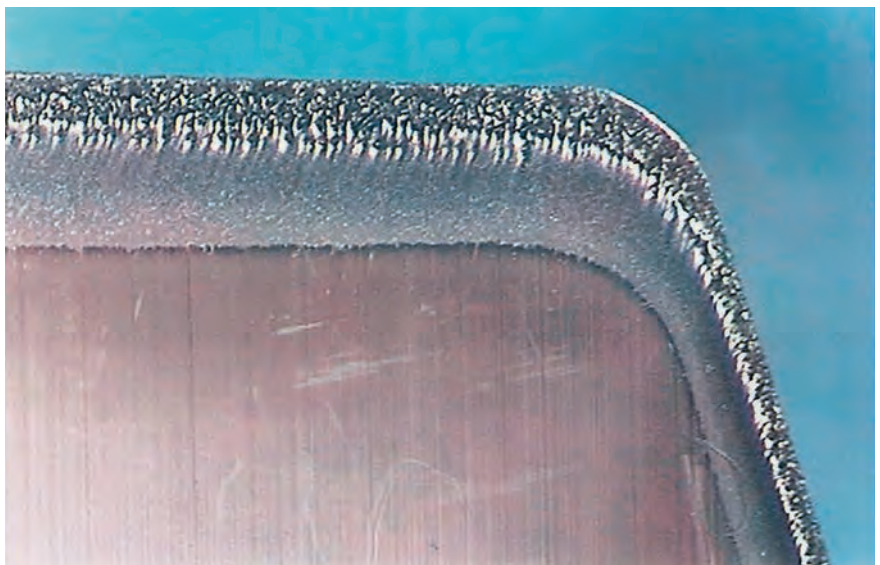


Cutting edge wear after machining chipboard.

### Chemical abrasion

When machining materials with a high tannic acid content (e.g. oak) the cutting edge is subject to chemical abrasion in addition to mechanical abrasion.

The cobalt binder material in the tungsten carbide is etched away through chemical abrasion, damaging the cutting material.



Chemical influence – cutting edge wear – after machining of oak.



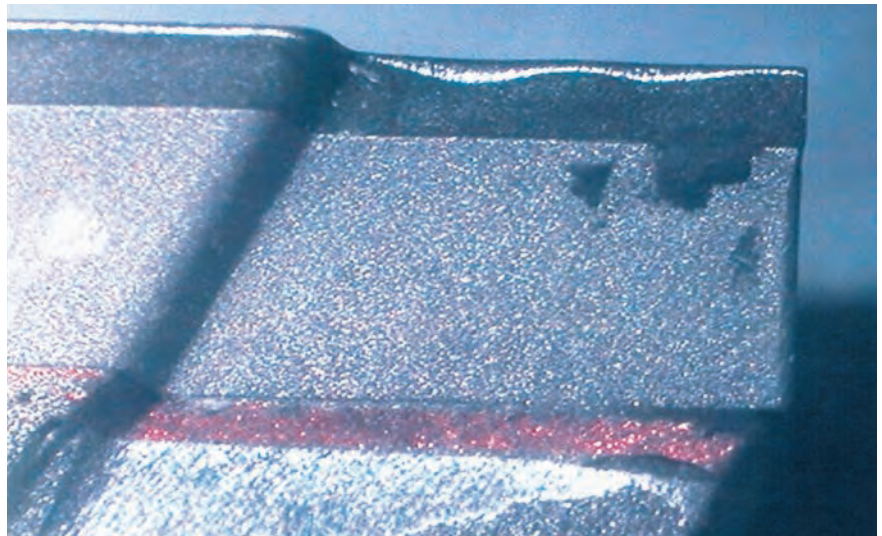
### Cutting edge wear

Mechanical abrasion causes continuous wear of the cutting edge when machining largely uniform materials.

The degree of the permissible wear is determined by the required machined quality. As a standard the width of wear VB of 0.2 up to maximum 0.3 mm should not be exceeded.

Because of the long performance time, resin can build up on cutting edges.

Performance time can be increased by regular cleaning.



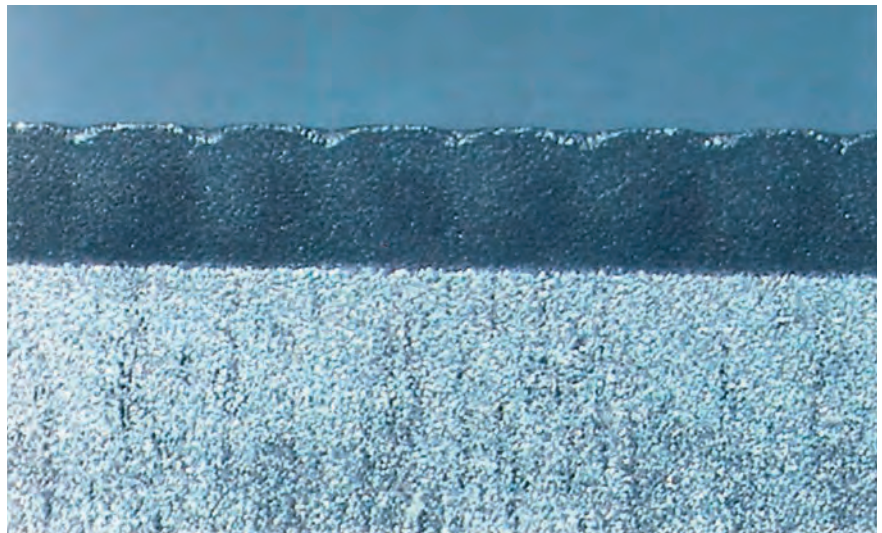
Cutting edge wear after machining GFK.

### Cutting edge wear and small fractures

When machining some wood derived and composite materials the cutting edge is damaged by small fractures as well as the usual wear.

This is usually caused by hard mineral particles in the workpiece material.

Fractures at the cutting edge can also be caused by high frequency machine vibrations. Imbalanced tools and chucks, worn spindles or machining close to a resonant RPM may cause such vibrations.

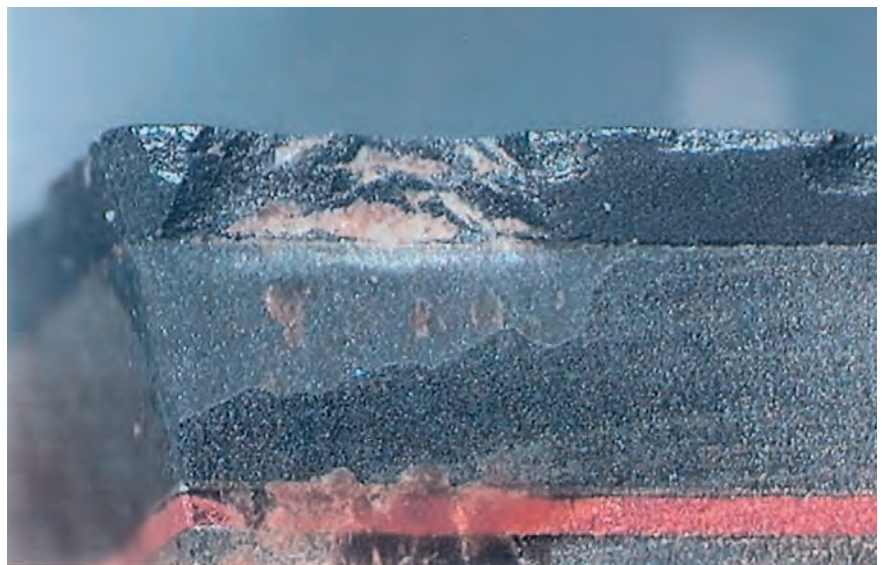


Cutting edge wear and fractures after machining HPL/CPL.

### Cutting edge destruction

The cutting edge can be destroyed when machining non-uniform materials containing mineral or metallic particles.

These particles cannot be detected prior to machining and limit the use of DP tools for machining such materials.



Cutting edge destruction by metallic particles embedded in the workpiece.

## Enquiry/order form special tools – routing



**Customer details:** Customer number:  
(if known)

--	--	--	--	--	--	--	--	--	--

- ☐ Enquiry  
☐ Order

Delivery date: (not binding)

--	--

CW

Company:

Street:

Post code/place:

Country:

Phone/fax:

Contact person:

Signature:

Date:

Enquiry/order no.:

Tool ID: (if known)

Quantity:

### Workpiece material:

Solid wood Type:

Wood-derived material Type:

Other Type:

Direction of machining for solid wood or veneered workpieces:

- ☐ along grain  
☐ across grain

Type of coating:

Additional information:

### Machine:

Manufacturer:

Range of RPM: min<sup>-1</sup>

Adaptor

(e.g. SK 30, HSK-F 63 etc.):

### Tool:

Tool type (see selection pages):

Dimensions:

Diameter: mm

Cutting width: mm

Shank diameter: mm

No. of teeth:

Cutting material:

- ☐ HS  
☐ HW  
☐ ST  
☐ DP

Direction of rotation:

- ☐ left hand  
☐ right hand

Type of feed:

- ☐ Mech. feed  
☐ Manual feed

State profile with sketch or drawing:

- ☐ Cutting on periphery only  
☐ Cutting in end grain (ramp plunging possible)  
☐ For plunging in z-axis

Arrangement of cutting edges:

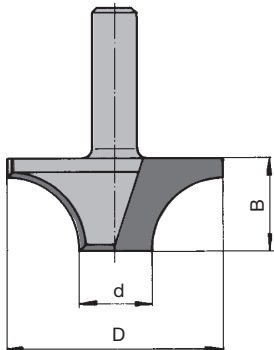
- ☐ with shear angle on one side  
☐ with alternate shear angle

☐ Please tick the appropriate box



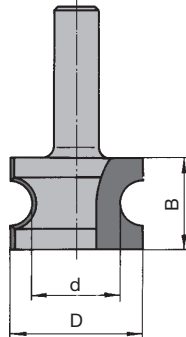
## Examples for profile groups 1 and 2:

WO 521 1  
open profile



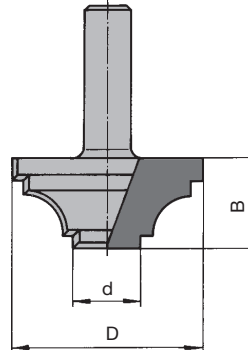
Profile group 1:  
cutting on periphery  
with bottom knife for  
cutting in end grain

WO 522 1  
closed profile



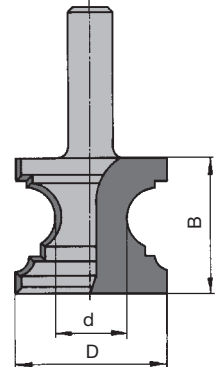
Profile group 1:  
cutting on periphery

WO 521 2  
open profile



Profile group 2:  
cutting on periphery  
with bottom knife for  
cutting in end grain

WO 522 2  
closed profile



Profile group 2:  
cutting on periphery  
with bottom knife for  
cutting in end grain

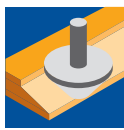
Sketch for application plan, profile drawing, special motor spindle etc.

Enter on sketch which side of workpiece to table i.e. face side on top/bottom

## Key to pictograms



Drilling  
blind holes



Panel raising



Mechanical  
knife clamping,  
adjustable  
- serrated



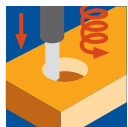
Slotting



Profiling



Resharpenable  
cutting face



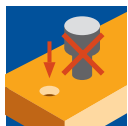
Spiral boring



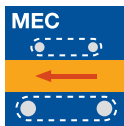
Profiling  
joints



Resharpenable  
clearance face



Non-axial boring



Mechanical  
feed



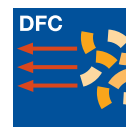
Low noise



Carving



Manual  
feed



Optimised  
chip flow



Grooving,  
sizing



Solid metal  
tool



Alloyed  
tool steel



Finish sizing



Tipped tool



High-speed  
steel



Grooving,  
horizontal  
and vertical



Special body  
alloy



Tungsten  
carbide



Jointing



Light alloy  
body



Polycrystalline  
diamond (PCD)



Rebating



Interchangeable  
knives



Carbide  
metal coating



Bevelling



Mechanical  
knife clamping,  
reversible



# Drilling

Leitz Lexicon Edition 7

Version 2

03/2021



## Explanation of abbreviations

A	= dimension A
$a_e$	= cutting thickness (radial)
$a_p$	= cutting depth (axial)
ABM	= dimension
APL	= panel raising length
APT	= panel raising depth
AL	= working length
AM	= number of knives
AS	= anti sound (low noise design)

b	= overhang
B	= width
BDD	= thickness of shoulder
BEM	= note
BEZ	= description
BH	= tipping height
BO	= bore diameter

CNC	= Computerized Numerical Control
-----	----------------------------------

d	= diameter
D	= cutting circle diameter
D0	= zero diameter
DA	= outside Diameter
DB	= diameter of shoulder
DFC	= Dust Flow Control (optimised chip clearance)
DGL	= number of links
DIK	= thickness
DKN	= double keyway
DP	= polycrystalline diamond
DRI	= rotation

FAB	= width of rebate
FAT	= depth of rebate
FAW	= bevel angle
FLD	= flange diameter
$f_z$	= tooth feed
$f_{z\text{ eff}}$	= effective tooth feed

GEW	= thread
GL	= total length
GS	= Plunging edge

H	= height
HC	= tungsten carbide, coated
HD	= wood thickness (thickness of workpiece)
HL	= high-alloyed tool steel
HS	= high-speed steel (HSS)
HW	= tungsten carbide (TCT)

ID	= ident number
IV	= insulation glazing

KBZ	= abbreviation
KLH	= clamping height
KM	= edge breaker
KN	= single keyway
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60

L	= length
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LH	= left hand rotation
----	----------------------

M	= metric thread
MBM	= minimum order quantity
MC	= multi-purpose steel, coated
MD	= thickness of knife
$\text{min}^{-1}$	= revolutions per minute (RPM)
MK	= morse taper
$\text{m min}^{-1}$	= metres per minute
$\text{m s}^{-1}$	= metres per second

n	= RPM
$n_{\text{max}}$	= maximum permissible RPM
NAL	= position of hub
ND	= thickness of hub
NH	= zero height
NL	= cutting length
NLA	= pinhole dimensions
NT	= grooving depth

P	= profile
POS	= cutter position
PT	= profile depth
PG	= profile group

QAL	= cutting material quality
-----	----------------------------

R	= radius
RD	= right hand twist
RH	= right hand rotation
RP	= radius of cutter

S	= shank dimension
SB	= cutting width
SET	= set
SLB	= slotting width
SLL	= slotting length
SLT	= slotting depth
SP	= tool steel
ST	= Cobalt-basis cast alloys, e.g. Stellite™
STO	= shank tolerance
SW	= cutting angle

TD	= diameter of tool body
TDI	= thickness of tool
TG	= pitch
TK	= reference diameter

UT	= cutting edges with irregular pitch
----	--------------------------------------

V	= number of spurs
$v_c$	= cutting speed
$v_f$	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
-----	----------------------

Z	= number of teeth
ZA	= number of fingers
ZF	= tooth shape (cutting edge shape)
ZL	= finger length

### Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



## 6. Drilling



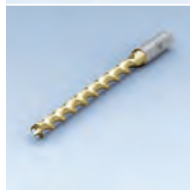
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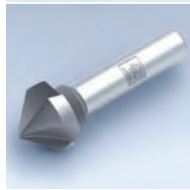
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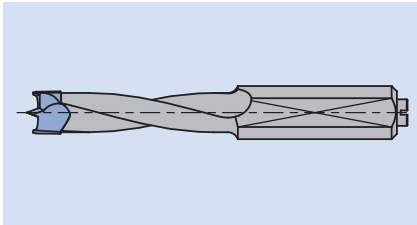
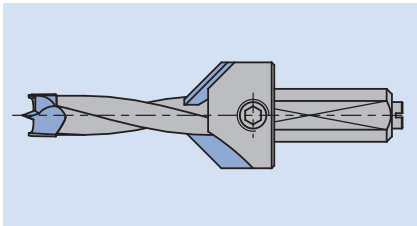
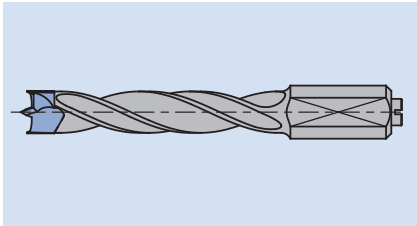
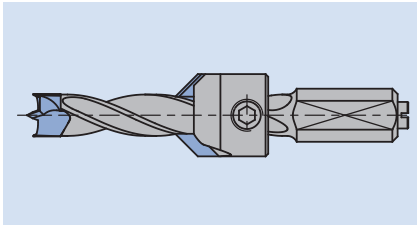


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<b>Application</b>	To drill tear-free dowel holes and blind holes.		
<b>Workpiece material</b>	Softwood and hardwood. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. Laminated veneer lumber (plywood, multiplex plywood, glued lumber etc.). Plastomers.		
<b>Machine</b>	Through feed drilling machines, Point-to-point drilling machines, CNC Machining centres, Hinge boring machines, Special purpose drilling machines.		
<b>Design</b>	Two dowel drill designs available:		
			<b>1. Design without heel</b> Optimised dowel drill for machining panels in the furniture industry. Minimum friction and feed forces as the flute has a smaller diameter. A loose countersink can be clamped on the shank.
			
			<b>2. Design with heel</b> Dowel drills with heel are used to drill holes in solid wood and for machines with insufficient guidance during drilling and return stroke. The drill has better guidance during the return stroke to prevent tear-outs at the edge. A loose countersink can be clamped on the heel and allows adjustment of the drilling and countersink depth.
			
<b>Shank</b>	Dowel drills usually have a shank diameter $d = 10$ mm. Drilling machines with only a small pitch between the drilling spindles may use dowel drills with a shank diameter $d = 8$ mm. Additionally, it is possible to mount the dowel drills directly on the drilling spindles with a threaded adaptor.  Adaptors are available with different combinations of threads and either cylindrical or tapered seatings.  Special shank dimensions available on request.		



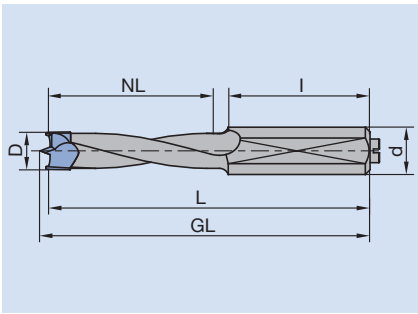
# 6. Drilling

## 6.1 Dowel drilling

### Technical features

The dimensions listed in the tool tables refer to the following tool parameters:

D	Drill diameter
d	Shank diameter
I	Shank length
NL	Working length = possible drilling depth
GL	Total length of the drill including the projection of the centre point
L	Total length of the drill excluding the projection of the centre point



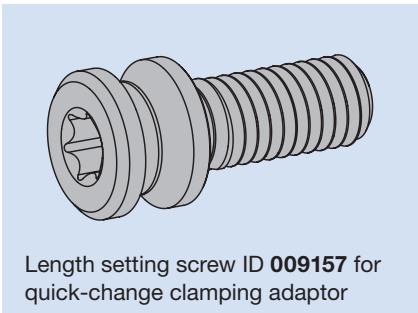
### Application data

#### RPM/feed speeds

The optimum RPM and feed speeds are detailed in the diagrams attached to the tool tables. Identification of the rotation: RH - black; LH - red.

### Information

The existing allen screws in the shanks must be replaced by the length setting screw ID **009157** when using dowel drills in Leitz quick-change drill adaptors.





#### Shank 8 mm

##### Application:

For drilling blind holes, particularly dowel holes in furniture construction. Recommended on drill spindles with limited rigidity.

##### Machine:

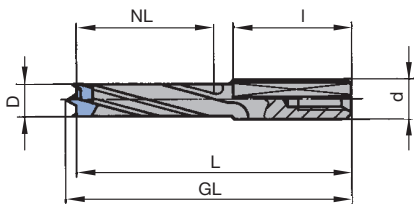
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

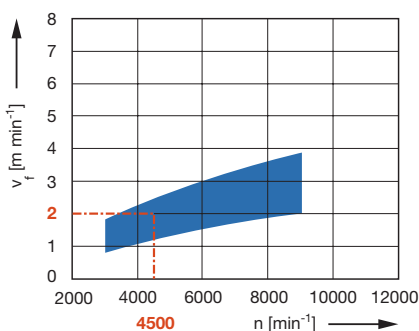
##### Technical information:

Spur geometry with shear cut. Drills can be combined with countersink WB 701 0 03. Countersink fixed on heel. Continuously adjustable boring and countersink depth. Good guidance on return stroke for tear-free holes.



Design with heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3

#### GL 55.5 mm, with heel, Z 2 / V 2

WB 120 0 23

D mm	GL mm	L mm	NL mm	S mm	ID LH	ID RH
5	55.5	54	30	8x19	042552 ●	042553 ●
6	55.5	54	30	8x19		042555 ●
8	55.5	53.5	30	8x19	042558 ●	042559 ●
10	55.5	53.5	30	8x21		042563 ●

#### GL 67 mm, with heel, Z 2 / V 2

WB 120 0 24

D mm	GL mm	L mm	NL mm	S mm	ID LH	ID RH
5	67	65.5	40	8x19	042568 ●	042569 ●
6	67	65.5	40	8x19	042570 ●	042571 ●
7	67	65.5	40	8x19		042573 ●
8	67	65	40	8x19	042574 ●	042575 ●
10	67	65	40	8x21		042579 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

##### Spare parts:

BEZ	ABM mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●



### Shank 10 mm

#### Application:

For drilling blind holes, particularly dowel holes in furniture construction.

#### Machine:

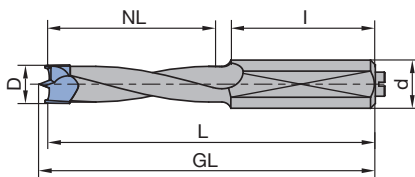
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

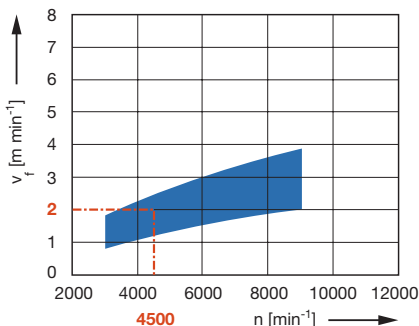
#### Technical information:

Spur geometry with shear cut. Recessed flute for minimised friction and feed force. Drills can be combined with countersink WB 701 0 02. Countersinks can be clamped on the shank.



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



#### Workpiece material:

Chipboard plastic coated

#### Operation:

Drilling

#### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3

### GL 57.5 mm, without heel, Z 2 / V 2

WB 120 0 12, WB 120 0 32

D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
3	57.5	56	25	10x25	033788 ●	033789 ●
3.18	57.5	56	25	10x27		033701 ●
4	57.5	56	25	10x27	033670 ●	033671 ●
4.5	57.5	56	25	10x27	033710 ●	033711 ●
5	57.5	56	25	10x27	033672 ●	033673 ●
5.1	57.5	56	25	10x27		033675 ●
5.2	57.5	56	25	10x27		033677 ●
6	57.5	56	25	10x27	033678 ●	033679 ●
7	57.5	56	25	10x27	033680 ●	033681 ●
8	57.5	55.5	25	10x27	033682 ●	033683 ●
8.2	57.5	55.5	25	10x27	033686 ●	033687 ●
9	57.5	55.5	25	10x27	033688 ●	033689 ●
10	57.5	55.5	25	10x27	033690 ●	033691 ●
12	57.5	55.5	30	10x22	033692 ●	033693 ●
15	57.5	55.5	30	10x22	033696 ●	033697 ●
16	57.5	55.5	30	10x22		033699 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

#### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw	M5x17	for quick-change drill	009157 ●
Torx® 20		adaptors	



### Shank 10 mm

#### Application:

For drilling blind holes, particularly dowel holes in furniture construction.

#### Machine:

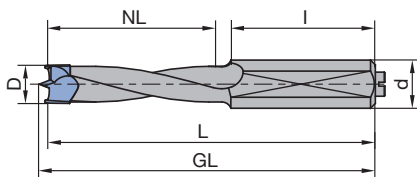
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Spur geometry with shear cut. Recessed flute for minimised friction and feed force. Drills can be combined with countersink WB 701 0 02. Countersinks can be clamped on the shank.



Design without heel

### GL 70 mm, without heel, Z 2 / V 2

WB 120 0 10, WB 120 0 33

D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
3	70	68.5	25	10x25	033550 ●	033551 ●
4	70	68.5	35	10x30	033476 ●	033477 ●
5	70	68.5	35	10x30	033440 ●	033441 ●
6	70	68.5	35	10x30	033442 ●	033443 ●
7	70	68.5	35	10x30	033444 ●	033445 ●
8	70	68	35	10x30	033446 ●	033447 ●
9	70	68	35	10x30	033478 ●	033479 ●
10	70	68	35	10x30	033448 ●	033449 ●
11	70	68	35	10x30	033480 ●	033481 ●
12	70	68	35	10x30	033450 ●	033451 ●
13	70	68	35	10x30	033452 ●	033453 ●
14	70	68	35	10x30	033454 ●	033455 ●
16	70	67.5	35	10x30	033456 ●	033457 ●

### GL 77 mm, without heel, Z 2 / V 2

WB 120 0 07

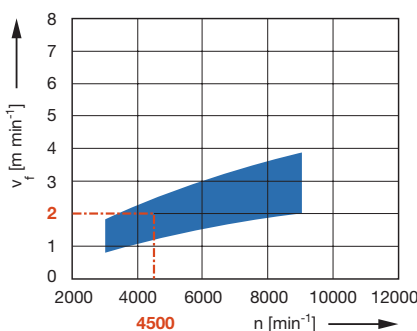
D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
5	78.5	77	45	10x30	033370 ●	033371 ●
6	78.5	77	45	10x30	033372 ●	033373 ●
7	78.5	77	45	10x30	033374 ●	033375 ●
8	78.5	77	45	10x30	033376 ●	033377 ●
10	79	77	45	10x30	033378 ●	033379 ●
12	79	77	45	10x30	033380 ●	033381 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

#### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

Feed speed  $v_f$  depending on the spindle RPM  $n$



#### Workpiece material:

Chipboard plastic coated

#### Operation:

Drilling

#### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3



#### Shank 10 mm

##### Application:

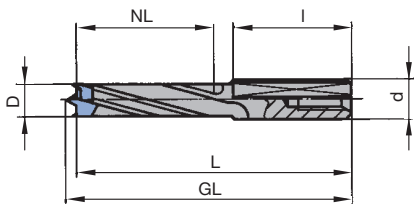
For drilling blind holes, particularly dowel holes in furniture construction. Recommended on drill spindles with limited rigidity.

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

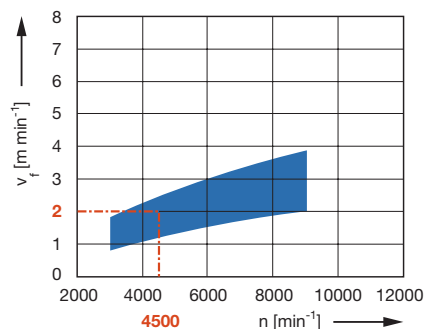
##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



Design with heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3

##### Technical information:

Spur geometry with shear cut. Drills can be combined with countersink WB 701 0 03. Countersink fixed on heel. Continuously adjustable boring and countersink depth. Good guidance on return stroke for tear-free holes.

##### GL 70 mm, with heel, Z 2 / V 2

WB 120 0 25, WB 120 0 26

D mm	GL mm	L mm	NL mm	S mm	ID LH	ID RH
5	70	68.5	43	10x19	042586 ●	042587 ●
6	70	68.5	43	10x19	042588 ●	042589 ●
8	70	68	43	10x19	042590 ●	042591 ●
10	70	68	43	10x19	042592 ●	042593 ●
12	70	68	43	10x19	042594 ●	042595 ●
25	70	68	40	10x25		042610 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

##### Note:

ID **042610** for holes in window manufacture.

##### Spare parts:

BEZ	ABM mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●



### Threaded shank

#### Application:

For drilling blind holes, particularly dowel holes in furniture construction.

#### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Spur geometry with shear cut. Recessed flute for minimised friction and feed force. Threaded shank for direct mounting in the drilling spindle.

#### M10, threaded shank with seating 11 mm, without heel, Z 2 / V 2

WB 120 0 17

D	GL	NL	A	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
5	75	40	60	M10	<b>035200 ●</b>	<b>035201 ●</b>
8	75	40	60	M10	<b>035204 ●</b>	<b>035205 ●</b>

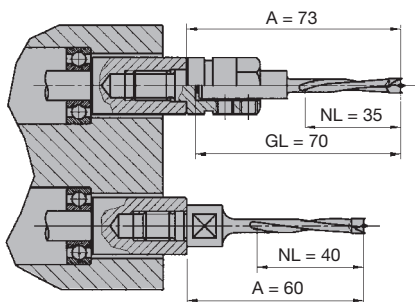
#### M10, threaded shank, without heel, Z 2 / V 2

WB 120 0 18

D	GL	NL	A	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
5	78	43	63	M10	<b>035260 ●</b>	<b>035261 ●</b>
8	78	43	63	M10	<b>035264 ●</b>	<b>035265 ●</b>

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

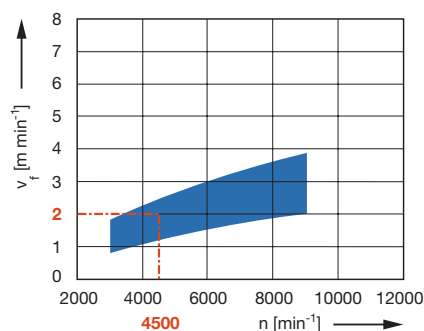
Boring bit mounted in reducing chucks



Boring bit with threaded shank mounted directly in the boring spindle

Length comparison: Dowel drills with threaded shank have a deeper boring depth than a comparable boring bit with cylindrical shank mounted in drill adaptors while having a lower overhang A with regard to the boring spindle.

Feed speed  $v_f$  depending on the spindle RPM  $n$



#### Workpiece material:

Chipboard plastic coated

#### Operation:

Drilling

#### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3

## 6. Drilling

### 6.1 Dowel drilling 6.1.2 Dowel drills - *Premium*



#### Shank 10 mm, HW tipped

##### Application:

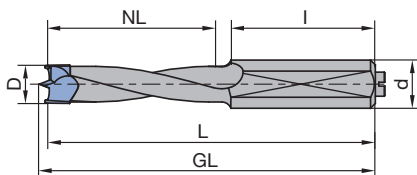
For drilling blind holes, particularly dowel holes in furniture construction. Suitable for drilling tear-free blind holes in visible areas and for machining panel materials which are covered with laminations difficult to machine (e.g. thin decorative paper).

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

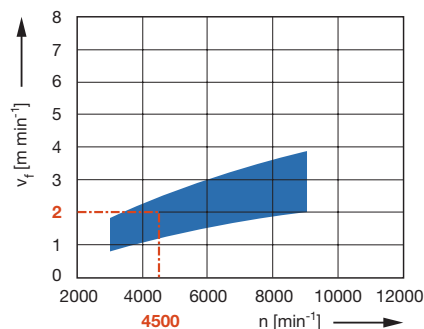
##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF, solid wood = 0.7

##### Technical information:

Spur geometry with high shear cut. High wear resistant tungsten carbide grade for maximum life time. Drills can be combined with countersink WB 701 0 02.

Countersinks can be clamped on the shank. Recessed flute for minimised friction and feed forces.

#### GL 57.5 mm, Z 2 / V 2

WB 120 0 29

D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
4	57.5	56	25	10x27		033715 ●
5	57.5	56	25	10x27	033716 ●	033717 ●
6	57.5	56	25	10x27	033718 ●	033719 ●
8	57.5	55.5	25	10x27	033720 ●	033721 ●
10	57.5	55.5	25	10x27	033722 ●	033723 ●

#### GL 70 mm, Z 2 / V 2

WB 120 0 30

D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
4	70	68.5	35	10x30	033482 ●	033483 ●
5	70	68.5	35	10x30	033484 ●	033485 ●
5.1	70	68.5	35	10x30	033492 ●	033493 ●
6	70	68.5	35	10x30	033486 ●	033487 ●
8	70	68.5	35	10x30	033488 ●	033489 ●
8.2	70	68.5	35	10x30	033494 ●	033495 ●
10	70	68.5	35	10x30	033490 ●	033491 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

##### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●





#### Shank 10 mm, HW solid

##### Application:

For drilling blind holes, particularly dowel holes in furniture construction. Suitable for drilling tear-free blind holes in visible areas and for machining panel materials which are covered with laminations difficult to machine (e.g. thin decorative paper).

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

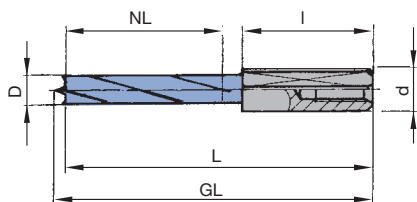
##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



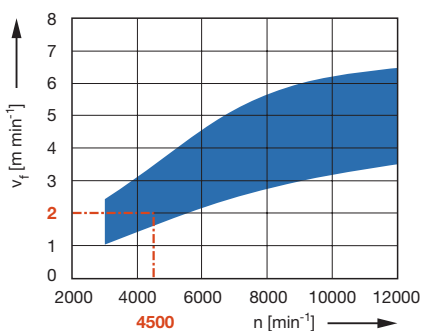
##### Technical information:

Spur geometry with high shear cut. Solid tungsten carbide design with high wear resistant tungsten carbide grade. High stability and long performance time. Polished gullet for minimum friction and feed forces. Very large resharpener area.



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3

#### GL 57.5 mm, Z 2 / V 2

WB 120 0 32

D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
3	57.5	56	25	10x25	033788 ●	033789 ●
4	57.5	56	25	10x25	033784 ●	033785 ●
5	57.5	56	25	10x25	033728 ●	033729 ●
6	57.5	56	25	10x25	033730 ●	033731 ●
8	57.5	56	25	10x25	033732 ●	033733 ●
10	57.5	55.5	25	10x25	033786 ●	033787 ●

#### GL 70 mm, Z 2 / V 2

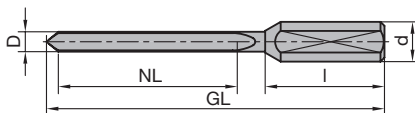
WB 120 0 33

D	GL	L	NL	S	ID	ID
mm	mm	mm	mm	mm	LH	RH
3	70	68.5	25	10x25	033550 ●	033551 ●
4	70	68.5	35	10x25	033542 ●	033543 ●
5	70	68.5	35	10x25	033496 ●	033497 ●
6	70	68.5	35	10x25	033498 ●	033499 ●
7	70	68.5	35	10x25	033548 ●	033549 ●
8	70	68.5	35	10x25	033500 ●	033501 ●
10	70	68	35	10x25	033540 ●	033541 ●

RPM:  $n = 3000 - 12000 \text{ min}^{-1}$

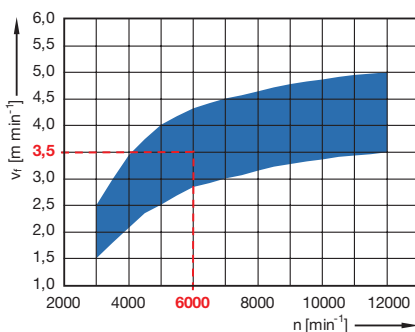
##### Spare parts:

BEZ	for S	ABM	BEM	ID
	mm	mm		
Allen screw	10x27	M5x8	Length adjustment	006378 ●
Allen screw	10x34/45	M5x10	Length adjustment	005802 ●
Anti-twist allen screw		M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20		M5x17	for quick-change drill adaptors	009157 ●



Boring pin WB 100 0 01

Feed speed  $v_f$  depending on the spindle RPM  $n$



**Workpiece material:**

Chipboard / MDF

**Operation:**

Horizontal edge drilling

### Shank 10 mm

#### Application:

For drilling blind holes, particularly dowel holes on the side of panel furniture parts.

#### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

#### Technical information:

Solid tungsten carbide design for high performance time. Large resharping area. Tool suitable for RH and LH rotation. Drill design D = 3 mm particularly suitable for pre-drilling screw holes in plastic coated and veneered furniture parts. Infeed depth in hardwood and glulam maximum 2 x D.

#### GL 57.5 / GL 70 mm, Z 1/1

WB 100 0 01

D mm	GL mm	NL mm	S mm	DRI	ID
3	57.5	25	10x27	LH, RH	230200 ●
3	70	35	10x27	LH, RH	230201 ●
5	70	35	10x27	LH, RH	230208 ●
6	70	35	10x27	LH, RH	230209 ●
8	70	35	10x27	LH, RH	230210 ●
5	57.5	25	10x27	LH, RH	230211 ●
6	57.5	25	10x27	LH, RH	230212 ●
8	57.5	25	10x27	LH, RH	230213 ●

#### GL 85 mm, Z 1/1

WB 100 0 01

D mm	GL mm	NL mm	S mm	DRI	ID
5	85	45	10x30	LH, RH	230202 ●
8	85	45	10x30	LH, RH	230204 ●

#### GL 105 mm, Z 1/1

WB 100 0 01

D mm	GL mm	NL mm	S mm	DRI	ID
5	105	65	10x30	LH, RH	230205 ●
8	105	65	10x30	LH, RH	230207 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

#### Note:

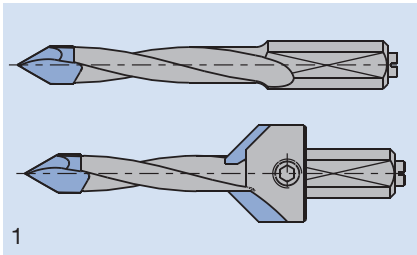
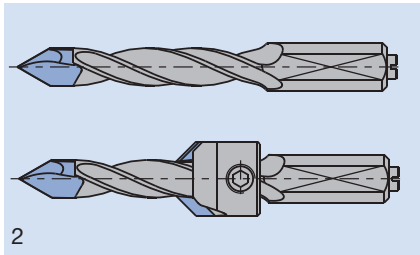
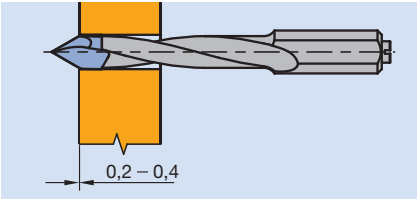
When using the bore pins in hardwood and glulam, the potential bore depth is restricted. Interim chip removal (return stroke) then is obligatory. Boring pins require more power compared to dowel drills. The maximum number of boring pins, used in one drilling unit, depends on the power of the machine.

#### Spare parts:

BEZ	for S mm	ABM mm	BEM	ID
Allen screw	10x27	M5x8	Length adjustment	006378 ●
Allen screw	10x30	M5x10	Length adjustment	005802 ●
Anti-twist allen screw		M5x10	Length adjustment	007438 ●
Length adjustment screw		M5x17	for quick-change drill adaptors	009157 ●
Torx® 20				

# 6. Drilling

## 6.2 Through hole drilling

<b>Application</b>	To drill tear-free through holes in panels.										
<b>Workpiece material</b>	Softwood and hardwood. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. Laminated veneer lumber (plywood, multiplex plywood, glued lumber etc.). Plastomers.										
<b>Machine</b>	Through feed drilling machines, Point-to-point drilling machines, CNC machining centres, Hinge boring machines, Special purpose drilling machines.										
<b>Design</b>	<p>Two available through hole drill designs:</p> <p><b>1. Design without heel</b> Optimised through hole drill for machining panels in the furniture industry. Minimum friction and feed forces as the flute has a smaller diameter. A loose countersink can be clamped on the shank.</p> <p><b>2. Design with heel</b> Through hole drills with heel are used to drill holes in solid wood and for machines with insufficient guidance during drilling and return stroke. The drill has better guidance during the return stroke to prevent tear-outs at the edge. A loose countersink can be clamped on the heel and allows adjustment of the drilling and countersink depth.</p> <div>   </div>										
<b>Shank</b>	Through hole drills usually have a shank diameter $d = 10$ mm. Drilling machines with a small pitch between the drilling spindles may use drills with a shank diameter $d = 8$ mm.										
<b>Technical features</b>	<p>The dimensions listed in the tool tables refer to the following tool parameters:</p> <table border="1"> <tr> <td>D</td><td>Drill diameter</td></tr> <tr> <td>d</td><td>Shank diameter</td></tr> <tr> <td>l</td><td>Shank length</td></tr> <tr> <td>NL</td><td>Working length = possible drilling depth</td></tr> <tr> <td>GL</td><td>Total length of the drill</td></tr> </table>	D	Drill diameter	d	Shank diameter	l	Shank length	NL	Working length = possible drilling depth	GL	Total length of the drill
D	Drill diameter										
d	Shank diameter										
l	Shank length										
NL	Working length = possible drilling depth										
GL	Total length of the drill										
<b>Application data</b>	<p><b>RPM/feed rates</b> The optimum RPM and feed speeds are detailed in the diagrams attached to the tool tables. Identification of rotation: RH - black; LH - red.</p>										
<b>Application recommendation</b>	<p>The drilling quality in brittle or low-adhesive surfaces can be improved when the feed speed is reduced as the drill breaks through the workpiece.</p> 										



### Shank 10 mm

#### Application:

For drilling through holes, particularly in furniture construction.

#### Machine:

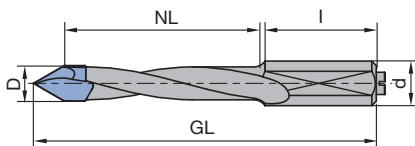
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

#### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), elastomers.

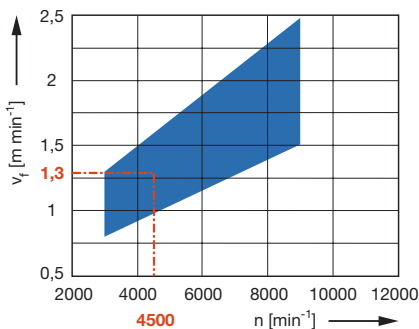
#### Technical information:

Drills can be combined with countersink WB 701 0 02. Countersinks can be clamped on the shank. Recessed flute for minimised friction and feed forces.



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



#### Workpiece material:

Chipboard plastic coated

#### Operation:

Drilling

#### Correction factor for $v_f$ :

Veneered = 0.8

MDF = 0.7

Chipboard, uncoated = 1.3

### GL 57.5 mm, without heel, Z 2

WB 101 0 02

D mm	GL mm	NL mm	S mm	ID LH	ID RH
5	57.5	25	10x24	034000 ●	034001 ●
6	57.5	25	10x24		034009 ●
8	57.5	25	10x24	034002 ●	034003 ●

### GL 70 mm, without heel, Z 2

WB 101 0 07

D mm	GL mm	NL mm	S mm	ID LH	ID RH
5	70	35	10x24	034074 ●	034075 ●
7	70	35	10x24	034106 ●	034107 ●
8	70	35	10x24	034076 ●	034077 ●
9	70	35	10x24	034108 ●	034109 ●
10	70	35	10x24	034110 ●	034111 ●

### GL 77 mm, without heel, Z 2

WB 101 0 03

D mm	GL mm	NL mm	S mm	ID LH	ID RH
5	77	44	10x24	034060 ●	034061 ●
6	77	44	10x24	034068 ●	034069 ●
8	77	44	10x24	034062 ●	034063 ●
10	77	44	10x24	034070 ●	034071 ●
12	77	44	10x24	034072 ●	034073 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101 0 04.

#### Spare parts:

BEZ	ABM mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●



#### Shank 10 mm

##### Application:

For drilling through holes, particularly in furniture construction. Recommended on drill spindles with limited rigidity

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), elastomers.



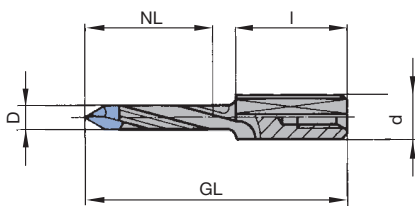
##### Technical information:

Drills can be combined with countersink WB 701 0 03. Countersinks fixed on heel. Continuously adjustable boring and countersink depth. Good guidance on return stroke for tear-free holes.

#### GL 57.5 mm, with heel, Z 2

WB 101 0 05

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	57.5	25	10x24	042630 ●	042631 ●



Design with heel

#### GL 77 mm, with heel, Z 2

WB 101 0 06

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	77	44	10x24	042640 ●	042641 ●
5.2	77	44	10x24	042644 ●	042645 ●
6	77	44	10x24		042647 ●
8	77	44	10x24	042648 ●	042649 ●
10	77	44	10x24		042651 ●
12	77	44	10x24		042653 ●

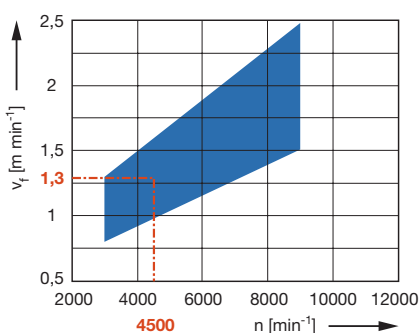
RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101 0 04.

##### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

MDF = 0.7

Chipboard, uncoated = 1.3



#### Shank 10 mm, HW tipped

##### Application:

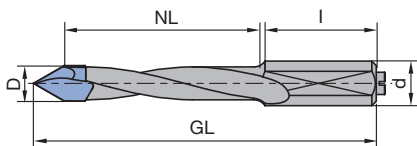
For drilling tear-free through holes, particularly in furniture construction, with maximised quality on the bottom side (exit).

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

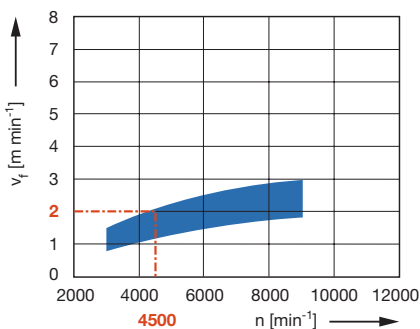
##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3

##### Technical information:

V-point tip with 2 bevels for maximised quality on the bottom side (exit). High wear resistant tungsten carbide grade for maximum lifetime. Drills can be combined with countersink WB 701 0 02. Countersinks can be clamped on the shank. Recessed flute for minimised friction and feed forces.

##### GL 57.5 mm, Z 2

WB 101 0 10

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	57.5	25	10x25	033960 ●	033961 ●
8	57.5	25	10x25	033962 ●	033963 ●

##### GL 70 mm, Z 2

WB 101 0 10

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	70	35	10x25	033964 ●	033965 ●
8	70	35	10x25	033966 ●	033967 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

(recommended  $n = 4500 - 9000 \text{ min}^{-1}$ )

##### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

## 6. Drilling

### 6.2 Through hole drilling 6.2.3 Through hole drills - *Excellent*



#### Shank 10 mm, HW solid

##### Application:

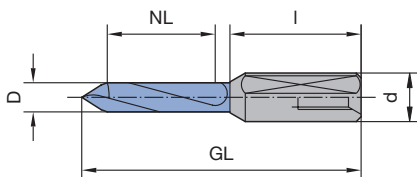
For drilling tear-free through holes, particularly in furniture construction, with maximised quality on the bottom side (exit).

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

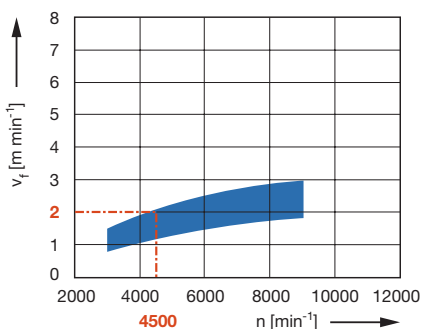
##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



Design without heel

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

MDF, solid wood = 0.7

Chipboard, uncoated = 1.3

##### Technical information:

V-point tip with 2 bevels for maximised quality on the bottom side (exit). Solid tungsten carbide design with high wear resistant tungsten carbide grade. High stability and long performance time. Polished gullet for minimum friction and feed forces. Very large reshaping area.

#### GL 57.5 mm, without heel, Z 2

WB 101 0 02

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	57.5	25	10x25	<b>034018</b> ●	<b>034019</b> ●
6	57.5	25	10x25	<b>034020</b> ●	<b>034021</b> ●
8	57.5	25	10x25	<b>034022</b> ●	<b>034023</b> ●

#### GL 70 mm, without heel, Z 2

WB 101 0 07

D	GL	NL	S	ID	ID
mm	mm	mm	mm	LH	RH
5	70	35	10x25	<b>034100</b> ●	<b>034101</b> ●
6	70	35	10x25	<b>034102</b> ●	<b>034103</b> ●
7	70	35	10x25	<b>034117</b> ●	<b>034118</b> ●
8	70	35	10x25	<b>034104</b> ●	<b>034105</b> ●
10	70	35	10x25	<b>034114</b> ●	<b>034115</b> ●

#### GL 100 mm, without heel, Z 2

WB 101 0 07

D	GL	NL	S	DRI	ID
mm	mm	mm	mm		
6	100	35	10x57	RH	<b>034116</b> ●

RPM:  $n = 3000 - 12000 \text{ min}^{-1}$

For diameters below 5 mm use type WB 101 0 04.

##### Spare parts:

BEZ	for S	ABM	BEM	ID
	mm	mm		
Allen screw	10x22/25/27	M5x8	Length adjustment	<b>006378</b> ●
Allen screw	10x57	M5x10	Length adjustment	<b>005802</b> ●
Anti-twist allen screw		M5x10	Length adjustment	<b>007438</b> ●
Length adjustment screw		M5x17	for quick-change drill	<b>009157</b> ●
Torx® 20			adaptors	





#### Shank 10 mm

##### Application:

For drilling tear-free through holes. Particularly suitable for drilling panel materials with abrasive components (fire proof material etc.).

##### Machine:

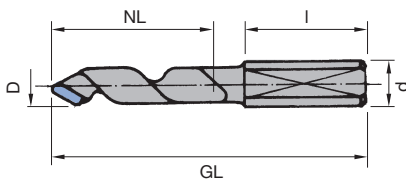
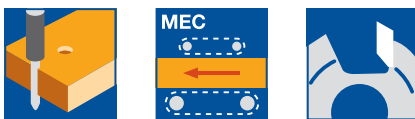
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Workpiece material:

Gypsum bonded particle and fibre materials, cement bonded particle and fibre materials, flame resistant particle and fibre materials, solid resin glulam, fibre reinforced plastics.

##### Technical information:

DP tipped through hole boring bit for maximum lifetime, particularly in abrasive materials. Large gullet for optimum chip removal.



WB 100 0 50

#### GL 70 mm, Z 1

WB 100 0 50

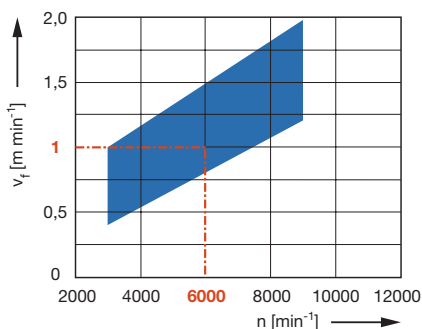
D mm	GL mm	NL mm	S mm	Z	ID LH	ID RH
5	70	30	10x27	1	091186 ●	091185 ●
6	70	30	10x27	1	091188 ●	091187 ●
8	70	30	10x27	1	091192 ●	091191 ●
10	70	30	10x27	1	091194 ●	091193 ●

RPM:  $n = 4000 - 9000 \text{ min}^{-1}$

##### Spare parts:

BEZ	ABM mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

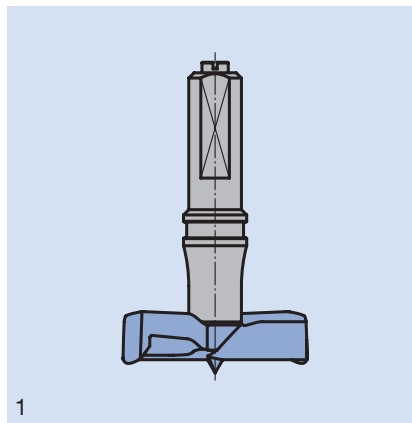
MDF = 0.7

Chipboard, uncoated = 1.2

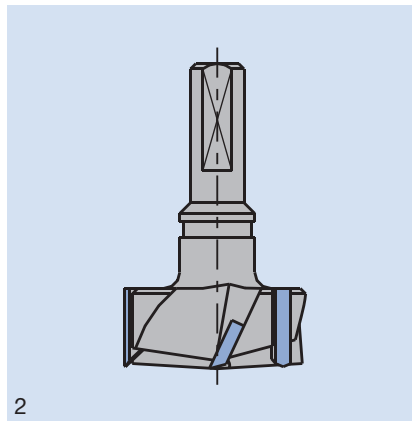
## 6. Drilling

### 6.3 Hinge drilling

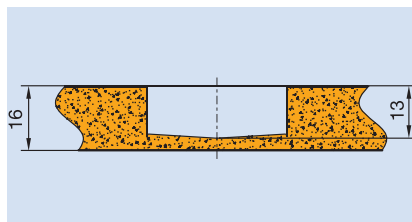
<b>Application</b>	To drill tear-free hinge holes.
<b>Workpiece material</b>	Softwood and hardwood. Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. Laminated veneer lumber (plywood, multiplex plywood etc.).
<b>Machine</b>	Through feed drilling machines, Point-to-point drilling machines, CNC machining centres, Hinge boring machines, Special purpose drilling machines.
<b>Design</b>	Two available hinge drill designs:



**1. Design with centre point,**  
2 spurs and 2 spiral cutting edges  
(Z 2/V 2). These drills are optimised for  
machining standard panels in the  
furniture industry.  
Design with short tip for deep holes  
in thin panels.



**2. Design without centre point,**  
3 spurs and 3 spiral cutting edges  
ground to a V point (Z 3/V 3). Recom-  
mended when there is the risk of the  
centre point marking or breaking  
through the back of the panel, e.g.  
when drilling a 13 mm deep hole in a  
16 mm thick workpiece.

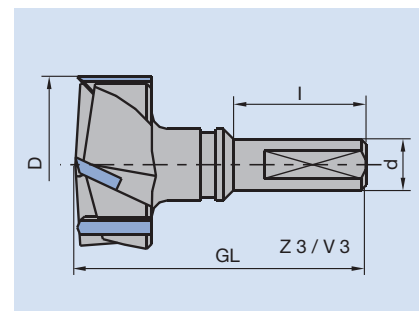
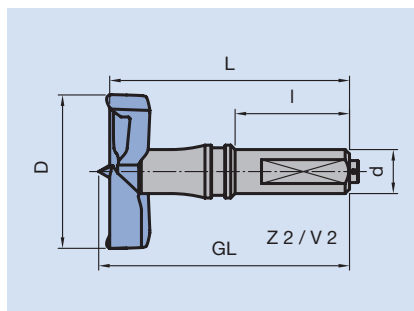


<b>Shank</b>	Hinge drills usually have a shank diameter of $d = 10 \text{ mm}$ .
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**Technical features**

The dimensions listed in the tool tables refer to the following tool parameters:

D	Drill diameter
d	Shank diameter
l	Shank length
L	Total length of the hinge drill excluding the projection of the centre point
GL	Total length of the hinge drill including the projection of the centre point

**Application data****RPM feed speeds**

The optimum RPM and feed speeds are detailed in the diagrams attached to the tool tables.



#### Shank 10 mm

##### Application:

For drilling hinge holes, particularly in furniture construction.

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

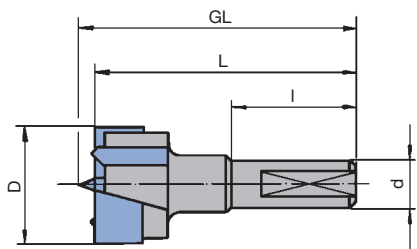
Good centering in solid wood by protruding centre point.



#### GL 57 mm, Z 2 / V 2

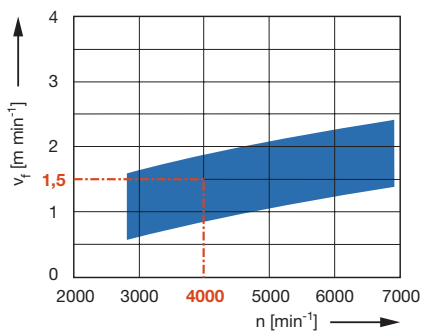
WB 310 0 04

D	GL	L	S	ID	ID
mm	mm	mm	mm	LH	RH
15	57	54.5	10x26	034630 ●	034631 ●
20	57	54.5	10x26		034637 ●
25	57	54.5	10x26		034643 ●
35	57	54.5	10x26		034651 ●
40	57	54.5	10x26		034677 ●



Z 2 / V 2 with centre point

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF, solid wood = 0.7

#### GL 70 mm, Z 2 / V 2

WB 310 0 04

D	GL	L	S	ID	ID
mm	mm	mm	mm	LH	RH
15	72.5	70	10x26	034663 ●	034664 ●
18	72.5	70	10x26		034678 ●
20	72.5	70	10x26	034665 ●	034666 ●
25	72.5	70	10x26		034668 ●
35	72.5	70	10x26	034671 ●	034672 ●

RPM:  $n = 2800 - 7000 \text{ min}^{-1}$

##### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

## 6. Drilling

### 6.3 Hinge drilling 6.3.2 Hinge drills, HW solid



#### Shank 10 mm

##### Application:

For drilling hinge holes, particularly in furniture construction, with increased lifetime and high-quality edge.

##### Machine:

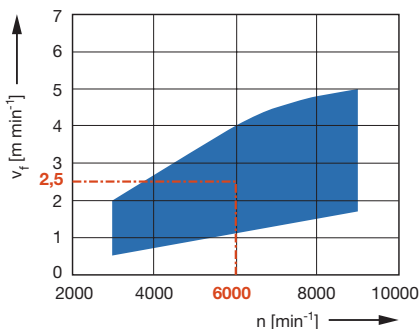
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Chipboard paper coated = 0.7

Chipboard veneered = 0.7

MDF plastic coated = 1.0

Glulam = 0.6

Solid wood = 1.0

##### Technical information:

Round spur geometry for increased edge quality. Solid tungsten carbide design. High wear resistant tungsten carbide grade. Tear-free edges in panels with glued plastic edgebanders when used on main spindle or stable drilling units.

#### GL 57 mm, Z 2 / V 2

WB 310 0 13

D mm	GL mm	L mm	S mm	ID LH	ID RH
15	57	54.5	10x26	034800 ●	034801 ●
16	57	54.5	10x26	034824 ●	034825 ●
18	57	54.5	10x26	034826 ●	034827 ●
20	57	54.5	10x26	034802 ●	034803 ●
22	57	54.5	10x26	034828 ●	034829 ●
24	57	54.5	10x26		034831 ●
25	57	54.5	10x26	034804 ●	034805 ●
26	57	54.5	10x26	034806 ●	034807 ●
28	57	54.5	10x26		034833 ●
30	57	54.5	10x26	034808 ●	034809 ●
35	57	54.5	10x26	034810 ●	034811 ●

#### GL 70 mm, Z 2 / V 2

WB 310 0 13

D mm	GL mm	L mm	S mm	ID LH	ID RH
15	70	68	10x26	034812 ●	034813 ●
18	70	68	10x26	034834 ●	034835 ●
20	70	68	10x26	034814 ●	034815 ●
25	70	68	10x26	034816 ●	034817 ●
26	70	68	10x26	034818 ●	034819 ●
30	70	68	10x26	034820 ●	034821 ●
34	70	68	10x26		037215 ●
35	70	68	10x26	034822 ●	034823 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

##### Spare parts:

BEZ	ABM mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●



#### Shank 10 mm, short centre point

##### Application:

For drilling hinge holes, particularly in furniture construction, with increased lifetime and high-quality edge.

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Workpiece material:

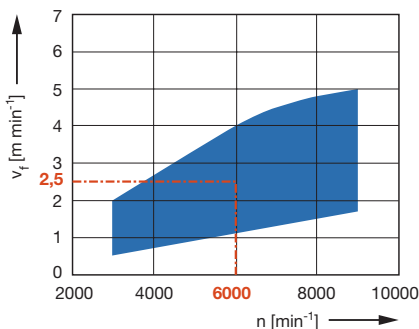
Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Round spur geometry for increased edge quality. Solid tungsten carbide design. High wear resistant tungsten carbide grade. Tear-free edges in panels with glued plastic edgebanders when used on main spindles or stable drilling units. Design with reduced protrusion of centre point and spurs for deep holes in thin panels.



Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Chipboard paper coated = 0.7

Chipboard veneered = 0.7

MDF plastic coated = 1.0

Glulam = 0.6

Solid wood = 1.0

##### GL 57 mm, Z 2 / V 2

WB 310 0 13

D mm	GL mm	L mm	S mm	ID LH	ID RH
15	57	54.5	10x26	034841 ●	034842 ●
20	57	54.5	10x26	034843 ●	034844 ●
25	57	54.5	10x26	034845 ●	034846 ●
26	57	54.5	10x26	034847 ●	034848 ●
35	57	54.5	10x26	037201 ●	037202 ●

##### GL 70 mm, Z 2 / V 2

WB 310 0 13

D mm	GL mm	L mm	S mm	ID LH	ID RH
15	70	68	10x26	037203 ●	037204 ●
20	70	68	10x26	037205 ●	037206 ●
25	70	68	10x26		037208 ●
26	70	68	10x26	037209 ●	037210 ●
30	70	68	10x26	037211 ●	037212 ●
35	70	68	10x26	037213 ●	037214 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

##### Spare parts:

BEZ	ABM mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●



#### Shank 10 mm, short centre point

##### Application:

For drilling hinge holes, particularly in furniture construction, with increased lifetime and high-quality edge. Design for higher feed speed in comparison to boring bits with Z 2 / V 2.

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

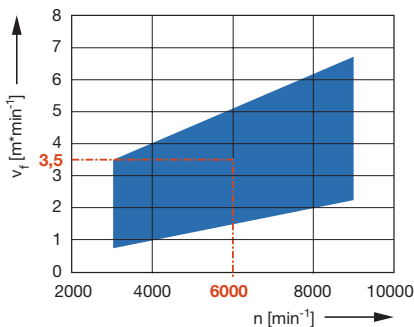
##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).



**HW**

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Chipboard paper coated = 0.7

Chipboard veneered = 0.7

MDF plastic coated = 1.0

Glulam = 0.6

Solid wood = 1.0

##### Technical information:

Round spur geometry for increased edge quality. Solid tungsten carbide design. High wear resistant tungsten carbide grade. Tear-free edges in panels with glued plastic edgebanders when used on main spindle, boring units as well as drilling machines.

#### GL 57 mm, Z 3 / V 3

WB 320 0 13

D	GL	L	S	ID	ID
mm	mm	mm	mm	LH	RH
18	57	54.5	10x26	037250 □	037251 □
20	57	54.5	10x26	037252 ●	037253 ●
22	57	54.5	10x26	037254 □	037255 □
24	57	54.5	10x26	037256 □	037257 □
25	57	54.5	10x26	037258 ●	037259 ●
26	57	54.5	10x26	037260 ●	037261 ●
28	57	54.5	10x26	037262 □	037263 □
30	57	54.5	10x26	037264 ●	037265 ●
35	57	54.5	10x26	037266 ●	037267 ●

#### GL 70 mm, Z 3 / V 3

WB 320 0 13

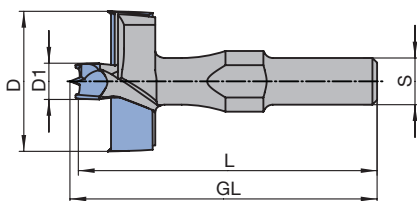
D	GL	L	S	ID	ID
mm	mm	mm	mm	LH	RH
18	70	68	10x26	037268 □	037269 □
20	70	68	10x26	037270 ●	037271 ●
25	70	68	10x26	037272 ●	037273 ●
26	70	68	10x26	037274 ●	037275 ●
30	70	68	10x26	037276 ●	037277 ●
34	70	68	10x26	037278 □	037279 □
35	70	68	10x26	037280 ●	037281 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

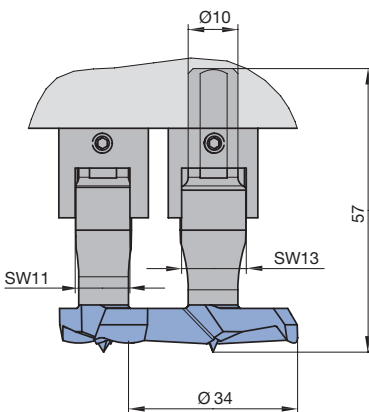
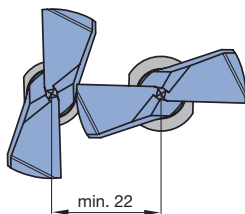
##### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●





Double hinge drill with pre-drill



Double hinge drills in aggregate

### Shank 10 mm, double furniture hinge

#### Application:

For drilling hinges and pivots in window manufacturing in single or twin drill design.

#### Machine:

Stationary routers with/without CNC control, machining centres, special boring machines for frame production, automatic boring machines, multi spindle units.

#### Workpiece material:

Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex plywood etc.), glued lumber.

#### Technical information:

Round spur geometry for high edge quality. Solid tungsten carbide design (ID 037218 / 037219 TC-tipped). High wear resistant tungsten carbide grade. Minimum distance of drill spindle 22 mm. ID 037218 / 037219 with pre-drill for corner pivots with pilot pin.

#### Boring bit set, consisting of 1 pc. RH and LH

AB 710 0

D	D1	GL	L	S	QAL	DRI	ID
mm	mm	mm	mm	mm			
34		57	54.5	10x23	HW solid	LH, RH	036784 □
30		57	54.5	10x23	HW solid	LH, RH	036785 □
30	8	66	64	10x23	HW	LH, RH	036786

Universally applicable for drilling hinges and pivots on machines and aggregates of the following manufacturers: Weinig, SCM, Ganner, Göttinger, Striffler etc.

#### GL 57 mm, Z 2 / V 2, single tool

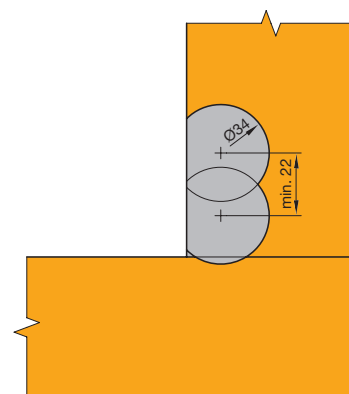
WB 203 0, WB 310 0 13

D	D1	GL	L	S	QAL	ID	ID
mm	mm	mm	mm	mm		LH	RH
34		57	54.5	10x23	HW solid	034839 ●	034838 ●
30		57	54.5	10x23	HW solid	037216 ●	037217 ●
30	8	66	64	10x23	HW	037218	037219

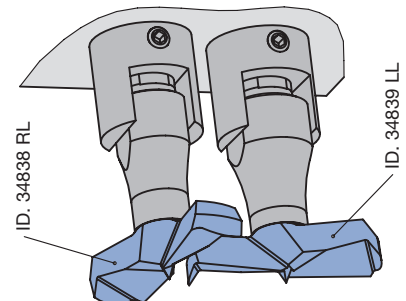
RPM: n = 3000 - 9000 min<sup>-1</sup>

#### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●



Application example:  
Double hinges for corner pivots.



## 6. Drilling

### 6.3 Hinge drilling 6.3.2 Hinge drills, HW solid



#### Shank 6 mm, Lamello® Cabineo®-System

##### Application:

For drilling the holes for the cabinet connectors of the Lamello® Cabineo®-System.

##### Machine:

Stationary routers with/without CNC control, machining centres, automatic boring machines, multi spindle units.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

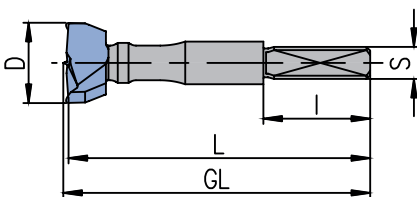
Round spur geometry for high edge quality. Solid tungsten carbide design. High wear resistant tungsten carbide grade.

##### Boring bit set, consisting of 1 pc. RL and 2 pcs. LL

AB 710 0

D	GL	L	S	QAL	DRI	ID
mm	mm	mm	mm			
15	57.5	56.5	6x20	HW solid	LH, RH	<b>036788</b> □

Can be used in aggregates from Benz and Atemag.



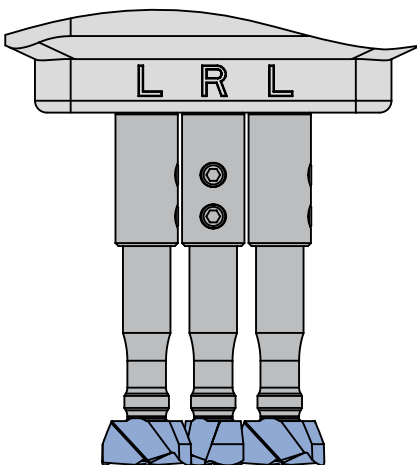
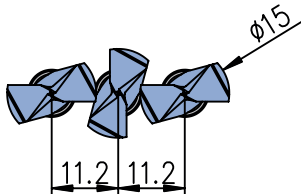
Z 2 / V 2 with centre point

##### GL 57 mm, Z 2 / V 2, single tool

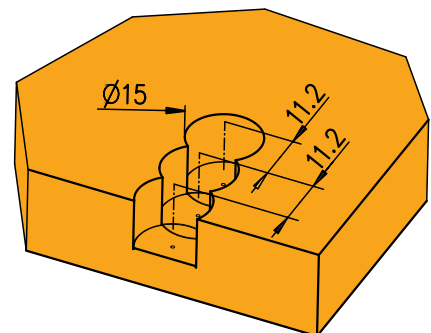
WB 310 0 13

D	GL	L	S	QAL	ID	ID
mm	mm	mm	mm		LH	RH
15	57.5	56.5	6x20	HW solid	<b>037220</b> ●	<b>037221</b> ●

RPM: n = 3000 - 9000 min<sup>-1</sup>



Drills in the unit



Application example:  
3-way drilling in the body component



#### Shank 10 mm

##### Application:

For drilling hinge holes, particularly in furniture construction.

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

Spurs and main cutting edge in turnblade design. Replaceable centre point, resharpenable and adjustable for deep holes near to the bottom surface layer without marks. Diameter constant tool.



#### GL 57 mm, Z 2 / V 2

WL 920 0

D	GL	L	S	ID
mm	mm	mm	mm	RH
35	57	54.5	10x26	034565 ●

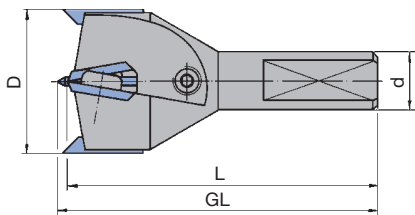
RPM:  $n = 2800 - 7000 \text{ min}^{-1}$

##### Spare knives:

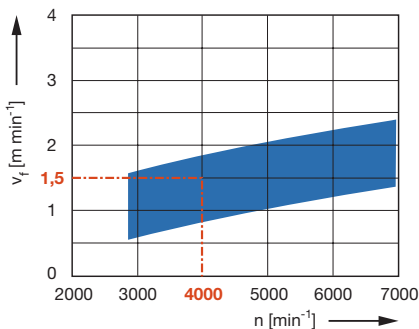
BEZ	ABM	QAL	BEM	ID
	mm			
Turnblade knife	15.7x12x1.5	HW	Ø35	007673 ●
Turnblade spur	18x6x3.5	HW		007669 ●
Centering pin	D3x40			008151 ●

##### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Screw	M3.5x4 (head D7)		006068 ●
Countersink screw	M3,5x6	Clamping screw for spur	007062 ●
Allen screw	M6x4	Clamping screw for centre point	005837 ●
Torx® key	Torx® 15		005457 ●
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw	M5x17	for quick-change drill	009157 ●
Torx® 20		adaptors	



Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF = 0.7



#### Shank 10 mm

##### Application:

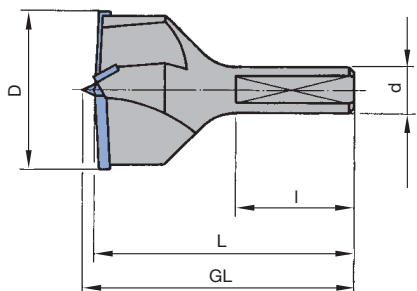
For drilling hinge holes, particularly in furniture construction with maximum durability. Specially for drilling materials with hard and abrasive coatings (e.g. HPL, CPL etc.).

##### Machine:

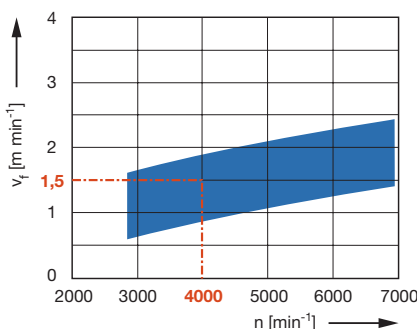
Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units.

##### Workpiece material:

Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., fire resistant particle and fibre materials, laminated veneer lumber (plywood, multiplex plywood etc.).



Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Veneered = 0.8

Paper coated = 0.8

MDF = 0.7

##### Technical information:

DP tipped for increased performance time compared to tungsten carbide. Suitability for high volume production. Diamaster PRO tipping, resharpenable two/three times with normal wear. Preferred used on automatic machines. Drills can only be used in vertical drilling machines when workpieces are clamped tightly.

##### GL 57 / GL 70 mm, Z 2 / V 2

WB 310 0 50

D mm	GL mm	L mm	S mm	ID LH	ID RH
15	70	68.5	10x26		191023 ●
20	57	54.5	10x26		191022 ●
25	70	68.5	10x26		091197 ●
26	70	68.5	10x26		191029 ●
35	57	54.5	10x26		091181 ●
35	70	68.5	10x26	091184 ●	091183 ●

RPM:  $n = 2800 - 7000 \text{ min}^{-1}$

##### Spare parts:

BEZ	ABM mm	BEM	ID
Allen screw	M5x10	Length adjustment	005802 ●
Anti-twist allen screw	M5x10	Length adjustment	007438 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●

**Application** To drill holes for the furniture industry and in timber frame construction.

**Workpiece material**  
**[recommended cutting material]** Softwood and hardwood.  
 Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. [only HW].  
 Laminated veneer lumber (plywood, multiplex plywood etc.) [only HW].

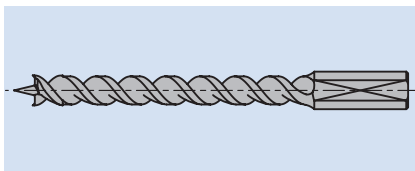
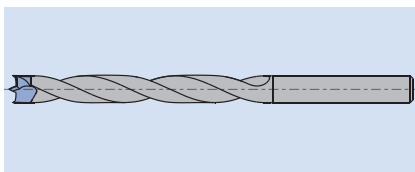
**Machine** Column drilling machines,  
 Drilling machines,  
 Special purpose drilling machines,  
 Portable drills.

### Design

#### 1. Twist drills

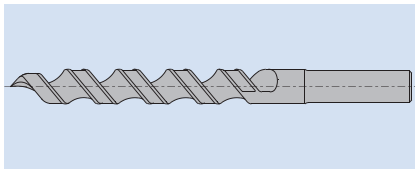
Twist drills with a centre point and spurs (Z 2/V 2) are used to drill holes deeper than possible with dowel drills.

There is a choice of cutting materials – SP, HS and HW. The matrix shows the recommended cutting material for the different workpiece materials:



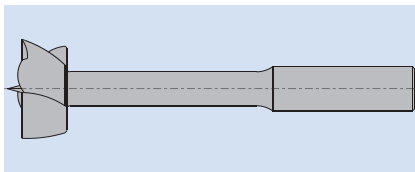
	SP	HS	HW
Softwood, dry	◆	◆	◆
Softwood, wet	◆	◆	◇
Hardwood, dry	◇	◆	◆
Hardwood, wet	◇	◆	◇
Laminated wood (plywood, etc.)			◆
Chipboard and fibre materials			
- paper coated			◆
- plastic coated			◆
- veneered			◆
Solid wood, veneered			◆
◆ suitable   ◇ partly suitable			

Tungsten carbide spiral drills are available with single or double heel. The design with double heel improves guidance during boring and return stroke and reduces the friction between flute and hole. Solid tungsten carbide Z 2/V 2 design suitable for drilling deep holes in solid wood without interim clearance strokes and for high feed speeds.



#### 2. Levin type drill

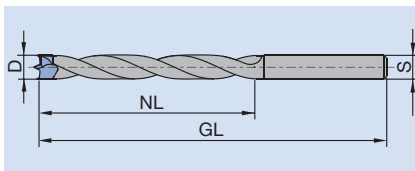
Levin type drills are used to drill deep holes. The key feature is a spiral flute with a large chip gullet cross section giving excellent chip clearance. With V point in HS, recommended for through hole drilling and drilling holes in end grain.



#### 3. Cylinder head drills

Cylinder head drills are used to drill tear-free holes in solid wood, for blind holes, for hinge holes and holes for repair plugs.

### Technical features



The dimensions listed in the tool tables refer to the following tool parameters:

D	Drill diameter
S	Shank diameter x shank length
NL	Working length = possible drilling depth
GL	Total length of the drill including the projection of the centre point

### Application data

#### RPM/feed speeds

The optimum RPM and feed speeds are detailed in the diagrams attached to the tool tables.



#### HW solid, Z 2

##### Application:

For multi-purpose drilling of blind and through holes.

##### Machine:

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units, column drilling machines, portable drills.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), plastics (thermoplastic, fibre reinforced etc.), NF-metals (aluminium, copper etc.).



##### Technical information:

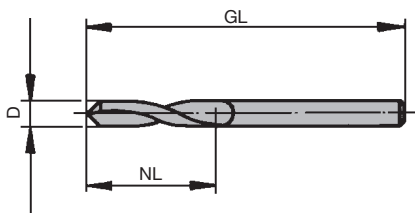
Flat V-point. Shank diameter identical to drill diameter. Convert for shank D 10 mm with reducing sleeve TB 110 0 or PM 320 0 25 (see following pages). Drilling in NF-metal requires suitable lubrication (spray mist or minimal lubrication).

##### V-point 120°

WB 101 0 04

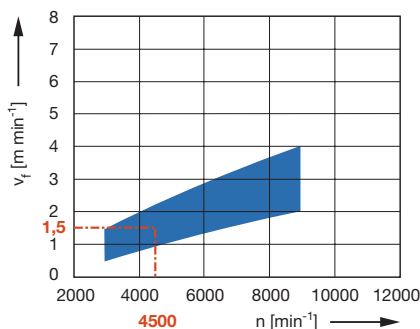
D mm	GL mm	NL mm	QAL	ID LH	ID RH
2	40	17.5	HW solid	<b>034410 ●</b>	<b>034411 ●</b>
2.5	40	18	HW solid	<b>034412 ●</b>	<b>034413 ●</b>
3	46	16	HW solid	<b>034414 ●</b>	<b>034415 ●</b>
3.2	49	18	HW solid	<b>034420 ●</b>	<b>034421 ●</b>
3.5	52	20	HW solid	<b>034416 ●</b>	<b>034417 ●</b>
4	55	22	HW solid	<b>034418 ●</b>	<b>034419 ●</b>
5	62	26	HW solid	<b>034424 ●</b>	<b>034425 ●</b>

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$



WB 101 0 04

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

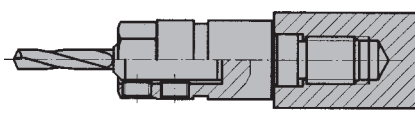
##### Operation:

Drilling

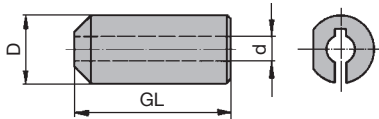
##### Correction factor for $v_f$ :

MDF, solid wood = 0.7

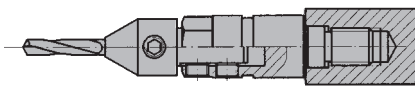
Chipboard, uncoated = 1.3



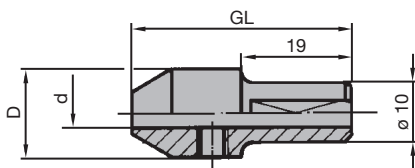
Drill bit clamping using the reducing sleeve TB 110 0 to use the full drill working length



Reducing sleeve with short clamping length



Drill bit clamping with increased stability using reducing sleeve PM 320 0 25



Reducing sleeve with increased clamping length

#### Application:

For clamping of twist drills WB 101 0 04. This enables the complete utilization of the drill working length.

#### Technical information:

Adaptor can be used in drilling spindles or adjustable drill chucks with side clamping screw. Not suitable for use in most quick-change drill adaptors such as PM 320 0 55/56/57/58/59.

#### Reducing sleeves with short clamping length

TB 110 0

D mm	d mm	GL mm	ID
10	2	23	034520 ●
10	2.5	23	034521 ●
10	3	23	034522 ●
10	3.18 / 3.2	23	034525 ●
10	3.5	23	034523 ●
10	4	23	034524 ●
10	5	23	034526 ●

#### Application:

For clamping of twist drills WB 101 0 04 with reduced risk of breaking of the clamped drill by reducing the length of the unsupported drill.

#### Technical information:

Adaptor with shank 10 mm and clamping area. Usable in drilling spindles or drill chucks with side clamping screw. By mounting the length adjustment screw ID 009157 in the shank of the reducing sleeve, easy clamping in the quick-change drill chuck PM 320 0 55/56/57/58/59 is possible.

#### Reducing sleeves with increased clamping length

PM 320 0 25

D mm	d mm	GL mm	S mm	ID
15	2	38	10x19	034490 ●
15	2.5	38	10x19	034491 ●
15	3	38	10x19	034492 ●
15	3.18 / 3.2	38	10x19	034495 ●
15	3.5	38	10x19	034493 ●
15	4	38	10x19	034494 ●
15	5	38	10x19	034496 ●

#### Spare parts:

BEZ	ABM mm	BEM	ID
Allen key	SW 3		005433 ●
Allen screw	M6x5		005836 ●
Length adjustment screw Torx® 20	M5x17	for quick-change drill adaptors	009157 ●





#### HS solid, Z 2 / V 2

##### Application:

For multi-purpose drilling of tear-free blind holes.

##### Machine:

Column drilling machines, drilling machines, multi spindle units, special purpose drilling machines, portable drills.

##### Workpiece material:

Softwood and hardwood, laminated veneer lumber (plywood, multiplex plywood etc.), plastics (thermoplastic).

##### Technical information:

Design in HS solid with long centre point and round spurs. Shank diameter identical to drill diameter. Design with single heel to reduce friction in the hole.



WB 120 0 02/05, with single heel

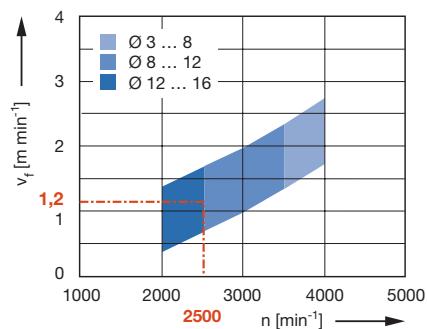
##### Shank diameter identical to drill diameter

WB 120 0 05

D	GL	NL	S	QAL	DRI	ID
mm	mm	mm	mm			
3	70	35	3x30	HS	RH	035852 ●
4	80	45	4x30	HS	RH	035853 ●
4.5	85	50	4.5x30	HS	RH	035892 ●
5	90	50	5x30	HS	RH	035854 ●
5.5	95	55	5.5x35	HS	RH	035893 ●
6	100	60	6x35	HS	RH	035855 ●
6.5	105	65	6.5x35	HS	RH	035894 ●
7	110	65	7x40	HS	RH	035856 ●
7.5	115	70	7.5x40	HS	RH	035895 ●
8	120	75	8x40	HS	RH	035857 ●
10	140	85	10x50	HS	RH	035859 ●
12	155	95	12x50	HS	RH	035861 ●

RPM:  $n = 1500 - 4000 \text{ min}^{-1}$

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Softwood

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Hardwood = 0.7

**HW, Z 2 / V 2, with heel****Application:**

For multi-purpose drilling of tear-free blind holes.

**Machine:**

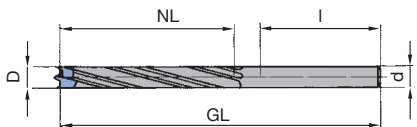
Column drilling machines, drilling machines, multi spindle units, special purpose drilling machines, portable drills.

**Workpiece material:**

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

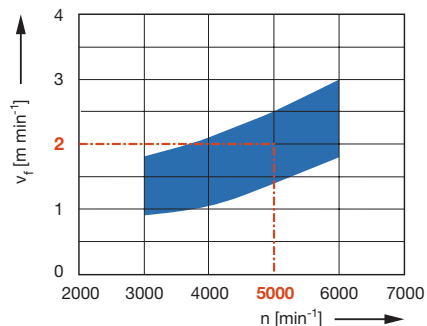
**Technical information:**

Tungsten carbide tipped design. Shank diameter identical to the drill diameter. Design with double heel for improved guidance during drilling and return stroke from the hole.



WB 120 0 25/27, with double heel

Feed speed  $v_f$  depending on the spindle RPM  $n$

**Workpiece material:**

Chipboard plastic coated

**Operation:**

Drilling

**Correction factor for  $v_f$ :**

Solid wood = 0.7

Laminated veneer lumber = 0.8

When drilling holes with a depth greater than  $4 \times D$  interim clearance stroke is recommended!

**Short design**

WB 120 0 27

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
5	70	35	5x35	HW	RH	035885 ●
6	70	35	6x35	HW	RH	035886 ●
8	70	35	8x35	HW	RH	035888 ●
10	70	35	10x35	HW	RH	035889 ●

**Long design**

WB 120 0 25

D mm	GL mm	NL mm	S mm	QAL	DRI	ID
4	80	55	4x25	HW	RH	035882 ●
5	90	60	5x30	HW	RH	035872 ●
6	100	65	6x35	HW	RH	035874 ●
7	110	70	7x40	HW	RH	035876 ●
8	120	75	8x45	HW	RH	035877 ●
9	130	80	9x50	HW	RH	035878 ●
10	140	90	10x50	HW	RH	035879 ●
12	155	100	12x55	HW	RH	035881 ●

RPM:  $n = 3000 - 6000 \text{ min}^{-1}$

**HW solid, Z 2 / V2, with heel****Application:**

For drilling deep holes. Particularly suitable for drilling connection and dowel holes in timber frame and window construction.

**Machine:**

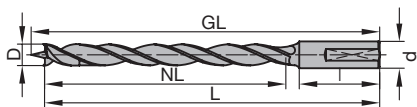
Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

**Workpiece material:**

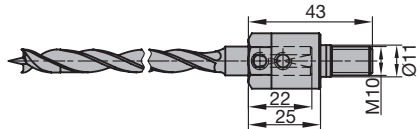
Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.

**Technical information:**

Design in solid tungsten carbide, Z 2/V 2 and centre point. Extra-long centre point for use of the drills at an angle. Design with double heel for improved guidance while drilling and return stroke from the hole. Shank design with reduced clamping area for good centering in shrink and collet chucks.

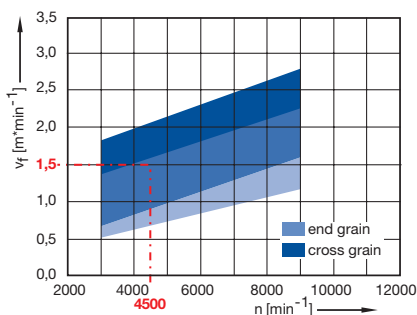
**HW**

WB 120 0 35, solid tungsten carbide drill



WB 120 0 35, solid tungsten carbide drill with adaptor

Feed speed  $v_f$  depending on the spindle RPM  $n$

**Workpiece material:**

Softwood

**Operation:**

Drilling

**Correction factor for  $v_f$ :**

Hardwood = 0.8

Laminated veneer lumber = 1.1

**GL 105 mm**

WB 120 0 35

D mm	GL mm	L mm	NL mm	S mm	QAL	DRI	ID with adaptor	ID without adaptor
6	105	100.5	70	10x25	HW solid	RH	<b>230158</b> □	<b>230058</b> ●
6	105	100.5	70	10x25	HW solid	LH	<b>230159</b> □	<b>230059</b> ●
8	105	100	70	10x25	HW solid	RH	<b>230160</b> □	<b>230060</b> ●
8	105	100	70	10x25	HW solid	LH	<b>230161</b> □	<b>230061</b> ●
10	105	99.5	70	10x25	HW solid	RH	<b>230162</b> □	<b>230062</b> ●
10	105	99.5	70	10x25	HW solid	LH	<b>230163</b> □	<b>230063</b> ●
12	105	99	70	10x25	HW solid	RH	<b>230164</b> □	<b>230064</b> ●
12	105	99	70	10x25	HW solid	LH	<b>230165</b> □	<b>230065</b> ●

**GL 130 mm**

WB 120 0 35

D mm	GL mm	L mm	NL mm	S mm	QAL	DRI	ID with adaptor	ID without adaptor
6	130	125.5	90	10x30	HW solid	RH	<b>230150</b> □	<b>230050</b> ●
6	130	125.5	90	10x30	HW solid	LH	<b>230151</b> □	<b>230051</b> ●
6.5	130	125.5	90	10x30	HW solid	RH	<b>230170</b> □	<b>230070</b> ●
8	130	125	90	10x30	HW solid	RH	<b>230152</b> □	<b>230052</b> ●
8	130	125	90	10x30	HW solid	LH	<b>230153</b> □	<b>230053</b> ●
10	130	124.5	90	10x30	HW solid	RH	<b>230154</b> □	<b>230054</b> ●
10	130	124.5	90	10x30	HW solid	LH	<b>230155</b> □	<b>230055</b> ●
12	130	124	90	10x30	HW solid	RH	<b>230156</b> □	<b>230056</b> ●
12	130	124	90	10x30	HW solid	LH	<b>230157</b> □	<b>230057</b> ●

**GL 150 mm**

WB 120 0 35

D mm	GL mm	L mm	NL mm	S mm	QAL	DRI	ID without adaptor
14	150	143.5	100	10x30	HW solid	RH	<b>230066</b> ●
16	150	143	100	10x30	HW solid	RH	<b>230068</b> ●

**RPM:**  $n = 3000 - 9000 \text{ min}^{-1}$



### HW solid, Z 2 / V 2, Marathon

#### Application:

For drilling very deep holes without interim clearance strokes. Particularly suitable for drilling connection and dowel holes in timber frame and window construction.

#### Machine:

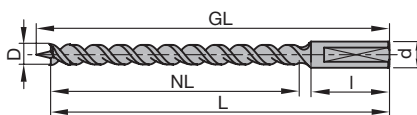
Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

#### Workpiece material:

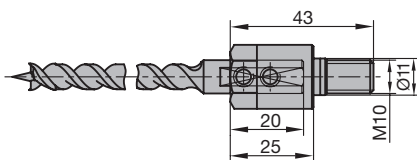
Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.

#### Technical information:

Design in solid tungsten carbide, Z 2/V 2 and centre point. Marathon coating for increased performance time. Extra-long centre point for use of the drills at an angle. Very large gullets for perfect chip removal particularly when drilling in end grain. Shank design with reduced clamping area for good centering in shrink and collet chucks.

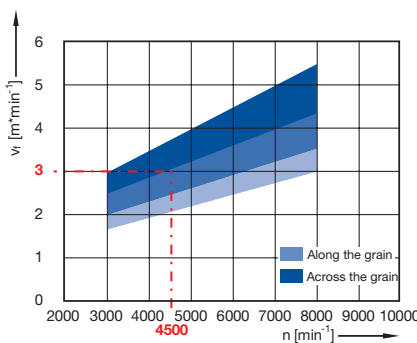


WB 120 0 34, solid tungsten carbide drill



WB 120 0 34, solid tungsten carbide drill with adaptor

Feed speed  $v_f$  depending on the spindle RPM  $n$



#### GL 105 mm

WB 120 0 34

D mm	GL mm	L mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
3	105	102	70	10x25	RH	230121 □	230021 ●
3.5	105	102	70	10x25	RH	230122 □	230022 ●
4.5	105	101	70	10x25	RH	230123 □	230023 ●
6	105	100.5	70	10x25	RH	230108 □	230008 ●
6	105	100.5	70	10x25	LH	230109 □	230009 ●
8	105	99.5	70	10x25	RH	230110 □	230010 ●
8	105	99.5	70	10x25	LH	230111 □	230011 ●
10	105	98.5	70	10x25	RH	230112 □	230012 ●
10	105	98.5	70	10x25	LH	230113 □	230013 ●
12	105	97.5	70	10x25	RH	230114 □	230014 ●
12	105	97.5	70	10x25	LH	230115 □	230015 ●

#### GL 130 mm

WB 120 0 34

D mm	GL mm	L mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
6	130	125.5	90	10x30	RH	230100 □	230000 ●
6	130	125.5	90	10x30	LH	230101 □	230001 ●
6.5	130	125.5	90	10x30	RH	230120 □	230020 ●
8	130	124.5	90	10x30	RH	230102 □	230002 ●
8	130	124.5	90	10x30	LH	230103 □	230003 ●
10	130	123.5	90	10x30	RH	230104 □	230004 ●
10	130	123.5	90	10x30	LH	230105 □	230005 ●
12	130	122.5	90	10x30	RH	230106 □	230006 ●
12	130	122.5	90	10x30	LH	230107 □	230007 ●

#### Diameter:

$D \leq 6$  mm

#### Workpiece material:

Softwood

#### Operation:

Drilling

#### Correction factor for $v_f$ :

Hardwood = 0.8

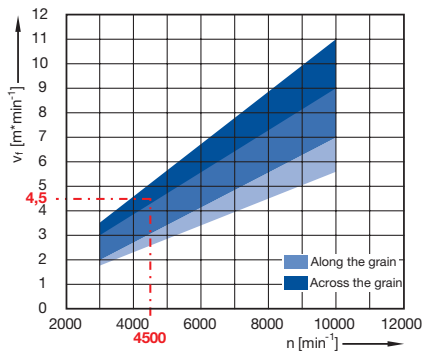
Laminated veneer lumber = 1.2

## 6. Drilling

## 6.4 Multi-purpose drilling

### 6.4.1 Twist drills

Feed speed  $v_f$  depending on the spindle RPM  $n$



**Diameter:**

$D = 6 - 12 \text{ mm}$

**Workpiece material:**

Softwood

**Operation:**

Drilling

**Correction factor for  $v_f$ :**

Hardwood = 0.8

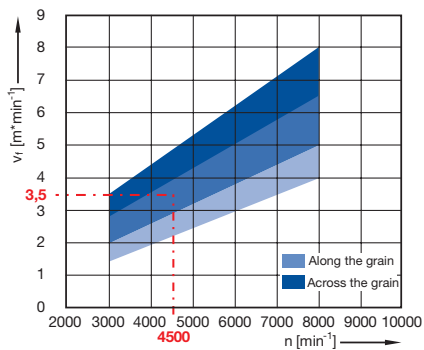
Laminated veneer lumber = 1.2

**GL 150 mm**

WB 120 0 34

D mm	GL mm	L mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
14	150	140.5	100	10x30	RH	230116 □	230016 ●
16	150	140	100	10x30	RH	230118 □	230018 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$



**Diameter:**

$D > 12 \text{ mm}$

**Workpiece material:**

Softwood

**Operation:**

Drilling

**Correction factor for  $v_f$ :**

Hardwood = 0.8

Laminated veneer lumber = 1.2



#### HW solid, Z 2, V-point

##### Application:

For drilling deep holes. Particularly for timber frame and window construction.

##### Machine:

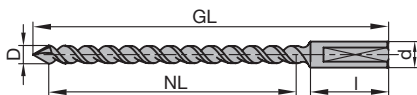
Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

##### Workpiece material:

Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.

##### Technical information:

Solid tungsten carbide design, Z 2 with V-point. Design with double heel for improved guidance while drilling and return stroke from the hole. Shank design with reduced clamping area for good centering in shrink and collet chucks.



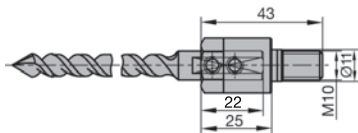
WB 101 0 13, twist drill with V-point

#### GL 130 / 160 mm

WB 101 0 13

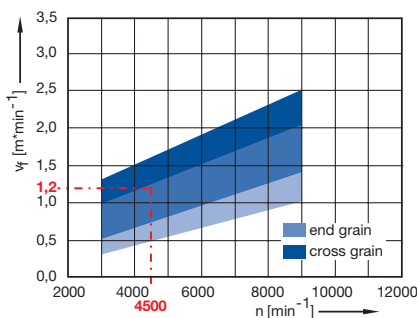
D mm	GL mm	NL mm	S mm	QAL	DRI	ID with adaptor	ID without adaptor
7	130	90	10x30	HW solid	RH	<b>230451</b> □	<b>230351</b> ●
8	160	120	10x30	HW solid	RH	<b>230455</b> □	<b>230355</b> ●
9	160	120	10x30	HW solid	RH	<b>230452</b> □	<b>230352</b> ●
10	160	120	10x30	HW solid	RH	<b>230453</b> □	<b>230353</b> ●
12	160	120	10x30	HW solid	RH	<b>230454</b> □	<b>230354</b> ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$



WB 101 0 13, twist drill with V-point, with adaptor

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Softwood

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Hardwood = 0.8

Laminated veneer lumber = 1.1



#### HW solid, Z 2, V-point, Marathon

##### Application:

For drilling very deep holes without interim clearance strokes at high feed speed particularly for timber frame and window construction.

##### Machine:

Stationary routers with/without CNC control, machining centres, special cutting machines to machine frame parts, column drilling machines, drilling machines, multi spindle units, portable drills.

##### Workpiece material:

Softwood and hardwood, modified timber for window construction, laminated veneer lumber (plywood, multiplex etc.), glued lumber.



##### Technical information:

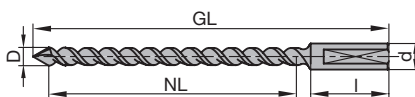
Solid tungsten carbide design, Z 2 with V-point. Marathon coating for increased performance time. Large gullets for perfect chip removal. Shank design with reduced clamping area for good centering in shrink and collet chucks.

##### GL 130 / 160 mm

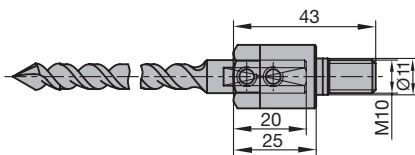
WB 101 0 12

D mm	GL mm	NL mm	S mm	DRI	ID with adaptor	ID without adaptor
6	130	90	10x30	RH	230400 □	230300 ●
7	130	90	10x30	RH	230401 □	230301 ●
8	160	120	10x30	RH	230405 □	230305 ●
9	160	120	10x30	RH	230402 □	230302 ●
10	160	120	10x30	RH	230403 □	230303 ●
12	160	120	10x30	RH	230404 □	230304 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$

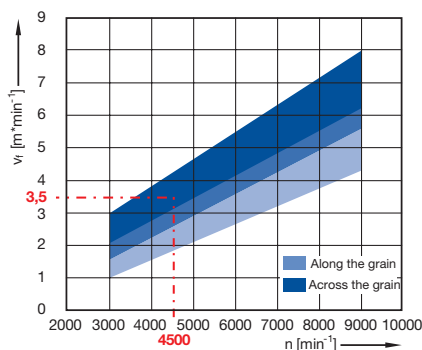


WB 101 0 12,  
twist drill with V-point



WB 101 0 12,  
twist drill with V-point, with adaptor

Feed speed  $v_f$  depending on the spindle  
RPM  $n$



##### Diameter:

$D = 6 - 12 \text{ mm}$

##### Workpiece material:

Softwood

##### Operation:

Drilling, through hole

##### Correction factor for $v_f$ :

Hardwood = 0.8

Laminated veneer lumber = 1.2





#### HS solid, Z 1

##### Application:

For drilling deep holes. Suitable for depths up to approx. 4 x D without interim clearance strokes.

##### Machine:

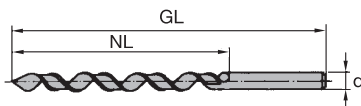
Column drilling machines, drilling machines, multi spindle units, special purpose drilling machines, portable drills.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Solid HS design, Z 1. V-point for producing tear-free holes on both sides when drilling through holes. Very large gullets for perfect chip removal particularly when drilling in end grain.



##### V-point for through hole drilling

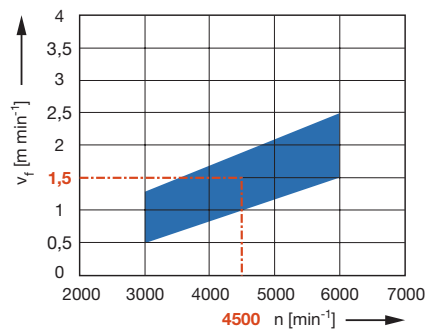
WB 100 0

D mm	GL mm	NL mm	S mm	QAL	Z	DRI	ID
5	90	50	5x35	HS	1	RH	<b>036110 ●</b>
6	100	60	6x35	HS	1	RH	<b>036111 ●</b>
8	120	80	8x40	HS	1	RH	<b>036112 ●</b>
10	120	80	10x40	HS	1	RH	<b>036113 ●</b>
12	140	100	12x40	HS	1	RH	<b>036114 ●</b>

**RPM:**  $n = 3000 - 6000 \text{ min}^{-1}$

WB 100 0, with V-point

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Solid wood

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Drilling depth  $> 4 \times D = 0.8$



#### HW, Z 1 / V 1

##### Application:

For drilling deep holes. Suitable for depths up to 75 mm without interim clearance strokes. Particularly suitable for producing joint holes in timber frame construction.

##### Machine:

Column drilling machines, drilling machines, multi spindle units, special purpose drilling machines, portable drills.

##### Workpiece material:

Softwood and hardwood, laminated veneer lumber (plywood, multiplex plywood etc.), glued lumber.

##### Technical information:

Tungsten carbide design, Z 1/V 1 and centre point. Very large gullets for good chip removal, particularly when drilling in end grain.

##### Drill point for blind holes

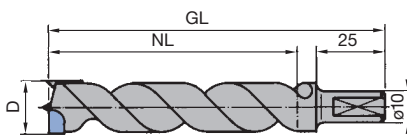
WB 110 0

D	GL	NL	S	QAL	ID	ID
mm	mm	mm	mm		LH	RH
12	110	80	10x25	HW	<b>036174 ●</b>	<b>036175 ●</b>
14	110	80	10x25	HW		<b>036177 ●</b>
16	110	80	10x25	HW	<b>036178 ●</b>	<b>036179 ●</b>

RPM:  $n = 3000 - 7500 \text{ min}^{-1}$

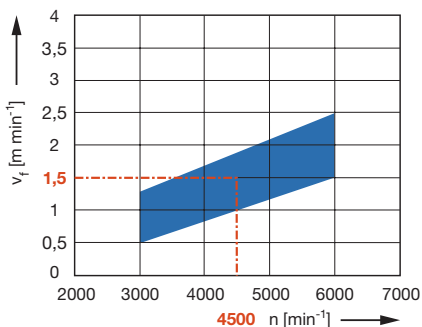
##### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Allen screw	M5x10	Length adjustment	<b>005802 ●</b>
Anti-twist allen screw	M5x10	Length adjustment	<b>007438 ●</b>



WB 110 0, shank with clamping flat and adjusting screw

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Solid wood

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Drilling depth  $> 4 \times D = 0.8$



#### SP, Z 2 / V 2

##### Application:

For drilling hinge holes, particularly in furniture construction and for fittings in timber construction.

##### Machine:

Column drilling machines, special purpose drilling machines, portable drills.

##### Workpiece material:

Softwood.

##### Technical information:

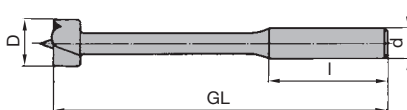
SP solid, Z 2/V 2. Shank 10 mm suitable for stationary boring machines and portable drills.



##### Shank 10 mm

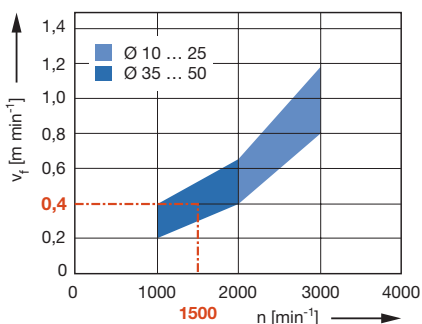
WB 310 0 03

D mm	GL mm	S mm	DRI	ID
15	90	10x55	RH	036650 ●
20	90	10x55	RH	036655 ●
25	90	10x70	RH	036658 ●
30	90	10x70	RH	036661 ●
35	90	10x65	RH	036664 ●
40	90	10x65	RH	036667 ●



WB 310 0 02, reinforced shank  
13/16 mm

Feed speed  $v_f$  depending on the spindle  
RPM  $n$



##### Workpiece material:

Softwood

##### Operation:

Drilling

##### Technical information:

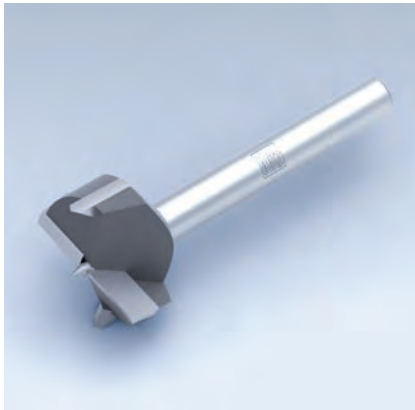
SP solid, Z 2/V 2. Reinforced shank for heavy machining in column drilling machines and powerful portable drills.

##### Shank 13 / 16 mm, reinforced design

WB 310 0 02

D mm	GL mm	S mm	DRI	ID
10	120	13x50	RH	036421 ●
12	120	13x50	RH	036422 ●
15	140	13x50	RH	036424 ●
20	140	13x50	RH	036427 ●
25	140	13x50	RH	036430 ●
30	140	13x50	RH	036433 ●
35	140	16x50	RH	036436 ●

RPM:  $n = 1000 - 3000 \text{ min}^{-1}$



#### HW, Z 2 / V 2

##### Application:

For drilling hinge holes, particularly in furniture construction.

##### Machine:

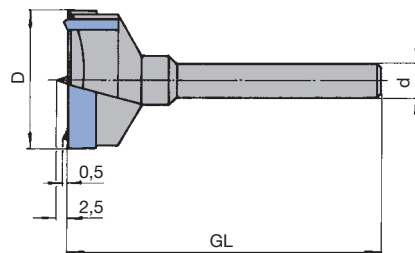
Column drilling machines, drilling machines, special purpose drilling machines, portable drills.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Tungsten carbide design, Z 2/V 2. Shank 10 mm suitable for stationary drilling machines and portable drills.



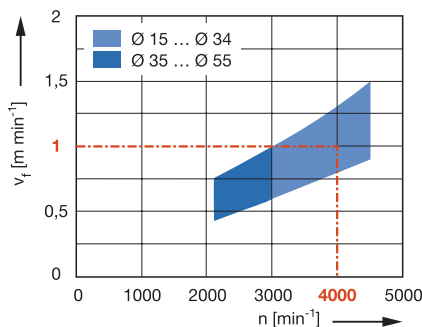
##### Shank 10 mm WB 310 0 03

D mm	GL mm	S mm	DRI	ID
15	90	10x55	RH	036668 ●
16	90	10x55	RH	036669 ●
17	90	10x55	RH	036670 ●
18	90	10x55	RH	036671 ●
19	90	10x55	RH	036672 ●
20	90	10x55	RH	036673 ●
22	90	10x55	RH	036674 ●
24	90	10x70	RH	036676 ●
25	90	10x70	RH	036677 ●
26	90	10x70	RH	036678 ●
28	90	10x70	RH	036679 ●
30	90	10x70	RH	036680 ●
34	90	10x65	RH	036682 ●
35	90	10x65	RH	036683 ●
40	90	10x65	RH	036686 ●

RPM:  $n = 1200 - 4500 \text{ min}^{-1}$

WB 310 0 03, shank 10 mm,  
GL = 90 mm

Feed speed  $v_f$  depending on the spindle  
RPM  $n$



##### Workpiece material:

Hardwood

##### Operation:

Drilling

##### Correction factor for $v_f$ :

Chipboard = 1.2

Laminated veneer lumber = 1.1



#### HW, Z 2 / V 2

##### Application:

For drilling hinge holes, particularly in furniture construction.

##### Machine:

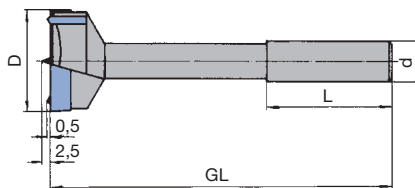
Column drilling machines, drilling machines, special purpose drilling machines, portable drills.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Tungsten carbide design, Z 2/V 2. Reinforced shank for heavy machining in column drilling machines and powerful portable drills.



##### Shank 13 / 16 mm, reinforced design

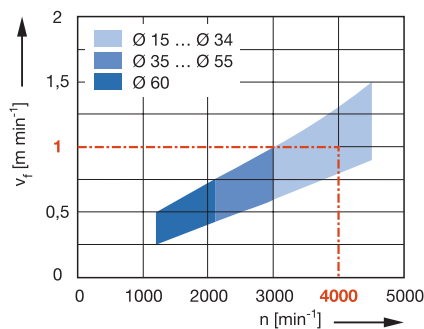
WB 310 0 02

D	GL	S	DRI	ID
mm	mm	mm		
20	140	13x50	RH	036462 ●
22	140	13x50	RH	036463 ●
25	140	13x50	RH	036465 ●
30	140	13x50	RH	036468 ●
35	140	16x50	RH	036471 ●
40	140	16x50	RH	036474 ●
50	150	16x50	RH	036480 ●
55	150	16x50	RH	036483 ●
60	150	16x50	RH	036486 ●

RPM:  $n = 1200 - 4500 \text{ min}^{-1}$

Tungsten carbide tipping with large resharping area

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Hardwood

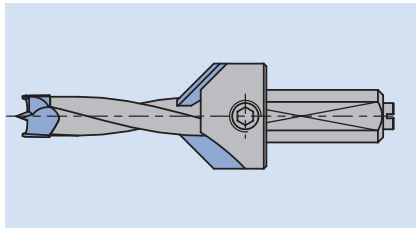
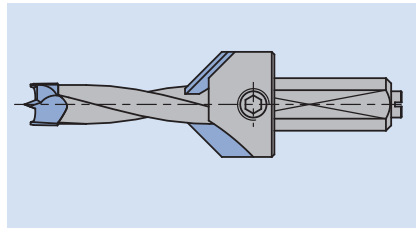
##### Operation:

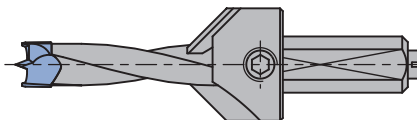
Drilling

##### Correction factor for $v_f$ :

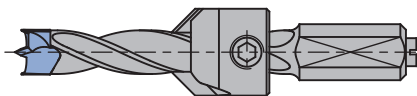
Chipboard = 1.2

Laminated veneer lumber = 1.1

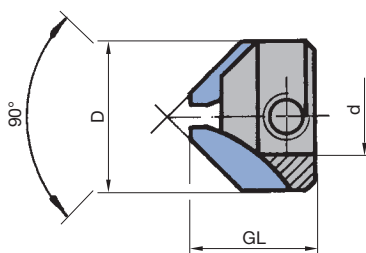
<b>Application</b>	Countersink of holes.
<b>Workpiece material [recommended cutting material]</b>	<p>Softwood and hardwood.</p> <p>Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc. [only HW].</p> <p>Laminated veneer lumber (plywood, multiplex plywood etc.) [only HW].</p> <p>Plastomers [only HW].</p> <p>Duromers [only HW].</p> <p>Solid surface material (Corian, Varicor, Noblan, etc.) [only HW].</p> <p>Decorative laminates (HPL-compact laminate, Trespa etc.) [only HW].</p> <p>Compound materials [only HW].</p> <p>Non-ferrous metals [only HW].</p>
<b>Machine</b>	<p>Through feed drilling machines,</p> <p>Point-to-point drilling machines,</p> <p>CNC machining centres,</p> <p>Column drilling machines,</p> <p>Drilling machines,</p> <p>Special purpose drilling machines,</p> <p>Portable drills.</p>
<b>Design</b>	<p><b>1. Loose countersink for mounting on dowel drills.</b></p> <p>The loose countersink is clamped on the shank or heel (for dowel drills or through hole drills with heel). It allows drilling and countersinking in one operation. It is possible to clamp and adjust the loose countersink on the heel of drills with heel.</p> <div data-bbox="585 1014 1002 1240" data-label="Image">  </div> <div data-bbox="1038 1014 1455 1240" data-label="Image">  </div> <p><b>2. Loose countersink for mounting on twist drills.</b></p> <p>Countersink with a countersink angle of 90° or 180° can be clamped on twist drills.</p> <p><b>3. Single part countersink.</b></p> <p>Single part countersinks are used for subsequent countersinking of holes. Nearly all materials can be countersunk with tungsten carbide design. Usually this countersink is used to countersink holes for flush screws.</p>



Mounting example fixing on drill shank



Mounting example fixing on heel



WB 701 0 02  
Countersink fixing on drill shank, suitable  
drill types  
WB 120 0 10/11/12/29/30

WB 701 0 03  
Countersink fixing on heel, suitable drill  
types  
WB 101 0 05/06  
WB 120 0 23/24/26

**HW, Z 2****Application:**

To countersink and drill in one operation.

**Machine:**

Point-to-point drilling machines, through feed drilling machines, CNC machining centres, hinge boring machines, multi spindle units, column drilling machines, portable drills.

**Workpiece material:**

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), plastics (thermoplastic, fibre reinforced etc.), NF-metals (aluminium, copper etc.).

**Technical information:**

Loose countersink 90°, fixed on the shank of dowel or through hole drills.

**Fixed on shank**

WB 701 0 02

D mm	GL mm	d mm	D <sub>Drill</sub> mm	Allen screw mm	ID LH	ID RH
20	17.5	10	6 - 10	M6x5	034350 ●	034351 ●

RPM: n = 3000 - 9000 min<sup>-1</sup>

**Spare parts:**

BEZ	ABM mm	for S mm	ID
Allen key	SW 3	M6	005433 ●
Allen screw	M6x5	SW 3	005836 ●

**Technical information:**

Loose countersink 90°. Fixed on heel of dowel and through hole drills with double heel. Stepless axial positioning of countersink on heel for variable drilling and countersink depth.

**Fixed on heel**

WB 701 0 03

D mm	GL mm	d mm	D <sub>Drill</sub> mm	Allen screw mm	ID LH	ID RH
15.5	17.5	4	4	M5x5		034371 ●
15.5	17.5	5	5	M5x5	034372 ●	034373 ●
15.5	17.5	6	6	M6x5	034374 ●	034375 ●
15.5	17.5	8	8	M6x4	034376 ●	034377 ●
20	17.5	10	10	M6x5	034378 ●	034379 ●

RPM: n = 3000 - 9000 min<sup>-1</sup>

**Spare parts:**

BEZ	ABM mm	for S mm	ID
Allen key	SW 2.5	M5	005432 ●
Allen key	SW 3	M6	005433 ●
Allen screw	M5x5	SW 2.5	005805 ●
Allen screw	M6x5	SW 3	005836 ●
Allen screw	M6x4	SW 3	005837 ●





#### SP, Z 2

##### Application:

To countersink and drill in one operation.

##### Machine:

Multi spindle unit, column drilling machines, portable drills.

##### Workpiece material:

Softwood and hardwood.

##### Technical information:

Loose countersink 90°, to mount on drills WB 120 0 05.



##### Countersink 90°

WB 701 0 01

D mm	GL mm	S mm	d mm	QAL	DRI	ID
16	55	10x30	3	SP	RH	036250 ●
16	55	10x30	4	SP	RH	036251 ●
16	55	10x30	5	SP	RH	036252 ●
16	55	10x30	6	SP	RH	036253 ●

##### Countersink 90°, with drill

SB 204 0

D mm	d mm	GL mm	NL mm	S mm	QAL	DRI	ID
16	3	136	38/15	10x60	SP/HS	RH	036257 □

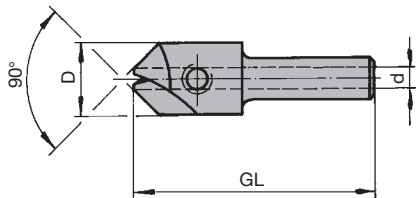
RPM:  $n = 3000 - 6000 \text{ min}^{-1}$

##### Spare parts:

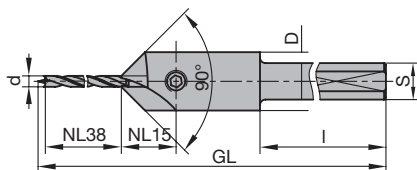
BEZ	ABM mm	ID
Allen key	SW 3	005433 ●
Allen screw	M6x5	005836 ●
Twist drill	D3/S3x30/GL70	035852 ●

##### Mounting example

Countersink WB 701 0 01 mounted on drill WB 120 0 05



WB 701 0 01, cylindrical shank



SB 204 0, countersink with drill

**HS, Z 2****Application:**

To countersink and drill in one operation.

**Machine:**

Multi spindle units, column drilling machines, portable drills.

**Workpiece material:**

Softwood and hardwood.

**Technical information:**

Loose countersink 180°, to mount on drills WB 120 2 05.

**Countersink 180°**

WB 711 0

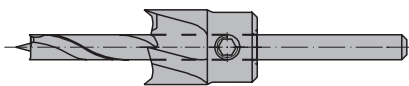


D	GL	NL	d	QAL	DRI	ID
mm	mm	mm	mm			
15	22	10	6	HS	RH	036301 ●
20	25	12	8	HS	RH	036303 ●
25	25	12	10	HS	RH	036305 ●

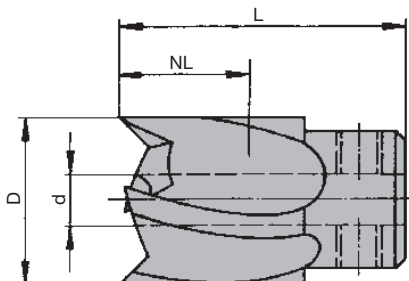
**RPM:** n = 3000 - 6000 min<sup>-1</sup>

**Spare parts:**

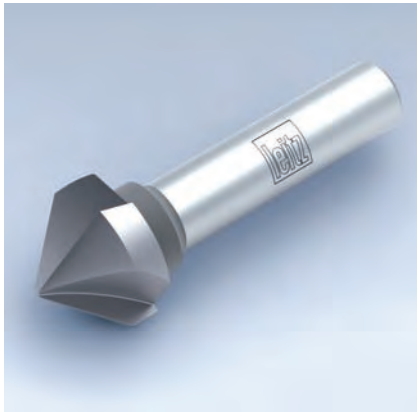
BEZ	ABM	BEM	ID
	mm		
Allen key	SW 2,5	for D = 15 - 25 mm / 180°	005432 ●
Allen screw	M5x5	for D = 15 - 25 mm / 180°	005805 ●
Allen key	SW 3	for D = 30 mm / 180°	005433 ●
Allen screw	M6x5	for D = 30 mm / 180°	005836 ●



Mounting example  
WB 711 0, cylindrical shank



WB 711 0, with 2 clamping screws

**Shank 10 mm****Application:**

For the additional countersinking of holes.

**Machine:**

Multi spindle units, column drilling machines, portable drills.

**Workpiece material:**

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.), plastics (thermoplastic, fibre reinforced etc.), NF-metals (aluminium, copper etc.).

**Technical information:**

Countersink 90° Z 1 solid SP (only for softwood and hardwood).

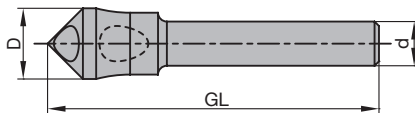
Countersink 90° Z 3 solid tungsten carbide. Special grinded section for clean and chatter-free cut.

**Countersink 90°**

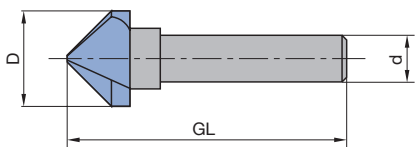
WB 700 0, WB 702 0

D	GL	S	QAL	DRI	ID
mm	mm	mm			
16	75	10x50	SP	RH	036220 ●
20.5	58	10x40	HW solid	RH	036255 ●

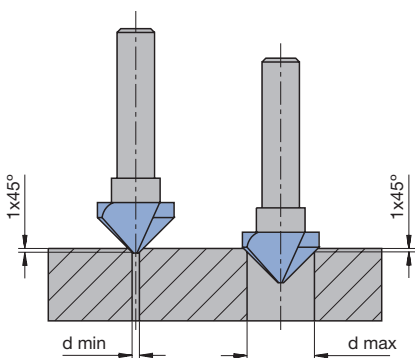
**RPM:**  $n = 2500 - 6000 \text{ min}^{-1}$



WB 700 0 countersink 90° SP, Z1



WB 702 0 countersink 90° solid tungsten carbide, Z 3



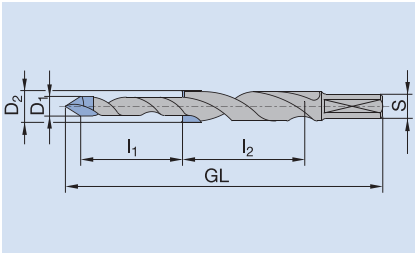
The illustrations shows the smallest and largest hole diameters possible, countersunk with a 1x45° bevel:

Countersink 90° SP:

$d_{\min} = 4.00 \text{ mm}$ ,  $d_{\max} = 12.00 \text{ mm}$

Countersink 90° HW:

$d_{\min} = 2.00 \text{ mm}$ ,  $d_{\max} = 18.00 \text{ mm}$

<b>Application</b>	To drill stepped holes.												
<b>Workpiece material</b>	<p>Softwood and hardwood.</p> <p>Chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc.</p> <p>Laminated veneer lumber (plywood, multiplex plywood etc.).</p> <p>Plastomers.</p> <p>Duromers.</p> <p>Solid surface material (Corian, Varicor, Noblan etc.).</p> <p>Compound materials.</p> <p>Non-ferrous metals.</p>												
<b>Machine</b>	<p>Through feed drilling machines,</p> <p>Point-to-point drilling machines,</p> <p>CNC machining centres,</p> <p>Column drilling machines,</p> <p>Drilling machines,</p> <p>Special purpose drilling machines,</p> <p>Portable drills.</p>												
<b>Design</b>	<p>Step drills are characterized by two drilling operations.</p> <p>The first drill can have either a V point or a centre point with spurs.</p> <p>The second operation can have either a flat 180° counterbore or an angled countersink &lt; 180°.</p>												
<b>Technical features</b>	<p>The dimensions listed in the tool tables refer to the following tool parameters:</p> <div data-bbox="134 1019 550 1270" data-label="Image">  <p>The diagram shows a side view of a stepped drill bit. It has two diameters: D1 (smaller) and D2 (larger). The first step has a working length I1, and the second step has a working length I2. The total length of the drill bit is GL. The shank diameter is S.</p> </div> <table border="1"> <tbody> <tr> <td>D<sub>1</sub></td><td>Diameter, pre-drill</td></tr> <tr> <td>D<sub>2</sub></td><td>Diameter, first step</td></tr> <tr> <td>I<sub>1</sub></td><td>Working length pre-drill</td></tr> <tr> <td>I<sub>2</sub></td><td>Working length, first step</td></tr> <tr> <td>S</td><td>Shank diameter x shank length</td></tr> <tr> <td>GL</td><td>Total length of the drill bit including the projection to the centre point</td></tr> </tbody> </table>	D <sub>1</sub>	Diameter, pre-drill	D <sub>2</sub>	Diameter, first step	I <sub>1</sub>	Working length pre-drill	I <sub>2</sub>	Working length, first step	S	Shank diameter x shank length	GL	Total length of the drill bit including the projection to the centre point
D <sub>1</sub>	Diameter, pre-drill												
D <sub>2</sub>	Diameter, first step												
I <sub>1</sub>	Working length pre-drill												
I <sub>2</sub>	Working length, first step												
S	Shank diameter x shank length												
GL	Total length of the drill bit including the projection to the centre point												
<b>Application data</b>	<p><b>RPM/feed speeds</b></p> <p>The optimum RPM and feed speeds are detailed in the diagrams attached to the tool tables.</p>												



#### HW solid, Z 2, Marathon

##### Application:

To produce stepped holes, particularly for screwed hinge holes for doors.

##### Machine:

Multi spindle units, CNC machining centres, portable drills.

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials (MDF, HDF etc.), uncoated, plastic coated, veneered etc., laminated veneer lumber (plywood, multiplex plywood etc.).

##### Technical information:

HW solid design, Z 2, two-steps. Extra-long centre point for perfect positioning of the boring bits even on inclined surfaces. Marathon coating for increased performance time.

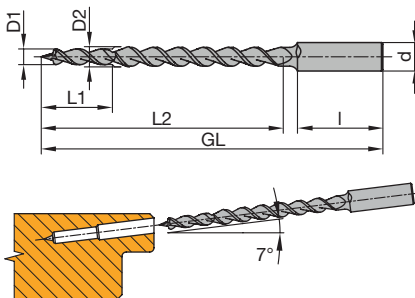


##### HW solid, Z 2

WB 201 0

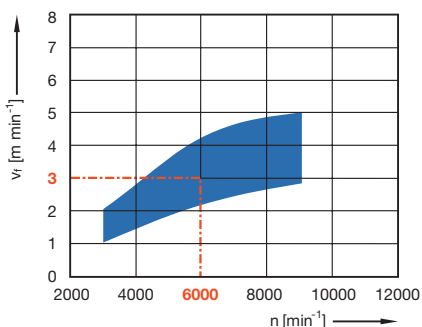
Type	D1 mm	D2 mm	GL mm	L1 mm	L2 mm	S mm	DRI	ID
Anuba 14,5	5.5	7.1	120	25	85	10x30	RH	035804 ●
Anuba 16	6.2	7.7	120	30	85	10x30	RH	035805 ●
Anuba 18	7.5	8.8	120	30	85	10x30	RH	035806 ●
Simons	5.5	6.8	120	25	85	10x30	RH	035807 ●

RPM:  $n = 3000 - 9000 \text{ min}^{-1}$



Drilling hole for screwed hinge at an inclined angle of 7° up to 9°

Feed speed  $v_f$  depending on the spindle RPM  $n$



##### Workpiece material:

Chipboard plastic coated

##### Operation:

Step drilling

##### Correction factor for $v_f$ :

MDF, solid wood = 0.7

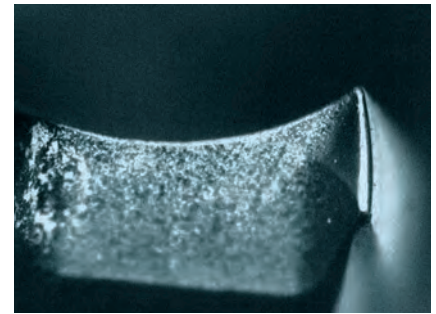
Problem	Possible cause	Action
<b>Drill wears quickly</b>	– Feed rate per rotation too low	Increase feed rate or reduce RPM (see charts on product pages)
<b>High wear to spurs</b>	– Tool remains stationary at the reversal point when drilling dowel holes	Reduce RPM or increase acceleration of the feed axis (when possible) Change program
	– Abrasive workpiece material	Select drills with more wear resistant cutting edge material (HW or DP)
<b>Uneven edges (new drill)</b>	– Feed rate per rotation too high as the bit enters or leaves the workpiece	Reduce feed rate or increase RPM (see charts on product pages)
	– Insufficient concentricity of drill	Check concentric clamping of bit and chuck Check spindle and chuck for deformation
	– Insufficient centering on return stroke of the drill	Check spindle and chuck for signs of wear Use drills with heel
<b>Chips and workpiece become hot</b>	– Tool too long at the reversal point when drilling dowel holes	Reduce RPM or increase acceleration of the feed axis (when possible) Change program
<b>Burn marks at the bore wall (new drill)</b>	– Insufficient chip flow	Clear gullet from time to time when drilling deep holes. Select drill type for high chip volumes (e.g. Levin type)
<b>Bore too large</b>	– Error in concentricity or the centre-point is not central	Check boring bit clamping for concentricity. Check boring bit chuck and motor spindle for deformation and wear Check the concentric running of the centre point
<b>Unclean countersunk wood</b>	– Chips jammed between flute and loose countersink	Use one-piece stepped boring bit when machining solid wood
<b>Broken drill</b>	– Wrong application parameters	Reduce feed rate, increase RPM (see charts on product pages)
	– Bore is full of chips	Clear gullet from time to time when boring deep holes. Select boring bit type for large chip quantities (e.g. Levin type).
	– Non-uniform workpiece material	Check workpiece for foreign objects Reduce feed rate
	– Premature loosening of workpiece clamping	Adjust program
	– Worn drilling spindle	Check spindle bearing, repair if necessary
<b>Broken spurs</b>	– High feed rate when drilling hard workpiece materials	Reduce feed rate
	– Workpiece material not suitable for machining with spurs	Grind off spur and chamfer cutting edge at change-over to the minor cutting edge

### **Worn spurs (abrasive wear)**

The natural end of the performance time of a dowel or hinge boring bit is determined by worn spurs by abrasion. The cutting forces on the workpiece surface increase with increasing wear. The surface is subject to severe deformation before it is cut.

Consequently, the edge of the boring hole arches. Coated panel materials will show tear-outs and veneered surfaces crack at the edge of the boring hole. The boring bit must be replaced.

The performance time is set by the quality requirement of the holes. With visible holes such as holes for shelves, drill replacement should be carried out earlier than for holes for dowel joints.



Worn spurs.

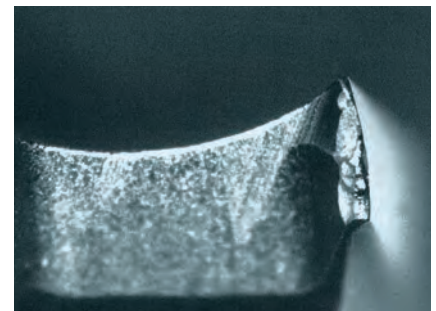
### **Broken spurs**

The sharp and precise spurs of dowel and hinge boring bits are prone to mechanical overstress. They can break when used under unfavourable operating conditions.

This can be caused by worn spindles or chucks if the workpiece is not clamped firmly, or by hard foreign objects in the workpiece such as small stones or metal particles.

Broken spurs do not produce a clean cut since the break geometry is random. As a rule, this results in break-outs or tear-outs at the edge of the hole.

If the break geometry is favourable, the drilling quality does not deteriorate immediately. With continued use, these broken spurs are subject to fast abrasive wear. Performance times are considerably reduced. The wear can conceal the damaged spurs.



Broken spurs.

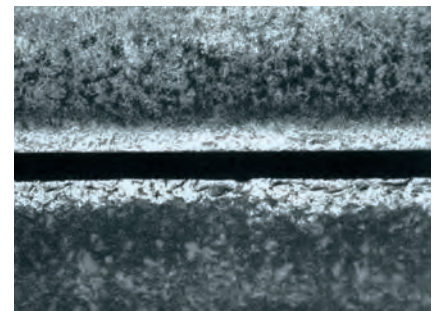
### **Thermal wear**

Because of the permanent contact between the cutting edges and the workpiece material and the deep boring depth, operating conditions can occur which lead to heat stress.

Heat stress occurs when the heat developed by the friction at the main cutting edges cannot be dispersed by the chips. This can be caused by the wrong operating conditions such as high RPM at a low feed rate or when the boring bit remains stationary too long at the reversal point when boring dowel holes.

Insufficient chip removal at deep depths or resin build-up at the gullet can also lead to frictional heat.

The structure of the cutting material is destroyed thermally regardless of using HS, HW or DP. HS cutting materials overheat and lose hardness. The binding agent of sintered cutting materials such as HW or DP is attacked, grain breakage at the cutting edge can occur.



The cutting edges in the illustrations show the difference between abrasive wear (top) and wear caused by heat (bottom).



## Enquiry/order form special tools – drilling



**Customer details:** Customer number:  
(if known)

--	--	--	--	--	--	--	--

☐ Enquiry  
☐ Order

Delivery date: (not binding)

--	--

CW

Company:

Street:

Date:

Post code/place:

Enquiry/order no.:

Country:

Tool ID: (if known)

Phone/fax:

No. of pieces:

Contact person:

Signature:

### Workpiece material:

Type:

☐ Solid wood

Type:

☐ Wood-derived material

Type:

☐ Others

Type:

Type of coating:

Type of coating:

Type of coating:

### Machining:

☐ along grain/across grain  
(solid wood only)

☐ through hole boring

Boring depth: mm

☐ in end grain (solid wood only)

☐ pocket boring

Boring depth: mm

### Machine:

Manufacturer:

Application data:

Type:

Feed rate:

m/min<sup>-1</sup>

RPM:

min<sup>-1</sup>

### Tool:

Tool type (see selection pages):

Dimensions:

Diameter: mm

Working length: mm

Shank diameter: mm

Total length: mm

No. of teeth:

Cutting material:

☐ SP

☐ HS

☐ HW

☐ HW solid

☐ DP

Direction of rotation:

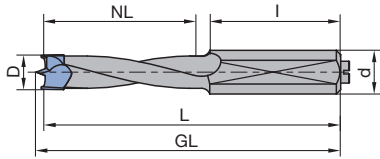
☐ left hand

☐ right hand

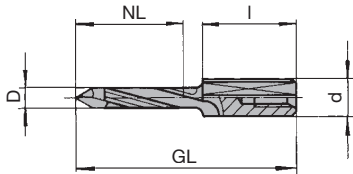
Please indicate existing data on tool,  
machine and workpiece material.

## Enquiry/order form special tools – drilling

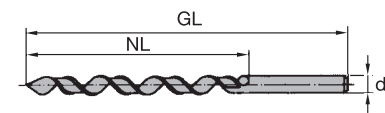
Illustrations show standard boring bit types – in case of order please indicate dimensions or make a sketch with all dimensions needed (see a bottom).



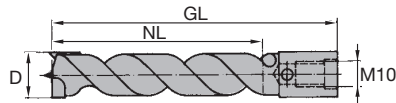
Dowel drill



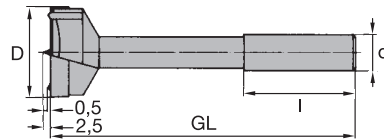
Through hole drilling



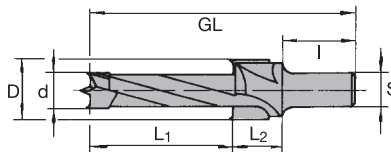
Levin type drill HS V point



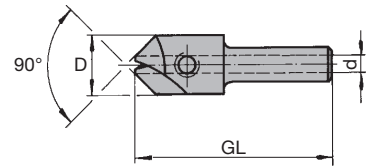
Levin type drill HW/HS Z1/V1



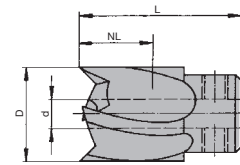
Machine bit



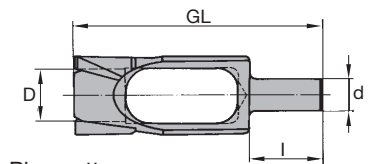
Step drill



Countersink 90°



Counterbore 180°



Plug cutter

Enter boring bit dimensions, special shank dimensions, workpiece side to table, face side on top/bottom on sketch.

# Key to pictograms



Drilling blind holes



Tungsten carbide



Drilling through holes



Polycrystalline diamond (PCD)



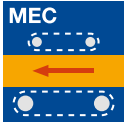
Step drilling



Carbide metal coating



Counter-sinking



Mechanical feed



Manual feed



Solid metal tool



Tipped tool



Mechanical knife clamping, reversible



Alloyed tool steel



High-speed steel



# Clamping systems

Leitz Lexicon Edition 7

Version 2

07/2022



## Explanation of abbreviations

A	= dimension A
$a_e$	= cutting thickness (radial)
$a_p$	= cutting depth (axial)
ABM	= dimension
APL	= panel raising length
APT	= panel raising depth
AL	= working length
AM	= number of knives
AS	= anti sound (low noise design)

b	= overhang
B	= width
BDD	= thickness of shoulder
BEM	= note
BEZ	= description
BH	= tipping height
BO	= bore diameter

CNC	= Computerized Numerical Control
-----	----------------------------------

d	= diameter
D	= cutting circle diameter
D0	= zero diameter
DA	= outside Diameter
DB	= diameter of shoulder
DFC	= Dust Flow Control (optimised chip clearance)
DGL	= number of links
DIK	= thickness
DKN	= double keyway
DP	= polycrystalline diamond
DRI	= rotation

FAB	= width of rebate
FAT	= depth of rebate
FAW	= bevel angle
FLD	= flange diameter
$f_z$	= tooth feed
$f_{z\text{ eff}}$	= effective tooth feed

GEW	= thread
GL	= total length
GS	= Plunging edge

H	= height
HC	= tungsten carbide, coated
HD	= wood thickness (thickness of workpiece)
HL	= high-alloyed tool steel
HS	= high-speed steel (HSS)
HW	= tungsten carbide (TCT)

ID	= ident number
IV	= insulation glazing

KBZ	= abbreviation
KLH	= clamping height
KM	= edge breaker
KN	= single keyway
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60

L	= length
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LH	= left hand rotation
----	----------------------

M	= metric thread
MBM	= minimum order quantity
MC	= multi-purpose steel, coated
MD	= thickness of knife
$\text{min}^{-1}$	= revolutions per minute (RPM)
MK	= morse taper
$\text{m min}^{-1}$	= metres per minute
$\text{m s}^{-1}$	= metres per second

n	= RPM
$n_{\text{max}}$	= maximum permissible RPM
NAL	= position of hub
ND	= thickness of hub
NH	= zero height
NL	= cutting length
NLA	= pinhole dimensions
NT	= grooving depth

P	= profile
POS	= cutter position
PT	= profile depth
PG	= profile group

QAL	= cutting material quality
-----	----------------------------

R	= radius
RD	= right hand twist
RH	= right hand rotation
RP	= radius of cutter

S	= shank dimension
SB	= cutting width
SET	= set
SLB	= slotting width
SLL	= slotting length
SLT	= slotting depth
SP	= tool steel
ST	= Cobalt-basis cast alloys, e.g. Stellite™
STO	= shank tolerance
SW	= cutting angle

TD	= diameter of tool body
TDI	= thickness of tool
TG	= pitch
TK	= reference diameter

UT	= cutting edges with irregular pitch
----	--------------------------------------

V	= number of spurs
$v_c$	= cutting speed
$v_f$	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
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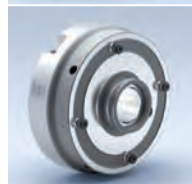
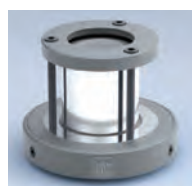
Z	= number of teeth
ZA	= number of fingers
ZF	= tooth shape (cutting edge shape)
ZL	= finger length

### Notes to the Lexicon concerning the diagrams and tables

The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.

































## 7. Clamping systems




























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## 7. Clamping systems

Adaptors  Tool types	 <b>Spindle without safety against twisting</b>	 <b>Spindle with safety against twisting - keyway</b>	 <b>Spindle with safety against twisting - hexagon Spindle D 30 Spindle D 40</b>	 <b>Spindle with HSK-F63 modified</b>
<b>Circular sawblades</b> 	 page 10 7.1.2 Hydro clamping - Closed system - Hydro-Duo clamping element with integrated safety against twisting	 page 16 7.1.3 Clamping sleeves - Flanged sleeve for circular sawblades with BO 65		 page 72 7.4.2 Arbors - Arbors HSK-F 63 modified A = 12,5, 20, 52 mm
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<b>Cutters/cutterheads</b>  	 page 6 7.1.1 Hydro clamping - Open system - clamping element with clamping nut - clamping element with end ring and clamping screws	 page 17 7.1.3 Clamping sleeves - Flanged sleeve for cutting- and hogging tools with BO 80	 page 13 7.1.2 Hydro clamping - Closed system - Hydro clamping element for cutting- and hogging tools for BO 60 und 80	 page 63 7.4.1 Hydro clamping arbors - Hydro clamping arbor HSK-F 63 mod. for tools with bore 60
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## 7. Clamping systems

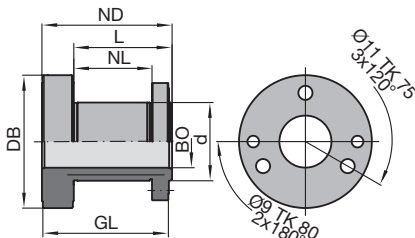
Adaptors  Tool types	 <b>Spindle without safety against twisting</b>	 <b>Spindle with safety against twisting - keyway</b>	 <b>Spindle with safety against twisting - hexagon Spindle D 30 Spindle D 40</b>	 <b>Spindle with HSK-F63 modified</b>
<b>Cutters/cutterheads</b>	 page 10   7.1.2 Hydro clamping - Closed system - Hydro-Duo clamping element with integrated safety against twisting	 page 24 7.2.2 Mechanical clamping - Quick clamping element Type 160 for cutting- and hogging tools	 page 20 7.2.1 Hydro clamping - Closed system - Quick clamping element Type 160 Hydro for cutting- and hogging tools  page 21 7.2.1 Hydro clamping - Closed system - Quick clamping element Type 160 Hydro-Duo for cutting- and hogging tools	
<b>Hogger sets/cutterhead sets</b>	 page 6   7.1.1 Hydro clamping - Open system - clamping element with clamping nut - clamping element with end ring and clamping screws  page 7 7.1.2 Hydro clamping - Closed system - clamping element with clamping nut - clamping element with end ring and clamping screws  page 8 7.1.2 Hydro clamping - Closed system - Clamping element with end ring Clamping screws and safe against twisting  page 9 7.1.2 Hydro clamping - Closed system - Hydro-Duo clamping element with 2 chambers, axial piston clamping and fine adjustment  page 18 7.1.3 Clamping sleeves - Clamping sleeve with end ring and safety against twisting - Spindle filling spacers with safety against twisting  page 19 7.1.3 Clamping sleeves - Reduction sleeve with collar - Reduction sleeve without collar		 page 11 7.1.2 Hydraulic clamping - Closed system - Hydro-clamping element for spindle d 40 and for toolsets with bore 60  page 12 - Hydro-clamping element for spindle d 30 and for tool with bore 60  page 14 7.1.2 Hydro clamping - Closed system - Hydro-Duo clamping element with double piston clamping and fine adjustment  page 15 7.1.2 Hydro clamping - Closed system - Hydro-Duo clamping element with 2 chambers axial piston clamping and fine adjustment	 page 63 7.4.1 Hydro clamping arbors - Hydro clamping arbor HSK-F 63 mod. for tools with bore 60  page 64 7.4.1 Hydro clamping arbors - Hydro clamping arbor HSK-F 63 mod. with stepless fine adjustment for tools with bore 60  page 72 7.4.2 Arbors - Arbors HSK-F 63 modified A = 12,5, 20, 52 mm

## 7. Clamping systems

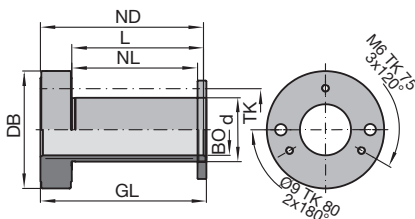
Adaptors Tool types	SK 30		BT 30 BT 35		SK 40		HSK-F 50	
								
<b>Router cutters</b> 	 page 27 7.3.1 Shrink-fit chucks  page 36 page 37 page 38 7.3.3 Collet chucks		 page 39 7.3.3 Collet chucks		 page 27 7.3.1 Shrink-fit chucks  page 38 7.3.3 Collet chucks		 page 40 page 41 7.3.3 Collet chucks	
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## 7. Clamping systems

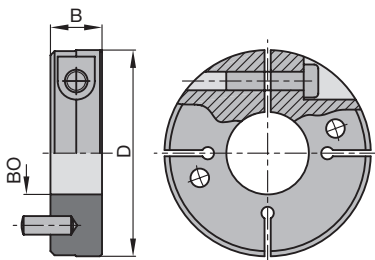
 <b>HSK-E 63</b>	 <b>HSK-F 63</b>	 <b>HSK 85 WS</b>	 <b>Threaded shank with/without tapered seating</b>
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Hydro-Duo clamping element  
PH 130 0 01 with clamping nut



Hydro-Duo clamping element  
PH 130 0 02 with end ring and clamping  
screws



Clamping collar without thread

### For spindle without safety device against twisting

#### Application:

Clamping sleeve for centric, play-free clamping of tools and cutterheads.

#### Machine:

Machines with high precision spindles e.g. moulders etc.

#### Technical information:

Hydro-Duo open clamping system, activation of hydro clamping by a grease gun.  
Suitable for right and left hand rotation.

#### With clamping nut

PH 130 0 01

d	BO	NL	L	GL	ND	DB	ID
mm	mm	mm	mm	mm	mm	mm	
60	40	60	75	100	100	102	030503 ●
60	45	60	75	100	100	102	030505 ●
60	50	60	75	100	100	102	030507 ●
60	50	40	55	80	80	102	030515 ●

#### Spare parts:

BEZ	ABM	ID
	mm	
Sickle spanner adjustable	D90/155; L290; DIN1816; tenon 6	005462 ●
Grease gun		008239 ●
Grease cartridge	for Hydro sleeve	007934 ●
Grease nipple	M10x1	007935 ●

#### With end ring and clamping screws

PH 130 0 02

d	BO	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	
50	40	98	105	130	100	92	65	030600 ●
60	45	28	35	59.5	59.5	102	75	030605 ●
60	50	98	105	130	130	102	75	030602 ●

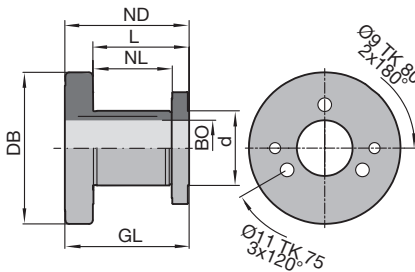
#### Spare parts:

BEZ	ABM	ID
	mm	
Allen key	SW 5	005452 ●
Grease gun		008239 ●
Grease cartridge	for Hydro sleeve	007934 ●
Grease nipple	M10x1	007935 ●
Cylindrical screw with ISK	M6x70	005936 ●
Cylindrical screw with ISK	M6x120	005942 ●

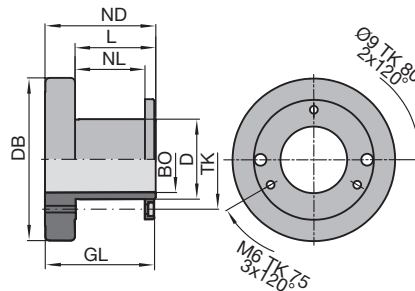
#### Clamping collars without thread

TD 870 0

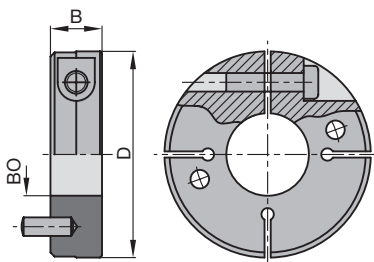
D	B	BO	ID
mm	mm	mm	
100	25	40	030700 ●
100	25	45	030701 ●
100	25	50	030702 ●



Hydro-Duo clamping element  
PH 130 0 05 with clamping nut



Hydro-Duo clamping element  
PH 130 0 06 with end ring and clamping  
screws



Clamping collar without thread

### For spindle without safety device against twisting

#### Application:

Clamping sleeve for centric clamping of tools, tool sets and cutterheads.

#### Machine:

Machines with high precision spindles, e.g. moulders, double-end tenoners, edgebanding machines, window production machines etc.

#### Technical information:

Hydro-Duo closed hydro clamping system, activation of hydro clamping by internal clamping system without grease gun. Suitable for right and left hand rotation.

#### With clamping nut

PH 130 0 05

d	BO	NL	L	GL	ND	DB	ID
mm	mm	mm	mm	mm	mm	mm	
60	45	63	77	100	100	122	031603
60	50	63	77	100	100	122	031601 ●
70	60	43	57	80	80	130	031605

#### Spare parts:

BEZ	ABM	ID
	mm	
Sickle spanner adjustable	D90/155; L290; DIN1816; tenon 6	005462 ●

#### With end ring and clamping screws

PH 130 0 06

d	BO	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	
60	50	52	60	83	83	122	75	031650 ●

#### Spare parts:

BEZ	ABM	ID
	mm	
Allen key	SW 5	005452 ●
Cylindrical screw with ISK	M6x70	005936 ●

#### Clamping collars without thread

TD 870 0

D	B	BO	ID
mm	mm	mm	
100	25	45	030701 ●
100	25	50	030702 ●





#### For spindle without safety device against twisting

##### Application:

Clamping sleeve for centric, play-free clamping of tool sets, for window tools on stacked spindle machines.

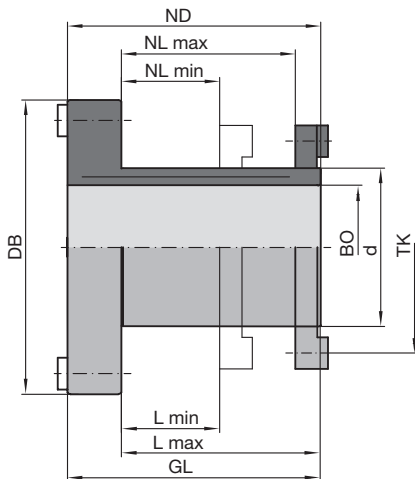
##### Machine:

Machines with high precision spindles, e.g. moulders, double-end tenoners, edgebanding machines, window production machines etc.

##### Technical information:

Hydro-Duo closed hydro clamping system, activation of hydro clamping by internal clamping system without grease gun.

Total length of sleeves adjusted as required.



Hydro-Duo clamping element  
PH 130 0 13 with end ring, clamping  
screws and safety device against  
twisting

#### With end ring, clamping screws and safety device against twisting

PH 130 0 13

d	BO	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	
50	40	35 - 55	43 - 63	80	80	93	65	031658 □
50	40	55 - 75	63 - 83	100	100	93	65	031659 □
50	40	75 - 95	83 - 103	120	120	93	65	031660 ●
60	40	95 - 115	103 - 123	140	140	93	75	031661 ●
60	50	35 - 55	43 - 63	80	80	93	75	031655 ●
60	50	55 - 75	63 - 83	100	100	93	75	031652 ●
60	50	75 - 95	83 - 103	120	120	93	75	031653 ●
60	50	95 - 115	103 - 123	140	140	93	75	031654 ●
60	50	115 - 135	123 - 143	160	160	93	75	031657 ●

##### Spare parts:

BEZ	ABM	BEM	ID
	mm		
Cylindrical screw with ISK	M6x50		005932 ●
Cylindrical screw with ISK	M6x70		005936 ●
Cylindrical screw with ISK	M6x90		005939 ●
Cylindrical screw with ISK	M6x100		005940 ●
Cylindrical screw with ISK	M6x110		005941 ●
Cylindrical screw with ISK	M6x130		006542 ●
Cylindrical screw with ISK	M6x150		006400 ●
Countersink screw, Torx® 15	M4x6	for feather key 3	007436 ●
Countersink screw, Torx® 15	M4x10-12.9	for feather key 1,2,4	007437 ●
Feather key 1	19x8x7		008525 ●
Feather key 2	10x8.5x6.5		008526 ●
Feather key 3	19x8x3.5		008527 ●
Feather key 4	19x8x7		008528 ●
Allen key	SW 5		005452 ●
Torx® key	Torx® 15		117507 ●

#### End ring with safety device against twisting

TR 112 0

D	BO	TK	B	ID
mm	mm	mm	mm	
85	50	65	8	008245 ●
93	60	75	8	008222 ●





### Spindle without safety device against twisting - Hydro-Duo clamping sleeve with stepless fine adjustment of 2 part tool sets

#### Application:

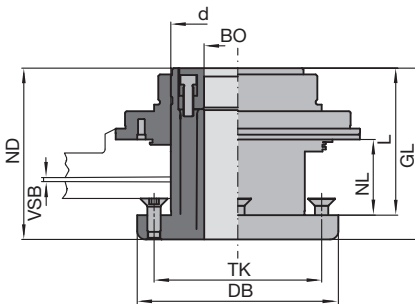
Hydro-Duo clamping sleeve with fine thread and axial piston clamping for stepless adjustment of 2 part tool sets. Additional clamping collar with safety device against twisting.

#### Machine:

Machines with high precision spindles, e.g. moulders, double-end tenoners, edge-banding machines etc.

#### Technical information:

High precision fine thread adjustment with a 0.01 mm scale for fine adjustment of 2 part cuttersets with repeatability. Adjustment range 10 mm. Maintenance free hydro clamping mechanism.



Hydro-Duo clamping element with axial piston clamping and fine adjustment  
PH 130 0 11

#### With Hydro-Duo 2 chamber axial piston clamping and fine adjustment

PH 130 0 11

d	BO	BO	NL	L	GL	ND	DB	VS	TK	ID
mm	mm	in	mm	mm	mm	mm	mm	mm	mm	
80	40		33.5 - 43.5	88	108	108	120	10	100	031555 □
80	45		33.5 - 43.5	85	100	100	120	10	100	031556 □
80	46.04	1 13/16"	33.5 - 43.5	85	100	100	120	10	100	031557 □
100	50		60 - 70	102	117	117	140	10	120	030566 □
100	53.97	2 1/8"	60 - 70	102	112	117	140	10	120	031552 □

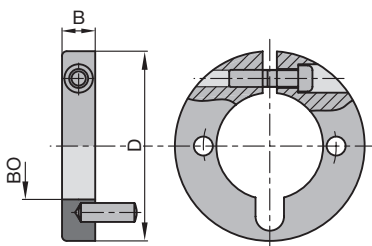
#### Spare parts:

BEZ	ABM	ID
	mm	
Allen key	SW 5	005452 ●

#### Clamping collars without thread

TD 870 0

D	B	BO	BO	ID
mm	mm	mm	in	
80	14	40		030713 ●
80	14	45		030714 ●
80	14	46.04	1 13/16"	030715 ●
80	14	50		030716 ●
80	14	53.97	2 1/8"	030717 ●



Clamping collar without thread



### For spindle without safety device against twisting - Hydro-Duo clamping sleeve for saws, cutters and hoggers

#### Application:

Hydro-Duo clamping sleeve for high precision clamping and flexible positioning of saws, cutters and hoggers on spindles without using spacers or spindle nuts.

#### Machine:

Multi-blade circular saw machines, four-sided moulders, double-end tenoners etc.

#### Technical information:

Closed hydro clamping system with maintenance free pressure piston mechanism.

#### With integrated safety device against twisting

PH 130 0 10

d	BO	NLA	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	mm	
60	40	3/M6/75	35	35	69	69	100	75	030572 ●
60	50	3/M6/75	35	35	69	69	100	75	030574 ●
90	70	6/M6/106	35	35	70	70	120	106	030571
115	100	6/M6/131	14	14	49.5	49.5	145	131	030557 ●
115	100	6/M6/131	48.5	48.5	84	84	145	131	030555 ●

with clamping screws.

#### Spacer set, aluminium screwed, for mounting saws

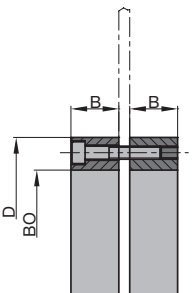
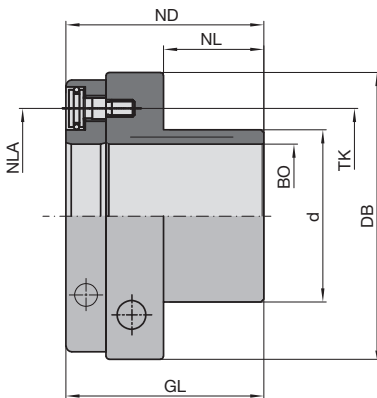
AT 102 0

D	B	BO	NLA	ID
mm	mm	mm	mm	
120	30	90	6/7/106	028482 ●
145	44	115	6/7/131	028480 ●

#### Steel spacers, for mounting sets of sawblades

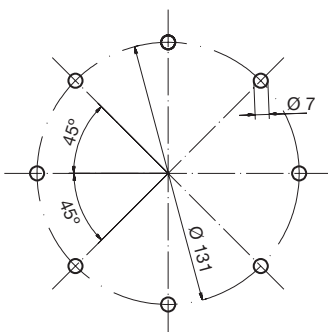
TR 100 0

D	B	BO	NLA	ID
mm	mm	mm	mm	
120	0.5	90	8/7/106	028679 ●
120	1	90	8/7/106	028680 ●
120	3	90	8/7/106	028681 ●
120	5	90	8/7/106	028682 ●
145	0.5	115	8/7/131	028683 ●
145	1	115	8/7/131	028684 ●
145	3	115	8/7/131	028685 ●
145	5	115	8/7/131	028686 ●

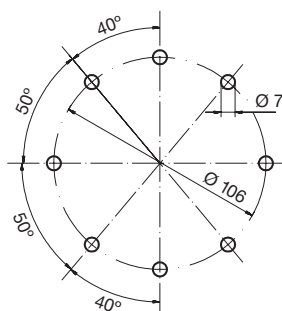


Set of spacers

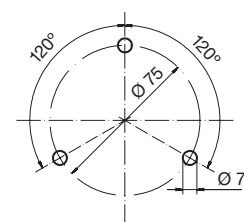
Bore pattern for tools for mounting on:



Hydro sleeve ID 030555 and 030557



Hydro sleeve ID 030571

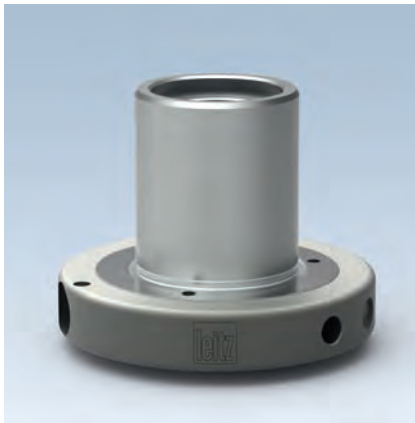


Hydro sleeve ID 030572 und 030574

## 7. Clamping systems

### 7.1 Clamping elements

#### 7.1.2 Hydro clamping - closed system



#### Spindle with safety device against twisting - hexagon HF spindle 40 Hydro-Duo clamping sleeve

##### Application:

Hydro-Duo clamping element for play-free clamping of cutting tools on high precision spindle with hexagon safety device against twisting (HF spindle) for high concentricity.

##### Machine:

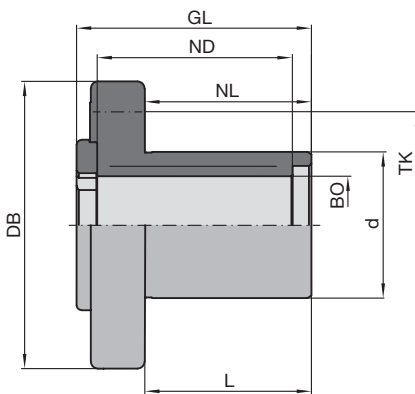
Machines with high precision spindles, e.g. moulders, double-end tenoners, edgebanding machines etc.

##### Technical information:

Closed hydro clamping system with maintenance free pressure piston mechanism.

RPM  $n_{\max}$  12000 min<sup>-1</sup>.

**Attention:** Comply with maximum admissible speed for the mounted tools!



Hydro Duo clamping element  
PH 130 0 04

##### With end ring and clamping screws, for tool sets with bore 60 mm

PH 130 0 04

d	BO	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	
60	40	68	68	96.5	88	118	75	<b>030559 ●</b>

Spindle fixture consisting of:

Conical spring washer, clamping screw, hexagon spanner, brace.

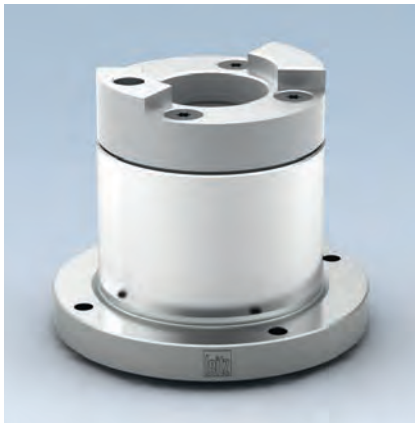
##### Spare parts:

BEZ	ABM	ID
	mm	
Securing part	for HF-spindle HF 40	<b>066473 ●</b>
Allen key	SW 5	<b>005452 ●</b>

## 7. Clamping systems

### 7.1 Clamping elements

#### 7.1.2 Hydro clamping - closed system



#### Spindle with safety device against twisting - hexagon HF spindle 30 Hydro clamping sleeve

##### Application:

Hydro clamping sleeve for play-free clamping of cutting tools on high precision spindle with hexagon safety device against twisting (HF spindle 30) for high concentricity.

##### Machine:

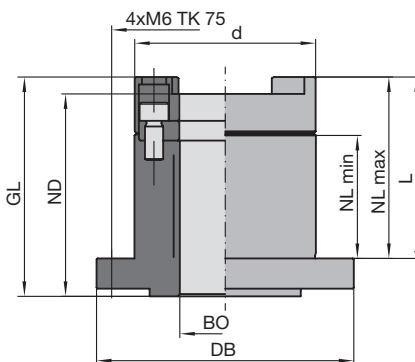
Machines with high precision spindles diameter 30 mm, e.g. edgebanding machines, double-end tenoners, moulders etc.

##### Technical information:

Closed hydro clamping system with maintenance free pressure piston mechanism. User friendly axial handling of the hydro clamping screw from top. Safety against twisting on the spindle through an appropriate hexagon in the spindle fixture.

RPM  $n_{\max}$  12000 min<sup>-1</sup>.

**Attention:** Comply with maximum admissible speed for the mounted tools!



Hydro clamping sleeve PH 130 0

##### For cutting tools with bore 60 mm

PH 130 0

d	BO	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	
60	30	40 - 60	60	72.5	67	85	75	<b>030567 •</b>

Spindle securing part consists of:

Securing parts, clamping screw, hexagon spanner, brace.

##### Spare parts:

BEZ	ABM	ID
	mm	
Securing part	for HF-spindle HF 30	<b>066563 •</b>
Allen key	SW 5, L 150	<b>005501 •</b>

## 7. Clamping systems

### 7.1 Clamping elements

#### 7.1.2 Hydro clamping - closed system



#### Spindle with safety device against twisting - hexagon HF spindle 40 Hydro clamping sleeve

##### Application:

Hydro clamping sleeve for play-free clamping of hogging/cutting tools on high precision spindle with hexagon safety device against twisting (HF spindle) for high concentricity.

##### Machine:

Machines with high precision spindles, e.g. moulders, double-end tenoners, edgebanding machines etc.

##### Technical information:

Closed hydro clamping system with maintenance free pressure piston mechanism.

RPM  $n_{\max}$  12000 min<sup>-1</sup>.

**Attention:** Comply with maximum admissible speed for the mounted tools!



##### For cutting tools and hoggers with bore 60/80 mm

PH 130 0 03

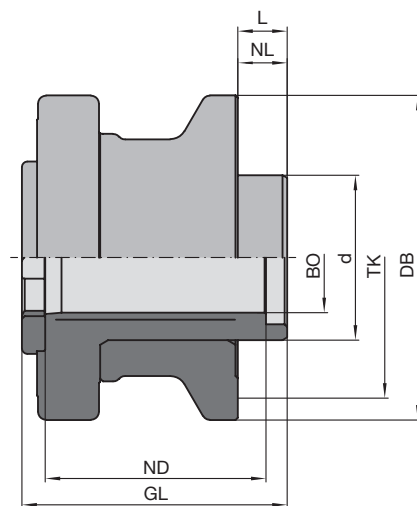
d	BO	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	
60	40	18	18	96.5	80.3	118	100	<b>061702 ●</b>
80	40	18	18	96.5	80.3	118	100	<b>061703 ●</b>

Spindle fixture consisting of:

Conical spring washer, clamping screw, hexagon spanner, brace.

##### Spare parts:

BEZ	ABM	ID
	mm	
Securing part	for HF-spindle HF 40	<b>066473 ●</b>



Hydro clamping sleeve PH 130 0 03

## 7. Clamping systems

### 7.1 Clamping elements

#### 7.1.2 Hydro clamping - closed system



#### Spindle with safety device against twisting - hexagon HF spindle 40 Hydro-Duo clamping sleeve, adjustable

##### Application:

Hydro-Duo clamping sleeve for play-free clamping of cutting tools on high precision spindle with hexagon safety device against twisting (HF spindle). With extra fine thread and dual piston clamping for stepless adjustment of 2 part tool sets on the spindle.

##### Machine:

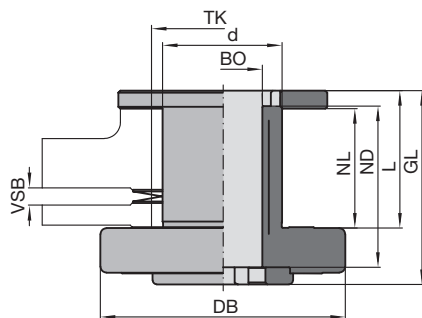
Machines with high precision spindles, e.g. moulders, double-end tenoners, edgbanding machines etc.

##### Technical information:

Closed hydro clamping system with maintenance free pressure piston mechanism. RPM  $n_{\max}$  12000 min<sup>-1</sup>.

Dual piston clamping, independent clamping: sleeve - spindle and sleeve - tool.

**Attention:** Comply with maximum admissible speed for the mounted tools!



Hydro-Duo clamping sleeve with fine adjustment PH 130 0 07

#### With dual piston clamping and hexagon safety device against twisting, fine adjustment

PH 130 0 07

d	BO	NL	L	GL	ND	DB	TK	VSB	ID
mm	mm	mm	mm	mm	mm	mm	mm		
60	40	57 - 59	68	96.5	80	122	75	2	030553 ●
80	40	49 - 59	68	106.5	80	122	75	10	030556 ●

Included in delivery: Duo sleeve complete with parts for mounting cutter and adjusting mechanism.

##### Spare parts:

BEZ	ABM	ID
	mm	
Allen key	SW 5	005452 ●

## 7. Clamping systems

### 7.1 Clamping elements

#### 7.1.2 Hydro clamping - closed system



#### Spindle with safety device against twisting - hexagon HF spindle 40 Hydro-Duo clamping sleeve, adjustable

##### Application:

Hydro-Duo clamping sleeve for play-free clamping of cutting tools on high precision spindle with hexagon safety device against twisting (HF spindle). Model with extra fine thread and axial dual piston clamping for stepless adjustment of 2 part tool sets on the spindle.

##### Machine:

Machines with high precision spindles, e.g. moulders, double-end tenoners, edgbanding machines etc.

##### Technical information:

Closed Hydro-Duo clamping system with axial dual piston clamping, independent clamping: sleeve - spindle and sleeve - tool.

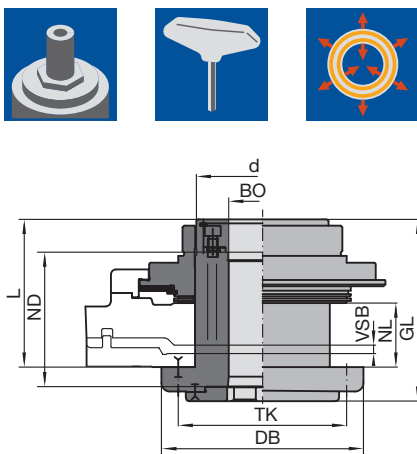
##### With dual piston clamping and hexagon safety device against twisting, fine adjustment

PH 130 0 14

d	BO	NL	L	GL	ND	DB	TK	VSB	ID
mm	mm	mm	mm	mm	mm	mm	mm	mm	
80	40	33.5 - 43.5	88	108	80	120	100	10	031560 □
80	40	44.4 - 54.4	88	108	80	120	100	10	030562 □

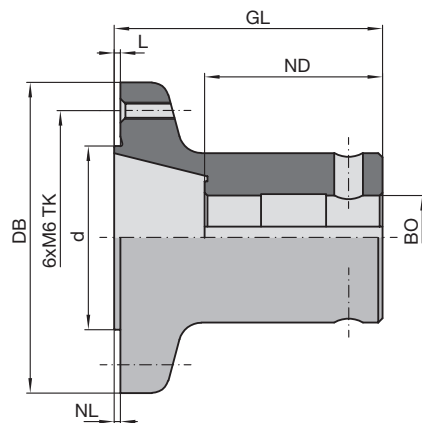
##### Spare parts:

BEZ	ABM	ID
	mm	
Allen key	SW 5	005452 ●



Hydro-Duo clamping element with axial piston clamping and fine adjustment  
PH 130 0 14





Flanged sleeve TB 300 0

### Flanged sleeve

#### Application:

Flanged sleeve for mounting scoring and grooving sawblades.

#### Machine:

Double-end tenoners, edgebanding machines etc.

#### Technical information:

For standard spindle (DKN). Case hardened steel tool body with high concentricity. Spindle fixing parts are supplied by the machine manufacturer.

#### For circular sawblades with bore 65 mm

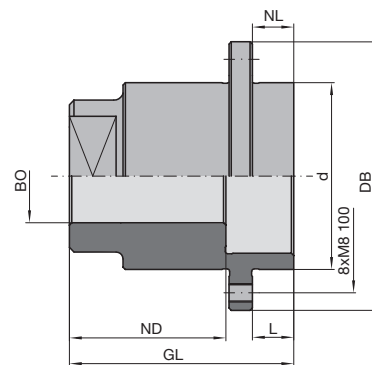
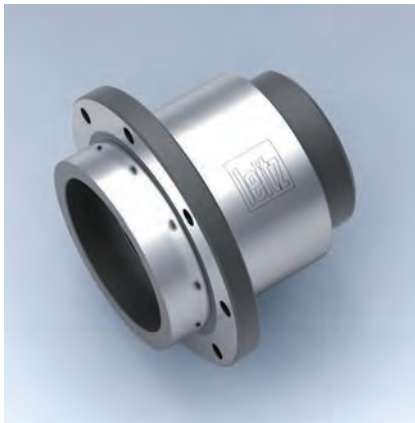
TB 300 0

Machine	d mm	BO mm	NL mm	L mm	GL mm	ND mm	DB mm	TK mm	ID
Homag, IMA	65	30 DKN	2.2	2.2	95	63	110	90	<b>065600 •</b>
Homag, IMA	65	35 DKN	2.2	2.2	95	63	110	90	<b>065606 •</b>

When ordering ID **65600**, check whether locking disk ID **66567** is required.

#### Spare parts:

BEZ	Machine	ABM mm	ID
Countersink screw with ISK		M6x10	<b>005780 •</b>
Spindle fixture left for sleeve ID 65600	Homag, IMA	48x24x18	<b>066561 •</b>
Spindle fixture right for sleeve ID 65600	Homag, IMA	48x24x18	<b>066562 •</b>
Spindle fixture left for sleeve ID 65606	Homag, IMA	60x18x21	<b>116015 •</b>
Spindle fixture right for sleeve ID 65606	Homag, IMA	60x18x21	<b>116016 •</b>
Locking disc for sleeve ID 65600	Homag, IMA	40x9x17	<b>066567 •</b>



Flanged sleeve TB 300 0

#### Flanged sleeve

##### Application:

Flanged sleeve for mounting hoggers, segment hoggers, solid hoggers and folding hoggers.

##### Machine:

Double-end tenoners, finger joint machines, edgebanding machines etc.

##### Technical information:

For standard spindle (with or without keyway). Case hardened steel tool body with high concentricity. Spindle fixing parts are supplied by the machine manufacturer.

##### For cutting and hogging tools with bore 80 mm

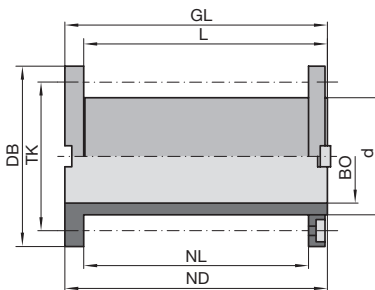
TB 300 0, TB 300 0 01, TB 300 0 03, TB 300 0 06, TB 300 0 08, TB 300 0 11, TB 300 0 12

Machine	d	BO	NL	L	GL	ND	DB	TK	ID
	mm	mm	mm	mm	mm	mm	mm	mm	
Schwabedissen	80	40 DKN	17.7	17.7	82	53	115	100	<b>061654</b> ●
Torwegge	80	35 DKN	17.7	17.7	90	63	115	100	<b>061655</b> ●
Celaschi	80	35 KN	17.7	17.7	95	65	115	100	<b>061652</b> ●
Grecon, Weinig	80	30 KN	17.7	17.7	75	45	115	100	<b>061660</b> ●
Homag, IMA	80	35 DKN	17.7	17.7	90	63	115	100	<b>061650</b> ●
Homag	80	35 DKN	17.7	17.7	104	63	115	100	<b>061685</b> ●
* Gabbiani	80	40 DKN	17.7	17.7	82	52	115	100	<b>061657</b> ●
Dimter, Grecon, Weinig	80	40 DKN	12.7	12.7	59	44	113	100	<b>061679</b> ●

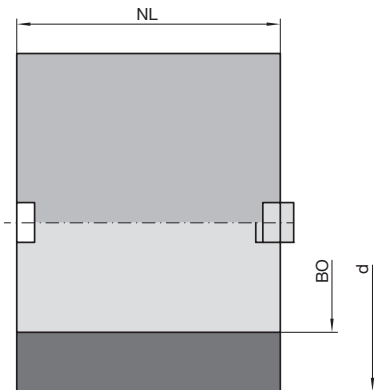
\* = L and KLH values include 13 mm spacer thickness.

##### Spare parts:

BEZ	ABM	ID
	mm	
Cylindrical screw with ISK	M8x18	<b>005945</b> ●
Cylindrical screw with ISK	M8x20	<b>005946</b> ●



Clamping sleeve TB 260 0 with end ring and safety device against twisting



Spacer with safety device against twisting

### Clamping sleeve with end ring

#### Application:

Clamping sleeve for mounting sets of single tools.

#### Machine:

Spindle moulders, moulders, double-end tenoners, edgebanding machines and window production machines.

#### Technical information:

Suitable for the use with several tool sets mounted on top of each other e.g. stacked spindle machines.

#### With end ring and safety device against twisting

TB 260 0

d	BO	NL	L	GL	ND	DB	TK	ID
mm	mm	mm	mm	mm	mm	mm	mm	
50	40	96	104	112	112	77	65	029676 ●
60	40	96	104	112	112	90	75	029677 ●
60	40	84	92	100	100	90	75	029678 ●
60	50	84	92	100	100	90	75	029679 ●
60	50	79	87	95	95	90	75	029680 ●
60	50	64	72	80	80	90	75	029697 ●

#### Spare parts:

BEZ	for L	ABM	ID
	mm	mm	
Cylindrical screw with ISK	80	M6x74	007075 ●
Cylindrical screw with ISK	100	M6x94	007077 ●
Cylindrical screw with ISK	112	M6x106	007078 ●
Countersink screw, Torx® 15		M4x10-12.9	007437 ●
Feather key		B 8x7x16	008506 ●
Allen key		SW 5	005452 ●
Torx® key		Torx® 15	117507 ●

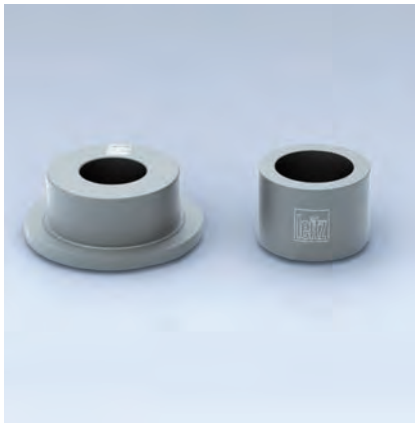
#### Application:

Spacer element for use with clamping sleeves with safety device against twisting to fill free spindle lengths.

#### Spindle filler spacers with safety device against twisting

TR 112 0

d	BO	NL	ID
mm	mm	mm	
77	50	60	027875 ●
77	50	80	027876 ●
77	50	100	027878 ●



### Reducing sleeve

#### Application:

Reducing sleeve with/without flange for cutting tools and tool sets for use on spindles of various diameters.

#### Machine:

Spindle moulders, plug cutters etc.

#### Technical information:

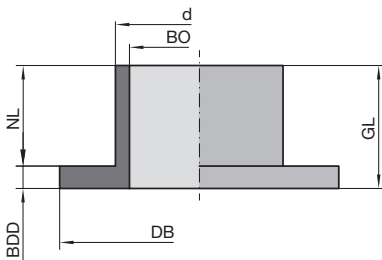
The length of the reducing sleeve should be approximately 2 mm shorter than the width of the hub or the total height of the tool/tool set.

For safety reasons, the use of reducing sleeves should be avoided if possible.

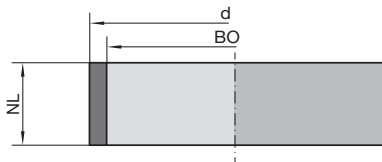
#### With flange

TB 200 0

d mm	BO mm	BO in	NL mm	GL mm	DB mm	BDD mm	ID
30	25		18	22	50	4	028201 ●
35	30		18	23	55	5	028204 ●
40	30		18	24	60	6	028206 ●
40	35		18	24	60	6	028207 ●
40	31.75	1 1/4"	18	24	60	6	028220 ●
50	30		18	24	70	6	028208 ●
50	35		18	24	70	6	028210 ●
50	40		18	24	70	6	028211 ●
50	45		18	24	70	6	028209 ●
60	30		18	24	80	6	028212 ●
60	40		18	24	80	6	028214 ●
60	50		18	24	80	6	028216 ●



Reducing sleeve TB 200 0 with flange



Reducing sleeve TB 100 0 01 without flange

#### Without flange

TB 100 0 01

d mm	BO mm	NL mm	ID
35	30	10	028290 ●
35	30	40	028293 ●
35	30	60	028294 ●
35	30	96	028295 ●
40	30	20	028296 ●
40	30	40	028298 ●
40	30	53	028300 ●
40	30	60	028301 ●
40	30	96	028302 ●
40	35	30	028304 ●
40	35	40	028305 ●
40	35	60	028306 ●
40	35	96	028307 ●
50	40	96	028310 ●

## 7. Clamping systems

### 7.2 Quick clamping elements

#### 7.2.1 Hydro clamping - closed system



#### Spindle with safety device against twisting - hexagon HF spindle 40 Quick clamping sleeve type 160 Hydro

##### Application:

Quick clamping sleeve for tools and hoggers on high precision spindle D = 40 mm with hexagon safety device against twisting.

##### Machine:

Double-end tenoners, edgebanding machines etc.

##### Technical information:

Hardened steel tool body, with mechanical quick clamping mechanism without compressed air. Tool is mounted directly on the quick clamping system without intermediate flange, closed hydro clamping system with maintenance free pressure piston mechanism, suitable for right hand and left hand rotation.

RPM  $n_{\max} = 9000 \text{ min}^{-1}$ . Tools must have four bayonet holes on 130 mm pitch.

**Attention:** Comply with maximum admissible speed for the mounted tools!

##### For tools and hoggers

PH 110 0 01

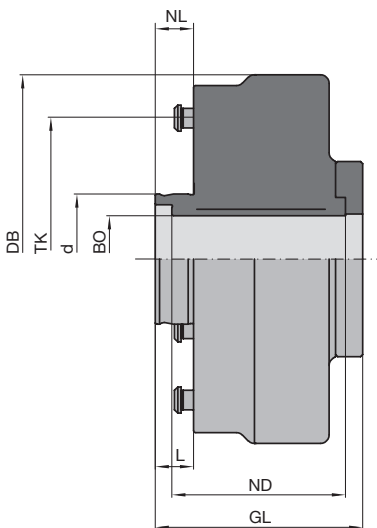
d	BO	NL	L	GL	ND	DB	TK	Clamping bolts	ID
mm	mm	mm	mm	mm	mm	mm	mm	PCS	
60	40	17.7	17.7	95.7	80	170	130	4	<b>150100 ●</b>

##### Spare parts:

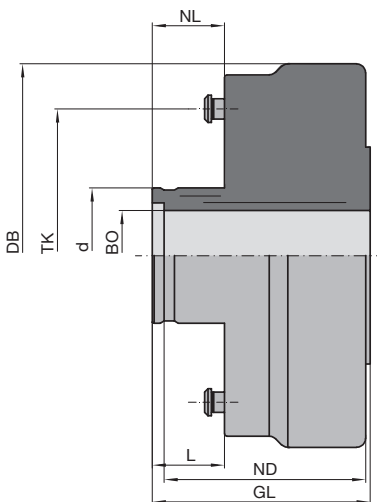
BEZ	ABM	ID
	mm	
Securing part	for HF-spindle HF 40	<b>066473 ●</b>
Hexagon key	SW 6	<b>117516 ●</b>

Spindle securing part consists of:

Conical spring washer, clamping screw, hexagon spanner, brace.



Hydro quick clamping sleeve  
type 160 HF



Hydro-Duo quick clamping sleeve  
type 160 HF

### Spindle with safety device against twisting - hexagon HF spindle 40 Quick clamping sleeve type 160 Hydro-Duo

#### Application:

Quick clamping sleeve for tools and hoggers on high precision spindle  $D = 40$  mm with hexagon safety device against twisting. Double acting hydro centering clamping eliminating the tolerance between spindle, clamping element and tool.

#### Machine:

Double-end tenoners, edgebanding machines etc.

#### Technical information:

Hardened steel tool body, with mechanical quick clamping mechanism without compressed air. Tool is mounted directly on the quick clamping system without intermediate flange, closed hydro clamping system with maintenance free pressure piston mechanism, suitable for right hand and left hand rotation.

$RPM\ n_{max} = 9000\ min^{-1}$ . Tools must have four bayonet holes on 130 mm pitch.

**Attention:** Comply with maximum admissible speed for the mounted tools!h.

#### For tools and hoggers

PH 110 0 02

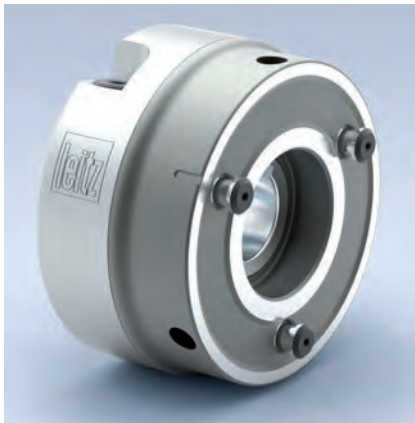
d	BO	NL	L	GL	ND	DB	TK	Clamping bolts	ID
mm	mm	mm	mm	mm	mm	mm	mm	PCS	
60	40	32	32	96.5	80	170	130	4	<b>150200 ●</b>

#### Spare parts:

BEZ	ABM	ID
	mm	
Securing part	for HF-spindle HF 40	<b>066473 ●</b>
Hexagon key	SW 6	<b>117516 ●</b>

Spindle securing part consists of:

Conical spring washer, clamping screw, hexagon spanner, brace.



#### Spindle with safety device against twisting - keyway Quick clamping sleeve type 110

##### Application:

For quick clamping of scoring sawblades, grooving sawblades and tools.

##### Machine:

Double-end tenoners, finger joint machines, edgebanding machines etc.

##### Technical information:

For standard spindle (DKN), hardened steel tool body with mechanical operation of the quick clamping mechanism without compressed air. Tool is mounted directly or by using a flange, suitable for right hand rotation and left hand rotation.

##### For scoring sawblades and tools

PM 110 0 01

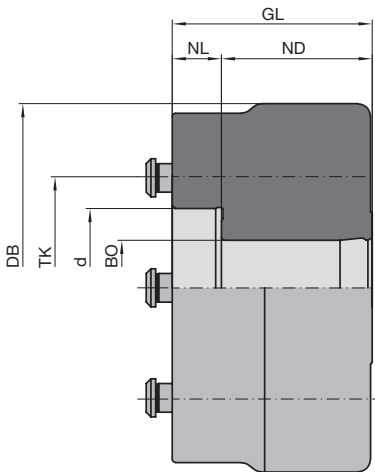
d	BO	NL	L	GL	ND	DB	TK	Clamping bolts	ID
mm	mm	mm	mm	mm	mm	mm	mm	PCS	
50	30 DKN	15.5	15.5	72	47.5	116	80	3	150000 ●

##### Spare parts:

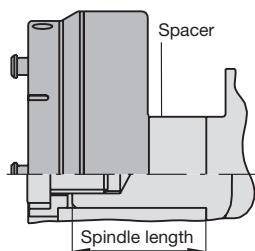
BEZ	Machine	ID	ID
		LH	RH
Securing part	IMA	066477 ●	066477 ●
Securing part	Homag	066541 ●	066540 ●
Hexagon key			117516 ●

Spindle securing part consists of:

Conical spring washer, clamping nut or clamping screw, spanner or hexagon spanner, brace.



Quick clamping sleeve



Quick clamping sleeve, flush mounted on spindle

##### Application:

Spacer for flush mounting when using flanges type 110/2.

##### Machine:

Double-end tenoners, finger joint machines, edgebanding machines etc.

##### Spacer for flush mounting

TR 111 0

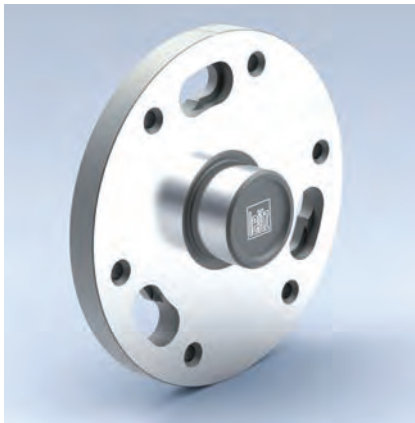
Machine	ABM	ABM-spindle	ID
	mm	mm	
Homag, IMA	60x26x30.DKN	30 DKN x68	028800 ●



## 7. Clamping systems

### 7.2 Quick clamping elements

#### 7.2.2 Mechanical clamping



#### Spindle with safety device against twisting - keyway tool flange type 110

##### Application:

Tool flange for quick clamping sleeve type 110. Hardened steel tool body for quick clamping of scoring/grooving sawblades.

##### Machine:

Double-end tenoners, finger joint machines, edgebanding machines etc.

##### Technical information:

Tool mounted directly on tool flange. RPM  $n_{\max}$  12000 min<sup>-1</sup>.

**Attention:** Comply with maximum admissible speed for the mounted tools!

##### Tool flange

TD 883 0 01

Tool Type

ID

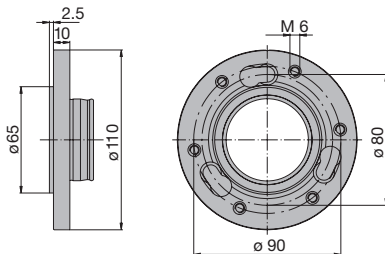
ID

LH

RH

110/2 for scoring saws mounted on flange

159051 • 159052 •



Tool flange type 110/2 for scoring saws



#### Spindle with safety device against twisting - keyway Quick clamping sleeve type 160

##### Application:

For quick clamping of hoggers and tools.

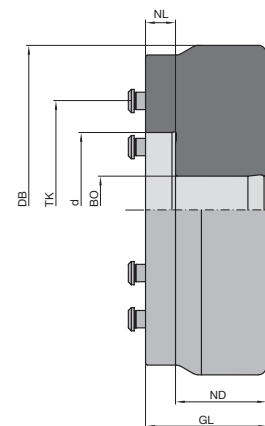
##### Machine:

Double-end tenoners, edgebanding machines etc.

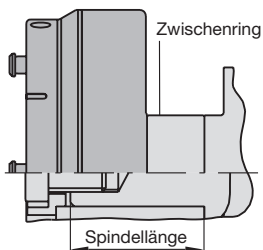
##### Technical information:

For standard spindle (KN/DKN). Hardened steel tool body, with mechanical operation of the quick clamping mechanism without compressed air. Tool is mounted directly on the quick clamping sleeve or by a flange, suitable for right hand rotation and left hand rotation. RPM  $n_{\max}$  9000 min<sup>-1</sup>.

**Attention:** Comply with maximum admissible speed for the mounted tools!



Quick clamping sleeve



Quick clamping sleeve, flush mounted on spindle

##### For tools and hoggers

PM 110 0 01

d	BO	NL	L	GL	ND	DB	TK	Clamping bolts	ID
mm	mm	mm	mm	mm	mm	mm	mm	PCS	
80	35 DKN	15.5	15.5	72	47.5	170	130	4	<b>150001 •</b>
80	40 DKN	15.5	15.5	72	47.5	170	130	4	<b>150008 •</b>

##### Spare parts:

Machine	BEZ	ID	ID
		LH	RH
Homag	Securing part	<b>066460 •</b>	<b>066461 •</b>
IMA	Securing part	<b>066556 •</b>	<b>066556 •</b>
	Hexagon key		<b>117516 •</b>

Spindle securing part consists of:

Conical spring washer, clamping nut or clamping screw, spanner or hexagon spanner, brace.

##### Application:

Spacer for flush mounting when using cutter flange type 160/2, type 160/3.

##### Spacer / set for flush mounting

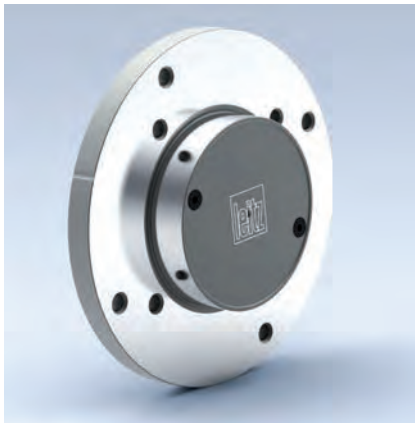
AT 100 0

Machine	Type	ABM	ABM-spindle	ID
		mm	mm	
IMA	160/2 - 3	60x15/20x35.DKN	35 DKNx93	<b>028803 •</b>
Homag	160/2 - 3	60x10/20x35.DKN	35 DKNx70	<b>028804 •</b>

## 7. Clamping systems

### 7.2 Quick clamping elements

#### 7.2.2 Mechanical clamping



### Spindle with safety device against twisting - keyway tool flange type 160

#### Application:

Tool flange for quick clamping sleeve type 160. Hardened steel tool body for quick clamping of tools and hoggers.

#### Machine:

Double-end tenoners, finger joint machines, edgebanding machines etc.

#### Technical information:

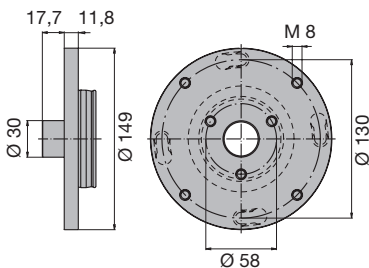
Tool mounted directly on the flange. RPM  $n_{\max}$  9000 min<sup>-1</sup>.

**Attention:** Comply with maximum admissible speed for the mounted tools!

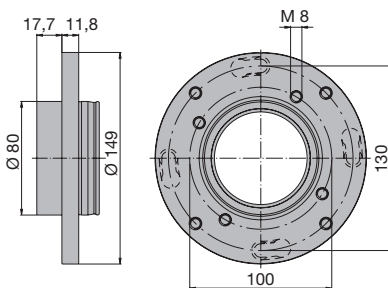
#### Tool flange

TD 882 0 01, TD 883 0 01

Tool Type	ID LH	ID RH
160/1 for cutting tools BO 30 mm/NL 17.7	<b>159059</b>	<b>159060</b>
160/2 for hoggers BO 80 mm/NL 17.7	<b>159063</b> ●	<b>159064</b> ●



Tool flange type 160/1, for tools



Tool flange type 160/2, for hoggers

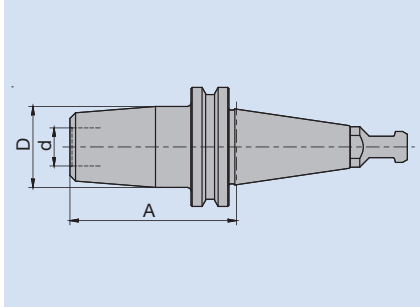
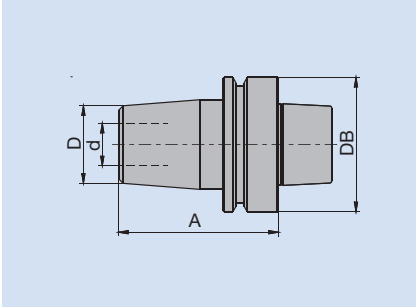
## 7. Clamping systems

### 7.3 Clamping chucks

#### 7.3.1 Shrink-fit chucks

<b>Application</b>	Clamping of shank tools with high precision and stability.
<b>Machine</b>	Stationary routers with/without CNC control and cutter spindles for automatic tool change. Milling machines with cutter spindles for automatic tool change.

#### Technical features



Shrink-fit chuck with hollow taper shank.

Shrink-fit chuck with steep taper.

D	Largest diameter of the chuck in the clamping area
d	Clamping or bore diameter
DB	Outer diameter of groove
A	Length from reference point on steep taper or HSK reference surface

<b>Permissible shank tolerances</b>	Tools clamped in shrink-fit chucks must have at least the following tool shank tolerances:
-------------------------------------	--

	Diameter of shank	
	< 12 mm	≥ 12 mm
Tools mounted in Shrink-fit chucks	ISO h6	ISO g6

<b>Application data</b>	<b>Maximum RPM</b> The maximum RPM for shrink-fit chucks: $n_{\max} = 36000 \text{ min}^{-1}$ .
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<b>Operation</b>	Shrink-fit chucks have a bore smaller than the diameter of the shank to be clamped. The chuck is opened by heating the chuck in the clamping area. The HF generator, enables quick and secure expansion of the shrink-fit chucks by induction heating allowing. The tool can be fitted / replaced. After the chuck has cooled down the tool is ready for use. After short, quick heating the tool can be removed or fitted. After the chuck has cooled down the tool can be used.
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Leitz High Frequency Generator ISG3400.



### Shrink-fit chuck ThermoGrip® Tapered

#### Application:

High precision tool chuck for clamping shank tools by thermal shrinking. Has the highest stability and rigidity of all known shank tools clamping systems, suitable for HSC and HPC machining.

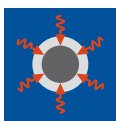
#### Technical information:

Tool chuck for high performance. Precision-balanced for speeds up to 36000 min<sup>-1</sup>. Short, slim design for improved chip flow extraction. For clamping tungsten carbide and steel shanks. Clamping eccentricity  $e \leq 0.01$  mm. Integrated length adjustment to adapt the clamping depth of the tool.

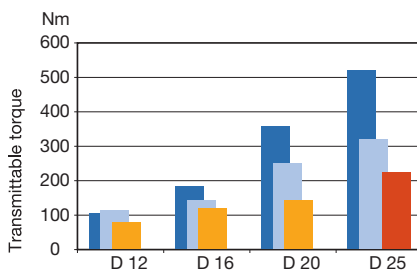
#### SK 30, DIN ISO 7388

PT 301 0

Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	Length adj. mm	STO	ID
A	12	34	50	70	141.8	0.7	7	g6	670200 <input type="checkbox"/>
A	16	34	50	70	141.8	0.7	7	g6	670201 <input type="checkbox"/>
A	20	42	50	70	141.8	0.8	7	g6	670202 <input type="checkbox"/>
A	25	42	50	80	151.8	1.0	7	g6	670210 <input type="checkbox"/>
B	12	34	50	70	141.8	0.7	7	g6	670203 <input type="checkbox"/>
B	16	34	50	70	141.8	0.7	7	g6	670204 <input type="checkbox"/>
B	20	42	50	70	141.8	0.8	7	g6	670205 <input type="checkbox"/>
B	25	42	50	80	151.8	1.0	7	g6	670211 <input type="checkbox"/>



Comparison of transferable torque of traditional clamping chucks



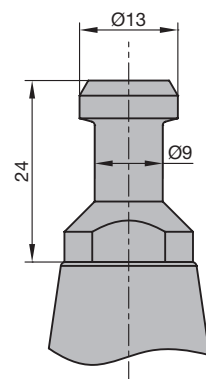
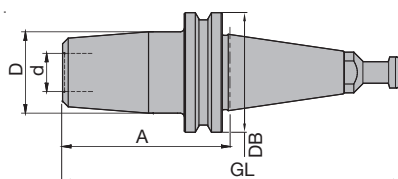
#### SK 40, DIN ISO 7388

PT 301 0

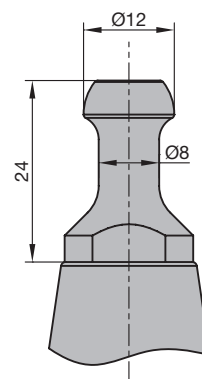
Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	Length adj. mm	STO	ID
E	12	34	63.5	70	164.4	1.1	7	g6	670206 <input type="checkbox"/>
E	16	34	63.5	70	164.4	1.1	7	g6	670207 <input type="checkbox"/>
E	20	42	63.5	70	164.4	1.2	7	g6	670208 <input type="checkbox"/>
E	25	42	63.5	80	174.4	1.2	7	g6	670209 <input type="checkbox"/>

- ThermoGrip® shrink-fit chuck
- Collet DIN ISO 10897-B25, 75 Nm Tightening torque
- Collet DIN ISO 15488-B32 (ER32), 75 Nm Tightening torque
- Hydro clamping chuck

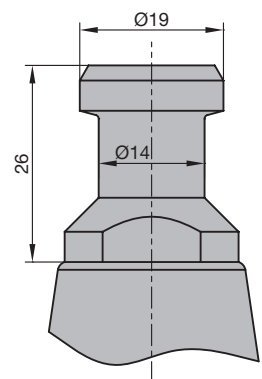
The clamping range of collet chucks and hydro clamping chucks includes shank tolerances g7 and h6. Leitz ThermoGrip® chucks are designed for a shank tolerance h6 for clamping diameters  $d < 12$  mm and a shank tolerance g6 for clamping diameters  $d \geq 12$  mm.



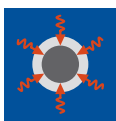
Type: A  
SK 30 pull stud as per DIN ISO 7388



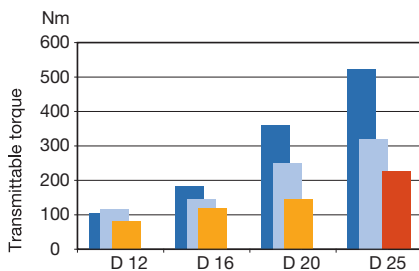
Type: B  
SK 30/ISO 30 pull stud for HSD spindles from construction year 9/92 on



Type: E  
SK 40 pull stud as per DIN ISO 7388

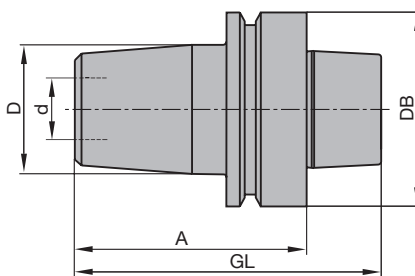


Comparison of transferable torque of traditional clamping chucks



- ThermoGrip® shrink-fit chuck
- Collet DIN ISO 10897-B25, 75 Nm Tightening torque
- Collet DIN ISO 15488-B32 (ER32), 75 Nm Tightening torque
- Hydro clamping chuck

The clamping range of collet chucks and hydro clamping chucks includes shank tolerances g7 and h6. Leitz ThermoGrip® chucks are designed for a shank tolerance h6 for clamping diameters  $d < 12$  mm and a shank tolerance g6 for clamping diameters  $d \geq 12$  mm.



### Shrink-fit chuck ThermoGrip® with hollow taper shank

#### Application:

High precision tool chuck for clamping shank tools by thermal shrinking. Has the highest stability and rigidity of all known shank tools clamping systems, suitable for HSC and HPC machining.

#### Technical information:

Tool chuck for high performance. Precision-balanced for speeds up to 36000 min<sup>-1</sup>. Short, slim design for improved chip flow extraction. For clamping tungsten carbide and steel shanks. Clamping eccentricity  $e \leq 0.01$  mm.

#### HSK-E 63, DIN 69893

PT 300 0

d mm	D mm	DB mm	A mm	GL mm	Weight kg	STO	ID without chip
8	27	63	75	107	0.9	h6	670002 ●
10	32	63	75	107	0.9	h6	670003 ●
12	34	63	75	107	0.9	g6	670004 ●
14	34	63	75	107	0.9	g6	670005 ●
16	34	63	75	107	0.9	g6	670006 ●
18	42	63	75	107	1.0	g6	670007 ●
20	42	63	75	107	1.0	g6	670008 ●
25	42	63	75	107	1.0	g6	670009 ●
32	53	63	90	122	1.2	g6	670016 ●

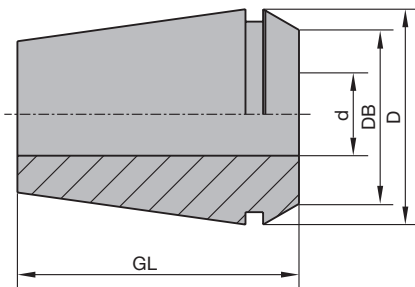
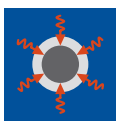
#### HSK-F 63, DIN 69893

PT 300 0

d mm	d in	D mm	DB mm	A mm	GL mm	Weight kg	STO	ID With chip	ID Without chip
6		27	63	75	100	0.8	h6	037753 □	037713 ●
8		27	63	75	100	0.8	h6	037754 □	037714 ●
9.53	3/8"	32	63	75	100	0.9	h6	670013 □	670010 ●
10		32	63	75	100	0.9	h6	037755 □	037715 ●
10		32	63	120	145	1.0	h6		670017 ●
12		34	63	75	100	0.9	g6	037752 □	037712 ●
12		34	63	90	115	1.0	g6		670018 ●
12		34	63	120	145	1.1	g6		670019 ●
12.7	1/2"	34	63	75	100	0.9	h6	670014 □	670011 ●
14		34	63	75	100	0.9	g6	037756 □	037716 ●
16		34	63	75	100	0.9	g6	037719 □	037709 ●
16		34	63	95	120	1.0	g6		670020 ●
16		34	63	120	145	1.0	g6		670021 ●
18		42	63	75	100	1.0	g6	037757 □	037718 ●
19.05	3/4"	42	63	75	100	0.9	h6	670015 □	670012 ●
20		42	63	75	100	1.0	g6	037750 □	037710 ●
20		42	63	100	125	1.2	g6		670022 ●
25		42	63	75	100	0.9	g6	037751 □	037711 ●
32		53	63	90	115	1.2	g6	670001 □	670000 ●

#### Note:

Chucks with chip already have a data chip (511 bytes) ID **081309** ex works. Chips with larger capacity are available on request.



Shrink-fit collet TER, TB 120 0 01

#### Note:

Corresponding accessories for shrink-fit units are required in order to use shrink-fit collets TER - ER together with the shrink-fit units ISG 22xx / 32xx or 24xx / 34xx.  
See: Brochure ThermoGrip® shrink-fit generator.

### Shrink collet ThermoGrip®, Type TER, DIN ISO 15488

#### Application:

High precision tool chuck for clamping shank tools by thermal shrinking. Has the highest stability and rigidity of all known shank tools clamping systems, suitable for HSC and HPC machining.

#### Technical information:

Replacement for conventional spring collets to increase concentricity, rigidity and speed strength. Universal design for the adaptation of shank tools in machining aggregates as well as direct clamping in spindles with integrated collet adaptor. For clamping of carbide and steel shanks. Clamping eccentricity  $e \leq 0.01$  mm.

**Attention:** In order to mount the collet nut in the shrunk tool, the tool diameter is not allowed to be larger than the collar diameter (DB) stated in the table. In individual cases the existing clamping nut must be exchanged with the version stated in the table.

#### TER - ER16, DIN ISO 15488, 8°

TB 120 0 01

BEZ	d mm	D mm	DB mm	GL mm	ID
Shrink collet	3	17	12	27	<b>679500</b> □
Shrink collet	4	17	12	27	<b>679501</b> □
Shrink collet	6	17	12	27	<b>679502</b> □
Shrink collet	8	17	12	27	<b>679503</b> □

#### Spare parts:

BEZ	ABM mm	D mm	ID
Collet chuck nut	M22x1.5	28	<b>006657</b> □

#### TER - ER20, DIN ISO 15488, 8°

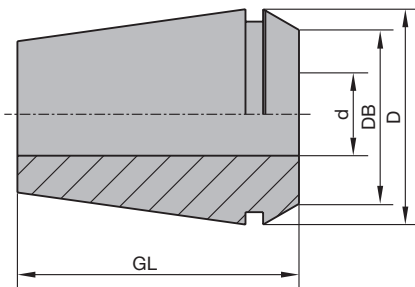
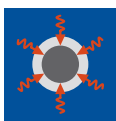
TB 120 0 01

BEZ	d mm	D mm	DB mm	GL mm	ID
Shrink collet	6	21	15.5	31	<b>679504</b> □
Shrink collet	8	21	15.5	31	<b>679505</b> □
Shrink collet	10	21	15.5	31	<b>679506</b> □

#### Spare parts:

BEZ	ABM mm	D mm	ID
Collet chuck nut	M25x1,5	34	<b>006658</b> □





Shrink-fit collet TER, TB 120 0 01

#### Note:

Corresponding accessories for shrink-fit units are required in order to use shrink-fit collets TER - ER together with the shrink-fit units ISG 22xx / 32xx or 24xx / 34xx.  
See: Brochure ThermoGrip® shrink-fit generator.

### Shrink collet ThermoGrip®, Type TER, DIN ISO 15488

#### Application:

High precision tool chuck for clamping shank tools by thermal shrinking. Has the highest stability and rigidity of all known shank tools clamping systems, suitable for HSC and HPC machining.

#### Technical information:

Replacement for conventional spring collets to increase concentricity, rigidity and speed strength. Universal design for the adaptation of shank tools in machining aggregates as well as direct clamping in spindles with integrated collet adaptor. For clamping of carbide and steel shanks. Clamping eccentricity  $e \leq 0.01$  mm.

**Attention:** In order to mount the collet nut in the shrunk tool, the tool diameter is not allowed to be larger than the collar diameter (DB) stated in the table. In individual cases the existing clamping nut must be exchanged with the version stated in the table.

#### TER - ER25, DIN ISO 15488, 8°

TB 120 0 01

BEZ	d mm	D mm	DB mm	GL mm	ID
Shrink collet	3	26	20.5	35	<b>679507</b> □
Shrink collet	4	26	20.5	35	<b>679508</b> □
Shrink collet	6	26	20.5	35	<b>679509</b> □
Shrink collet	8	26	20.5	35	<b>679510</b> □
Shrink collet	10	26	20.5	35	<b>679511</b> □
Shrink collet	12	26	20.5	35	<b>679512</b> □
Shrink collet	14	26	20.5	35	<b>679513</b> □
Shrink collet	16	26	20.5	35	<b>679514</b> □

#### Spare parts:

BEZ	ABM mm	D mm	ID
Collet chuck nut	M32x1,5	42	<b>006659</b> □

#### TER - ER32, DIN ISO 15488, 8°

TB 120 0 01

BEZ	d mm	D mm	DB mm	GL mm	ID
Shrink collet	6	33	26.5	40	<b>679515</b> □
Shrink collet	8	33	26.5	40	<b>679516</b> □
Shrink collet	10	33	26.5	40	<b>679517</b> □
Shrink collet	12	33	26.5	40	<b>679518</b> □
Shrink collet	14	33	26.5	40	<b>679519</b> □
Shrink collet	16	33	26.5	40	<b>679520</b> □
Shrink collet	18	33	26.5	40	<b>679521</b> □
Shrink collet	20	33	26.5	40	<b>679522</b> □

#### Spare parts:

BEZ	ABM mm	D mm	ID
Collet chuck nut	M40x1,5	50	<b>006660</b> □

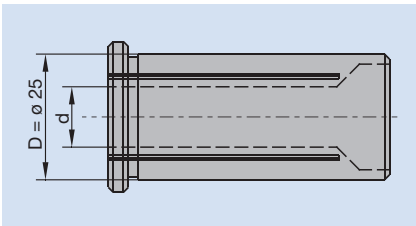
## 7. Clamping systems

### 7.3 Clamping chucks

#### 7.3.2 Hydro chucks

Application	High precision clamping of shank tools.								
Machine	Stationary routers with CNC control and spindles for automatic tool change. Milling machines with spindles for automatic tool change.								
Technical features	Hydro chucks are used to clamp shank tools in spindles with high precision. Hydro chucks have the same concentric run out tolerance as shrink-fit chucks, but shrink-fit chucks have considerably higher stability. Shrink-fit chucks are recommended for high cutting forces machining operations.								
Permissible shank tolerances	Tools clamped in hydro chucks must have the following tool shank tolerances: <table><tr><td></td><td colspan="2">Diameter of shank</td></tr><tr><td rowspan="2">Tools mounted in Hydro chucks</td><td>&lt; 12 mm</td><td>≥ 12 mm</td></tr><tr><td>ISO h6</td><td>ISO g6</td></tr></table>		Diameter of shank		Tools mounted in Hydro chucks	< 12 mm	≥ 12 mm	ISO h6	ISO g6
	Diameter of shank								
Tools mounted in Hydro chucks	< 12 mm	≥ 12 mm							
	ISO h6	ISO g6							
Application data	<b>Maximum RPM</b> Maximum RPM for hydro chucks: $n_{\max} = 25000 \text{ min}^{-1}$ .								
Reducing the clamping diameter	The standard clamping diameter for Leitz hydro chucks is 25 mm. Other shank diameters are clamped using reducing sleeves. The use of reducing sleeves significantly decreases the clamping force and the concentric run out tolerance. It is recommended not to reduce the shank diameter except when absolutely necessary.								

The following shank diameters can be clamped with reducing sleeves:



D	25 mm
d	12 mm
	14 mm
	16 mm
	20 mm



### Hydro chucks for shank tools with hollow shank taper HSK-F 63

#### Application:

High precision tool chuck for hydro clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 25$  mm.

#### Technical information:

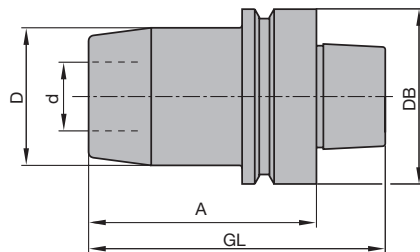
Reduction of clamping diameter by special reduction inserts. Independent of direction of rotation, suitable for right hand and left hand rotation tool. Easy handling clamping system. Tool adaptor finely balanced. Maximum admissible speed  $n_{\max} = 25000 \text{ min}^{-1}$ .

#### Clamping diameter 25 mm

PH 350 0

d	D	DB	A	GL	Weight	ID
mm	mm	mm	mm	mm	kg	
25	50	63	85	100	1.1	039086 ●

Sales unit consisting of chuck and clamping key.



Hydro chuck HSK-F 63

#### Spare parts:

BEZ	ABM	ID
	mm	
Reducing sleeve	d12/25x56x12	039081 ●
Reducing sleeve	d14/25x56x14	039082 ●
Reducing sleeve	d16/25x56x16	039083 ●
Reducing sleeve	d20/25x56x20	039084 ●
Allen key	SW 5	005446 ●

## 7. Clamping systems

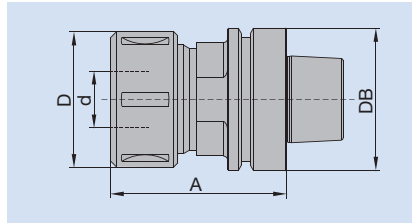
### 7.3 Clamping chucks

#### 7.3.3 Collet chucks

**Application** Clamping system for shank tools.

**Machine** Stationary routers with/without CNC control, CNC machining centres  
Milling machines with spindles to mount shank tools,  
Router machines without automatic tool change,  
Portable routers.

#### Technical features



Collet chuck HSK-F 63.

D	Largest diameter of the chuck in the clamping area
d	Tool shank clamping diameter
DB	Diameter of chuck face
A	Length to reference point (SK) or to reference surface (HSK)

**Permissible shank tolerances** Tools clamped in collet chucks must have at least the following tool shank tolerances:

Tools mounted in Collet chuck	Diameter of shank	
	< 12 mm	≥ 12 mm
	ISO g7	ISO g7

**Collet nut clamping torque** The following torques are required for safe clamping of the tool in the collet chuck:

Collet nut thread	Spanner type	Clamping torque
M 30 x 1,5	SW 40/42	60 Nm
M 33 x 1,5	SW 40/42	60 Nm
M 40 x 1,5	SW 45/50	80 Nm
M 48 x 2	SW 58/62	100 Nm
M 50 x 1,5	SW 58/62	100 Nm

#### Application data

##### Maximum RPM

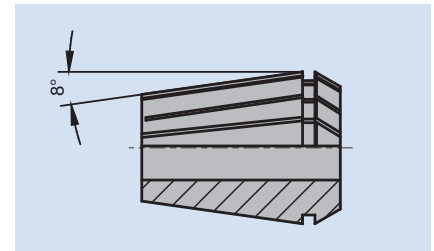
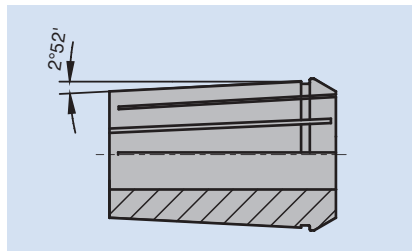
The maximum RPM for collet chucks:

$n_{\max} = 24000 \text{ min}^{-1}$  (shank diameters up to 25 mm).

HSC Collet chucks (High Speed Cutting) have a maximum RPM:  $n_{\max} = 30000 \text{ min}^{-1}$ .

#### Collet chuck design

Leitz collet chucks are available for the two designs of collet below.



Collet taper angle 2°52': DIN ISO 10897.

Collet taper angle 8°: DIN ISO 15488.

Collets with a taper angle of 2°52', taper tolerance 1:10, DIN ISO 10897 are recommended.



### Precision collet chuck, cylindrical shank

#### Application:

Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 16$  mm.

#### Technical information:

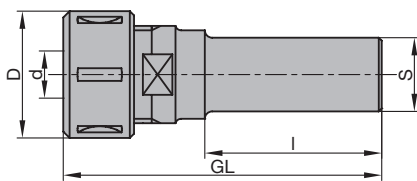
Exact concentricity through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design.

#### Model with ball bearing collet nut

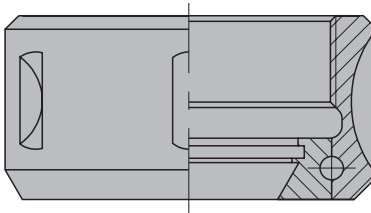
PM 350 0 03

d	D	A	GL	S	Weight	Type	ID
mm	mm	mm	mm	mm	kg		
6 - 12.7	35		77	25x50	0.6	1	671001 ●
6 - 16	43	55	115	MK II / M30	0.8	2	037493 ●
6 - 16	43		108	25x60	0.8	2	037494 ●

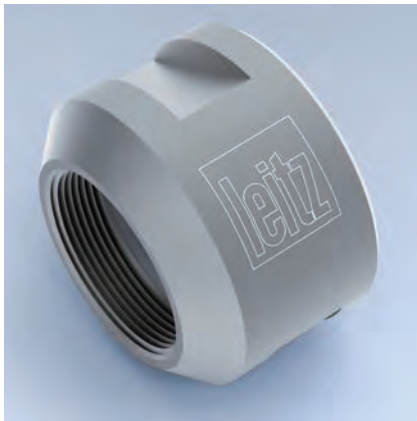
Sales unit consists of clamping chuck, collet nut and key, without collet.



Collet chuck with cylindrical shank



Ball bearing collet nut



#### Spare parts:

BEZ	ABM	for S	ID	ID
	mm	mm	1	2
Collet (2°52')		6	679013 ●	679005 ●
Collet (2°52')		7	679015 ●	
Collet (2°52')		8	679016 ●	679032 ●
Collet (2°52')		9	679017 ●	679033 ●
Collet (2°52')		9.5		679034 ●
Collet (2°52')		10	679019 ●	679006 ●
Collet (2°52')		11		679035 ●
Collet (2°52')		12	679020 ●	679036 ●
Collet (2°52')		13		679007 ●
Collet (2°52')		14		679037 ●
Collet (2°52')		16		679008 ●
Collet (2°52')		6.35 (1/4")	679014 ●	679009 ●
Collet (2°52')		9.53 (3/8")	679018 ●	679010 ●
Collet (2°52')		12.7 (1/2")	679021 ●	679011 ●
Sickle spanner	34/36		005498 ●	
Sickle spanner	40/42			005469 ●
Collet chuck nut	M27x1.5		006653 ●	
Collet chuck nut with ball bearing	M33x1.5			005685 ●

### Clamping nut for morse taper II shanks

#### Application:

For clamping tools or tool chucks with morse taper II shanks (MK II).

#### Technical information:

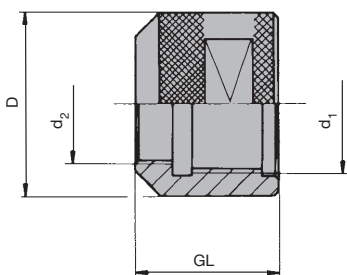
$d_1 = W 1 \frac{1}{8}$ " suitable for Perske and Maka motor spindles.

$d_1 = M 33 \times 3$  suitable for Italian routers.

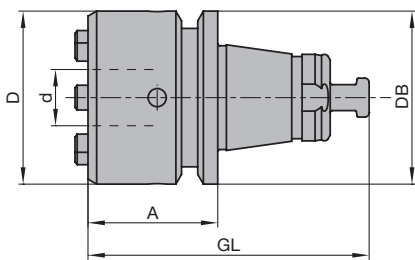
#### With differential thread

TK 510 0

D	$d_1$	$d_2$	GL	ID
mm	mm	mm	mm	RH
45	W 1 1/8"	M30x1,5	30	005682 ●
45	M33x3	M30x1,5	35	006624 ●



Fixing nut TK 510 0  
 $d_1$  = machine related  
 $d_2$  = tool related



Collet chuck

### Collet chuck with steep taper for CNC aggregates

#### Application:

Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 16 \text{ mm}$  (5/8").

#### Technical information:

Steep taper design for Flex 5+ aggregates (Homag Group) and 5-motion-Plus aggregate (Felder Format-4). Exact concentric running through hardened, ground and double slotted collets. Easy handling through automatic opening of the collet when opening the collet nut. Tool adaptor and collet nut fine balanced. Maximum tool protrusion of the chuck = 50 mm. A collet with clamping diameter 10 mm is included.

#### A = 30 mm, diameter range 3-16 mm

PM 350 0

Machine	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
Felder Format-4, Homag Group	3 - 16	40	40	30	65	0.3	<b>672002 •</b>

#### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (8°)		6	<b>037979 •</b>
Collet (8°)		8	<b>037980 •</b>
Collet (8°)		10	<b>037981 •</b>
Collet (8°)		12	<b>037982 •</b>
Collet (8°)		14	<b>037983 •</b>
Collet (8°)		16	<b>037984 •</b>
Collet (8°)		6.35 (1/4")	<b>679027 •</b>
Collet (8°)		9.53 (3/8")	<b>679028 •</b>
Collet (8°)		12.7 (1/2")	<b>679029 •</b>
Collet (8°)		15.88 (5/8")	<b>679030 •</b>
Clamping key	E25AX		<b>117519 •</b>
Collet chuck nut	ERAX25		<b>116501 □</b>



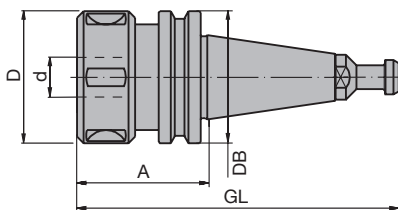
### Collet chuck with steep taper SK 30

#### Application:

Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 20$  mm.

#### Technical information:

Steep taper design as per DIN ISO 7388, without grooves and notches. Exact concentric running through hardened, ground and double slotted collets. Vibration free cutting by short design. Easy handling through automatic opening of the collet when loosening the collet nut. Suitable for right hand and left hand rotation due to ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.

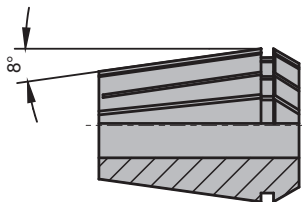


**SK 30, A = 50 / 63 mm, diameter range 6-20 mm, 8° taper angle of the collet**  
PM 350 0 04

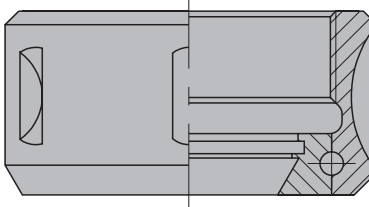
Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
B	6 - 20	50	50	50	121.8	0.6	037904 ●
B	6 - 20	50	50	63	134.8	0.7	672001 ●

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

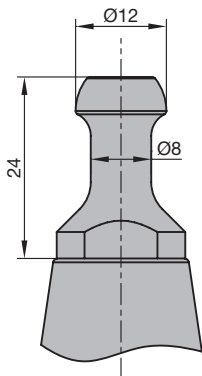
Collet chuck with steep taper



Collet angle 8°: DIN ISO 15488



Ball bearing collet nut



Type: B  
SK 30/ISO 30 pull stud for HSD spindles  
from construction year 9/92 on

#### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (8°)		6	037439 ●
Collet (8°)		8	037440 ●
Collet (8°)		10	037441 ●
Collet (8°)		12	037442 ●
Collet (8°)		13	037443 ●
Collet (8°)		14	037444 ●
Collet (8°)		16	037445 ●
Collet (8°)		18	037446 ●
Collet (8°)		20	037447 ●
Collet (8°)		6.35 (1/4")	037509 ●
Collet (8°)		9.53 (3/8")	037510 ●
Collet (8°)		12.7 (1/2")	037511 ●
Collet (8°)		15.88 (5/8")	037507 ●
Collet (8°)		19.05 (3/4")	037506 ●
Sickle spanner	45/50		005491 ●
Collet chuck nut with ball bearing	M40x1.5		005718 ●





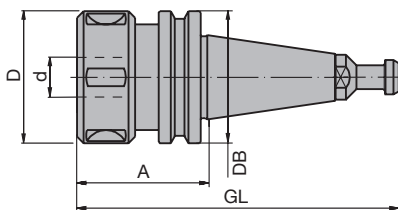
### Collet chuck with steep taper SK 30

#### Application:

Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{max} = 25.4 \text{ mm}$  (1").

#### Technical information:

Steep taper design as per DIN ISO 7388, without grooves and notches. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.



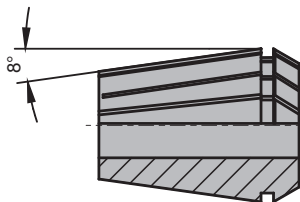
#### SK 30, A = 61 mm, 8° taper angle of collet, diameter range 6-25.4 mm

PM 350 0 16

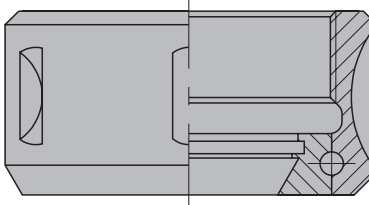
Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
B	6 - 25.4	63	50	61	108.8	0.9	<b>037968 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

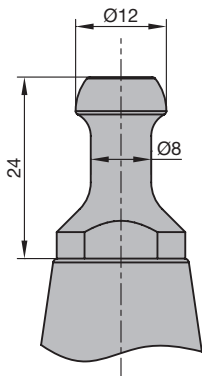
Collet chuck with steep taper



Collet angle 8°: DIN ISO 15488



Ball bearing collet nut



Type: B  
SK 30/ISO 30 pull stud for HSD spindles  
from construction year 9/92 on

#### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (8°)		6	<b>037926 ●</b>
Collet (8°)		8	<b>037927 ●</b>
Collet (8°)		10	<b>037928 ●</b>
Collet (8°)		12	<b>037929 ●</b>
Collet (8°)		14	<b>037930 ●</b>
Collet (8°)		16	<b>037931 ●</b>
Collet (8°)		20	<b>037932 ●</b>
Collet (8°)		25	<b>037933 ●</b>
Collet (8°)		6.35 (1/4")	<b>037934 ●</b>
Collet (8°)		9.53 (3/8")	<b>037935 ●</b>
Collet (8°)		12.7 (1/2")	<b>037936 ●</b>
Collet (8°)		15.88 (5/8")	<b>037937 ●</b>
Collet (8°)		19.05 (3/4")	<b>037938 ●</b>
Collet (8°)		25.4 (1")	<b>037939 ●</b>
Sickle spanner	58/62		<b>005458 ●</b>
Collet chuck nut with ball bearing	M50x1.5		<b>006639 ●</b>



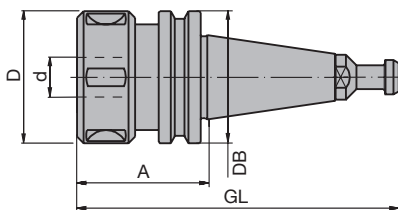
### Collet chuck with steep taper SK 30 / SK 40

#### Application:

Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 25.4 \text{ mm}$  (1").

#### Technical information:

Steep taper design as per DIN ISO 7388, without grooves and notches. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.



#### SK 30, A = 70 mm, diameter range 6-25.4 mm

PM 350 0 05

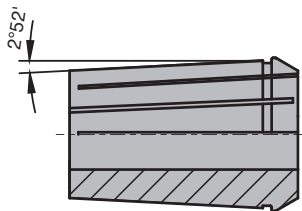
Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
A	6 - 25.4	60	50	70	141.8	0.9	<b>037421 •</b>

#### SK 40, A = 70 mm, diameter range 6-25.4 mm

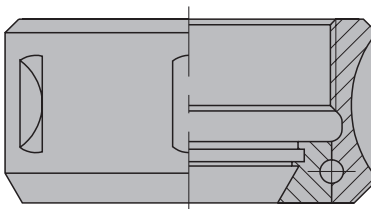
PM 350 0 05

Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
E	6 - 25.4	60	63.55	70	164.6	1.5	<b>037422 •</b>

Collet chuck with steep taper



Collet angle 2°52': DIN ISO 10897

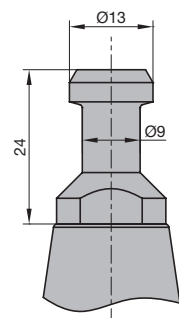


Ball bearing collet nut

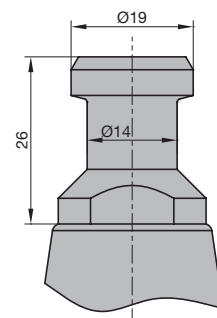
Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

#### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (2°52')		6	<b>037429 •</b>
Collet (2°52')		8	<b>037430 •</b>
Collet (2°52')		10	<b>037431 •</b>
Collet (2°52')		12	<b>037432 •</b>
Collet (2°52')		13	<b>037433 •</b>
Collet (2°52')		14	<b>037434 •</b>
Collet (2°52')		16	<b>037435 •</b>
Collet (2°52')		18	<b>037436 •</b>
Collet (2°52')		20	<b>037437 •</b>
Collet (2°52')		25	<b>037438 •</b>
Collet (2°52')		6.35 (1/4")	<b>037495 •</b>
Collet (2°52')		9.53 (3/8")	<b>037505 •</b>
Collet (2°52')		12.7 (1/2")	<b>037496 •</b>
Collet (2°52')		15.88 (5/8")	<b>037502 •</b>
Collet (2°52')		19.05 (3/4")	<b>037497 •</b>
Collet (2°52')		25.4 (1")	<b>037508 •</b>
Sickle spanner	58/62		<b>005458 •</b>
Collet chuck nut with ball bearing	M48x2		<b>005714 •</b>
Locking nut with Euchner chip	SK 40, 511 Bytes		<b>081600 •</b>
Locking nut with Balluff chip	SK 40, 511 Bytes		<b>081601 •</b>



Type: A  
SK 30 pull stud as per  
DIN ISO 7388



Type: E  
SK 40 pull stud as  
per DIN ISO 7388



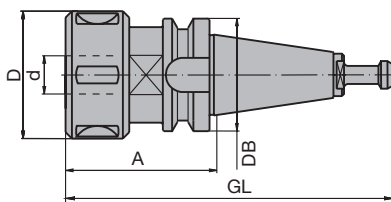
### Collet chuck with steep taper BT 30 and BT 35

#### Application:

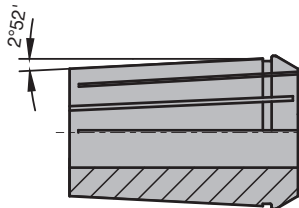
Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 25.4 \text{ mm}$  (1").

#### Technical information:

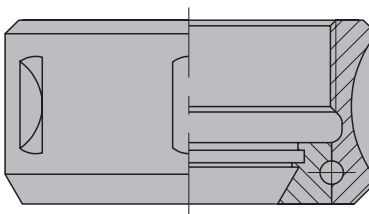
Steep taper design BT 30 or BT 35. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts. (Design for SK 30).



Collet chuck BT 35



Collet angle 2°52': DIN ISO 10897



Ball bearing collet nut

#### Steep taper BT 30 without grooves and notches

PM 350 0 07

Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
F	6 - 25.4	60	46	70	141.4	0.9	<b>037962 •</b>

#### Steep taper BT 35 with grooves and notches

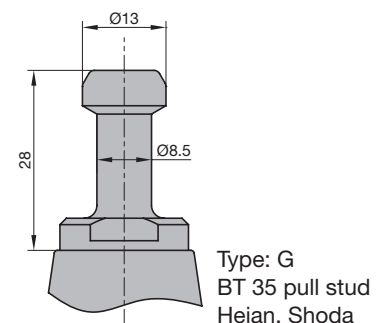
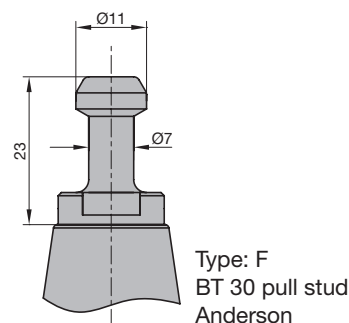
PM 350 0 07

Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
G	6 - 25.4	60	53	70	154.4	1	<b>037414 •</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

#### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (2°52')		6	<b>037429 •</b>
Collet (2°52')		8	<b>037430 •</b>
Collet (2°52')		10	<b>037431 •</b>
Collet (2°52')		12	<b>037432 •</b>
Collet (2°52')		13	<b>037433 •</b>
Collet (2°52')		14	<b>037434 •</b>
Collet (2°52')		16	<b>037435 •</b>
Collet (2°52')		18	<b>037436 •</b>
Collet (2°52')		20	<b>037437 •</b>
Collet (2°52')		25	<b>037438 •</b>
Collet (2°52')		6.35 (1/4")	<b>037495 •</b>
Collet (2°52')		9.53 (3/8")	<b>037505 •</b>
Collet (2°52')		12.7 (1/2")	<b>037496 •</b>
Collet (2°52')		15.88 (5/8")	<b>037502 •</b>
Collet (2°52')		19.05 (3/4")	<b>037497 •</b>
Collet (2°52')		25.4 (1")	<b>037508 •</b>
Sickle spanner	58/62		<b>005458 •</b>
Collet chuck nut with ball bearing	M48x2		<b>005714 •</b>





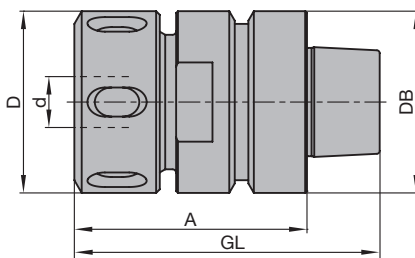
### Collet chuck with hollow taper shank HSK-F 50

#### Application:

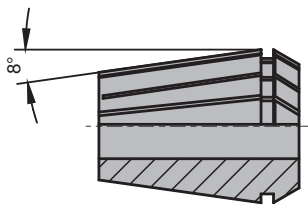
Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 20$  mm.

#### Technical information:

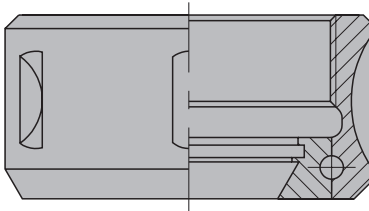
Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.



Collet chuck HSK-F 50



Collet angle 8°: DIN ISO 15488



Ball bearing collet nut

#### HSK-F 50, DIN 69893, diameter range up to 20 mm, 8° angle of the collet

PM 350 0 15

d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
6 - 20	50	50	64	84	0.9	<b>037999 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet and spanner.

#### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (8°)		6	<b>037439 ●</b>
Collet (8°)		8	<b>037440 ●</b>
Collet (8°)		10	<b>037441 ●</b>
Collet (8°)		12	<b>037442 ●</b>
Collet (8°)		13	<b>037443 ●</b>
Collet (8°)		14	<b>037444 ●</b>
Collet (8°)		16	<b>037445 ●</b>
Collet (8°)		18	<b>037446 ●</b>
Collet (8°)		20	<b>037447 ●</b>
Collet (8°)		6.35 (1/4")	<b>037509 ●</b>
Collet (8°)		9.53 (3/8")	<b>037510 ●</b>
Collet (8°)		12.7 (1/2")	<b>037511 ●</b>
Collet (8°)		15.88 (5/8")	<b>037507 ●</b>
Collet (8°)		19.05 (3/4")	<b>037506 ●</b>
Sickle spanner	45/50		<b>005491 ●</b>
Collet chuck nut with ball bearing	M40x1.5		<b>005718 ●</b>



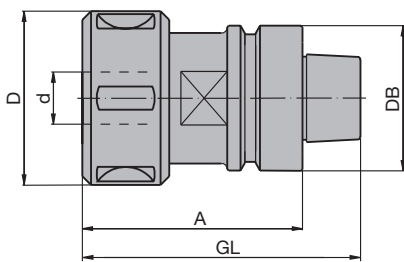
#### Collet chuck with hollow taper shank HSK-F 50

##### Application:

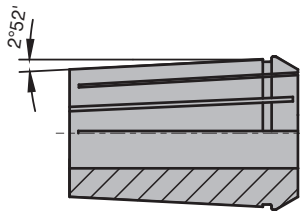
Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 25.4 \text{ mm}$  (1").

##### Technical information:

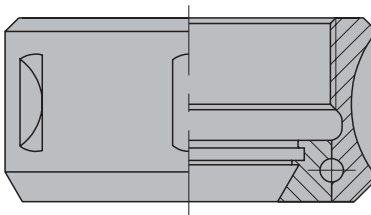
Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.



Collet chuck HSK-F 50



Collet angle 2°52': DIN ISO 10897



Ball bearing collet nut

#### HSK-F 50, DIN 69893, diameter range up to 25.4 mm

PM 350 0 06

d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
6 - 25.4	60	50	76	96	0.9	<b>037500 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

##### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (2°52')		6	<b>037429 ●</b>
Collet (2°52')		8	<b>037430 ●</b>
Collet (2°52')		10	<b>037431 ●</b>
Collet (2°52')		12	<b>037432 ●</b>
Collet (2°52')		13	<b>037433 ●</b>
Collet (2°52')		14	<b>037434 ●</b>
Collet (2°52')		16	<b>037435 ●</b>
Collet (2°52')		18	<b>037436 ●</b>
Collet (2°52')		20	<b>037437 ●</b>
Collet (2°52')		25	<b>037438 ●</b>
Collet (2°52')		6.35 (1/4")	<b>037495 ●</b>
Collet (2°52')		9.53 (3/8")	<b>037505 ●</b>
Collet (2°52')		12.7 (1/2")	<b>037496 ●</b>
Collet (2°52')		15.88 (5/8")	<b>037502 ●</b>
Collet (2°52')		19.05 (3/4")	<b>037497 ●</b>
Collet (2°52')		25.4 (1")	<b>037508 ●</b>
Sickle spanner	58/62		<b>005458 ●</b>
Collet chuck nut with ball bearing	M48x2		<b>005714 ●</b>



#### Collet chuck with hollow taper shank HSK-E 63

##### Application:

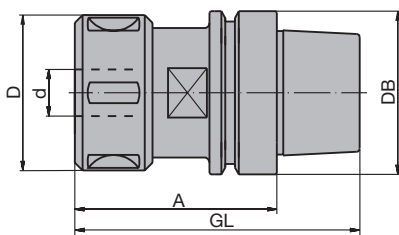
Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 30$  mm.

##### Technical information:

Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Vibration free cutting by short design. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.

#### HSK-E 63, DIN 69893, A = 76 mm, diameter range 6-30 mm, 8° taper angle of the collet

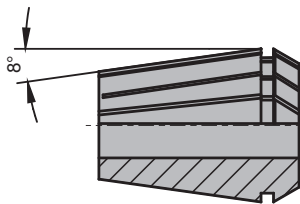
PM 350 0 15



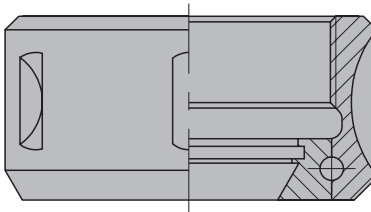
d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
6 - 30	63	63	76	108.5	1.1	<b>679040 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

Collet chuck HSK-E 63



Collet angle 8°: DIN ISO 15488



Ball bearing collet nut

##### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (8°)		6	<b>037926 ●</b>
Collet (8°)		8	<b>037927 ●</b>
Collet (8°)		10	<b>037928 ●</b>
Collet (8°)		12	<b>037929 ●</b>
Collet (8°)		14	<b>037930 ●</b>
Collet (8°)		16	<b>037931 ●</b>
Collet (8°)		20	<b>037932 ●</b>
Collet (8°)		25	<b>037933 ●</b>
Collet (8°)		30	<b>679039 ●</b>
Collet (8°)		6.35 (1/4")	<b>037934 ●</b>
Collet (8°)		9.53 (3/8")	<b>037935 ●</b>
Collet (8°)		12.7 (1/2")	<b>037936 ●</b>
Collet (8°)		15.88 (5/8")	<b>037937 ●</b>
Collet (8°)		19.05 (3/4")	<b>037938 ●</b>
Collet (8°)		25.4 (1")	<b>037939 ●</b>
Sickle spanner	58/62		<b>005458 ●</b>
Collet chuck nut with ball bearing	M50x1.5		<b>006639 ●</b>
Chip-Balluff	511 Bytes		<b>081309 ●</b>
Chip-Balluf	2047 Bytes		<b>081330 □</b>





### Collet chuck with hollow taper shank HSK-E 63

#### Application:

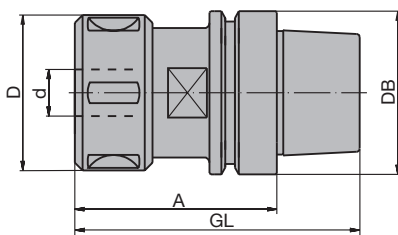
Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 25.4 \text{ mm}$  (1").

#### Technical information:

Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Vibration free cutting by short design. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.

#### HSK-E 63, DIN 69893, A = 78 mm, diameter range 6-25.4 mm

PM 350 0 06



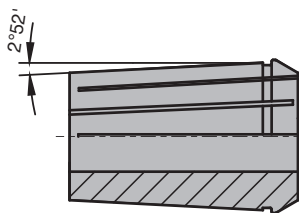
d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
6 - 25.4	60	63	78	110	1.1	<b>037914 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

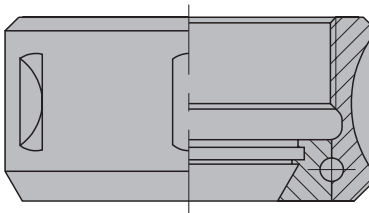
#### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (2°52')		6	<b>037429 ●</b>
Collet (2°52')		8	<b>037430 ●</b>
Collet (2°52')		10	<b>037431 ●</b>
Collet (2°52')		12	<b>037432 ●</b>
Collet (2°52')		13	<b>037433 ●</b>
Collet (2°52')		14	<b>037434 ●</b>
Collet (2°52')		16	<b>037435 ●</b>
Collet (2°52')		18	<b>037436 ●</b>
Collet (2°52')		20	<b>037437 ●</b>
Collet (2°52')		25	<b>037438 ●</b>
Collet (2°52')		6.35 (1/4")	<b>037495 ●</b>
Collet (2°52')		9.53 (3/8")	<b>037505 ●</b>
Collet (2°52')		12.7 (1/2")	<b>037496 ●</b>
Collet (2°52')		15.88 (5/8")	<b>037502 ●</b>
Collet (2°52')		19.05 (3/4")	<b>037497 ●</b>
Collet (2°52')		25.4 (1")	<b>037508 ●</b>
Sickle spanner	58/62		<b>005458 ●</b>
Collet chuck nut with ball bearing	M48x2		<b>005714 ●</b>
Chip-Balluff	511 Bytes		<b>081309 ●</b>
Chip-Balluf	2047 Bytes		<b>081330 □</b>

Collet chuck HSK-E 63



Collet angle 2°52': DIN ISO 10897



Ball bearing collet nut





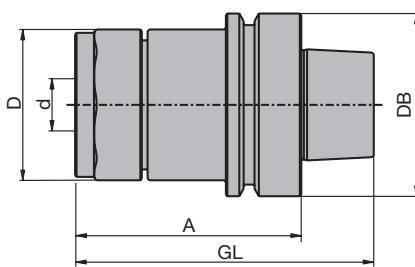
#### NiRo Collet chuck *Premium* with hollow taper shank HSK-F 63

##### Application:

Precision tool chuck especially for use in difficult climatic conditions with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 25.4 \text{ mm}$  (1").

##### Technical information:

Long tool life due to the use of corrosion-resistant steel. Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts. Easy and safe clamping and releasing by clamping key with optimised spanner flats.



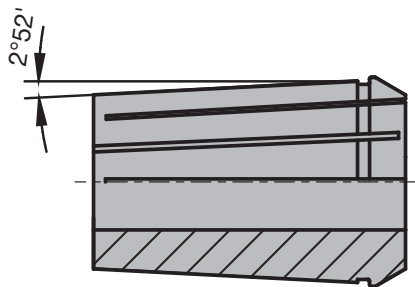
NiRo collet chuck Premium HSK-F 63

#### HSK-F 63, DIN 69893, A = 78, diameter range 6-25.4 mm

PM 350 0 17

d	D	DB	A	GL	Weight	ID
mm	mm	mm	mm	mm	kg	
6 - 25,4	52	63	78	103	1.1	<b>679043 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or clamping key.



Collet angle 2°52': DIN ISO 10897



Special key especially for  
NiRo collet chuck Premium

##### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (2°52')		6	<b>037429 ●</b>
Collet (2°52')		8	<b>037430 ●</b>
Collet (2°52')		10	<b>037431 ●</b>
Collet (2°52')		12	<b>037432 ●</b>
Collet (2°52')		13	<b>037433 ●</b>
Collet (2°52')		14	<b>037434 ●</b>
Collet (2°52')		16	<b>037435 ●</b>
Collet (2°52')		18	<b>037436 ●</b>
Collet (2°52')		20	<b>037437 ●</b>
Collet (2°52')		25	<b>037438 ●</b>
Collet (2°52')		6,35 (1/4")	<b>037495 ●</b>
Collet (2°52')		9,53 (3/8")	<b>037505 ●</b>
Collet (2°52')		12,7 (1/2")	<b>037496 ●</b>
Collet (2°52')		15,88 (5/8")	<b>037502 ●</b>
Collet (2°52')		19,05 (3/4")	<b>037497 ●</b>
Collet (2°52')		25,4 (1")	<b>037508 ●</b>
Clamping key			<b>117540 ●</b>
Collet chuck nut NiRo	TR44x1,5		<b>006663 ●</b>
with ball bearing			
Chip-Balluff	511 Bytes		<b>081309 ●</b>
Chip-Balluff	2047 Bytes		<b>081330 □</b>



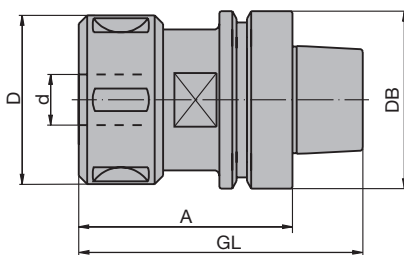
#### Collet chuck with hollow taper shank HSK-F 63

##### Application:

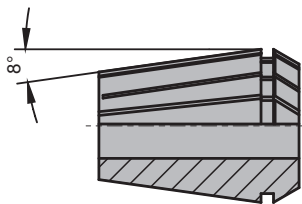
Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 30 \text{ mm}$  (1").

##### Technical information:

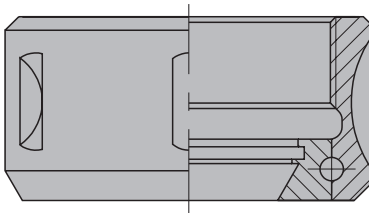
Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.



Collet chuck HSK-F 63



Collet angle 8°: DIN ISO 15488



Ball bearing collet nut

**HSK-F 63, DIN 69893, A = 76 mm, diameter range 6-30 mm, short design, 8° taper angle of the collet**

PM 350 0 15

d	D	DB	A	GL	Weight	ID
mm	mm	mm	mm	mm	kg	
6 - 30	63	63	76	101.5	1	<b>037970 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

##### Spare parts:

BEZ	ABM	for S	ID
	mm	mm	
Collet (8°)		6	<b>037926 ●</b>
Collet (8°)		8	<b>037927 ●</b>
Collet (8°)		10	<b>037928 ●</b>
Collet (8°)		12	<b>037929 ●</b>
Collet (8°)		14	<b>037930 ●</b>
Collet (8°)		16	<b>037931 ●</b>
Collet (8°)		20	<b>037932 ●</b>
Collet (8°)		25	<b>037933 ●</b>
Collet (8°)		30	<b>679039 ●</b>
Collet (8°)		6.35 (1/4")	<b>037934 ●</b>
Collet (8°)		9.53 (3/8")	<b>037935 ●</b>
Collet (8°)		12.7 (1/2")	<b>037936 ●</b>
Collet (8°)		15.88 (5/8")	<b>037937 ●</b>
Collet (8°)		19.05 (3/4")	<b>037938 ●</b>
Collet (8°)		25.4 (1")	<b>037939 ●</b>
Sickle spanner	58/62		<b>005458 ●</b>
Collet chuck nut with ball bearing	M50x1.5		<b>006639 ●</b>
Chip-Balluff	511 Bytes		<b>081309 ●</b>
Chip-Balluf	2047 Bytes		<b>081330 □</b>



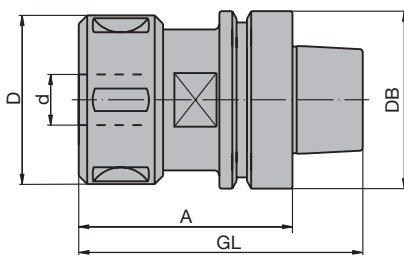
### Collet chuck with hollow taper shank HSK-F 63

#### Application:

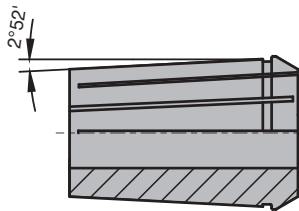
Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 25.4 \text{ mm}$  (1").

#### Technical information:

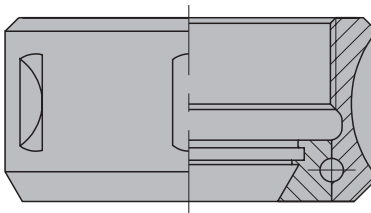
Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.



Collet chuck HSK-F 63



Collet angle 2°52': DIN ISO 10897



Ball bearing collet nut

#### HSK-F 63, DIN 69893, A = 78 / 105 mm, diameter range 6-25.4 mm

PM 350 0 06

d	D	DB	A	GL	Weight	ID
mm	mm	mm	mm	mm	kg	
6 - 25.4	60	63	78	103	1.1	<b>037412 ●</b>
6 - 25.4	60	63	105	130	1.5	<b>037924 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

#### Spare parts:

BEZ	ABM	for S	ID
	mm	mm	
Collet (2°52')		6	<b>037429 ●</b>
Collet (2°52')		8	<b>037430 ●</b>
Collet (2°52')		10	<b>037431 ●</b>
Collet (2°52')		12	<b>037432 ●</b>
Collet (2°52')		13	<b>037433 ●</b>
Collet (2°52')		14	<b>037434 ●</b>
Collet (2°52')		16	<b>037435 ●</b>
Collet (2°52')		18	<b>037436 ●</b>
Collet (2°52')		20	<b>037437 ●</b>
Collet (2°52')		25	<b>037438 ●</b>
Collet (2°52')		6.35 (1/4")	<b>037495 ●</b>
Collet (2°52')		9.53 (3/8")	<b>037505 ●</b>
Collet (2°52')		12.7 (1/2")	<b>037496 ●</b>
Collet (2°52')		15.88 (5/8")	<b>037502 ●</b>
Collet (2°52')		19.05 (3/4")	<b>037497 ●</b>
Collet (2°52')		25.4 (1")	<b>037508 ●</b>
Sickle spanner	58/62		<b>005458 ●</b>
Collet chuck nut with ball bearing	M48x2		<b>005714 ●</b>
Chip-Balluff	511 Bytes		<b>081309 ●</b>
Chip-Balluf	2047 Bytes		<b>081330 □</b>



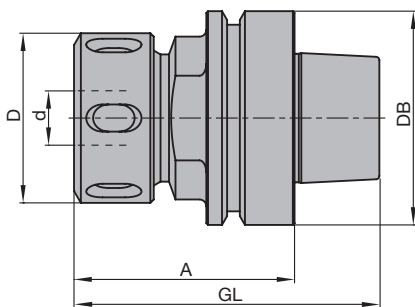
### Collet chuck with hollow taper shank HSK-F 63, HSC machining

#### Application:

Precision tool chuck with collet for clamping shank tools with cylindrical shank. For speeds up to  $n_{\max} = 30000 \text{ min}^{-1}$ .

#### Technical information:

Hollow taper shank as per DIN 69893. Exact concentric running through hardened, ground and double slotted collets. Vibration free cutting by short design. Easy handling as loosening the ball bearing collet nut automatically opens the collet. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device VN 799 0 see section Knives and Spare Parts.



**HSK-F 63, DIN 69893, A = 65 mm diameter range up to 20 mm,**

**$n_{\max} = 30000 \text{ min}^{-1}$**

PM 350 0 15

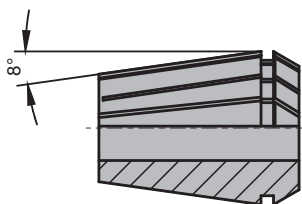
d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
6 - 20	50	63	65	90	0.85	<b>679041 ●</b>

Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

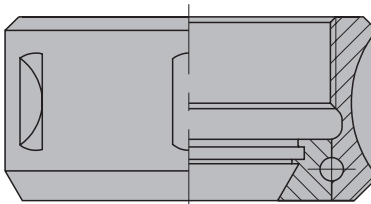
#### Spare parts:

BEZ	ABM mm	for S mm	ID
Collet (8°)		6	<b>037439 ●</b>
Collet (8°)		8	<b>037440 ●</b>
Collet (8°)		10	<b>037441 ●</b>
Collet (8°)		12	<b>037442 ●</b>
Collet (8°)		13	<b>037443 ●</b>
Collet (8°)		14	<b>037444 ●</b>
Collet (8°)		16	<b>037445 ●</b>
Collet (8°)		18	<b>037446 ●</b>
Collet (8°)		20	<b>037447 ●</b>
Collet (8°)		6.35 (1/4")	<b>037509 ●</b>
Collet (8°)		9.53 (3/8")	<b>037510 ●</b>
Collet (8°)		12.7 (1/2")	<b>037511 ●</b>
Collet (8°)		15.88 (5/8")	<b>037507 ●</b>
Collet (8°)		19.05 (3/4")	<b>037506 ●</b>
Sickle spanner	45/50		<b>005491 ●</b>
Collet chuck nut with ball bearing	M40x1.5		<b>005718 ●</b>
Chip-Balluff	511 Bytes		<b>081309 ●</b>
Chip-Balluf	2047 Bytes		<b>081330 □</b>

Collet chuck HSK-F 63



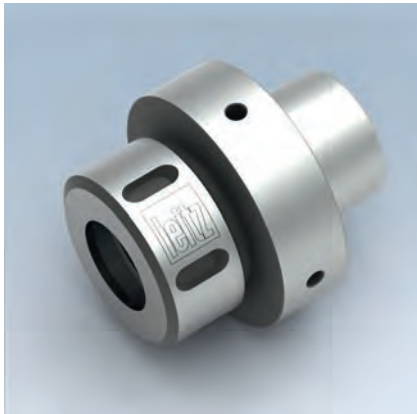
Collet angle 8°: DIN ISO 15488



Ball bearing collet nut

#### Table for max. tool projection:

shank diameter d	max. projection
20	2,2 x d
12-16	3,0 x d
6-10	3,0 x d



### Collet chuck with hollow taper shank HSK 85 WS

#### Application:

Precision tool chuck with collet for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 30 \text{ mm}$  (1").

#### Technical information:

Exact concentric running through hardened, ground and double slotted collets. Easy handling by automatic collet opening when loosening the collet nut. Suitable for right hand and left hand rotation because of ball bearing collet nut. Ball bearing collet nut for increased clamping forces and improved concentricity compared to monobloc design. Tool chuck and collet nut fine balanced. Suitable mounting device ID **079010**.

#### HSK 85 WS, A = 61 mm, diameter range 6-30 mm, 8° taper angle of the collet

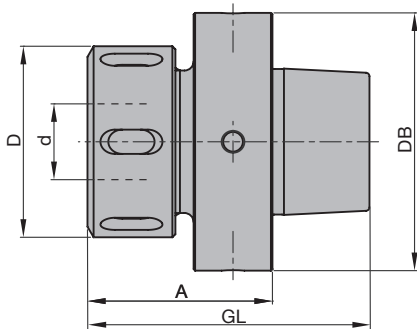
PM 350 0 15

Machine	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
Weinig	6 - 30	63	85	61	93	1.2	<b>679038</b>

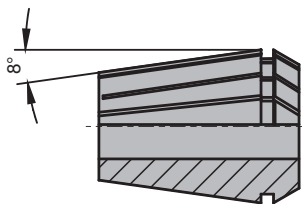
Sales unit consisting of clamping chuck with ball bearing collet nut, without collet or spanner.

#### Spare parts:

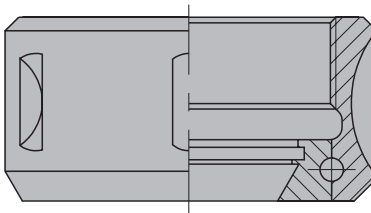
BEZ	ABM mm	for S mm	ID
Collet (8°)		6	<b>037926 ●</b>
Collet (8°)		8	<b>037927 ●</b>
Collet (8°)		10	<b>037928 ●</b>
Collet (8°)		12	<b>037929 ●</b>
Collet (8°)		14	<b>037930 ●</b>
Collet (8°)		16	<b>037931 ●</b>
Collet (8°)		20	<b>037932 ●</b>
Collet (8°)		25	<b>037933 ●</b>
Collet (8°)		30	<b>679039 ●</b>
Collet (8°)		6.35 (1/4")	<b>037934 ●</b>
Collet (8°)		9.53 (3/8")	<b>037935 ●</b>
Collet (8°)		12.7 (1/2")	<b>037936 ●</b>
Collet (8°)		15.88 (5/8")	<b>037937 ●</b>
Collet (8°)		19.05 (3/4")	<b>037938 ●</b>
Collet (8°)		25.4 (1")	<b>037939 ●</b>
Sickle spanner	58/62		<b>005458 ●</b>
Collet chuck nut with ball bearing	M50x1.5		<b>006639 ●</b>



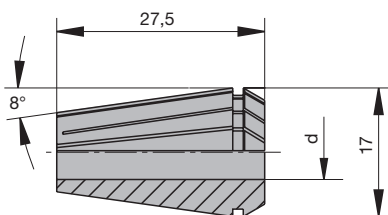
Collet chuck HSK 85 WS



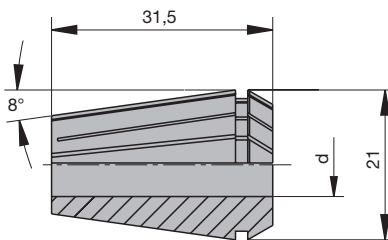
Collet angle 8°: DIN ISO 15488



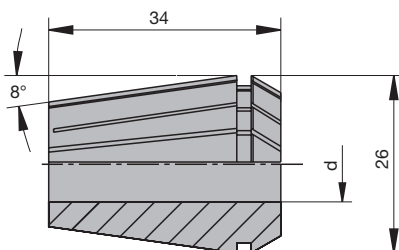
Ball bearing collet nut



ER 16 collet diameter range  
6-10 mm



ER 20 collet diameter range  
6-13 mm



ER 25 collet diameter range  
6-16 mm

### Collets, type ER, DIN ISO 15488

#### Application:

For collet chucks and multi spindle units and trimming units with 8° taper angle (type ER, DIN ISO 15488).

#### Technical information:

Double slotted design for maximum clamping forces and concentricity.

#### Diameter range 6-10 mm, ER 16, Type 426E, DIN ISO 15488

PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5.5 - 6	17	27.5	037972 ●
Collet (8°)	8	7.5 - 8	17	27.5	037973 ●
Collet (8°)	10	9.5 - 10	17	27.5	037974 ●
Collet (8°)	6.35 (1/4")	5.85 - 6.35	17	27.5	679022 ●
Collet (8°)	9.53 (3/8")	9.03 - 9.53	17	27.5	679023 ●

#### Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	30/32		6 - 10		005516 ●
Collet chuck nut with ball bearing	M22x1.5	32	6 - 10	RH	006645 ●

#### Diameter range 6-13 mm, ER 20, Type 428E, DIN ISO 15488

PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5.5 - 6	21	31.5	037975 ●
Collet (8°)	8	7.5 - 8	21	31.5	037976 ●
Collet (8°)	10	9.5 - 10	21	31.5	037977 ●
Collet (8°)	12	11.5 - 12	21	31.5	037978 ●
Collet (8°)	6.35 (1/4")	5.85 - 6.35	21	31.5	679024 ●
Collet (8°)	9.53 (3/8")	9.03 - 9.53	21	31.5	679025 ●
Collet (8°)	12.7 (1/2")	12.2 - 12.7	21	31.5	679026 ●

#### Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	34/36		6 - 12.7		005498 ●
Collet chuck nut with ball bearing	M25x1.5	35	6 - 13	RH	006647 ●

#### Diameter range 6-16 mm, ER 25, Type 430E, DIN ISO 15488

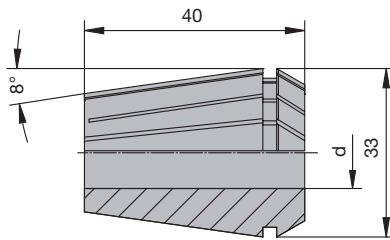
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5.5 - 6	26	34	037979 ●
Collet (8°)	8	7.5 - 8	26	34	037980 ●
Collet (8°)	10	9.5 - 10	26	34	037981 ●
Collet (8°)	12	11.5 - 12	26	34	037982 ●
Collet (8°)	14	13.5 - 14	26	34	037983 ●
Collet (8°)	16	15.5 - 16	26	34	037984 ●
Collet (8°)	6.35 (1/4")	5.85 - 6.35	26	34	679027 ●
Collet (8°)	9.53 (3/8")	9.03 - 9.53	26	34	679028 ●
Collet (8°)	12.7 (1/2")	12.2 - 12.7	26	34	679029 ●
Collet (8°)	15.88 (5/8")	15.38 - 15.88	26	34	679030 ●

#### Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	40/42		6 - 16		005518 ●
Collet chuck nut with ball bearing	M32x1.5	42	6 - 16	RH	006649 ●





ER 32 collet diameter range  
6-20 mm

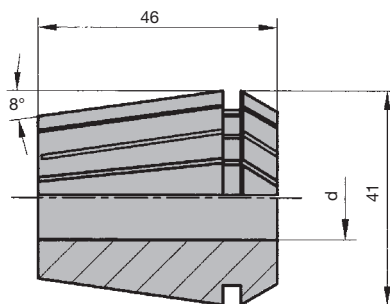
#### Diameter range 6-20 mm, ER 32, Type 470E, DIN ISO 15488

PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5.5 - 6	33	40	037439 ●
Collet (8°)	8	7.5 - 8	33	40	037440 ●
Collet (8°)	10	9.5 - 10	33	40	037441 ●
Collet (8°)	12	11.5 - 12	33	40	037442 ●
Collet (8°)	13	12.5 - 13	33	40	037443 ●
Collet (8°)	14	13.5 - 14	33	40	037444 ●
Collet (8°)	16	15.5 - 16	33	40	037445 ●
Collet (8°)	18	17.5 - 18	33	40	037446 ●
Collet (8°)	20	19.5 - 20	33	40	037447 ●
Collet (8°)	6.35 (1/4")	5.85 - 6.35	33	40	037509 ●
Collet (8°)	9.53 (3/8")	9.03 - 9.53	33	40	037510 ●
Collet (8°)	12.7 (1/2")	12.2 - 12.7	33	40	037511 ●
Collet (8°)	15.88 (5/8")	15.38 - 15.88	33	40	037507 ●
Collet (8°)	19.05 (3/4")	18.55 - 19.05	33	40	037506 ●

#### Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	45/50				005491 ●
Collet chuck nut with ball bearing	M40x1.5	50	6 - 20	RH	005718 ●



ER 40 collet diameter range  
6-26 mm

#### Diameter range 6-26 mm, ER 40, Type 472E, DIN ISO 15488

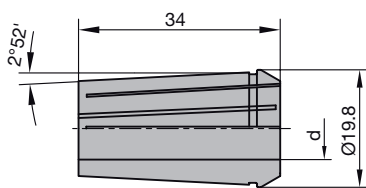
PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (8°)	6	5.5 - 6	41	46	037926 ●
Collet (8°)	8	7.5 - 8	41	46	037927 ●
Collet (8°)	10	9.5 - 10	41	46	037928 ●
Collet (8°)	12	11.5 - 12	41	46	037929 ●
Collet (8°)	14	13.5 - 14	41	46	037930 ●
Collet (8°)	16	15.5 - 16	41	46	037931 ●
Collet (8°)	20	19.5 - 20	41	46	037932 ●
Collet (8°)	25	24.5 - 25	41	46	037933 ●
Collet (8°)	30	29.5 - 30	41	46	679039 ●
Collet (8°)	6.35 (1/4")	5.85 - 6.35	41	46	037934 ●
Collet (8°)	9.53 (3/8")	9.03 - 9.53	41	46	037935 ●
Collet (8°)	12.7 (1/2")	12.2 - 12.7	41	46	037936 ●
Collet (8°)	15.88 (5/8")	15.38 - 15.88	41	46	037937 ●
Collet (8°)	19.05 (3/4")	18.55 - 19.05	41	46	037938 ●
Collet (8°)	25.4 (1")	24.9 - 25.4	41	46	037939 ●

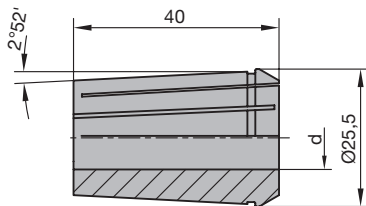
#### Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	58/62		6 - 25.4		005458 ●
Collet chuck nut with ball bearing	M50x1.5	63	6 - 25.4	RH	006639 ●





Collet type 407E diameter range  
6-12.7 mm



Collet type 415E diameter range  
6-16 mm

### Collets, DIN ISO 10897, taper ratio 1:10

#### Application:

For collet chucks as well as for multi spindle units and trimming units with 2°52' taper angle (taper ratio 1:10).

#### Technical information:

Double slotted design for maximum clamping forces and concentricity.

#### Diameter range 6-12.7 mm, Type 407E, DIN ISO 10897

PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (2°52')	6	6	19.8	34	<b>679013 ●</b>
Collet (2°52')	7	7	19.8	34	<b>679015 ●</b>
Collet (2°52')	8	8	19.8	34	<b>679016 ●</b>
Collet (2°52')	9	9	19.8	34	<b>679017 ●</b>
Collet (2°52')	10	10	19.8	34	<b>679019 ●</b>
Collet (2°52')	12	12	19.8	34	<b>679020 ●</b>
Collet (2°52')	6.35 (1/4")	6.35	19.8	34	<b>679014 ●</b>
Collet (2°52')	9.53 (3/8")	9.53	19.8	34	<b>679018 ●</b>
Collet (2°52')	12.7 (1/2")	12.7	19.8	34	<b>679021 ●</b>

#### Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	34/36		6 - 12.7		<b>005498 ●</b>
Collet chuck nut	M27x1.5	35		RH	<b>006653 ●</b>

#### Diameter range 6-16 mm, Type 415E, DIN ISO 10897

PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (2°52')	6	6	25.5	40	<b>679005 ●</b>
Collet (2°52')	8	8	25.5	40	<b>679032 ●</b>
Collet (2°52')	9	9	25.5	40	<b>679033 ●</b>
Collet (2°52')	9.5	9.5	25.5	40	<b>679034 ●</b>
Collet (2°52')	10	10	25.5	40	<b>679006 ●</b>
Collet (2°52')	11	11	25.5	40	<b>679035 ●</b>
Collet (2°52')	12	12	25.5	40	<b>679036 ●</b>
Collet (2°52')	13	13	25.5	40	<b>679007 ●</b>
Collet (2°52')	14	14	25.5	40	<b>679037 ●</b>
Collet (2°52')	16	16	25.5	40	<b>679008 ●</b>
Collet (2°52')	6.35 (1/4")	6.35	25.5	40	<b>679009 ●</b>
Collet (2°52')	9.53 (3/8")	9.53	25.5	40	<b>679010 ●</b>
Collet (2°52')	12.7 (1/2")	12.7	25.5	40	<b>679011 ●</b>
Collet (2°52')	15.88 (5/8")	15.88	25.5	40	<b>679012 ●</b>

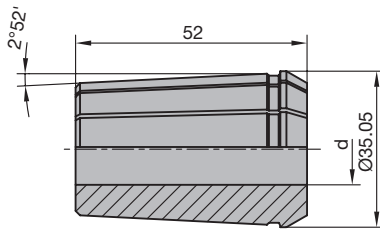
#### Spare parts:

BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	40/42		6 - 16		<b>005469 ●</b>
Collet chuck nut with ball bearing	M33x1.5	43		RH	<b>005685 ●</b>

## 7. Clamping systems

### 7.3 Clamping chucks

#### 7.3.3 Collet chucks



Collet type 462E diameter range  
6-25.4 mm

#### Diameter range 6-25.4 mm, Type 462E, DIN ISO 10897

PM 150 0

BEZ	for S mm	d mm	D mm	GL mm	ID
Collet (2°52')	6	6	35.05	52	<b>037429 ●</b>
Collet (2°52')	8	8	35.05	52	<b>037430 ●</b>
Collet (2°52')	10	10	35.05	52	<b>037431 ●</b>
Collet (2°52')	12	12	35.05	52	<b>037432 ●</b>
Collet (2°52')	13	13	35.05	52	<b>037433 ●</b>
Collet (2°52')	14	14	35.05	52	<b>037434 ●</b>
Collet (2°52')	16	16	35.05	52	<b>037435 ●</b>
Collet (2°52')	18	18	35.05	52	<b>037436 ●</b>
Collet (2°52')	20	20	35.05	52	<b>037437 ●</b>
Collet (2°52')	25	25	35.05	52	<b>037438 ●</b>
Collet (2°52')	6.35 (1/4")	6.35	35.05	52	<b>037495 ●</b>
Collet (2°52')	9.53 (3/8")	9.53	35.05	52	<b>037505 ●</b>
Collet (2°52')	12.7 (1/2")	12.7	35.05	52	<b>037496 ●</b>
Collet (2°52')	15.88 (5/8")	15.88	35.05	52	<b>037502 ●</b>
Collet (2°52')	19.05 (3/4")	19.05	35.05	52	<b>037497 ●</b>
Collet (2°52')	25.4 (1")	25.4	35.05	52	<b>037508 ●</b>

#### Spare parts:

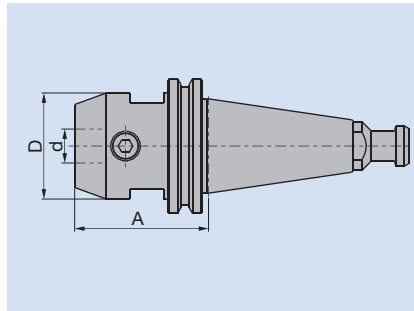
BEZ	ABM mm	D mm	Diameter range mm	DRI	ID
Sickle spanner	58/62		6 - 25.4		<b>005458 ●</b>
Collet chuck nut with ball bearing	M48x2	60		RH	<b>005714 ●</b>

## 7. Clamping systems

### 7.3 Clamping chucks

#### 7.3.4 Weldon chucks

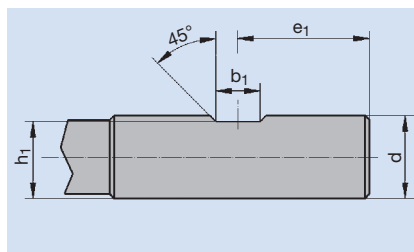
<b>Application</b>	High-stability shank tool clamping.
<b>Machine</b>	Stationary routers with CNC control and spindles for automatic tool change. Milling machines with spindles for automatic tool change.
<b>Technical features</b>	Weldon chucks are used to clamp shank tools rigidly. Weldon chucks have a similar rigidity to shrink-fit chucks, but the run out tolerance of shrink-fit chucks is significantly higher. Shrink-fit chucks are recommend for machining operations demanding high quality.



D	Largest diameter of the chuck in the clamping area
d	Clamping or bore diameter
A	Length from the reference point on the steep taper or the HSK reference surface

<b>Permissible shank tolerances</b>	Tools clamped in weldon chucks must have at least the following tool shank tolerances:	
	Diameter of shank	
Tools mounted in Weldon chucks	16 mm	20 mm
	ISO g7	ISO g7

<b>Clamping flat</b>	The shanks of tools clamped in Weldon chucks must have a driving flat to DIN 1835.  The following drawing details the dimensions of the clamping flat:
----------------------	--



d	e <sub>1</sub>	b <sub>1</sub>	h <sub>1</sub>
16	24	10	14.2
20	25	11	18.2

<b>Application data</b>	<b>Maximum RPM</b> Maximum RPM for Weldon chucks: $n_{\max} = 24000 \text{ min}^{-1}$ .
<b>Order information</b>	Weldon chucks with adaptors SK 30 / SK 40 as well as HSK-E / HSK-F supplied on request.



#### Clamping chuck with steep taper for CNC aggregates

##### Application:

Precision tool chuck for clamping shank tools with cylindrical shank and shank diameters up to  $d_{\max} = 16$  mm.

##### Technical information:

Steep taper design for Flex 5+ aggregates (Homag Group) and 5-motion-Plus aggregate (Felder Format-4). High stability for medium difficult cutting operations. Easy tool change through opening of the radial clamping screw. Tool adaptor fine balanced. Maximum tool protrusion (length projecting of the chuck) 60 mm.

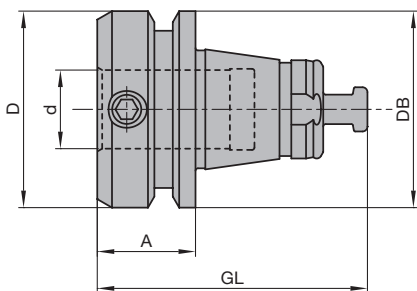
##### A = 20 mm, clamping diameter 16 mm

PM 320 0 53

Machine	d mm	D mm	DB mm	A mm	GL mm	Weight kg	ID
Felder Format-4, Homag Group	16	40	40	20	55	0.3	<b>037722</b> □

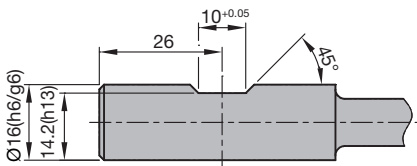
##### Spare parts:

BEZ	ABM mm	ID
Clamping screw	M8x10	<b>007800</b> □
Allen key	SW 4	<b>005434</b> ●



Weldon clamping chuck

Required shank design:



<b>Application</b>	Clamping drills.
<b>Machine</b>	Stationary routers with CNC control and spindles for automatic tool change. Milling machines with spindles for automatic tool change. Routers without automatic tool change. Drilling machines.
<b>Technical features</b>	<p>1. Conventional drill adaptors</p> <p>Drill adaptors are used to mount dowel drills, through hole drills or hinge boring bits in drilling machines.</p> <p>Below an overview of the available adaptors:</p> <div style="display: flex; flex-wrap: wrap;"> <div style="width: 50%;"> <p><b>A</b></p> <p>Nottmeyer (old machine design)</p> </div> <div style="width: 50%;"> <p><b>E</b></p> <p>Bilek Type K and N Knoevenagel</p> </div> <div style="width: 50%;"> <p><b>B</b></p> <p>Ayen, Brandt Knoevenagel Mayer Reichenbacher Torwegge Zubiola</p> </div> <div style="width: 50%;"> <p><b>F</b></p> <p>Alberti, Balestrini, Bilek Busellato, Dubus, Goma Grotefeld, Ompec, Reimall SCM, Schleicher, Tanzani Viciani, Vitap (before year 4/91) Weingärtner</p> </div> <div style="width: 50%;"> <p><b>C</b></p> <p>Lehbrink Nottmeyer (new machine design)</p> </div> <div style="width: 50%;"> <p><b>G</b></p> <p>Morbidelli</p> </div> <div style="width: 50%;"> <p><b>D</b></p> <p>Alberti, Balestrini, Biesse Böttcher &amp; Gessner Busellato, Goma, Grotefeld Hüllhorst, Holz-Her, Koch Morbidelli, Reimall, Torwegge Vitap (after year 4/91) Weeke</p> </div> <div style="width: 50%;"> <p><b>H</b></p> <p>Scheer</p> </div> </div>

The drill is clamped in the adaptor by a screw. The shank has to have a driving flat.

## 7. Clamping systems

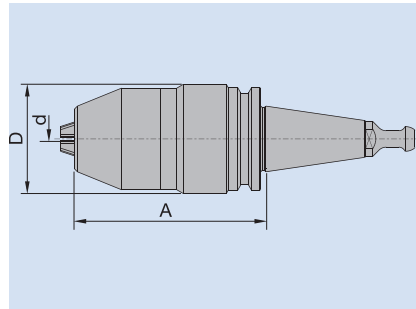
### 7.3 Clamping chucks

#### 7.3.5 Drill adaptors

##### 2. Drill chuck for CNC machining centres

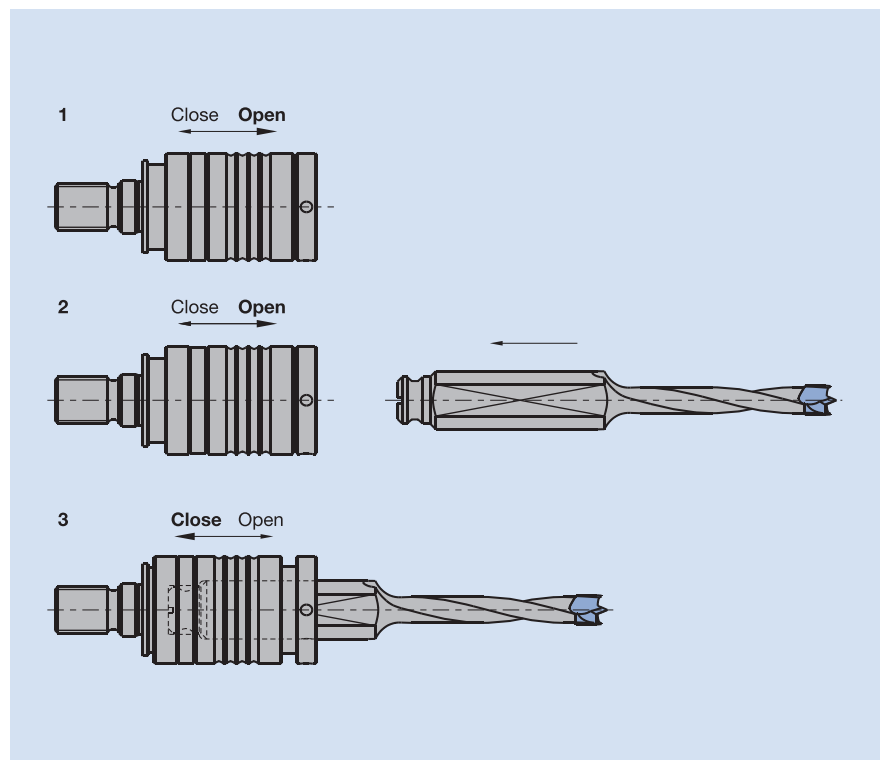
Drill chucks are an easy way to carry drills in machines with magazines. The drill chuck is a 3 wedge chuck with an interface to suit the tool spindle.

D	Largest external diameter of the chuck
d	Clamping diameter
A	Length from the reference point (steep taper) or reference surface (HSK)



##### 3. Quick change adaptor

Adaptor system for dowel drills, through hole drills and hinge boring bits for different drilling machines. The quick change adaptor is a quick and easy way to change drills in the machine without using tools.

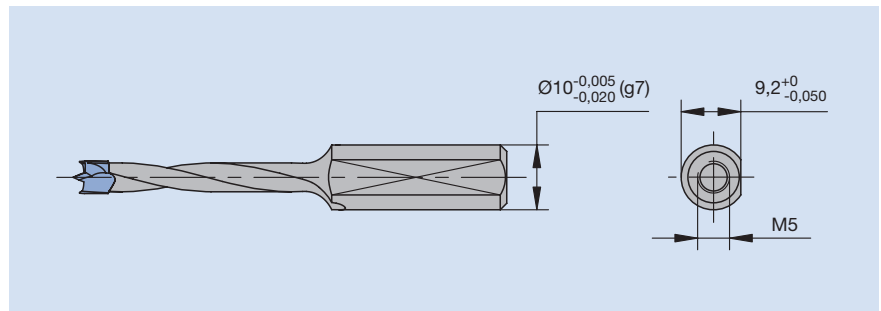


##### Changing a drill.

For a perfect fit of the shank a special length adjustment screw (ID **009157**) is required. This screw allows exact length adjustment of the mounted drills.

##### Required shank tolerance

Clamping drills safely requires the following shank and driving flat tolerance:



##### Application Data

##### Maximum allowable RPM

Maximum allowable RPM for drill adaptors (adaptor in spindle):

$$n_{\max} = 9000 \text{ min}^{-1}.$$

Conventional drill adaptors and quick change adaptors can be used up to

$$n_{\max} = 12000 \text{ min}^{-1}.$$





### Drill adaptor, conventional clamping

#### Application:

Clamping chuck for drill bits with 10 mm shank diameter and driving flat for drilling spindles with threaded adaptor.

#### Technical information:

Stable and secure clamping of drills by 2 clamping screws. Smallest spindle pitch in the drilling unit: 21 mm. For narrower pitches, 8 mm shank chucks and drills must be used.

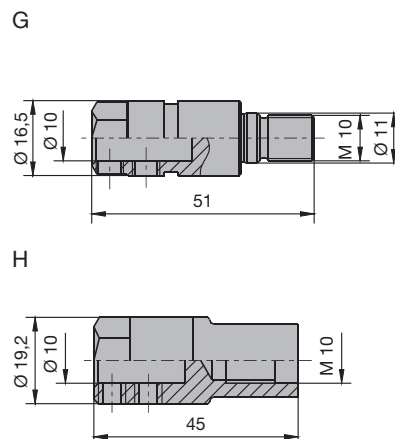
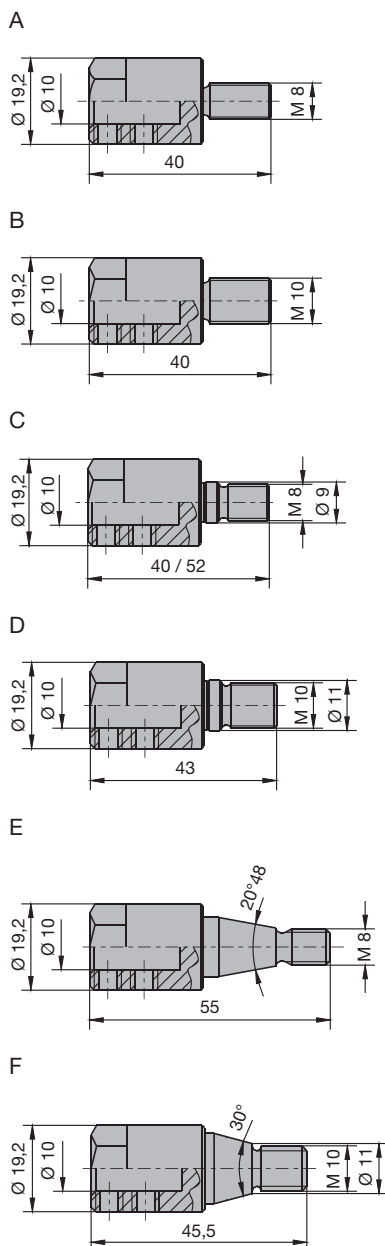
#### Clamping chuck for drills with 10 mm shank and driving flat

PM 320 0 28, PM 320 0 29, PM 320 0 30, PM 320 0 32, PM 320 0 34, PM 320 0 40, PM 320 0 42, PM 320 0 46, PM 320 0 50

Machine	GL mm	Pic.	ID LH	ID RH
Nottmeyer (old machine type)	40	A	033088 ●	033089 ●
Ayen, Brandt, Holzma, Knoevenagel,	40	B	033092 ●	033093 ●
Mayer, Reichenbacher, Torwegge, Zubiola	40	C	033080 ●	033081 ●
Lehbrink, Nottmeyer (new machine type)	52	C	033082 ●	033083 ●
Lehbrink, Nottmeyer (new machine type)	43	D	033086 ●	033087 ●
Alberti, Balestrini, Biesse,				
Böttcher & Gessner, Busellato, Goma,				
Grotefeld, Holz-Her, Hüllhorst, Koch,				
Morbidelli, Reimall, Torwegge,				
Vitap (from YOM 4/91 on), Weeke				
Bilek, Knoevenagel	55	E	033084 ●	033085 ●
Alberti, Balestrini, Bilek, Busellato,	45.5	F	033090 ●	033091 ●
Dubus, Goma, Grotefeld, Ompec, Reimall,				
Schleicher, SCM, Tanzani, Viciani,				
Vitap (up to YOM 4/91), Weingärtner				
Morbidelli	51	G	033094 ●	033095 ●
Scheer	45	H	033096 ●	033097 ●

#### Spare parts:

BEZ	ABM mm	ID
Allen key	SW 3	005433 ●
Allen screw	M6x5	005836 ●





## Drill adaptor, quick clamping design

### Application:

Quick clamping chuck for drills with 10 mm shank and driving flat for drilling spindles with threaded adaptor.

### Technical information:

The drill is held in the chuck by the length adjusting screw (ID **009157**). Ideal if the hole diameter must be changed quickly. Quick clamping chucks not in use should be covered using the optional dust cover.

**Note:** The drill shanks require an appropriate shank and driving flat dimensional tolerance to ensure trouble free operation. Drills from the Leitz range guarantees functional reliability. Speed up to 12000 min<sup>-1</sup> (quick change drill adaptor without drill must be covered with the dust cover ID **115521** for speeds exceeding 9000 min<sup>-1</sup> to prevent unbalance).

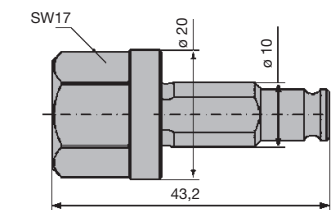
### Clamping chuck for drills with 10 mm shank and driving flat

PM 320 0, PM 320 0 55, PM 320 0 56, PM 320 0 57, PM 320 0 58, PM 320 0 59

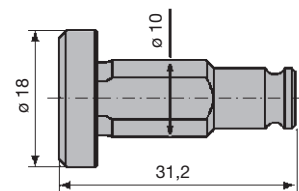
Machine	BEM	GL mm	Pic.	ID LH	ID RH
Lehbrink, Nottmeyer (new machine type)		45	A	<b>033102</b> •	<b>033103</b> •
Ayen, Brandt, Holzma, Knoevenagel, Mayer, Reichenbacher, Torwegge, Zubiola		45	B	<b>033104</b> •	<b>033105</b> •
Nottmeyer (old machine type)		45	C	<b>033098</b> •	<b>033099</b> •
Alberti, Biesse, Böttcher & Gessner, Busellato, Goma, Grotefeld, Holz-Her, Hüllhorst, Koch, Morbideilli, Reimall, Torwegge, Vitap (from YOM 4/91 on), Weeke		46	D	<b>033100</b> •	<b>033101</b> •
Weeke	from YOM 2/04 on	40.25	E	<b>033109</b> •	<b>033110</b> •
Universal	Shank D-10 mm	50	F	<b>033106</b> •	<b>033106</b> •

### Spare parts:

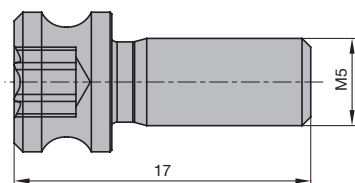
BEZ	ABM mm	ID
Dust cover	d8/10/D18/L31.2	<b>115521</b> •
Mounting device	d8/10/D20/L43.2/SW17	<b>115522</b> •
Length adjustment screw Torx® 20	M5x17	<b>009157</b> •



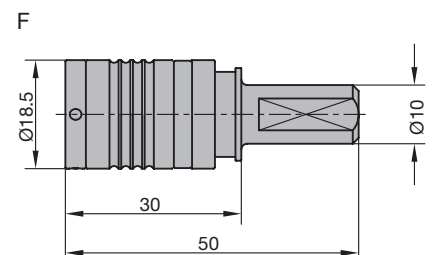
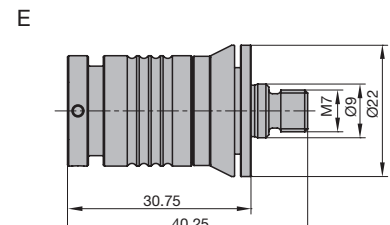
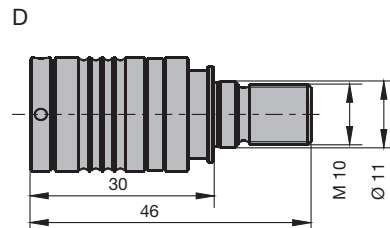
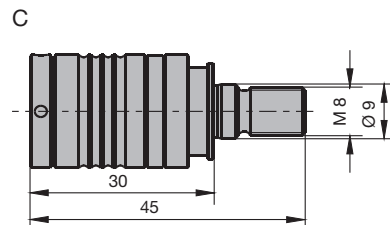
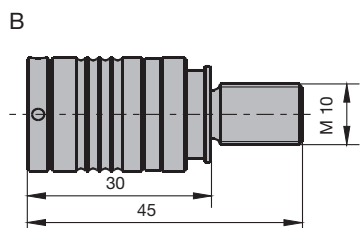
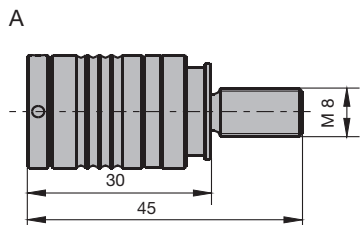
Mounting device ID **115522**

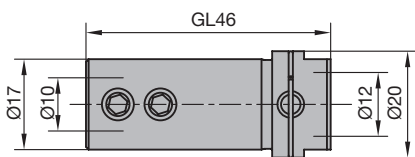


Dust cover ID **115521**



Length adjustment screw ID **009157**





Drill adaptor for Weeke

### Drill adaptor

#### Application:

For mounting dowel drills, through hole drills and hinge boring bits on point-to-point drilling machines, through feed drilling machines and stationary drilling machines.

#### Technical information:

Wear resistant material, ground surface. High concentricity for clean holes and long drill life time.

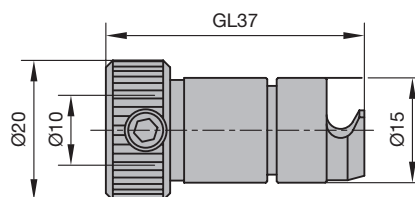
#### For Weeke through-feed machines

PM 320 0

Machine	d mm	D mm	GL mm	ID
Weeke	10	20	46	<b>033107 •</b>

#### Spare parts:

BEZ	ABM mm	ID
Allen key	SW 3	<b>005433 •</b>
Allen screw	M6x4	<b>005837 •</b>



Drill adaptor for Biesse

### Drill adaptor

#### Application:

For mounting dowel drills, through hole drills and hinge boring bits on point-to-point drilling machines, through feed drilling machines and stationary drilling machines.

#### Technical information:

Wear resistant material, ground surface. High concentricity for clean holes and long drill life time.

#### For Biesse boring units

PM 320 0

Machine	d mm	D mm	GL mm	ID
Biesse	10	20	37	<b>033108 •</b>

#### Spare parts:

BEZ	ABM mm	ID
Allen key	SW 3	<b>005433 •</b>
Allen screw	M6x5	<b>005836 •</b>



### Quick change drill adaptor, spare parts for previous system

#### Tool adaptor for drills with 10 mm shanks

PM 320 0 02

d	D	GL	ID	ID
mm	mm	mm	LH	RH
10	20	29	033270 ●	033271 ●

#### Spare parts:

BEZ	ABM	ID
	mm	
Allen key	SW 3	005433 ●
Allen screw	M6x5	005836 ●

#### Tool adaptor for drills with 8 mm shanks

PM 320 0 01

d	D	GL	ID	ID
mm	mm	mm	LH	RH
8	15.5	29	033170 ●	033171 ●

#### Spare parts:

BEZ	ABM	ID
	mm	
Allen key	SW 3	005433 ●
Allen screw	M6x5	005836 ●



### Drill chuck for CNC spindle

#### Application:

Clamping chuck for drills for CNC routers and machining centres.

#### Technical information:

Precision design with high concentricity < 0.02 mm. Special clamping mechanism with improved holding forces to prevent the tool shank from slipping. Stepless adjustable clamping range: 1-13 mm (SK 30, ISO 30, SK 40), 1-16 mm (HSK-E/-F 63). Fine balanced design. Clamping wedges hardened for improved wear resistance. Suitable for right hand and left hand rotation. Only to be used for drills.

#### Stepless adjustable clamping range

PM 330 0

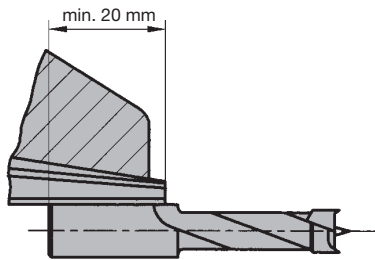
Type	d mm	D mm	DB mm	A mm	GL mm	Weight kg	S mm	ID
A	1 - 13	50	50	103	174.8	1.30	SK 30	037758 □
B	1 - 13	50	50	103	174.8	1.30	SK 30	037759 □
E	1 - 13	50	63.55	87.5		1.50	SK 40	037761 ●
	1 - 16	50	63	98	129.6	1.80	HSK-E 63	037763 ●
	1 - 16	50	63	98	123	1.70	HSK-F 63	037762 ●

#### Spare parts:

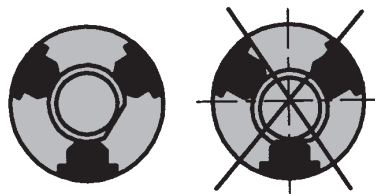
BEZ	for S mm	ABM mm	L mm	ID
Allen key	SK	SW 6	100	005447 ●
Allen key	HSK	SW 4	100	005503 ●

#### Conditions to be observed during clamping:

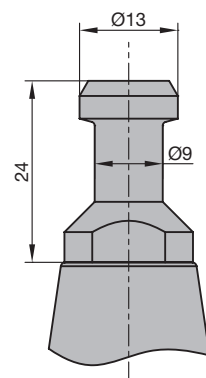
- Minimum clamping length  
 $l_{\min} = 20 \text{ mm}$
- Maximum clamping length  
 $l_{\max} = 29 \text{ mm}$



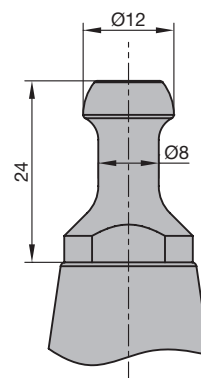
- Do not clamp tapered shanks
- If possible use cylindrical shanks
- without clamping flat, grooves or other recesses



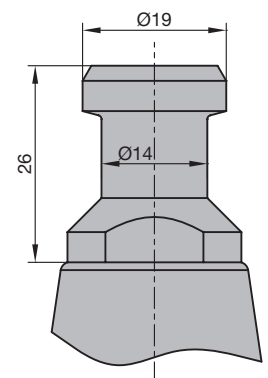
- If drills with driving flat are used, the clamping flat is not allowed to touch the clamping wedges. See illustration



Type: A  
SK 30 pull stud as per DIN ISO 7388

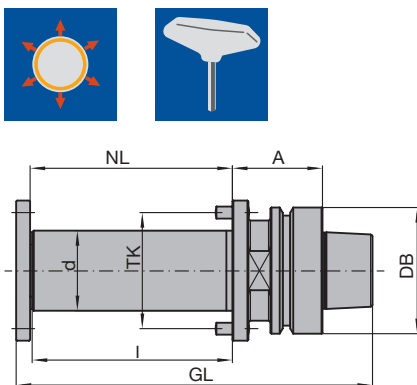


Type: B  
SK 30/ISO 30 pull stud for HSD spindles from construction year 9/92 on



Type: E  
SK 40 pull stud as per DIN ISO 7388





Hydro clamping arbor HSK-F 63

### Hydro clamping arbor HSK-F 63 / HSK-E 63

#### Application:

For precise and play-free mounting of tools with bore, such as sawblades, tools, toolsets and cutterheads.

#### Machine:

Machines with HSK-F 63 or HSK-E 63 adaptor, e.g. moulders, window producing machines, CNC-machining centres etc.

#### Technical information:

Hollow taper shank design as per DIN 69863. Play-free and precise adaption of bore tools through hydro clamping arbors. Axial clamping actuation of the closed hydro system. Safety against twisting of the tools through pins and screws.

**Note:** Please observe the admitted maximum weight and diameters as well as the maximum tool RPM of the machine producer!

#### HSK-F / E 63, A = 45 / 90 mm

PH 160 0 04, PH 160 0 05

d	l	NL	A	GL	DB	TK	Weight	S	ID
mm	mm	mm	mm	mm	mm	mm	kg	mm	
40	100	101	45	178	63	58	2.18	HSK-F 63	<b>663811</b>
40	140	141	45	218	63	58	2.67	HSK-F 63	<b>663812</b>
40	190	191	45	268	63	58	3.05	HSK-F 63	<b>663813 ●</b>
40	190	191	90	313	63	58	4.41	HSK-F 63	<b>663814</b>
40	190	191	45	275	63	58	3.2	HSK-E 63	<b>663815</b>
40	190	191	90	320	63	58	4.5	HSK-E 63	<b>663816</b>

### Hydro clamping arbor HSK-F 63 mod.

#### Application:

Hydro clamping arbor for precise and play-free mounting of tools with bore such as circular sawblades, tools, toolsets and cutterheads for high concentricity.

#### Machine:

Machines with HSK-F 63 interface, e.g. laminate and parquet flooring lines, edgebanding machines, double-end tenoners, profile cutting machines etc.

#### Technical information:

Closed hydro clamping system with maintenance free pressurising piston mechanism. User friendly axial positioned hydro clamping screw. Play-free and precise mounting of tools with bores on hydro clamping arbors. Suitable for RH and LH.

RPM  $n_{max}$  12000<sup>-1</sup>.

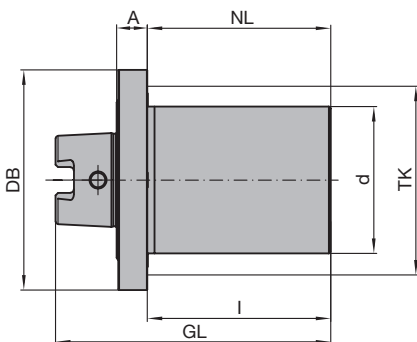
**Note:** Check the allowed maximum RPM of the tool mounted on the arbor!

#### HSK-F 63 mod. for tools with bore 60 mm, A = 12.5 mm

PH 160 0 02

Machine	d	l	NL	GL	DB	TK	Weight	ID
	mm	mm	mm	mm	mm	mm	kg	
Homag	60	75	75	112.5	63	75	2.25	<b>663804</b>

Suitable spacers, see section Knives and Spare Parts.



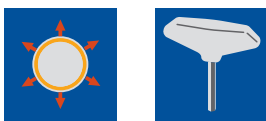
Hydro clamping arbor HSK-F 63 mod.  
PH 160 0 02



## 7. Clamping systems

### 7.4 Clamping arbors

#### 7.4.1 Hydro clamping arbors



#### Hydro clamping arbor HSK-F 63 mod. with stepless fine adjustment

##### Application:

Hydro clamping arbor for precise and play-free mounting of tools with bore such as circular sawblades, toolsets and sets of cutterheads for high concentricity. Fine thread design of the hydro clamping arbor allows stepless fine adjustment of multi part tooling sets.

##### Machine:

Machines with HSK-F 63 adaptor, e.g. laminate and parquet flooring lines, edgebanding machines, double-end tenoners, profile cutting machines etc.

##### Technical information:

Closed hydro clamping system with maintenance free pressurising piston mechanism. User friendly axial positioned hydro clamping screw. Play-free and precise mounting of tools with bores on hydro clamping arbors. Suitable for RH and LH.

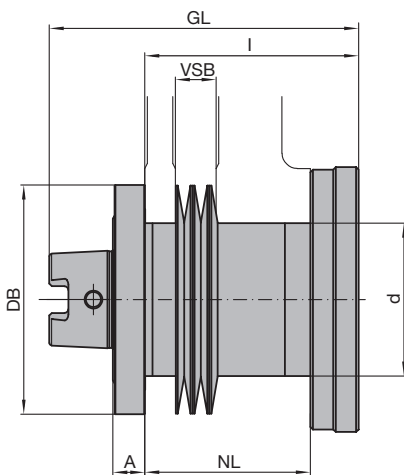
RPM  $n_{\max}$  12000<sup>-1</sup>.

**Note:** Check the allowed maximum RPM of the tool mounted on the arbor!

#### HSK-F 63 mod. for tools with bore 60 mm, A = 12.5 mm

PH 160 0 03

Machine	d mm	l mm	NL mm	VSB	GL mm	DB mm	TK mm	Weight kg	ID
Homag	60	75	42 - 52	10	116.5	63	75	2.8	663803 ●



Hydro clamping arbor HSK-F 63 mod.  
with stepless fine adjustment  
PH 160 0 03

## 7. Clamping systems

### 7.4 Clamping arbors 7.4.1 Hydro clamping arbors



#### Hydro clamping arbor HSK 85 WS

##### Application:

For precise, play-free mounting of tools with bore, such as sawblades, cutting tools, sets of cutting tools and cutterheads.

##### Machine:

Machines with HSK 85 WS adaptor e.g. moulders (Weinig Powermat), window production machines etc.

##### Technical information:

Play-free and precise mounting of tools with bore by hydro arbors. Radial clamping by closed hydro system. Easy and safe handling with optionally lifting rings.

**Note:** Observe the information of the machine producer for the permitted maximum weight and diameter as well as the maximum tool RPM!

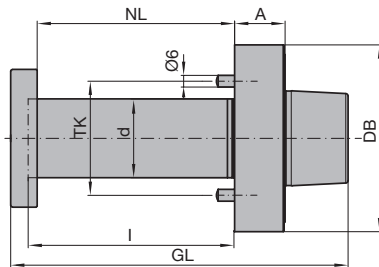


##### HSK 85 WS, A = 26 mm

PH 160 0 01

Machine	d mm	l mm	NL mm	GL mm	DB mm	TK mm	Weight kg	ID
Weinig	40	105.5	100	171.5	85	58	2.9	663800 ●
Weinig	40	175.5	170	265.5	85	58	3.8	663802 ●

Suitable spacers, see section Knives and Spare Parts.

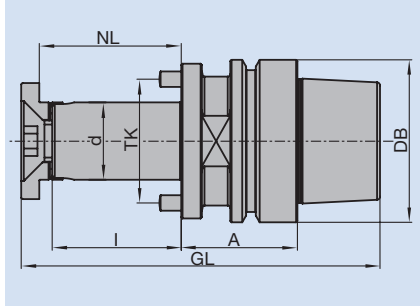


Hydro clamping arbor HSK 85 WS -  
PH 160 0 01

# 7. Clamping systems

## 7.4 Clamping arbors

### 7.4.2 Cutter arbors

<b>Application</b>	For mounting single cutters or cuttersets with bore.										
<b>Machine</b>	Stationary routers with CNC control and spindles for automatic tool change, Through-feed machines and milling machines with spindles for automatic tool change.										
<b>Technical features</b>	<p>Cutter arbors are used to mount tools, cutterheads, cutters and sawblades on CNC machining centres or trough-feed machines with spindles for automatic tool change. The arbor clamping length can be altered to suit the application and tool.</p>  <table border="1"> <tbody> <tr> <td>d</td><td>Diameter of the arbor</td></tr> <tr> <td>I</td><td>Clamping length</td></tr> <tr> <td>DB</td><td>Outer diameter groove</td></tr> <tr> <td>A</td><td>Length from reference point (steep taper) or reference surface (HSK)</td></tr> <tr> <td>DTK</td><td>Pitch diameter, screw or pin bore</td></tr> </tbody> </table>	d	Diameter of the arbor	I	Clamping length	DB	Outer diameter groove	A	Length from reference point (steep taper) or reference surface (HSK)	DTK	Pitch diameter, screw or pin bore
d	Diameter of the arbor										
I	Clamping length										
DB	Outer diameter groove										
A	Length from reference point (steep taper) or reference surface (HSK)										
DTK	Pitch diameter, screw or pin bore										
<b>Permissible bore tolerances</b>	<p>Tools mounted on arbors must have at least the following bore tolerance:</p> <table border="1"> <thead> <tr> <th></th><th>Bore tolerance</th></tr> </thead> <tbody> <tr> <td>Tools mounted on arbors</td><td>ISO H7</td></tr> </tbody> </table>		Bore tolerance	Tools mounted on arbors	ISO H7						
	Bore tolerance										
Tools mounted on arbors	ISO H7										
<b>Information</b>	Please observe the data of the machine producer for the allowed maximal weight and diameter as well as the maximal tool RPM!										



#### Cutter arbor with cylindrical shank

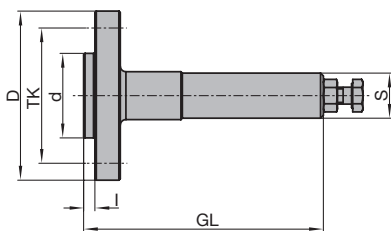
##### Application:

Arbor for single tools with bore or tool sets with bore.

##### Technical information:

Cylindrical shank design. Short design for grooving cutter and sawblades up to widths NB = 10 mm. Long design for one part or multi part tools/tool sets. Safety device against tool twisting by screw or pin. Cutter arbors are fine balanced. If conical spring washers with safety device against twisting are used, slots are required in the cutter arbor.

**Note:** Maximum admissible speed  $n_{max}$  depends on the mounted tools. Please comply with the specifications regarding the maximum admissible weight and diameters detailed by the machine manufacturer.



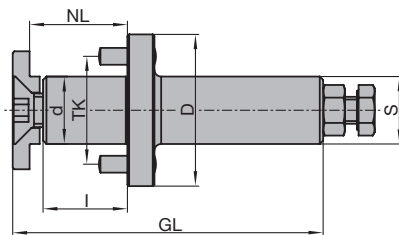
Arbor, short design

##### Short version

TI 501 0 04

d	l	D	GL	TK	S	ID
mm	mm	mm	mm	mm	mm	
30	4	60	85	48	16x50	041429 ●
30	4	59	102	48	20x50	041368 ●
30	4	59	102	48	25x60	041367 ●
30	4	59	127	48	25x60	042980 ●

With four countersunk screws M6X16. Maximum diameter for circular saw blades = 250 mm.



Arbor, long design

##### Long design

TI 501 0 03

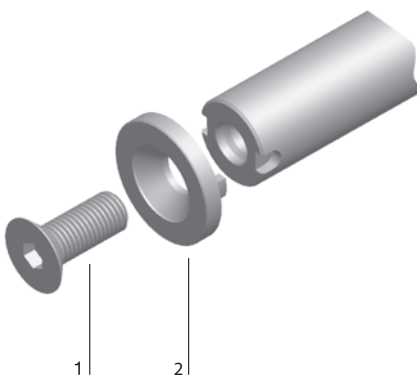
d	l	NL	D	GL	TK	S	ID
mm	mm	mm	mm	mm	mm	mm	
20	25	29	50	92	32	20x50	042982 □
20	40	44	50	107	32	20x50	042983 □
20	55	59	50	122	32	20x50	042984 ●
20	40	44	50	116	32	25x60	041124 ●
20	55	59	50	131	32	25x60	041125 ●
20	70	74	50	146	32	25x60	041126 ●
30	25	30	59	95	48	20x50	042985 □
30	40	45	59	110	48	20x50	042986 ●
30	25	30	59	105	48	25x60	041127 □
30	40	45	59	120	48	25x60	041128 ●

Sales unit consisting of arbor, clamping screw and conical spring washer (flat design), without spacers.

##### Spare parts:

BEZ	ABM	for d	ID
	mm	mm	
Washer with safety device against twisting, M10	20/35x13x10.5	20	006768 ●
Washer with safety device against twisting, M16	30/45x15x16.5	30	006769 ●

Suitable spacers, see section Knives and Spare Parts.



- 1 Clamping screw
- 2 Conical spring washer for safety against twisting



### Cutter arbor with steep taper SK 30 / SK 40

#### Application:

Arbor for single tools with bore or tool sets with bore.

#### Technical information:

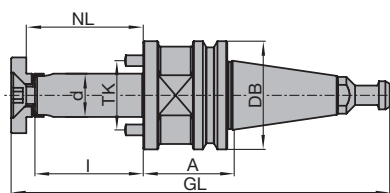
Steep taper design as per DIN ISO 7388, without grooves and notches. Short design, suitable for low vibration cutting. Safety device against tool twisting by screw or pin. Arbors are fine balanced. If conical spring washers with safety device against twisting are used, slots are required in the arbor. For suitable mounting device VN 799 0, see section Knives and Spare Parts.

**Note:** Please comply with the specifications regarding the maximum admissible weight and diameters detailed by the machine manufacturer!

#### SK 30, A = 42 mm

TI 501 0 01

Type	d mm	l mm	NL mm	GL mm	DB mm	TK mm	Weight kg	ID
A	20	70	74	194.8	50	32	1	<b>041137</b> □
A	30	80	85	205.8	50	48	1.3	<b>042814</b> □
B	20	70	74	194.8	50	32	1	<b>041370</b> □
B	30	80	85	205.8	50	48	1.3	<b>041373</b> □
C	20	70	74	194.8	50	32	1	<b>042832</b> □
C	30	80	85	205.8	50	48	1.3	<b>042836</b> □



Arbor SK 30/SK 40

#### SK 40, A = 42 mm

TI 501 0 01

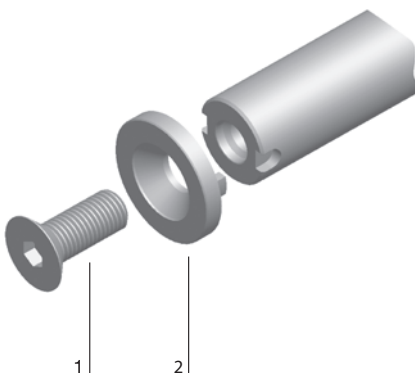
Type	d mm	l mm	NL mm	GL mm	DB mm	TK mm	Weight kg	ID
E	30	80	85	228.5	63.55	48	1.8	<b>042815</b> □

Sales unit consists of arbor with pull stud, clamping screw and conical spring washer (flat design), without spacers.

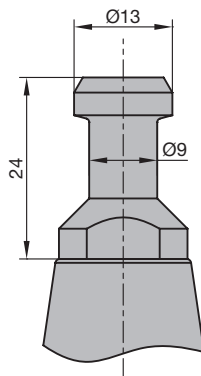
#### Spare parts:

BEZ	ABM mm	for d mm	ID
Washer with safety device against twisting, M10	20/35x13x10.5	20	<b>006768</b> ●
Washer with safety device against twisting, M16	30/45x15x16.5	30	<b>006769</b> ●
Locking nut with Balluff chip	SK 40, 511 Bytes		<b>081601</b> ●

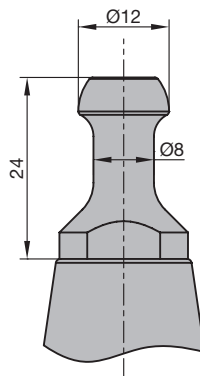
Suitable spacers, see section Knives and Spare Parts.



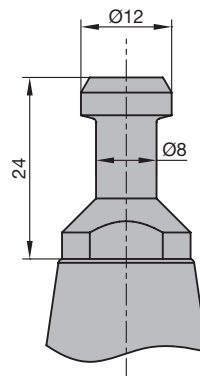
- 1 Clamping screw
- 2 Conical spring washer for safety against twisting



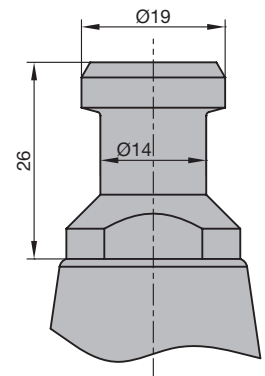
Type: A  
SK 30 pull stud as per DIN ISO 7388



Type: B  
SK 30/ISO 30 pull stud for HSD spindles from construction year 9/92 on



Type: C  
SK 30/ISO 30 pull stud Biesse until construction year 9/92



Type: E  
SK 40 pull stud as per DIN ISO 7388



### Cutter arbor with steep taper SK 30 / SK 40

#### Application:

Arbor for single tools with bore or tool sets with bore.

#### Technical information:

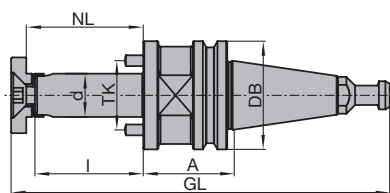
Steep taper design as per DIN ISO 7388, without grooves and notches. Outside dimension A = 63 mm for longer tool length in the machine. Safety device against tool twisting by screw or pin. Arbors are fine balanced. If conical spring washers with safety device against twisting are used, slots are required in the arbor. For suitable mounting device VN 799 0, see section Knives and Spare Parts.

**Note:** Please comply with the specifications regarding the maximum admissible weight and diameters detailed by the machine manufacturer!

#### SK 30, A = 63 mm

TI 501 0 01

Type	d mm	l mm	NL mm	GL mm	DB mm	TK mm	Weight kg	ID
A	20	70	74	215.8	50	32	1.3	<b>042818</b> □
A	30	80	85	226.8	50	48	1.6	<b>042822</b> □



Arbor SK 30/SK 40

#### SK 40, A = 63 mm

TI 501 0 01

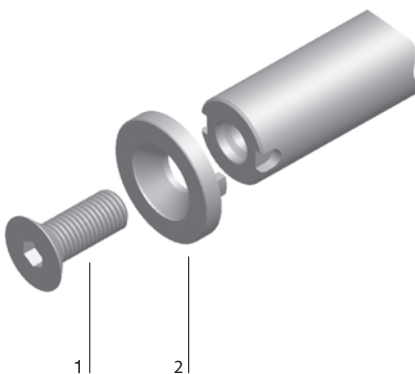
Type	d mm	l mm	NL mm	GL mm	DB mm	TK mm	Weight kg	ID
E	30	80	85	249.5	63.55	48	2.2	<b>042829</b> □

Sales unit consists of arbor with pull stud, clamping screw and conical spring washer (flat design), without spacers.

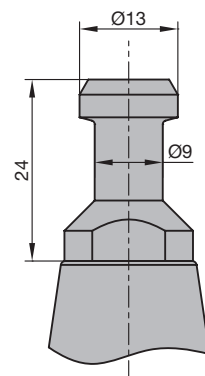
#### Spare parts:

BEZ	ABM mm	for d mm	ID
Washer with safety device against twisting, M10	20/35x13x10.5	20	<b>006768</b> ●
Washer with safety device against twisting, M16	30/45x15x16.5	30	<b>006769</b> ●
Locking nut with Balluff chip	SK 40, 511 Bytes		<b>081601</b> ●

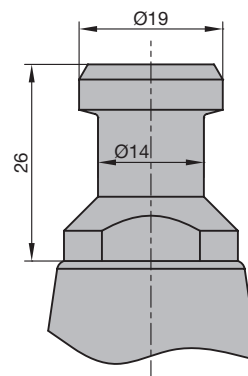
Suitable spacers, see section Knives and Spare Parts.



- 1 Clamping screw
- 2 Conical spring washer for safety against twisting



Type: A  
SK 30 pull stud as per DIN ISO 7388



Type: E  
SK 40 pull stud as per DIN ISO 7388



### Cutting arbor with hollow taper shank HSK-E 63

**Application:**

Arbor for single tools with bore or tool sets with bore.

**Technical information:**

Hollow taper shank design as per DIN 69893. Safety device against tool twisting by screw or pin. Arbors are fine balanced. Spring washers with safety against twisting. For suitable mounting device VN 799 0, see section Knives and Spare Parts.

**Note:** Please comply with the specifications regarding the maximum admissible weight and diameters detailed by the machine manufacturer.

**HSK-E 63, DIN 69893, A = 45 mm**

TI 501 0 07

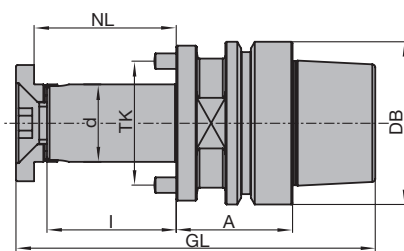
d mm	l mm	NL mm	GL mm	DB mm	TK mm	Weight kg	ID
20	70	75	159	63	32	1.2	039801 ●
30	80	85	169	63	48	1.6	039805 ●
30	140	145	229	63	48	1.9	663071 ●
35	192	197	281	63	52	2.6	039806 ●

Sales unit consisting of arbor, clamping screw and conical spring washer (flat design) with safety device against twisting, without spacers.

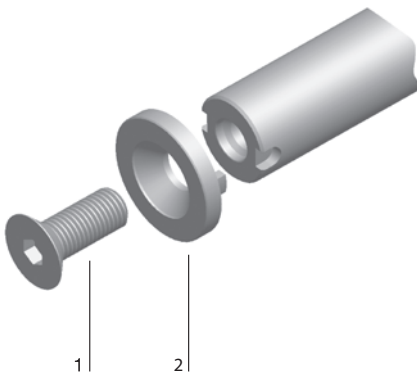
**Spare parts:**

BEZ	ABM mm	for d mm	ID
Washer with safety device against twisting, M10	20/35x13x10.5	20	006768 ●
Washer with safety device against twisting, M16	30/45x15x16.5	30	006769 ●
Washer with safety device against twisting, M16	35/50x15x16.5	35	006770 ●
Chip-Balluff	511 Bytes		081309 ●
Chip-Balluff	2047 Bytes		081330 □

Suitable spacers, see section Knives and Spare Parts.



Arbor HSK-E 63



- 1 Clamping screw  
2 Conical spring washer for safety against twisting





### Cutting arbor with hollow taper shank HSK-F 63

#### Application:

Arbor for single tools with bore or tool sets with bore.

#### Technical information:

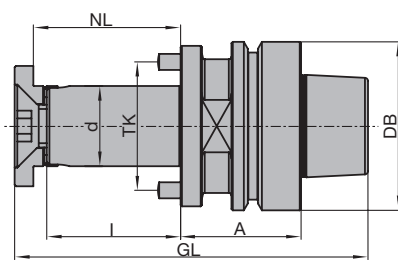
Hollow taper shank design as per DIN 69893. Safety device against tool twisting by screw or pin. Arbors are fine balanced. Spring washers with safety against twisting. For suitable mounting device VN 799 0, see section Knives and Spare Parts.

**Note:** Preferably use the short model for low vibration cutting. Please comply with the specifications regarding the maximum admissible weight and diameters detailed by the machine manufacturer.

#### HSK-F 63, DIN 69893, A = 45 mm

TI 501 0 07

d	l	NL	GL	DB	TK	Weight	ID
mm	mm	mm	mm	mm	mm	kg	
20	70	75	152	63	32	1.2	042987 ●
30	80	85	162	63	48	1.6	042988 ●
30	140	145	222	63	48	1.9	041426 ●
35	192	197	274	63	52	2.6	041425 ●



Arbor HSK-F 63

#### HSK-F 63, DIN 69893, A = 80 mm

TI 501 0 07

d	l	NL	GL	DB	TK	Weight	ID
mm	mm	mm	mm	mm	mm	kg	
20	70	75	187	63	32	1.7	042847 ●
30	80	85	197	63	48	2.1	042951 ●
30	120	125	237	63	48	2.4	041427 ●

#### HSK-F 63, DIN 69893, A = 90 mm

TI 501 0 07

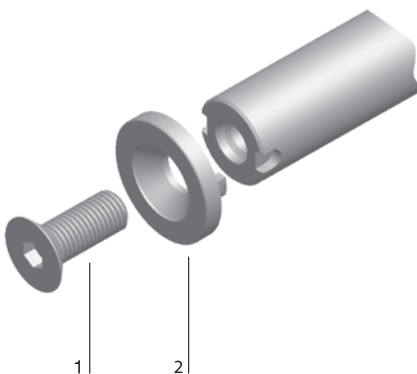
d	l	NL	GL	DB	TK	Weight	ID
mm	mm	mm	mm	mm	mm	kg	
35	170	175	297	63	52	3.2	041428 ●

Sales unit consisting of arbor, clamping screw and conical spring washer (flat design) with safety device against twisting, without spacers.

#### Spare parts:

BEZ	ABM	for d	ID
	mm	mm	
Washer with safety device against twisting, M10	20/35x13x10.5	20	006768 ●
Washer with safety device against twisting, M16	30/45x15x16.5	30	006769 ●
Washer with safety device against twisting, M16	35/50x15x16.5	35	006770 ●
Chip-Balluff	511 Bytes		081309 ●
Chip-Balluff	2047 Bytes		081330 □

Suitable spacers, see section Knives and Spare Parts.



- 1 Clamping screw  
2 Conical spring washer for safety against twisting



#### Cutting arbor with hollow taper shank HSK-F 63 mod.

##### Application:

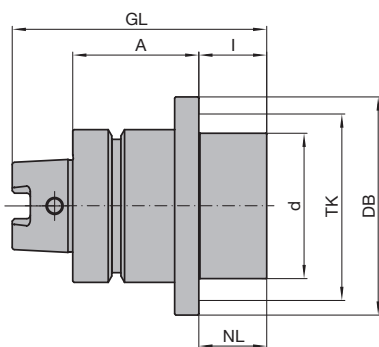
Arbors for single tools with bore or tool sets with bore. For precise clamping in the machine spindle and quick tool change, mainly on Homag through feed machines with HSK-F 63 mod. motor spindle.

##### Machine:

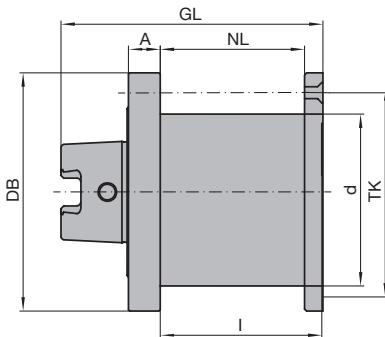
Double-end tenoner, flooring machines, edgebanding machines etc.

##### Technical information:

Fine balanced arbors with hollow shank taper modified design as per DIN 69893 HSK-F 63. Precise tool clamping for high concentricity. Clamping screws and end ring are part of the arbor.



Arbors HSK-F 63 mod. (ID **663052**) with flange



Arbor HSK-F 63 mod. (ID **663053**) with end ring and clamping screws

#### HSK-F 63 mod., A = 12.5 mm and 52 mm

TB 300 0

Machine	d	I	NL	A	GL	DB	TK	Weight	ID
	mm	mm	mm	mm	mm	mm	mm	kg	
Homag	60	28	28	52	105	63	75	2.1	<b>663052</b> ●
Homag	60	59.5	54.5	12.5	99	63	75	2.2	<b>663053</b> ●

##### Spare parts:

BEZ	ABM	ID
	mm	
Cylindrical screw with ISK	M6x30	<b>005928</b> ●
Cylindrical screw with ISK	M6x65	<b>005935</b> ●
Allen key	SW 5	<b>005452</b> ●



#### Cutting arbor with hollow shank taper HSK 85 WS

##### Application:

For mounting saws, cutting tools, sets of cutting tools and cutterheads.

##### Machine:

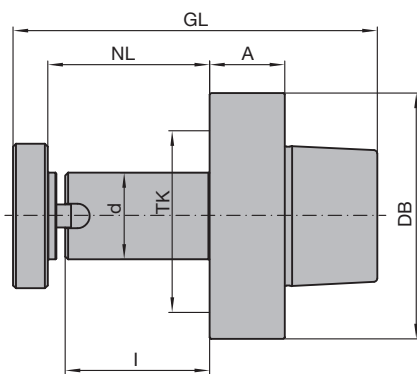
Machines with HSK 85 WS adaptor e.g. moulders (Weinig Powermat), window production machines etc.

##### Technical information:

Easy and safe handling with optional lifting rings.

##### HSK 85 WS, A = 26 mm, for Weinig Powermat without safety device against twisting

TI 501 0 14

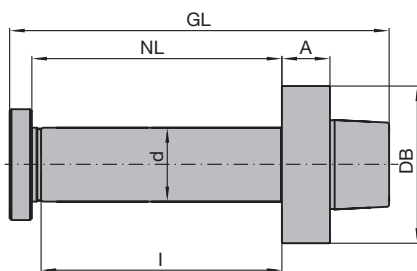


Cutting arbor HSK 85 WS with clamping spacer and safety device against twisting

Machine	d mm	l mm	NL mm	GL mm	DB mm	TK mm	Weight kg	ID
Weinig	30	50	55	125	85	48	1.7	663101 ●
Weinig	30	80	85	155	85	48	1.9	663102 ●
Weinig	30	105	110	180	85	48	2.0	663103 ●
Weinig	40	80	85	155	85		2.3	663075 ●
Weinig	40	100	105	175	85		2.5	663083 □
Weinig	40	130	135	205	85		2.8	663077 ●
Weinig	40	145	150	220	85		3.0	663084 □
Weinig	40	165	170	240	85		3.3	663078 ●
Weinig	40	205	210	280	85		3.6	663085 □
Weinig	40	235	240	310	85		4.2	663079 ●
Weinig	50	80	85	155	85		2.9	663076 ●
Weinig	50	100	105	175	85		3.2	663086 □
Weinig	50	130	135	205	85		3.7	663080 ●
Weinig	50	145	150	220	85		3.9	663087 □
Weinig	50	165	170	240	85		4.7	663081 ●
Weinig	50	205	210	280	85		4.8	663088 □
Weinig	50	235	240	310	85		5.3	663082 ●

##### Spare parts:

BEZ	ABM mm	for d mm	ID
Washer with safety device against twisting	50/20	30	008376 ●
Washer with safety device against twisting	60/20	40	008368 ●
Washer with safety device against twisting	70/20	50	008369 ●
Cylindrical screw with ISK	M8x20	40/50	114048 ●



Cutting arbor HSK 85 WS with clamping spacer and safety device against twisting in HSK.

#### Cutting arbor with hollow shank taper HSK 85 WS

##### Application:

For mounting saws, cutting tools, sets of cutting tools and cutterheads.

##### Machine:

Machines with HSK 85 WS adaptor e.g. moulders (Weinig Powermat), window production machines etc.

##### Technical information:

Easy and safe handling with optional lifting rings.

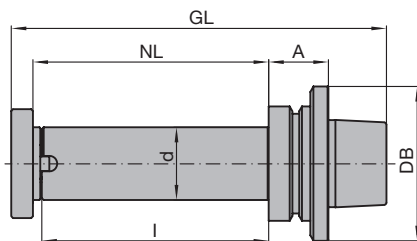
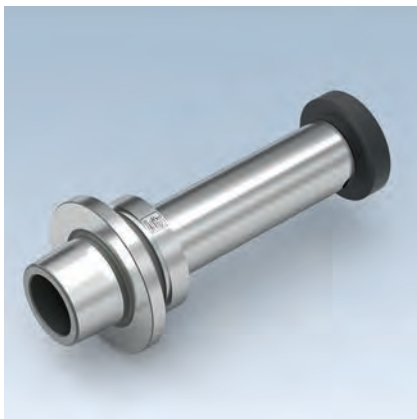
#### HSK 85 WS, A = 26 mm, for Weinig Powermat with two safety device grooves against twisting in the HSK

TI 501 0 16

Machine	d mm	l mm	NL mm	GL mm	DB mm	Weight kg	ID
Weinig	40	165	170	240	85	3.2	<b>663104</b> □
Weinig	40	235	240	310	85	3.9	<b>663105</b> □
Weinig	60	105.5	100	176	85	4.2	<b>663106</b> ●

##### Spare parts:

BEZ	ABM mm	for d mm	ID
Washer with safety device against twisting	60/20	40	<b>008370</b> ●
Washer with safety device against twisting	90/18	60	<b>008379</b> ●
Cylindrical screw with ISK	M8x20	40/60	<b>114048</b> ●



Cutting arbor HSK 85 - TI 501 0 14

#### Cutting arbor with hollow shank taper HSK 85

##### Application:

For mounting saws, cutting tools, sets of cutting tools and cutterheads.

##### Machine:

Machines with HSK 85 WS adaptor e.g. moulders, window production machines etc.

##### Technical information:

Easy and safe handling with optional lifting rings.

#### HSK 85, A = 33 mm and A = 26 mm, for SCM

TI 501 0 14

Machine	d mm	l mm	NL mm	GL mm	DB mm	Weight kg	ID
SCM	40	125	130	207	85	2.6	<b>663061</b> ●
SCM	50	325	320	413	85	7.3	<b>663055</b> ●

##### Spare parts:

BEZ	ABM mm	for d mm	ID
Washer with safety device against twisting	60/20		<b>008368</b> ●
Washer with safety device against twisting	70/20	50	<b>008375</b> ●
Cylindrical screw with ISK	M8x20	40	<b>114048</b> ●
Cylindrical screw with ISK	M8x35	50	<b>006524</b> ●

## 7. Clamping systems

### 7.4 Clamping arbors

#### 7.4.2 Cutter arbors



#### Blanking arbor HSK 85 WS

##### Application:

Dust cover for spindles when not in use.

##### Machine:

Machines with HSK 85 WS adaptor e.g. moulders (Weinig Powermat), window production machines etc.

##### Blanking arbor for Weinig Powermat

TI 501 0 14

Machine	ID
Weinig	663044 ●



#### Lifting ring, HSK 85 WS

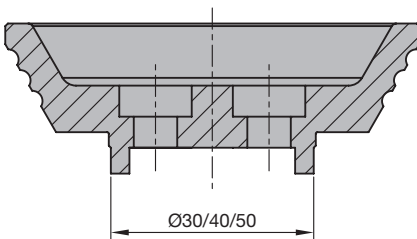
##### Application:

Lifting rings can be mounted on arbors for easy and safe tool handling.

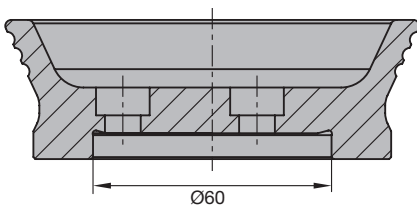
##### Lifting ring for HSK 85 WS arbors

TK 540 0

Machine	BEZ	ABM mm	TK	ID
Weinig	Spindle lifting rings	for d=30 with safety device against twisting	18	008378 ●
Weinig	Spindle lifting rings	for d=40 with safety device against twisting	25	008365 ●
Weinig	Spindle lifting rings	for d=50 with safety device against twisting	32	008366 ●
Weinig	Spindle lifting rings	for d=60 with safety device against twisting	45	008380 ●

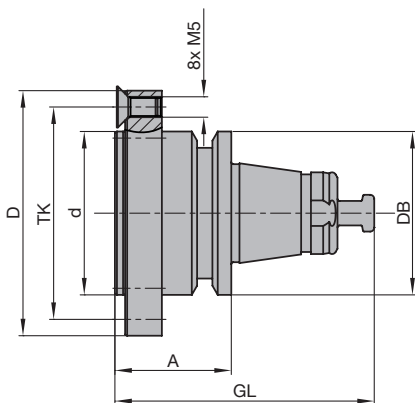


ID 008378/ 008365 / 008366



ID 008380





Saw blade adaptor

#### Tool adaptor for circular sawblades for CNC aggregates

##### Application:

Tool adaptor with flange for the adaption of circular sawblades.

##### Technical information:

Steep taper design for Flex 5+ aggregate (Homag Group) and 5-motion-Plus aggregate (Felder Format-4). The circular sawblade is fixed through 8 countersink screws M5 on the flange. Maximum sawblade diameter 220 mm (limitation through the aggregate). The maximum cutting width of sawblade is limited to 6 mm. Tool adaptor is fine balanced.

##### Sawblade adaptor

TI 501 0

Machine	d mm	l mm	NL mm	A mm	GL mm	DB mm	TK mm	Weight kg	ID
Felder Format-4, Homag Group	40	2.5	2.5 - 4	23.5	62.5	40	52	0.4	<b>663074 ●</b>

##### Spare parts:

BEZ	ABM mm	ID
Countersink screw	M5x10	<b>005779 ●</b>
Allen key	SW 3	<b>005433 ●</b>





### Tool adaptor for circular sawblades

#### Application:

Tool adaptor with flange for the adaption of circular sawblades.

#### Technical information:

Optionally mounting the sawblade by means of counterscrews or with the enclosed counterflange. Mounting with counterflange is preferred for increased stability and concentricity in case of precision cuts. Application without counterflange is preferred for producing mitre and rafter cuts. Maximum diameter of sawblade 350 mm (450 mm with counter flange).

#### HSK-F 63, DIN 69893

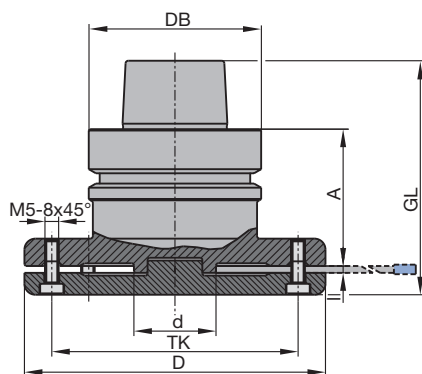
TI 501 0 07

Machine	d mm	l mm	NL mm	A mm	GL mm	DB mm	TK mm	Weight kg	ID
Homag	30	2.5	2.5 - 3.5	40	75.5	63	90	2.0	<b>663094 ●</b>
	30	2.5	2.5 - 3.5	50	85.5	63	90	2.2	<b>663093 ●</b>
SCM	30	2.5	2.5 - 3.5	60	95.5	63	90	2.5	<b>663109 ●</b>

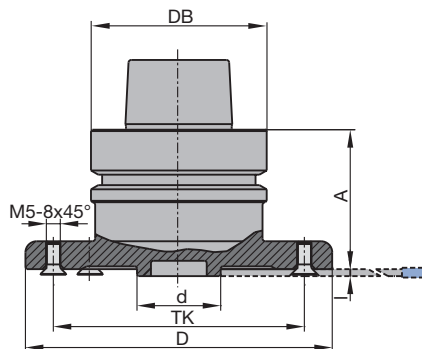
Sales unit consisting of HSK-flange with counterscrews as well as counterflange with cylindrical screws.

#### Spare parts:

BEZ	ABM mm	ID
Cylindrical screw with ISK	M5x12	<b>006414 ●</b>
Countersink screw, Torx® 20	M5x8.5	<b>007808 ●</b>
Allen key	SW 4, L 71	<b>005468 ●</b>
Torx® key	Torx® 20	<b>117511 ●</b>



Clamping variant with counter flange



Clamping variant with concentrically mounted sawblade



### Flange for circular sawblades

#### Application:

To mount circular sawblades on arbors.

#### Technical information:

Sawblade flange is mounted on arbor with diameter  $d = 30$  mm by clamping screws and pins. The length and the dimension A are flexible and defined by spacers. Maximum sawblade diameter 350 mm.

#### Flange adaptor

TR 810 0

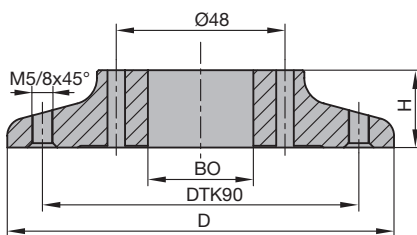
Machine	D	H	BO	NL	TK	Weight	ID
	mm	mm	mm	mm	mm	kg	
Universal	110	22	30	2 - 3.5	90	0.9	<b>066752 •</b>

#### Spare parts:

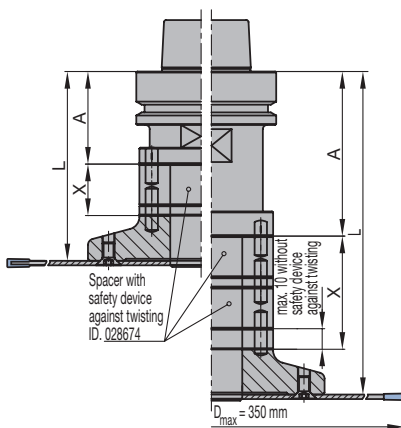
BEZ	ABM	ID
	mm	
Countersink screw, Torx® 20	M5x12	<b>006247 •</b>
Torx® key	Torx® 20	<b>117511 •</b>
Spacer with cylindrical pins	60x20x30	<b>028674 •</b>

Suitable spacers, see section Knives and Spare Parts.

Clamping length L depending on spacer thickness X and the dimension A of the arbor used:

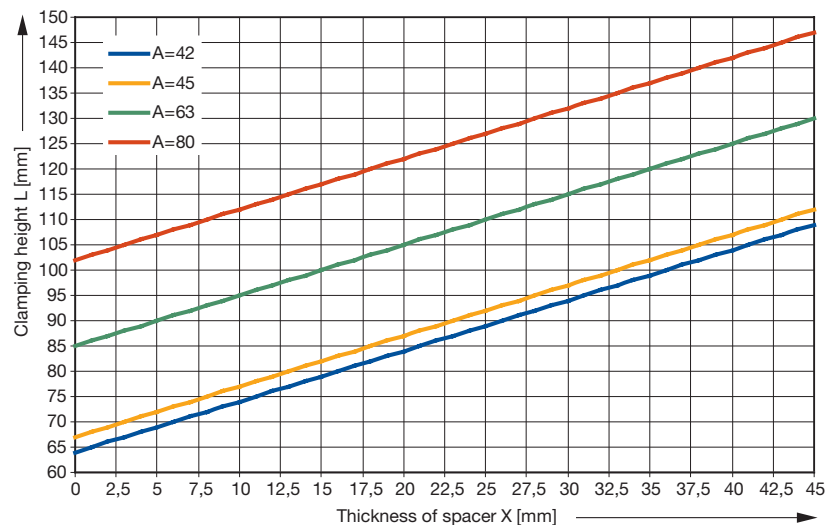


Flange TR 810 0



#### Note:

Variable clamping length through the combination of spacers without pins and spacers with pins for the safety device against twisting ID **028674**. Maximum thickness of the spacers without safety device against twisting = 10 mm.





Spindle without  
twist protection



Spindle with  
anti-twist keyway



Spindle with  
anti-twist hexagon



Hydro clamping  
system - open



Hydro clamping  
system - closed



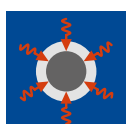
Hydro-Duo  
(bi-directional) clamping



Hydro clamping arbors



Hydro clamping



Shrink-fit clamping



Quick

Quick clamping system

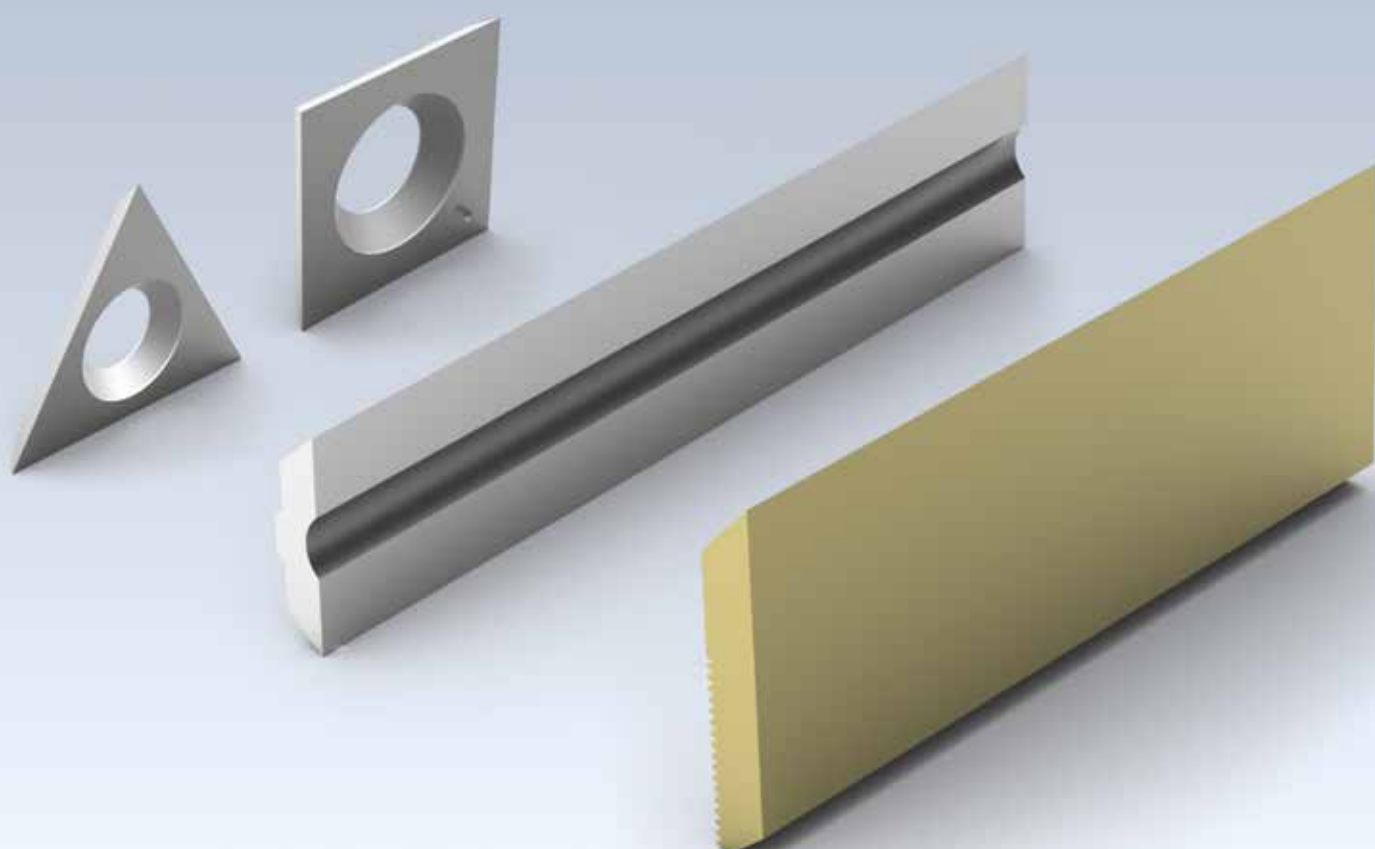


# Knives and spare parts

Leitz Lexicon Edition 7

Version 2

04/2022



## Explanation of abbreviations

A	= dimension A
$a_e$	= cutting thickness (radial)
$a_p$	= cutting depth (axial)
ABM	= dimension
APL	= panel raising length
APT	= panel raising depth
AL	= working length
AM	= number of knives
AS	= anti sound (low noise design)

b	= overhang
B	= width
BDD	= thickness of shoulder
BEM	= note
BEZ	= description
BH	= tipping height
BO	= bore diameter

CNC	= Computerized Numerical Control
-----	----------------------------------

d	= diameter
D	= cutting circle diameter
D0	= zero diameter
DA	= outside Diameter
DB	= diameter of shoulder
DFC	= Dust Flow Control (optimised chip clearance)
DGL	= number of links
DIK	= thickness
DKN	= double keyway
DP	= polycrystalline diamond
DRI	= rotation

FAB	= width of rebate
FAT	= depth of rebate
FAW	= bevel angle
FLD	= flange diameter
$f_z$	= tooth feed
$f_{z\text{ eff}}$	= effective tooth feed

GEW	= thread
GL	= total length
GS	= Plunging edge

H	= height
HC	= tungsten carbide, coated
HD	= wood thickness (thickness of workpiece)
HL	= high-alloyed tool steel
HS	= high-speed steel (HSS)
HW	= tungsten carbide (TCT)

ID	= ident number
IV	= insulation glazing

KBZ	= abbreviation
KLH	= clamping height
KM	= edge breaker
KN	= single keyway
KNL	= combination pinhole consists of 2/7/42 2/9/46,35 2/10/60

L	= length
I	= clamping length
LD	= left hand twist
LEN	= Leitz standard profiles

LH	= left hand rotation
----	----------------------

M	= metric thread
MBM	= minimum order quantity
MC	= multi-purpose steel, coated
MD	= thickness of knife
$\text{min}^{-1}$	= revolutions per minute (RPM)
MK	= morse taper
$\text{m min}^{-1}$	= metres per minute
$\text{m s}^{-1}$	= metres per second

n	= RPM
$n_{\text{max}}$	= maximum permissible RPM
NAL	= position of hub
ND	= thickness of hub
NH	= zero height
NL	= cutting length
NLA	= pinhole dimensions
NT	= grooving depth

P	= profile
POS	= cutter position
PT	= profile depth
PG	= profile group

QAL	= cutting material quality
-----	----------------------------

R	= radius
RD	= right hand twist
RH	= right hand rotation
RP	= radius of cutter

S	= shank dimension
SB	= cutting width
SET	= set
SLB	= slotting width
SLL	= slotting length
SLT	= slotting depth
SP	= tool steel
ST	= Cobalt-basis cast alloys, e.g. Stellite™
STO	= shank tolerance
SW	= cutting angle

TD	= diameter of tool body
TDI	= thickness of tool
TG	= pitch
TK	= reference diameter

UT	= cutting edges with irregular pitch
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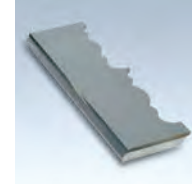
V	= number of spurs
$v_c$	= cutting speed
$v_f$	= feed speed
VE	= packing unit
VSB	= adjustment range

WSS	= workpiece material
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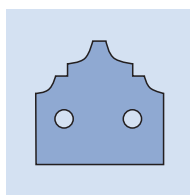
Z	= number of teeth
ZA	= number of fingers
ZF	= tooth shape (cutting edge shape)
ZL	= finger length

### Notes to the Lexicon concerning the diagrams and tables

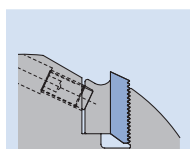
The statements made in the diagrams and tables relate to specific conditions and represent parameters from tests subjected to defined conditions. Variations when using tools in individual case due to special application conditions may be possible. Our support team will provide you with detailed information.



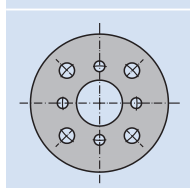
## 8. Knives and spare parts



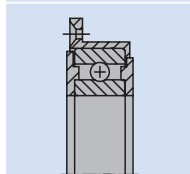
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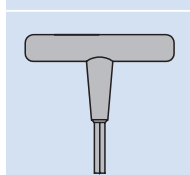
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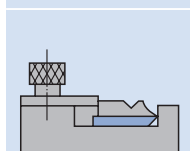
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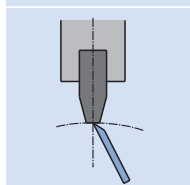
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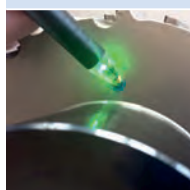
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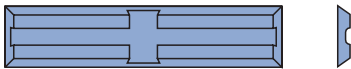
ID index	49
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## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.1 Turnblade knives



Turnblade knife for router cutter  
WL 100 1

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW

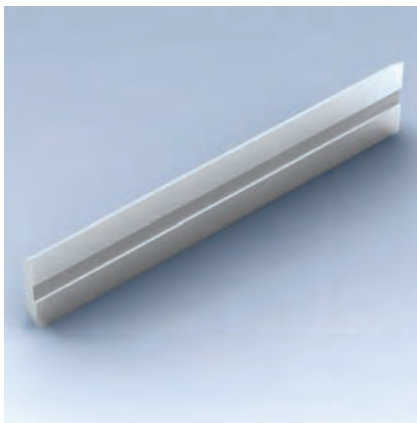
#### Knife height up to 5.5 mm

**HW-05**

TM 410 0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
20	4.1	1.1	WL 100-1	HW-05	10	005186 ●
20	5.5	1.1	WL 100-1	HW-05	10	005187 ●
25	5.5	1.1	WL 100-1	HW-05	10	005188 ●
30	5.5	1.1	WL 100-1	HW-05	10	005189 ●
40	5.5	1.1	WL 100-1	HW-05	10	005190 ●
50	5.5	1.1	WL 100-1	HW-05	10	005191 ●

ID = 1 piece.



Turnblade knife HW

#### Knife height 8 mm

**HW-30F / HW-05**

TM 410 0

SB mm	H mm	DIK mm	VE PCS	ID HW-05	ID HW-30F
7.7	8	1.5	10	005053 ●	005068 ●
9.7	8	1.5	10	005054 ●	005197 ●
11.7	8	1.5	10	005055 ●	005069 ●
14.7	8	1.5	10	005056 ●	005070 ●
19.7	8	1.5	10	005057 ●	005071 ●
25	8	1.5	10	005058 ●	005198 ●
30	8	1.5	10	005059 ●	005072 ●
35	8	1.5	10	005400 ●	005073 ●
40	8	1.5	10	005401 ●	005074 ●
45	8	1.5		007681 ●	007679 □
50	8	1.5	10	005402 ●	005075 ●
60	8	1.5	10	005403 ●	005076 ●
70	8	1.5		007682 ●	007680 □
80	8	1.5	10		005077 ●
80	8	1.5		005404 ●	
100	8	1.5		005405 ●	005184 ●
120	8	1.5		005406 ●	005185 ●

ID = 1 piece.

Cutting material recommendation	HW-30F	HW-05
Softwood	◆	◇
Hardwood	◇	◆
Glulam	◇	◆
Chipboard	◇	◆
MDF	◇	◆
Thermoplastics (PE, PP, PVC, etc.)	◇	◆

◆ suitable ◇ partly suitable

**Cutting material:**

HW fine grain quality/ HW



Turnblade knife HW

Cutting material recommendation	HW-30F MC	HW-30F MC Micro
Softwood	◆	◆
Hardwood	◇	◆
Glulam	◇	◇
Chipboard		
MDF		
Thermoplastics (PE, PP, PVC, etc.)	◇	◇
	HW-05 MC	TDC
Softwood	◇	◇
Hardwood	◆	◇
Glulam	◆	◆
Chipboard	◆	◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆

◆ suitable ◇ partly suitable

#### Coating:

Marathon MC (Multi Coating) / Marathon TDC (Tungsten Diamond Coating)

#### Attention:

HW-30F MC cutting edges with microfinish for high demands on finish quality and cutting performance

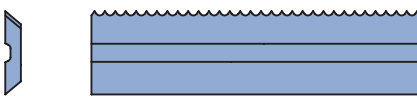
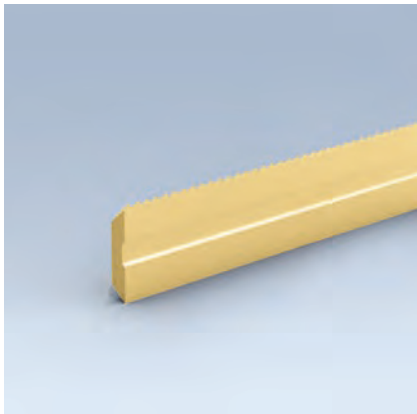
### Knife height 8 mm Marathon

#### HW-30F MC / HW-30F MC Micro / HW-05 MC / HW TDC

TM 410 0, TM 410 0 50, TM 410 0 70

SB mm	H mm	DIK mm	VE PCS	ID HW-30F MC	ID HW-30F MC Micro	ID HW-05 MC	ID HW TDC
7.7	8	1.5	10	601600 ●	601704 ●	601628 ●	601416
9.7	8	1.5	10	601601 ●	601705 ●	601629 ●	601417
11.7	8	1.5	10	601602 ●	601706 ●	601630 ●	601418
14.7	8	1.5	10	601603 ●	601707 ●	601631 ●	601419
19.7	8	1.5	10	601604 ●	601708 ●	601632 ●	601420
25	8	1.5	10	601605 ●	601709 ●	601633 ●	601421
30	8	1.5	10	601606 ●	601710 ●	601634 ●	601422
35	8	1.5	10	601607 ●	601711 ●	601635 ●	601423
40	8	1.5	10	601608 ●	601712 ●	601636 ●	601424
45	8	1.5	1	601609 □	601713 □	601637 ●	601425
50	8	1.5	1		601714 ●		
50	8	1.5	10	601610 ●		601638 ●	601426
60	8	1.5	1		601715 ●		
60	8	1.5	10	601611 ●		601639 ●	601427
70	8	1.5	1	601612 □	601716 □	601640 ●	601428
80	8	1.5	1		601717 ●	601641 ●	
80	8	1.5	10	601613 ●			601429
100	8	1.5	1	601614 ●	601718 ●	601642 ●	601430
120	8	1.5	1	601615 ●	601719 ●	601643 ●	601431

ID = 1 piece.



One-way knife HW



**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW fine grain quality (HW 30F)  
HW (HW-05)

**Coating:**  
Marathon MC (Multi Coating)

**RipTec:**  
Cutting edges with RipTec profile for high surface quality and cutting performance

#### Changeable knife 8 mm Marathon RipTec for turnblade knife tools Integral

##### HW-30F MC RipTec

TM 140 0 08

SB	H	DIK	KBZ	QAL	VE	ID
mm	mm	mm			PCS	
8	8	1.5	EPR 8/8-MC	HW-30F MC	10	601744
10	8	1.5	EPR 8/10-MC	HW-30F MC	10	601745
12	8	1.5	EPR 8/12-MC	HW-30F MC	10	601746
14	8	1.5	EPR 8/15-MC	HW-30F MC	10	601747
20	8	1.5	EPR 8/20-MC	HW-30F MC	10	601748
24	8	1.5	EPR 8/25-MC	HW-30F MC	10	601749
29	8	1.5	EPR 8/30-MC	HW-30F MC	10	601750
34	8	1.5	EPR 8/35-MC	HW-30F MC	10	601751
39	8	1.5	EPR 8/40-MC	HW-30F MC	10	601752
44	8	1.5	EPR 8/45-MC	HW-30F MC		601753
49	8	1.5	EPR 8/50-MC	HW-30F MC	10	601754
59	8	1.5	EPR 8/60-MC	HW-30F MC	10	601755
69	8	1.5	EPR 8/70-MC	HW-30F MC		601756
78	8	1.5	EPR 8/80-MC	HW-30F MC	10	601757
98	8	1.5	EPR 8/100-MC	HW-30F MC		601758
118	8	1.5	EPR 8/120-MC	HW-30F MC		601759

ID = 1 piece.

##### HW-05 MC RipTec

TM 140 0 08

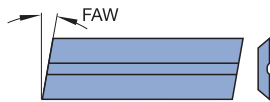
SB	H	DIK	KBZ	QAL	VE	ID
mm	mm	mm			PCS	
8	8	1.5	EPR 8/8B-MC	HW-05 MC	10	601760
10	8	1.5	EPR 8/10B-MC	HW-05 MC	10	601761
12	8	1.5	EPR 8/12B-MC	HW-05 MC	10	601762
14	8	1.5	EPR 8/15B-MC	HW-05 MC	10	601763
20	8	1.5	EPR 8/20B-MC	HW-05 MC	10	601764
24	8	1.5	EPR 8/25B-MC	HW-05 MC	10	601765
29	8	1.5	EPR 8/30B-MC	HW-05 MC	10	601766
34	8	1.5	EPR 8/35B-MC	HW-05 MC	10	601767
39	8	1.5	EPR 8/40B-MC	HW-05 MC	10	601768
44	8	1.5	EPR 8/45B-MC	HW-05 MC		601769
49	8	1.5	EPR 8/50B-MC	HW-05 MC		601770
59	8	1.5	EPR 8/60B-MC	HW-05 MC		601771
69	8	1.5	EPR 8/70B-MC	HW-05 MC		601772
78	8	1.5	EPR 8/80B-MC	HW-05 MC		601773
98	8	1.5	EPR 8/100B-MC	HW-05 MC		601774
118	8	1.5	EPR 8/120B-MC	HW-05 MC		601775

ID = 1 piece.

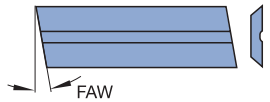
## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.1 Turnblade knives



Turnblade knife ZM 10/x



Turnblade knife ZM 11/x

#### Workpiece material:

Softwood and hardwood

#### Cutting material:

HW fine grain quality

#### Knife height 8 mm (bevel/tenoning tools)

##### HW-F

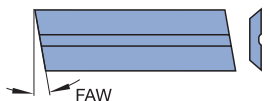
TM 410 0

SB mm	H mm	DIK mm	FAW °	KBZ	QAL	ID
21	8	1.5	10°	ZM 10/1	HW-F	005004 ●
15	8	1.5	14°	ZM 10/4	HW-F	005050 ●
21	8	1.5	10°	ZM 11/1	HW-F	005006 ●
15	8	1.5	14°	ZM 11/4	HW-F	005051 ●

ID = 1 piece.



Turnblade knife ZM 10/x



Turnblade knife ZM 11/x

#### Knife height 8 mm Marathon (bevel/tenoning tools)

##### HW-30F MC / HW-05 MC

TM 410 0 50

SB mm	H mm	DIK mm	FAW °	ID HW-05 MC	ID HW-30F MC
15	8	1.5	8°	601645 ●	601616 ●
15	8	1.5	8°	601644 ●	601617 ●
15	8	1.5	14°	601647 ●	601618 ●
15	8	1.5	14°	601646 ●	601619 ●
21	8	1.5	10°	601649 ●	601620 ●
21	8	1.5	10°	601648 ●	601621 ●

ID = 1 piece.

Cutting material recommendation	HW-30F MC	HW-05 MC
Softwood	◆	◇
Hardwood	◇	◆
Glulam	◇	◆
Chipboard		◆
MDF		◆
Thermoplastics (PE, PP, PVC, etc.)	◇	◆

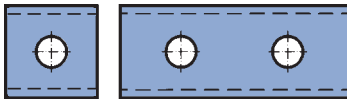
◆ suitable ◇ partly suitable

#### Coating:

Marathon MC (Multi Coating)



Knife type:  
Type 1 Type 2



Turnblade knife

Cutting material recommendation	HW-05F	HW-02UF	TDC
Softwood	◆	◇	◇
Hardwood	◆	◆	◇
Glulam	◇	◆	◆
Chipboard	◇	◆	◆
MDF	◇	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◇	◆	◆

◆ suitable ◇ partly suitable

#### Knife height 12 mm

##### HW-05F / HW-02UF

TM 405 0

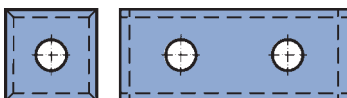
Knife	SB mm	H mm	DIK mm	VE PCS	ID HW-05F	ID HW-02UF	ID TDC
1	7.6	12	1.5	10	005080 ●		602414
1	9	12	1.5	10	005158 ●		602415
1 *	12	12	1.5	10	005081 ●		602416 ●
1	15	12	1.5	10	005082 ●		602417
1	20	12	1.5	10	005083 ●	602001 ●	602418
2	30	12	1.5	10	005084 ●	602002 ●	602419 ●
2	40	12	1.5	10	005085 ●	602003 ●	602420
2	50	12	1.5	10	005086 ●	602004 ●	602421 ●
2	60	12	1.5	10	005087 ●		602422

ID = 1 piece.

\* = with 4 cutting edges.

##### Cutting material:

HW / HW ultra fine grain quality



Turnblade knife with 4 cutting edges

Cutting material recommendation	HW-05F	HW-02UF
Softwood	◆	◇
Hardwood	◆	◆
Glulam	◇	◆
Chipboard	◇	◆
MDF	◇	◆
Thermoplastics (PE, PP, PVC, etc.)	◇	◆

◆ suitable ◇ partly suitable

#### Knife height 12 mm with 4 cutting edges

##### HW-05F / HW-02UF

TM 405 0

SB mm	H mm	DIK mm	VE PCS	ID HW-02UF	ID HW-05F
30	12	1.5	10	602005 ●	005161 ●
50	12	1.5	10	602006 ●	006506 ●

ID = 1 piece.

##### HW-05F with 3 holes

TM 405 0

SB mm	H mm	DIK mm	QAL	VE PCS	ID
50	12	1.7	HW-05F	10	007668 ●

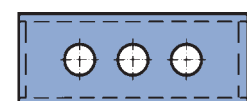
ID = 1 piece.

##### Workpiece material:

Solid wood, wood derived materials

##### Cutting material:

HW



Turnblade knife with 4 cutting edges  
and 3 holes



Turnblade knife

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW

#### Knife height 12 mm (slotting tools)

**HW**

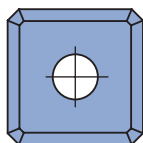
TM 405 0

SB	H	DIK	KBZ	QAL	ID
mm	mm	mm			
7.6	12	1.5	SM 1/1	HW	005120 ●
9.6	12	1.5	SM 1/2	HW	005121 ●
11.6	12	1.5	SM 1/3	HW	005122 ●

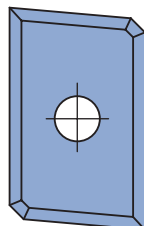
**Knife type:**

Type 1

Type 2



Turnblade knife



**Workpiece material:**

Softwood and hardwood

**Cutting material:**

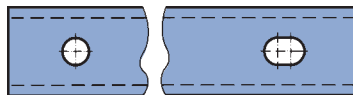
HW

#### Knife height 12 mm with bevel

**HW**

TM 405 0

Knife	SB	H	DIK	FAW	QAL	ID
	mm	mm	mm	°		
1	12	12	1.5	1x45°	HW	602009 ●
2	19.7	12	1.5	5°	HW	602010 ●



Turnblade knife

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW

#### Knife height 13 mm

**HW**

TM 405 0

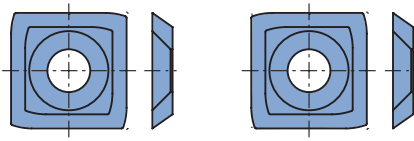
SB	H	DIK	QAL	VE	ID
mm	mm	mm		PCS	
80	13	2.2	HW	10	005096 ●
100	13	2.2	HW	10	005097 ●
120	13	2.2	HW	10	005098 ●

ID = 1 piece.

## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.1 Turnblade knives



#### Turnblade knife with radius for calibration moulder System Rotoles

##### HW

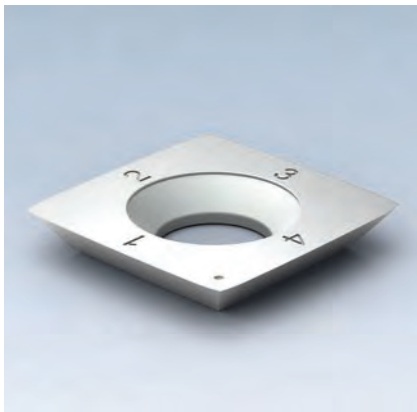
TM 435 0

SB	H	DIK	QAL	VE	ID	ID
mm	mm	mm		PCS	left	right
14.3	14.3	2.5	HW	10	602525 ●	602526 ●
14	14	2	HW-10F	10	602527 ●	602528 ●

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW / HW fine grain quality

ID = 1 piece.



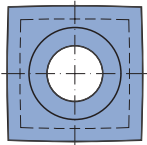
#### Turnblade knives for cutterhead system HeliCut

##### HW / TDC

TM 135 0, TM 405 0, TM 435 0

BEM	SB	H	DIK	QAL	VE	ID
	mm	mm	mm		PCS	
HeliCut 15	15	15	2.5	HW	10	009549 ●
HeliCut 15	15	15	2.5	HW-MF	10	009543 ●
HeliCut 15	15	15	2.5	TDC		602900 ●
HeliCut 11 (peripheral tip)	11	11	1.5	HW	10	602515 ●
HeliCut 11 (peripheral tip)	11	11	1.5	TDC		602904 ●
HeliCut 11 (plunging tip D30)	20.6	12.7	2	HW	10	602531 ●
HeliCut 11 (plunging tip D40)	22	12.7	2	HW	10	602516 ●

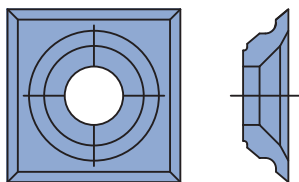
ID = 1 piece.



HW turnblade knife

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW / TDC



Turnblade knife with 4 cutting edges

#### Knife height 21 mm with 4 cutting edges

##### HW

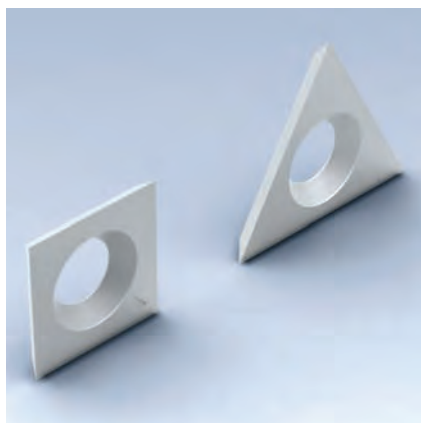
TM 410 0

SB	H	DIK	QAL	ID
mm	mm	mm		
21	21	5.5	HW	009527 ●

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW





### Spurs

#### HW / DP

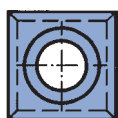
TM 405 0, TM 480 0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
14	14	2	VS 1	HW-F	10	005099 ●
14	14	1.2	VS 4	HW	10	005130 ●
14	14	1.2	Holz-Her	HW	10	602500 ●
15	15	2		HW		005100 ●
19		2	VS 2	HW-F	10	005115 ●
19		2	VS 2R*	HW-F	10	006615 ●
19		2	VS 2L*	HW-F	10	006616 ●
19		2	VS 2	DP*	2	006607 ●
19		2	VS 3R	HW-F		005116 ●
19		2	VS 3L	HW-F		005159 ●

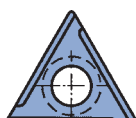
\* = Spurs with reduced slotting depth. Knives can be used alternatively in VS2 knife seating.

DP\* = diamond coated.

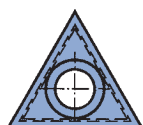
ID = 1 piece.



VS 1



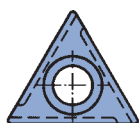
VS 3L



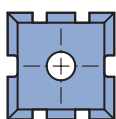
VS 2



VS 4



VS 3R



ID 005100

#### Workpiece material:

Solid wood, wood derived materials

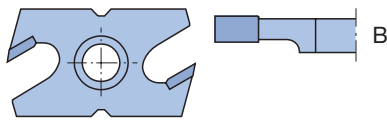
#### Cutting material:

HW fine grain quality / DP\*

## 8. Knives and spare parts

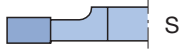
### 8.1 Knives and blank knives

#### 8.1.3 Grooving knives / profile grooving knives



Grooving knife

Grooving knife image



Grooving knife mirror image

#### Workpiece material:

Softwood and hardwood

#### Cutting material:

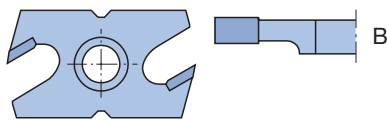
HW fine grain quality

### Grooving knives

#### Mechanical feed

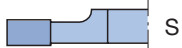
TM 460 0

SB mm	KBZ	QAL	ID
3	NA 3B	HW-F	008315 ●
3	NA 3S	HW-F	008316 ●
3	NAK 3B*	HW-F	616002 ●
3	NAK 3S*	HW-F	616003 ●
4,5	NA 4,5	HW-F	008333 ●
4	NA 4	HW-F	008317 ●
5	NA 5	HW-F	008318 ●
7	NA 7	HW-F	008319 ●
8	NAN 8	HW-F	008349 ●
9	NA 9	HW-F	008320 ●



Grooving knife

Grooving knife image



Grooving knife mirror image

#### Workpiece material:

Softwood and hardwood

#### Cutting material:

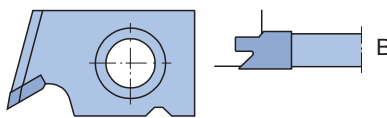
HW fine grain quality

#### Manual feed

TM 460 1

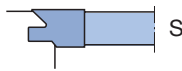
SB mm	KBZ	QAL	ID
3	NB 3B	HW-F	008321 ●
3	NB 3S	HW-F	008322 ●
3	NBK 3B*	HW-F	616000 ●
3	NBK 3S*	HW-F	616001 ●
4	NB 4	HW-F	008323 ●
5	NB 5	HW-F	008324 ●
7	NB 7	HW-F	008325 ●
8	NBN 8	HW-F	008348 ●
9	NB 9	HW-F	008326 ●

\* Grooving knife with reduced grooving depth.



Profile grooving knife

Profile grooving knife image



Profile grooving knife mirror image

#### Workpiece material:

Softwood and hardwood

#### Cutting material:

HW fine grain quality

### Profile grooving knives

#### For sealing strip

TM 160 0

SB mm	KBZ	QAL	ID
8	NC 1B	HW-F	008327 ●
8	NC 1S	HW-F	008328 ●



Lamello turnblade knives

**Cutting material:**

HW

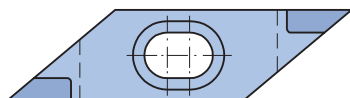
#### Lamello turnblade knives

**HW**

TM 463 0

SB mm	H mm	DIK mm	KBZ	QAL	VE PCS	ID
18	18	1.95	WP 18/1,95	HW	10	<b>005114 ●</b>
18	18	2.5	WP 18/2,5	HW	10	<b>005195 ●</b>

ID = 1 piece



Rhomboid turnblade knives

**Cutting material:**

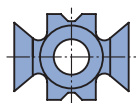
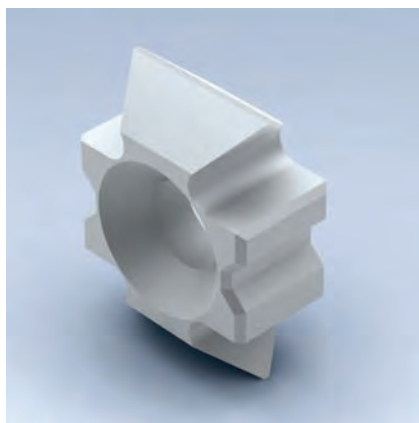
HW fine grain quality

#### Rhomboid turnblade knives

**HW-F**

TM 461 0

L mm	H mm	SB mm	KBZ	QAL	ID
45.416	12	5.6	RMA 5,6	HW-F	<b>008329 ●</b>
45.416	12	6.6	RMA 6,6	HW-F	<b>008330 ●</b>



**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW fine grain quality

#### Mechanical feed

##### HW-F

TM 462 0

SB mm	H mm	DIK mm	KBZ	QAL	ID
20	15	8	KM 11/0 45°	HW-F	008268 ●
20	15	7	KM 12/4 R1,5	HW-F	008272 ●
20	15	7.3	KM 12/3 R2	HW-F	008307 ●
22.3	15	9	KM 12/0 R3	HW-F	008270 ●
22	15	9	KM 15/0 R3	HW-F	008275 ●
20	15	9	KM 12/1 R3	HW-F	008271 ●
17.5	15	8	KM 11/1 60°	HW-F	008269 ●
18.3	15	7.3	KM 12/3F R2F	HW-F	008308 ●
22.3	15	10	KM 12/5 R3F	HW-F	008273 ●
22.3	15	7.3	KM 13/0 N5	HW-F	008274 ●
22.3	15	9	KM 13/1 N7	HW-F	008287 ●
22.3	15	7.3	KM 16/0	HW-F	008286 ●
22.3	15	7.3	KM 14/0 R5	HW-F	008347 ●

KM 11/0



KM 12/5



KM 11/1



KM 13/0



KM 12/0



KM 13/1



KM 12/1



KM 14/0



KM 12/3



KM 15/0



KM 12/3F



KM 16/0



KM 12/4



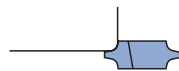
KC 1 B

KC 2 B



KC 1 S

KC 2 S



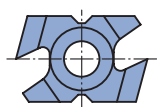
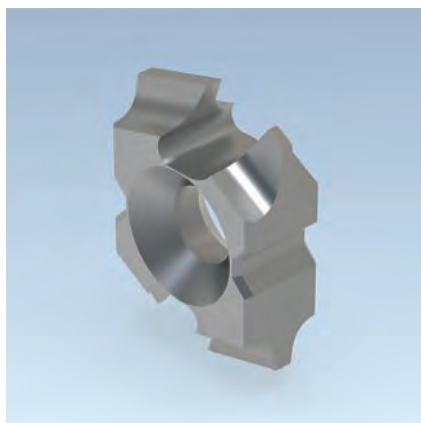
**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
HW fine grain quality

##### HW-F, with bevelled cutting area

TM 462 0

SB mm	H mm	DIK mm	KBZ	QAL	ID
20	15	8.3	KC 1B (R2)	HW-F	008334 ●
20	15	10	KC 2B (R3)	HW-F	008335 ●
20	15	8.3	KC 1S (R2)	HW-F	008336 ●
20	15	10	KC 2S (R3)	HW-F	008337 ●

**Workpiece material:**

Softwood and hardwood

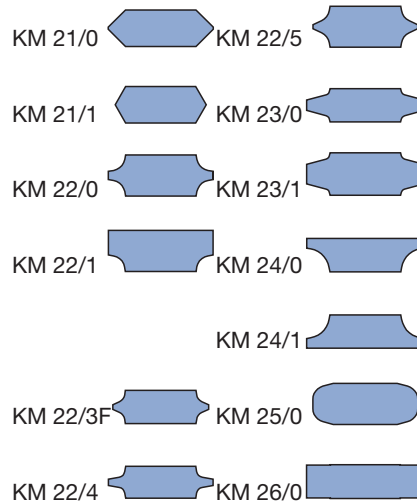
**Cutting material:**

HW fine grain quality

**Manual feed****HW-F**

TM 462 1

SB mm	H mm	DIK mm	KBZ	QAL	ID
23	15	7.3	KM 22/3 R2	HW-F	008309 ●
23	15	8	KM 21/0 45°	HW-F	008292 ●
23	15	9	KM 22/1 R3	HW-F	008290 ●
25.7	15	7.3	KM 24/0 R5	HW-F	008305 ●
23	15	7	KM 22/4 R1,5	HW-F	008295 ●
23	15	9	KM 25/0 R3	HW-F	008291 ●
25.7	15	9.3	KM 23/1 N7	HW-F	008298 ●
25.7	15	7.3	KM 24/1 R5	HW-F	008306 ●
23	15	9	KM 22/0 R3	HW-F	008293 ●
20.5	15	8	KM 21/1 60°	HW-F	008294 ●
21	15	7.3	KM 22/3F R2F	HW-F	008310 ●
23	15	9	KM 22/5 R3F	HW-F	008296 ●
25.7	15	7.3	KM 23/0 N5	HW-F	008297 ●
25.7	15	7.3	KM 26/0	HW-F	008299 ●





Cutting material recommendation	HS Classic / Premium	MC33	HW
Solid wood dry	◆	◆	◇
Solid wood wet	◇	◆	
Hardwood dry	◇		◆
Hardwood wet	◇	◆	
Glulam		◇	◇
Thermoplastics (PE, PP, PVC, etc.)	◆	◆	◇
WPC			
(Wood-Plastic-Composite)	◇	◆	◇

◆ suitable ◇ partly suitable



Cross section of planer knife (HS Classic / HS Premium / MC33)



Cross section of planer knife (HW)

#### Cutting material:

HS Classic / HS Premium / MC33 / HW

#### Wedge angle:

40° (HS Classic / HS Premium / MC33)

45° (HW)

### Knife height 30 mm

#### For planerhead wedge-type system WM 200 2 05

TM 100 0, TM 100 0 03, TM 100 0 05

SB	H	DIK	VE	ID	ID	ID	ID
mm	mm	mm	PCS	HS Classic	HS Premium	MC33	HW
60	30	3	2	605000	027101 ●	606700 ●	027277 ●
80	30	3	2	605001	027102 ●	606701 ●	027278 ●
100	30	3	2	605002 ●	027103 ●	606702 ●	027279 ●
110	30	3	2	605003	027104 ●	606703 ●	027280 ●
120	30	3	2	605004	027105 ●	606704 ●	027281 ●
130	30	3	2	605005 ●	027106 ●	606705 ●	027282 ●
150	30	3	2	605006 ●	027107 ●	606706 ●	027283 ●
160	30	3	2	605045 ●	027163 ●	606745 ●	
170	30	3	2	605007 ●	027108 ●	606707 ●	027284 ●
180	30	3	2	605008 ●	027109 ●	606708 ●	027285 ●
190	30	3	2	605009	027144 ●	606709 ●	027322 ●
210	30	3	2	605010	027110 ●	606710 ●	027286 ●
230	30	3	2	605011 ●	027111 ●	606711 ●	027287 ●
240	30	3	2	605012 ●	027134 ●	606712 ●	027323 ●
250	30	3	2	605013	027161 ●	606713 ●	
260	30	3	2	605014 ●	027112 ●	606714 ●	027288 ●
270	30	3	2	605015	027162 ●	606715 ●	
310	30	3	2	605016 ●	027113 ●	606716 ●	027289 ●
320	30	3	2	605046	027164 ●	606746 ●	
360	30	3	2	605029	027114 ●	606729 ●	027292 ●
400	30	3	2	605030	027115 ●	606730 ●	
410	30	3	2	605031 ●	027116 ●	606731 ●	027293 ●
460	30	3	2	605032	027130 ●	606732 □	027295 ●
500	30	3	2	605033	027117 ●	606733 □	
510	30	3	2	605034 ●	027118 ●	606734 □	027296 ●
600	30	3	2	605035	027119 ●	606735 □	
610	30	3	2	605036 ●	027120 ●	606736 □	027297 ●
630	30	3	2	605037	027125 ●	606737 □	027298 ●
640	30	3	2	605038 ●	027121 ●	606738 □	027299 ●
710	30	3	2	605039	027122 ●	606739 □	027300 ●
810	30	3	2	605040 ●	027123 ●	606740 □	027302 ●

ID = 1 piece.

### Knife height 35 mm

#### For long planerheads wedge-type system

TM 100 0, TM 100 0 03, TM 100 0 05

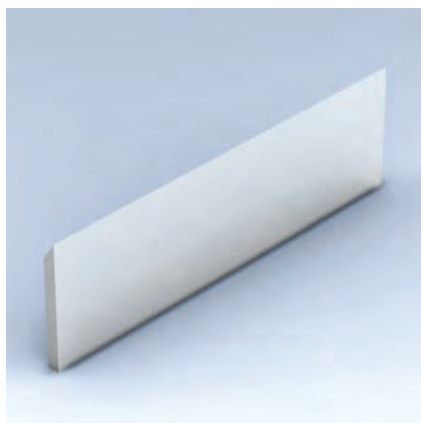
SB	H	DIK	VE	ID	ID	ID	ID
mm	mm	mm	PCS	HS Classic	HS Premium	MC33	HW
60	35	3	2	605119	027387 ●	606819 ●	
100	35	3	2	605120	027388 ●	606820 ●	
160	35	3	2	605121	027389 ●	606821 ●	
230	35	3	2	605122	027390 ●	606822 ●	
310	35	3	2	605100	027351 ●	606800 ●	027303 ●
320	35	3	2	605101	027352 ●	606801 ●	027304 □
330	35	3	2	605102	027353 ●	606802 ●	027305 □
360	35	3	2	605103	027354 ●	606803 ●	027306 □
400	35	3	2	605104	027355 ●	606804 ●	027307 □
410	35	3	2	605105 ●	027356 ●	606805 ●	027308 ●
450	35	3	2	605106	027357 ●	606806 □	027309 □
460	35	3	2	605107	027358 ●	606807 □	027310 □
500	35	3	2	605108 ●	027359 ●	606808 □	027311 □
510	35	3	2	605109 ●	027360 ●	606809 □	027312 ●
600	35	3	2	605110	027361 ●	606810 □	027313 □
610	35	3	2	605111 ●	027362 ●	606811 □	027314 □
630	35	3	2	605112	027363 ●	606812 □	027315 ●
635	35	3	2	605113	027364 ●	606813 □	027316 ●
640	35	3	2	605114 ●	027365 ●	606814 □	027317 ●
660	35	3	2		027371 ●		
700	35	3	2	605115	027366 ●	606815 □	027318 □
710	35	3	2	605116	027367 ●	606816 □	027319 □
740	35	3	2	605117	027368 ●	606817 □	027320 □
810	35	3	2	605118 ●	027369 ●	606818 □	027321 ●

ID = 1 piece.

● available ex stock

□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)



#### Knives for cassette system

##### Planer knives 30 mm with threaded bore

TM 105 0

SB mm	H mm	DIK mm	VE PCS	ID HS	ID HW
130	30	3	2	006825 ●	006915 ●
150	30	3	2	006928 ●	006931 ●
180	30	3	2	006826 ●	006916 ●
190	30	3	2	006929 ●	
230	30	3	2	006827 ●	006917 ●
240	30	3	2	006926 ●	

ID = 1 piece.

Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Chipboard		◇
MDF		◇
Thermoplastics (PE, PP, PVC, etc.)		◇
WPC		
(Wood-Plastic-Composite)		◇

◆ suitable ◇ partly suitable



Cross section of planer knife  
(HS Classic / HS Premium / MC33)



Cross section of planer knife (HW)

#### Cutting material:

HS / HW





#### Planer knives with 60° back serration

For planerhead with 60° back serrated knife fixture

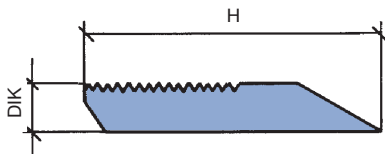
AT 103 0 29

SB mm	H mm	DIK mm	SET PCS	QAL	ID
150	30	5	2	MC33	<b>697359</b> □
230	30	5	2	MC33	<b>697360</b> □
310	30	5	2	MC33	<b>697361</b> □
320	30	5	2	MC33	<b>697362</b> □
330	30	5	2	MC33	<b>697363</b> □
40	40	5	2	MC33	<b>697300</b> ●
60	40	5	2	MC33	<b>697301</b> ●
80	40	5	2	MC33	<b>697302</b> ●
100	40	5	2	MC33	<b>697303</b> ●
130	40	5	2	MC33	<b>697304</b> ●
150	40	5	2	MC33	<b>697305</b> ●
170	40	5	2	MC33	<b>697306</b> ●
180	40	5	2	MC33	<b>697307</b> ●
190	40	5	2	MC33	<b>697308</b> ●
210	40	5	2	MC33	<b>697309</b> ●
230	40	5	2	MC33	<b>697310</b> ●
240	40	5	2	MC33	<b>697311</b> ●
270	40	5	2	MC33	<b>697312</b> ●
310	40	5	2	MC33	<b>697313</b> ●

Set of the same weight.

Cutting material recommendation	MC 33
Solid wood dry	◆
Solid wood wet	◆
Hardwood dry	◆
Hardwood wet	◆
Glulam	◇
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	◆
WPC (Wood-Plastic-Composite)	◆

◆ suitable ◇ partly suitable

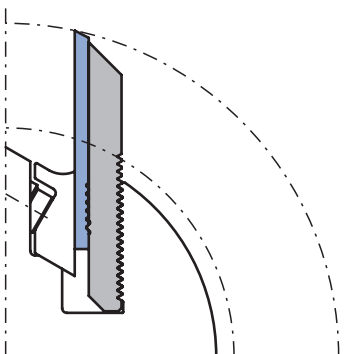
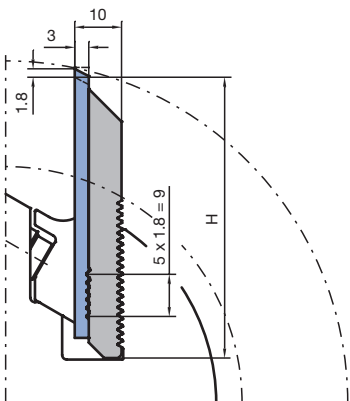


Cutting material:  
MC33



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	◆	
Solid wood wet		
Hardwood dry	◆	◆
Hardwood wet		◇
Glulam	◇	◆
Chipboard		◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◆	◆

◆ suitable ◇ partly suitable



### Planer knives Powerknife System PKS®

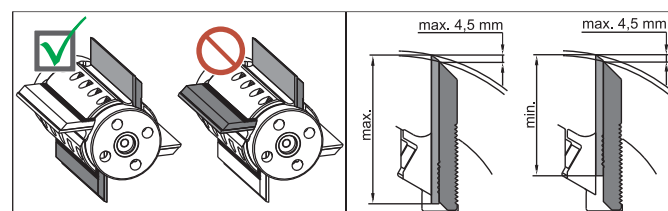
For planerhead with 60° back serrated knife fixture

AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	40	10	2	HW-30F	696614 □	697814 □
60	40	10	2	HW-30F	696615 □	697815 □
80	40	10	2	HW-30F	696616 □	697816 □
100	40	10	2	HW-30F	696617 □	697817 □
130	40	10	2	HW-30F	696618 □	697818 □
150	40	10	2	HW-30F	696619 ●	697819 ●
170	40	10	2	HW-30F	696620 ●	697820 ●
180	40	10	2	HW-30F	696621 □	697821 □
190	40	10	2	HW-30F	696622 □	697822 □
210	40	10	2	HW-30F	696623 ●	697823 ●
230	40	10	2	HW-30F	696624 □	697824 □
240	40	10	2	HW-30F	696625 ●	697825 ●
270	40	10	2	HW-30F	696626 □	697826 □
310	40	10	2	HW-30F	696627 ●	697827 ●
40	40	10	2	HW-10F	696600 □	697800 □
60	40	10	2	HW-10F	696601 □	697801 □
80	40	10	2	HW-10F	696602 □	697802 □
100	40	10	2	HW-10F	696603 □	697803 □
130	40	10	2	HW-10F	696604 □	697804 □
150	40	10	2	HW-10F	696605 ●	697805 ●
170	40	10	2	HW-10F	696606 ●	697806 ●
180	40	10	2	HW-10F	696607 □	697807 □
190	40	10	2	HW-10F	696608 □	697808 □
210	40	10	2	HW-10F	696609 ●	697809 ●
230	40	10	2	HW-10F	696610 □	697810 □
240	40	10	2	HW-10F	696611 ●	697811 ●
270	40	10	2	HW-10F	696612 □	697812 □
310	40	10	2	HW-10F	696613 ●	697813 ●

- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpener area 10.8 mm at maximum profile depth.

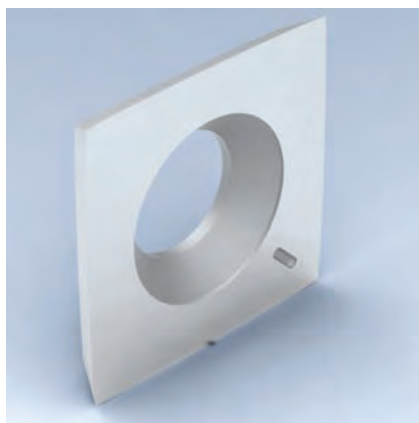
Set of the same weight.



**Cutting material:**  
HW-30F / HW-10F

#### Attention:

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.



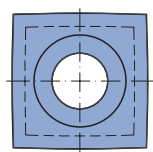
#### Turnblade planing knives HeliPlan

For cutterhead system HeliPlan

TM 405 0

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	<b>009535 •</b>
Turnblade knife	15x15x2.5	TDC		<b>602901 •</b>

ID = 1 piece.



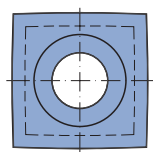
HW turnblade knife

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW / TDC



HW turnblade knife

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW

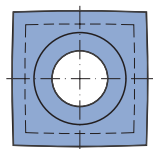
#### Turnblade planing knives CASTOR

For cutterhead system CASTOR-Finish

TM 405 0

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	15x15x2.5	HW	10	<b>009540 •</b>

ID = 1 piece.



HW turnblade knife

**Workpiece material:**

Softwood and hardwood

**Cutting material:**

HW

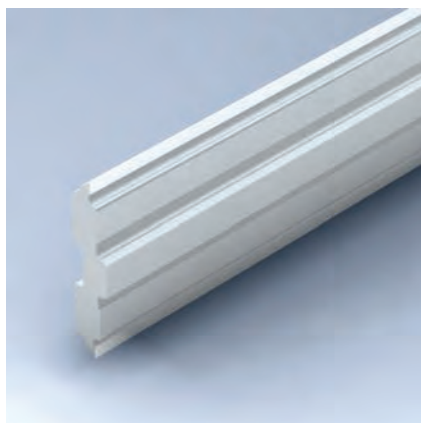
#### Turnblade planing knives Silent Power

For cutterhead system Silent Power

TM 405 0

BEZ	ABM mm	QAL	VE PCS	ID
Turnblade knife	13,8x13,8x2,5	HW	10	<b>602534 •</b>

ID = 1 piece



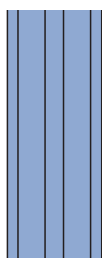
### Turnblade planing knives CentroStar, CentroFix, QuickFix

For cutterhead system CentroStar, CentroFix, QuickFix - HS

AT 103 0 02, AT 103 0 20

Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable



Turnblade knife CentroFix

**Cutting material:**

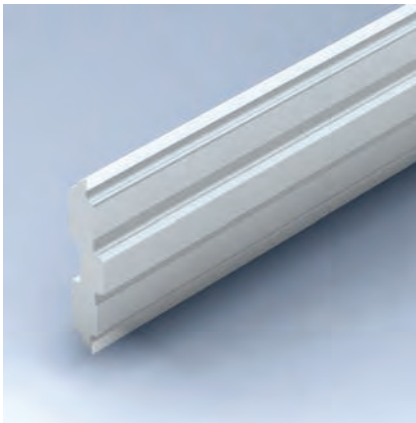
HS

SB	H	DIK	SET	QAL	ID
mm	mm	mm	PCS		
100	12	2.7	4	HS	610203 ●
120	12	2.7	4	HS	610204 ●
124.6	12	2.7	4	HS	610244 ●
130	12	2.7	4	HS	610205 ●
136	12	2.7	4	HS	610206 ●
150	12	2.7	4	HS	610208 ●
166	12	2.7	4	HS	610286 ●
170	12	2.7	4	HS	610210 ●
180	12	2.7	4	HS	610211 ●
186	12	2.7	3	HS	610247 ●
190	12	2.7	4	HS	610212 ●
210	12	2.7	4	HS	610213 ●
230	12	2.7	4	HS	610214 ●
236	12	2.7	4	HS	610287 ●
240	12	2.7	4	HS	610215 ●
256	12	2.7	4	HS	610288 ●
260	12	2.7	4	HS	610017 ●
310	12	2.7	4	HS	610018 ●
400	12	2.7	4	HS	610022 ●
410	12	2.7	4	HS	610023 ●
410	12	2.7	3	HS	610043 ●
420	12	2.7	4	HS	610024 ●
430	12	2.7	4	HS	610025 ●
500	12	2.7	4	HS	610028 ●
510	12	2.7	4	HS	610029 ●
520	12	2.7	4	HS	610030 ●
530	12	2.7	4	HS	610031 ●
540	12	2.7	4	HS	610032 ●
610	12	2.7	4	HS	610034 ●
630	12	2.7	4	HS	610036 ●
640	12	2.7	4	HS	610038 ●
710	12	2.7	4	HS	610040 ●
810	12	2.7	4	HS	610042 ●

## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.5 Planer knives



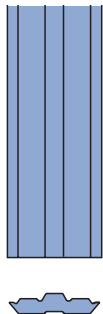
For cutterhead system CentroStar, CentroFix, QuickFix - MC  
AT 103 0 20

SB mm	H mm	DIK mm	SET PCS	QAL	ID
100	12	2.7	4	MC	610278 ●
120	12	2.7	4	MC	610279
130	12	2.7	4	MC	610280 ●
150	12	2.7	4	MC	610281
180	12	2.7	4	MC	610282 ●
230	12	2.7	4	MC	610283 ●
240	12	2.7	4	MC	610284 ●
310	12	2.7	4	MC	610285

Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable

Cutting material:  
MC

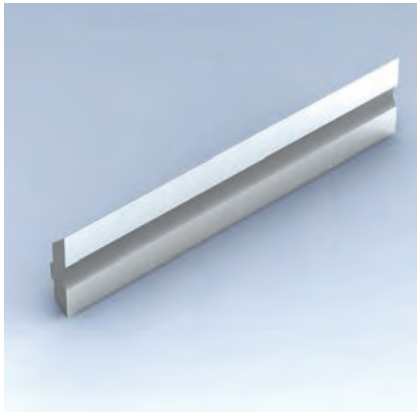


Turnblade knife CentroFix

Cutting material:  
HW-F

For cutterhead system CentroStar, CentroFix, QuickFix - HW-F  
AT 103 0 20, TM 410 0 02

SB mm	H mm	DIK mm	SET PCS	QAL	ID
100	12	2.7	2	HW-F	610606 ●
120	12	2.7	2	HW-F	610610 ●
130	12	2.7	2	HW-F	610612 ●
136	12	2.7	2	HW-F	610614 ●
150	12	2.7	2	HW-F	610616 ●
166	12	2.7	2	HW-F	610680 ●
170	12	2.7	2	HW-F	610620 ●
180	12	2.7	2	HW-F	610621 ●
190	12	2.7	2	HW-F	610625 ●
210	12	2.7	2	HW-F	610627 ●
230	12	2.7	2	HW-F	610629 ●
236	12	2.7	2	HW-F	610679 ●
240	12	2.7	2	HW-F	610631 ●
256	12	2.7	2	HW-F	610681
400	12	2.7	1	HW-F	612016 ●
410	12	2.7	1	HW-F	612017 ●
420	12	2.7	1	HW-F	612018 ●
430	12	2.7	1	HW-F	612019 ●
500	12	2.7	1	HW-F	612022 ●
510	12	2.7	1	HW-F	612023 ●
520	12	2.7	1	HW-F	612024 ●
530	12	2.7	1	HW-F	612025 ●
540	12	2.7	1	HW-F	612026 ●

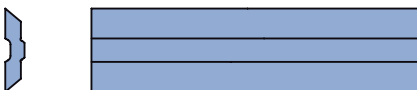


Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Clipboard		◇
MDF		◇

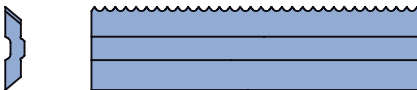
◆ suitable ◇ partly suitable

**Cutting material:**  
HS / HW

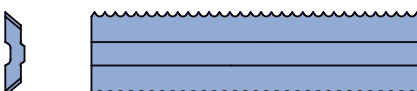
**Cutting material:**  
HW



Turnblade knife VariPlan HS / HW  
resharpenable, for finish cutting of  
softwood and hardwood



Turnblade knife VariPlan HW Integral  
resharpenable, for pre and finish cutting  
softwood and hardwood



Turnblade knife VariPlan HW RipTec  
resharpenable, for pre-cutting softwood  
and hardwood

### Turnblade planing knives VariPlan / VariPlan Plus

For cutterhead system VariPlan / VariPlan Plus

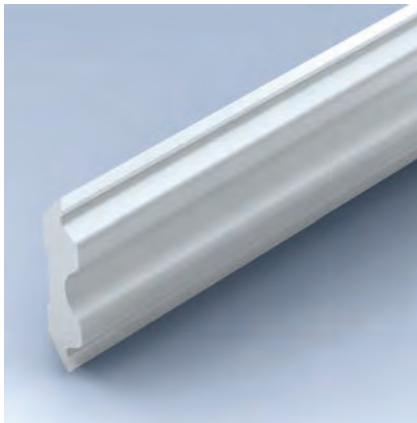
AT 103 0 03, AT 103 0 27

SB mm	H mm	DIK mm	SET PCS	ID Type HS	ID Type HW Microfinish
50	16	3.7	2	610500 □	617100 □
60	16	3.7	2	610501 □	617101 □
80	16	3.7	2	610502 □	617102 □
100	16	3.7	2	610504 ●	617104 □
120	16	3.7	2	610505 ●	617105 □
130	16	3.7	2	610506 ●	617106 ●
150	16	3.7	2	610509 ●	617109 ●
166	16	3.7	2	610571 □	617171 ●
170	16	3.7	2	610511 ●	617111 ●
180	16	3.7	2	610512 ●	617112 ●
190	16	3.7	2	610514 ●	617114 ●
210	16	3.7	2	610515 ●	617115 ●
230	16	3.7	2	610516 ●	617116 ●
236	16	3.7	2	610569 □	617169 ●
240	16	3.7	2	610518 ●	617118 ●
256	16	3.7	2	610572 □	617172 ●
270	16	3.7	2		617165 ●
310	16	3.7	2	610522 ●	617122 ●
330	16	3.7	2		617124 □
360	16	3.7	2		617125 □
400	16	3.7	2	610526 □	617126 □
410	16	3.7	2	610527 ●	617127 □
410	16	3.7	3	610528 □	
420	16	3.7	2	610529 □	617129 □
430	16	3.7	2	610530 □	617130 □
500	16	3.7	2	610533 ●	617133 □
510	16	3.7	4	610562 □	617162 □
520	16	3.7	4	610563 □	617163 □
530	16	3.7	2	610536 □	617136 □
540	16	3.7	2	610537 □	617137 □
600	16	3.7	2	610538 ●	617138 □
610	16	3.7	2	610539 □	617139 □
630	16	3.7	2	610541 ●	617141 □
640	16	3.7	4	610564 □	617164 □

For cutterhead system VariPlan Plus

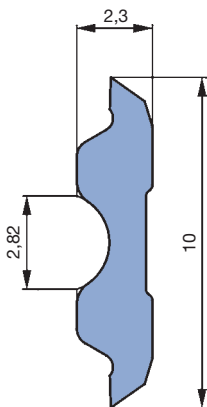
AT 103 0 23, AT 103 0 24

SB mm	H mm	DIK mm	SET PCS	ID Type HW Integral	ID Type HW RipTec
100	16	3.7	2	611904	611204 □
120	16	3.7	2	611905	611205 □
130	16	3.7	2	611906 ●	611206 ●
150	16	3.7	2	611909	611209 ●
166	16	3.7	2		611271 ●
170	16	3.7	2	611911 ●	611211 ●
180	16	3.7	2	611912 ●	611212 ●
190	16	3.7	2	611914	611214 ●
210	16	3.7	2	611915	611215 ●
230	16	3.7	2	611916	611216 ●
236	16	3.7	2		611269 ●
240	16	3.7	2	611918 ●	611218 ●
270	16	3.7	2	611965	611265 ●
310	16	3.7	2	611922	611222 ●



Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Clipboard		◇
MDF		◇

◆ suitable ◇ partly suitable



Turnblade knife MicroTec  
Turnblade knife TriTec

#### Workpiece material:

Softwood and hardwood

#### Cutting material:

HS

Suitable for:

#### Long planerheads

on surface planers and thickness planing machines with centrifugal force clamping system (e.g. SCM, SAC, Panhans, Martin)

#### Cutterheads

with centrifugal force clamping system for 4-sided moulders (e.g. Weinig, SCM, Leadermac)

### Turnblade planing knives TriTec

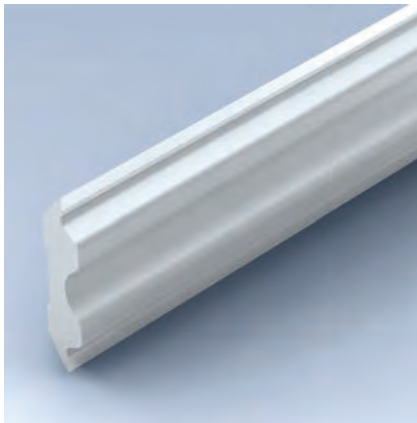
For cutterhead system Tersa, HS

AT 103 0 12

SB mm	H mm	DIK mm	QAL	SET PCS	ID
60	10	2.3	HS	4	610900 □
80	10	2.3	HS	4	610901 □
100	10	2.3	HS	4	610902 ●
110	10	2.3	HS	4	610903 ●
120	10	2.3	HS	4	610904 ●
130	10	2.3	HS	4	610905 ●
140	10	2.3	HS	4	610906 ●
150	10	2.3	HS	4	610907 ●
170	10	2.3	HS	4	610908 ●
180	10	2.3	HS	4	610909 ●
190	10	2.3	HS	4	610910 ●
200	10	2.3	HS	4	610911 ●
210	10	2.3	HS	4	610912 ●
220	10	2.3	HS	4	610913 ●
230	10	2.3	HS	4	610914 ●
240	10	2.3	HS	4	610915 ●
250	10	2.3	HS	4	610916 ●
260	10	2.3	HS	4	610917 ●
265	10	2.3	HS	4	610918 ●
270	10	2.3	HS	4	610919 ●
300	10	2.3	HS	4	610920 ●
310	10	2.3	HS	4	610921 ●
350	10	2.3	HS	4	610922 ●
360	10	2.3	HS	4	610923 □
400	10	2.3	HS	4	610924 ●
410	10	2.3	HS	4	610925 ●
420	10	2.3	HS	4	610926 □
430	10	2.3	HS	4	610927 ●
450	10	2.3	HS	4	610928 □
460	10	2.3	HS	4	610929 □
500	10	2.3	HS	4	610930 ●
510	10	2.3	HS	4	610931 ●
520	10	2.3	HS	4	610932 ●
530	10	2.3	HS	4	610933 ●
600	10	2.3	HS	4	610934 □
610	10	2.3	HS	4	610935 ●
630	10	2.3	HS	4	610936 ●
640	10	2.3	HS	4	610937 ●
660	10	2.3	HS	4	610938 ●
710	10	2.3	HS	4	610939 ●
740	10	2.3	HS	4	610940 □
810	10	2.3	HS	4	610941 ●

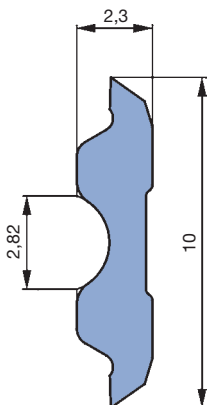
Further dimensions on request.





Cutting material recommendation	HS	HW
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Clipboard		◇
MDF		◇

◆ suitable ◇ partly suitable



Turnblade knife MicroTec  
Turnblade knife TriTec

**Cutting material:**  
HW

**Note:**  
Knives longer than 540 mm are cut into pieces.

Suitable for:  
**Long planerheads**  
on surface planers and thickness planing machines with centrifugal force clamping system (e.g. SCM, SAC, Panhans, Martin)  
**Cutterheads**  
with centrifugal force clamping system for 4-sided moulders (e.g. Weinig, SCM, Leadermac)

### Turnblade planing knives MicroTec

For cutterhead system Torsa, HW  
AT 103 0 12

SB mm	H mm	DIK mm	QAL	SET PCS	ID
60	10	2.3	HW	2	610950 □
80	10	2.3	HW	2	610951 □
100	10	2.3	HW	2	610952 □
110	10	2.3	HW	2	610953 □
120	10	2.3	HW	2	610954 □
130	10	2.3	HW	2	610955 □
140	10	2.3	HW	2	610956 □
150	10	2.3	HW	2	610957 □
170	10	2.3	HW	2	610958 □
180	10	2.3	HW	2	610959 □
190	10	2.3	HW	2	610960 □
200	10	2.3	HW	2	610961 □
210	10	2.3	HW	2	610962 □
220	10	2.3	HW	2	610963 □
230	10	2.3	HW	2	610964 □
240	10	2.3	HW	2	610965 □
250	10	2.3	HW	2	610966 □
260	10	2.3	HW	2	610967 □
265	10	2.3	HW	2	610968 □
270	10	2.3	HW	2	610969 □
300	10	2.3	HW	2	610970 □
310	10	2.3	HW	2	610971 □
350	10	2.3	HW	2	610972 □
360	10	2.3	HW	2	610973 □
400	10	2.3	HW	2	610974 □
410	10	2.3	HW	2	610975 □
420	10	2.3	HW	2	610976 □
430	10	2.3	HW	2	610977 □
450	10	2.3	HW	2	610978 □
460	10	2.3	HW	2	610979 □
500	10	2.3	HW	2	610980 □
510	10	2.3	HW	2	610981 □
520	10	2.3	HW	2	610982 □
530	10	2.3	HW	2	610983 □

Further dimensions on request.



### Turnblade planing knives Centrolock

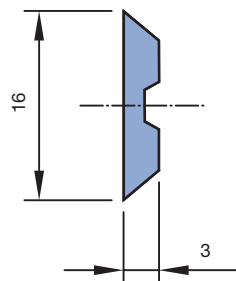
For cutterhead system Centrolock / Easylock

AT 103 0 13

SB mm	H mm	DIK mm	SET PCS	ID HS	ID HW	ID MC
60	16	3	2	611801 ●	611861 ●	611831 ●
80	16	3	2	611802 ●	611862 ●	611832 ●
100	16	3	2	611803 ●	611863 ●	611833 ●
130	16	3	2	611804 ●	611864 ●	611834 ●
150	16	3	2	611805 ●	611865 ●	611835 ●
170	16	3	2	611806 ●	611866 ●	611836 ●
180	16	3	2	611807 ●	611867 ●	611837 ●
190	16	3	2	611808 ●	611868 ●	611838 ●
230	16	3	2	611809 ●	611869 ●	611839 ●
240	16	3	2	611810 ●	611870 ●	611840 ●
260	16	3	2	611811 ●	611871 ●	611841 ●
270	16	3	2	611812 ●	611872 ●	611842 ●
285	16	3	2	611817 ●	611877 ●	611847
310	16	3	2	611813 ●	611873 ●	611843 ●
460	16	3	2	611814 ●		

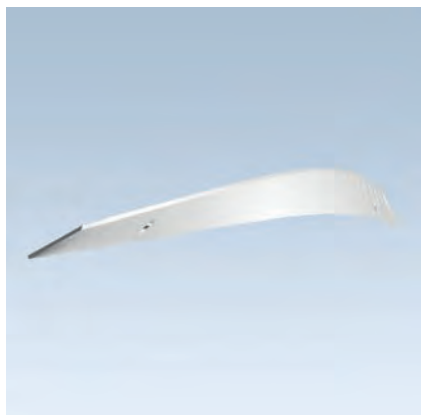
Cutting material recommendation	HS	MC	HW
Solid wood dry	◆	◆	
Solid wood wet	◇	◆	
Hardwood dry		◇	◆
Hardwood wet		◆	◆
Glulam		◆	◆
Clipboard			◇
MDF			◇

◆ suitable ◇ partly suitable



Cutting material:

HS / MC / HW



### Spiral planer knife

One-way knife for spiral long planerhead

TM 101 0

BEZ	SB mm	QAL	ID
HS-Spiral knife, one-way	410	HS	006841 ●
HS-Spiral knife, one-way	420	HS	006910
HS-Spiral knife, one-way	510	HS	006842 ●
HS-Spiral knife, one-way	520	HS	006911 ●
HS-Spiral knife, one-way	610	HS	006843 ●
HS-Spiral knife, one-way	630	HS	006912 ●
HS-Spiral knife, one-way	640	HS	006844 ●

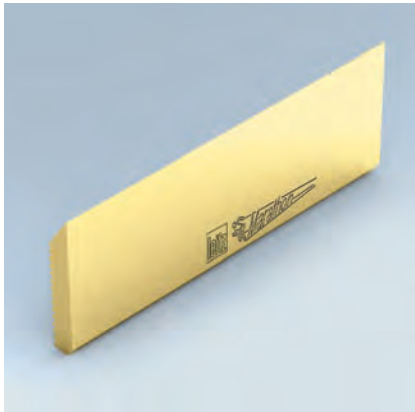
Resharpenable knife for spiral long planerhead

TM 106 0

BEZ	SB mm	QAL	ID
HS-Spiral knife, resharpenable	410	HS	006828 ●
HS-Spiral knife, resharpenable	420	HS	006907
HS-Spiral knife, resharpenable	510	HS	006829 ●
HS-Spiral knife, resharpenable	520	HS	006908
HS-Spiral knife, resharpenable	610	HS	006830 ●
HS-Spiral knife, resharpenable	630	HS	006909 ●
HS-Spiral knife, resharpenable	640	HS	006831 ●

Cutting material:

HS

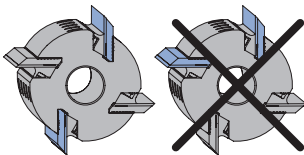
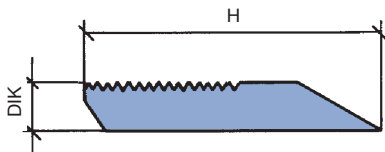


Cutting material recommendation	HS Classic / Premium	MC33	HW
Solid wood dry	◆	◆	◇
Solid wood wet	◇	◆	◆
Hardwood dry	◇	◆	◆
Hardwood wet	◇	◆	◆
Glulam		◇	◇
Thermoplastics (PE, PP, PVC, etc.)	◆	◆	◇
WPC (Wood-Plastic-Composite)	◇	◆	◇

◆ suitable ◇ partly suitable

H	PT
mm	mm
50	15
60	20
70	30

Table to determine maximum profile depth. The profile depth figures are to be regarded as standard values. The maximum profile depth depends on the tool diameter and cutting angle.



#### Attention:

For safety reasons, always mount knives of the same weight in opposite seatings

#### Cutting material:

HS / MC33

The Leitz MC33 cutting material replaces previous design in MC Marathon

### Blank knives with 60° back serration

HS and MC33 blank knives, for profile and hydro profile cutterheads

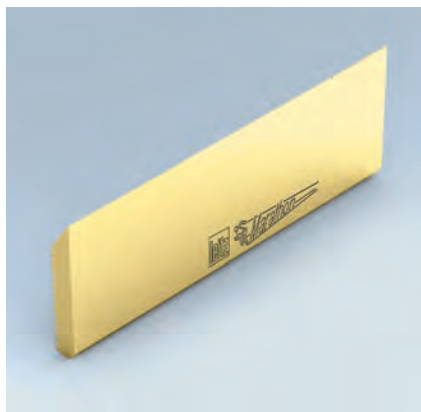
AT 103 0 28, AT 103 0 29

SB	H	DIK	PT <sub>max</sub>	SET	ID	ID
mm	mm	mm	mm	PCS	HS	MC33
40	50	8	15	2	697500	697314 ●
60	50	8	15	2	697501	697315 ●
80	50	8	15	2	697502	697316 ●
100	50	8	15	2	697503	697317 ●
130	50	8	15	2	697504	697318 ●
150	50	8	15	2	697505	697319 ●
170	50	8	15	2	697506	697320 ●
180	50	8	15	2	697507	697321 □
190	50	8	15	2	697508	697322 □
210	50	8	15	2	697509	697323 □
230	50	8	15	2	697510	697324 ●
240	50	8	15	2	697511	697325 ●
260	50	8	15	2	697512	697326 □
270	50	8	15	2	697513	697327 □
310	50	8	15	2	697514	697328 ●
40	60	8	20	2	697515	697329 ●
60	60	8	20	2	697516	697330 ●
80	60	8	20	2	697517	697331 ●
100	60	8	20	2	697518	697332 ●
130	60	8	20	2	697519	697333 ●
150	60	8	20	2	697520	697334 ●
170	60	8	20	2	697521	697335 ●
180	60	8	20	2	697522	697336 □
190	60	8	20	2	697523	697337 □
210	60	8	20	2	697524	697338 □
230	60	8	20	2	697525	697339 ●
240	60	8	20	2	697526	697340 ●
260	60	8	20	2	697527	697341 □
270	60	8	20	2	697528	697342 □
310	60	8	20	2	697529	697343 ●
40	70	8	30	2	697530	697344 ●
60	70	8	30	2	697531	697345 ●
80	70	8	30	2	697532	697346 ●
100	70	8	30	2	697533	697347 ●
130	70	8	30	2	697534	697348 ●
150	70	8	30	2	697535	697349 ●
170	70	8	30	2	697536	697350 ●
180	70	8	30	2	697537	697351 ●
190	70	8	30	2	697538	697352 □
210	70	8	30	2	697539	697353 □
230	70	8	30	2	697540	697354 □
240	70	8	30	2	697541	697355 ●
260	70	8	30	2	697542	697356 □
270	70	8	30	2	697543	697357 □
310	70	8	30	2	697544	697358 □

Set of the same weight.

#### Attention:

Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.



#### Blank knives with 60° back serration

##### HS and MC33 blank knives for cutting to individual cutting width

TC 110 0, TC 110 0 03

SB	H	DIK	PT <sub>max</sub>	ID	ID
mm	mm	mm	mm	HS	MC33
650	38.1	8	5	635003 □	635206 □
650	45	8	10	635004 □	635207 □
650	50	8	15	635000 ●	635203 □
650	60	8	20	635001 ●	635204 □
650	70	8	30	635002 ●	635205 □

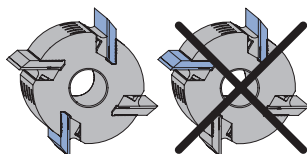
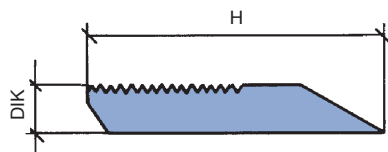
ID = 1 piece.

##### Attention:

Please do not mix new MC33 blank knives with previous MC blank knives in one cutterhead due to weight difference.

Cutting material recommendation	HS	MC 33
Solid wood dry	◆	◆
Solid wood wet	◇	◆
Hardwood dry	◇	◆
Hardwood wet	◇	◆
Glulam		◇
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◇	◆

◆ suitable ◇ partly suitable

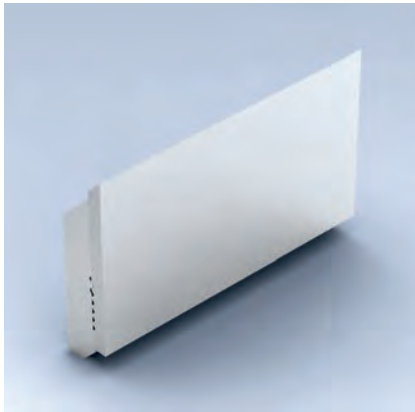


##### Attention:

For safety reasons, always mount knives of the same weight in opposite seatings

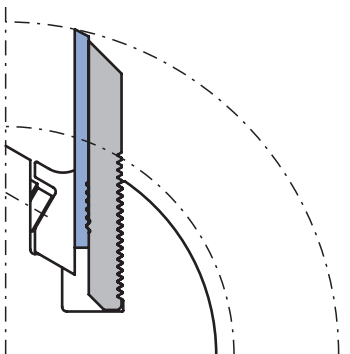
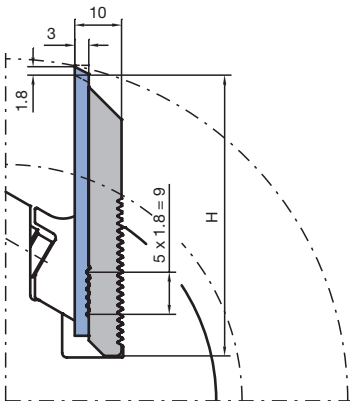
##### Cutting material:

HS / MC33



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	◆	
Solid wood wet		
Hardwood dry	◆	◆
Hardwood wet		◇
Glulam	◇	◆
Chipboard		◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◆	◆

◆ suitable ◇ partly suitable



## Blank knives / backing plates Powerknife System PKS®

For profile and hydro profile cutterheads, PT 15 mm

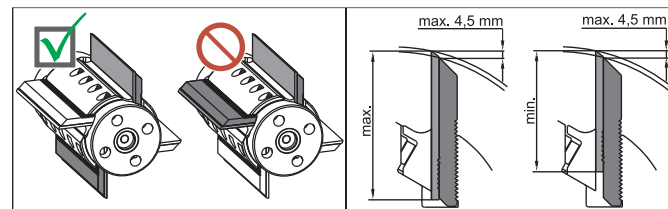
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT <sub>max</sub> mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	50	10	15	2	HW-30F	696642 ●	697842 ●
60	50	10	15	2	HW-30F	696643 ●	697843 ●
80	50	10	15	2	HW-30F	696644 ●	697844 ●
100	50	10	15	2	HW-30F	696645 ●	697845 ●
130	50	10	15	2	HW-30F	696646 ●	697846 ●
150	50	10	15	2	HW-30F	696647 ●	697847 ●
170	50	10	15	2	HW-30F	696648 □	697848 □
180	50	10	15	2	HW-30F	696649 □	697849 □
190	50	10	15	2	HW-30F	696650 □	697850 □
210	50	10	15	2	HW-30F	696651 □	697851 □
230	50	10	15	2	HW-30F	696652 □	697852 □
240	50	10	15	2	HW-30F	696653 ●	697853 ●
270	50	10	15	2	HW-30F	696654 □	697854 □
310	50	10	15	2	HW-30F	696655 ●	697855 ●
40	50	10	15	2	HW-10F	696628 ●	697828 ●
60	50	10	15	2	HW-10F	696629 ●	697829 ●
80	50	10	15	2	HW-10F	696630 ●	697830 ●
100	50	10	15	2	HW-10F	696631 ●	697831 ●
130	50	10	15	2	HW-10F	696632 ●	697832 ●
150	50	10	15	2	HW-10F	696633 ●	697833 ●
170	50	10	15	2	HW-10F	696634 □	697834 □
180	50	10	15	2	HW-10F	696635 □	697835 □
190	50	10	15	2	HW-10F	696636 □	697836 □
210	50	10	15	2	HW-10F	696637 □	697837 □
230	50	10	15	2	HW-10F	696638 □	697838 □
240	50	10	15	2	HW-10F	696639 ●	697839 ●
270	50	10	15	2	HW-10F	696640 □	697840 □
310	50	10	15	2	HW-10F	696641 ●	697841 ●

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.

- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpener area 10.8 mm at maximum profile depth.

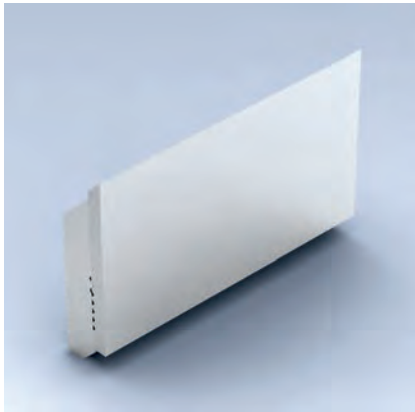


Cutting material:

HW-30F / HW-10F

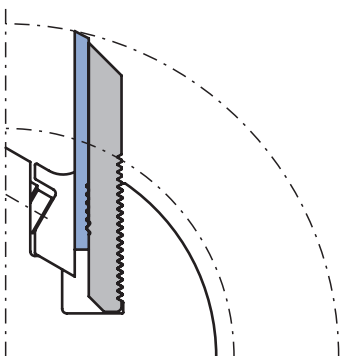
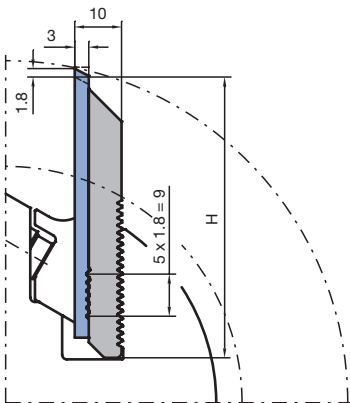
Attention:

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.



Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	◆	
Solid wood wet		
Hardwood dry	◆	◆
Hardwood wet		◇
Glulam	◇	◆
Chipboard		◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◆	◆

◆ suitable ◇ partly suitable



### Blank knives / backing plates Powerknife System PKS®

For profile and hydro profile cutterheads, PT 20 mm

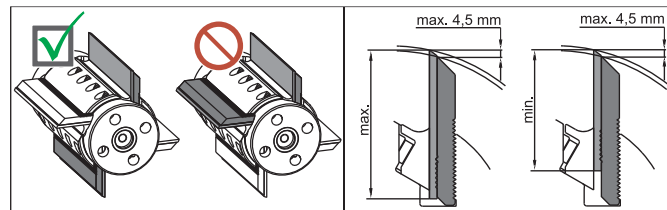
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT <sub>max</sub> mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	60	10	20	2	HW-30F	696670 ●	697870 ●
60	60	10	20	2	HW-30F	696671 ●	697871 ●
80	60	10	20	2	HW-30F	696672 ●	697872 ●
100	60	10	20	2	HW-30F	696673 ●	697873 ●
130	60	10	20	2	HW-30F	696674 ●	697874 ●
150	60	10	20	2	HW-30F	696675 ●	697875 ●
170	60	10	20	2	HW-30F	696676 □	697876 □
180	60	10	20	2	HW-30F	696677 □	697877 □
190	60	10	20	2	HW-30F	696678 □	697878 □
210	60	10	20	2	HW-30F	696679 □	697879 □
230	60	10	20	2	HW-30F	696680 □	697880 □
240	60	10	20	2	HW-30F	696681 ●	697881 ●
40	60	10	20	2	HW-10F	696656 ●	697856 ●
60	60	10	20	2	HW-10F	696657 ●	697857 ●
80	60	10	20	2	HW-10F	696658 ●	697858 ●
100	60	10	20	2	HW-10F	696659 ●	697859 ●
130	60	10	20	2	HW-10F	696660 ●	697860 ●
150	60	10	20	2	HW-10F	696661 ●	697861 ●
170	60	10	20	2	HW-10F	696662 □	697862 □
180	60	10	20	2	HW-10F	696663 □	697863 □
190	60	10	20	2	HW-10F	696664 □	697864 □
210	60	10	20	2	HW-10F	696665 □	697865 □
230	60	10	20	2	HW-10F	696666 □	697866 □
240	60	10	20	2	HW-10F	696667 ●	697867 ●

The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.

- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpener area 10.8 mm at maximum profile depth.



**Cutting material:**

HW-30F / HW-10F

**Attention:**

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.

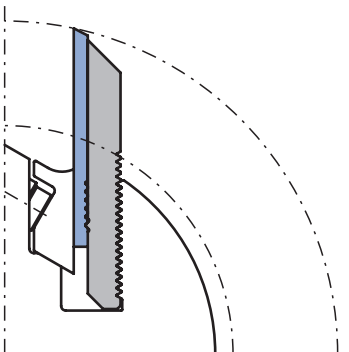
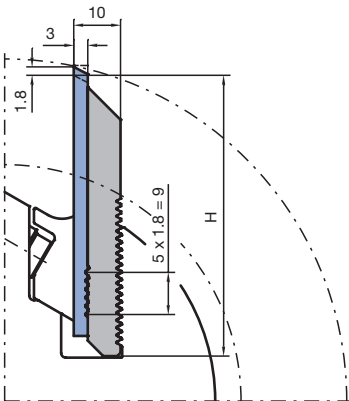
## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.6 Blank knives

Cutting material recommendation	HW-30F jointable	HW-10F not jointable
Solid wood dry	◆	
Solid wood wet		
Hardwood dry	◆	◆
Hardwood wet		◇
Glulam	◇	◆
Chipboard		◆
MDF	◆	◆
Thermoplastics (PE, PP, PVC, etc.)	◆	◆
WPC (Wood-Plastic-Composite)	◆	◆

◆ suitable ◇ partly suitable



**Cutting material:**  
HW-30F / HW-10F

#### Attention:

Maximum knife protrusion above the backing plate 4.5 mm. For safety reasons, only mount knives and backing plates of same weight in opposite seatings.

#### For profile and hydro profile cutterheads, PT 30 mm

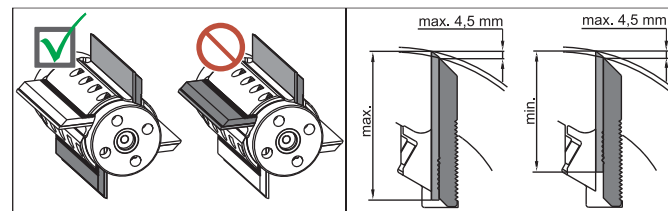
AT 103 0 26, AT 107 0 26

SB mm	H mm	DIK mm	PT <sub>max</sub> mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set with backing plate
40	70	10	30	2	HW-30F	696691 ●	697891 ●
60	70	10	30	2	HW-30F	696692 ●	697892 ●
80	70	10	30	2	HW-30F	696693 ●	697893 ●
100	70	10	30	2	HW-30F	696694 ●	697894 ●
130	70	10	30	2	HW-30F	696695 ●	697895 ●
150	70	10	30	2	HW-30F	696696 ●	697896 ●
40	70	10	30	2	HW-10F	696684 ●	697884 ●
60	70	10	30	2	HW-10F	696685 ●	697885 ●
80	70	10	30	2	HW-10F	696686 ●	697886 ●
100	70	10	30	2	HW-10F	696687 ●	697887 ●
130	70	10	30	2	HW-10F	696688 ●	697888 ●
150	70	10	30	2	HW-10F	696689 ●	697889 ●

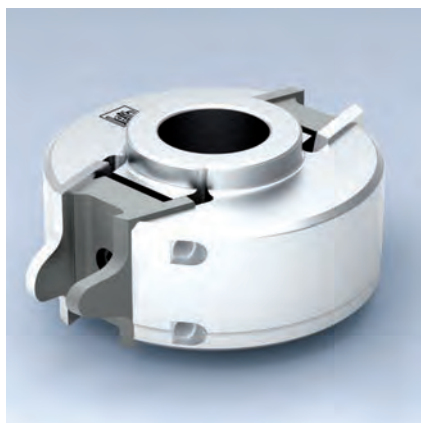
The indicated profile depth values should be regarded as standard values for information. The maximum profile depth depends on the tool diameter and cutting angle.

Set of the same weight.

- Blank knives with polished cutting face for high cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps).
- Knives supported by profiled backing plates.
- Resharpener area 10.8 mm at maximum profile depth.





**Workpiece material:**

Softwood

**Cutting material:**

SP

For multi-purpose profile cutterheads:

WM 502 2

WM 510 1 01

WM 510 1 02

Profiles to scale 1:1 can be found on the  
Leitz Homepage [www.leitz.org](http://www.leitz.org)**Profile knives for multi-purpose cutterheads****Knives**

TM 135 1

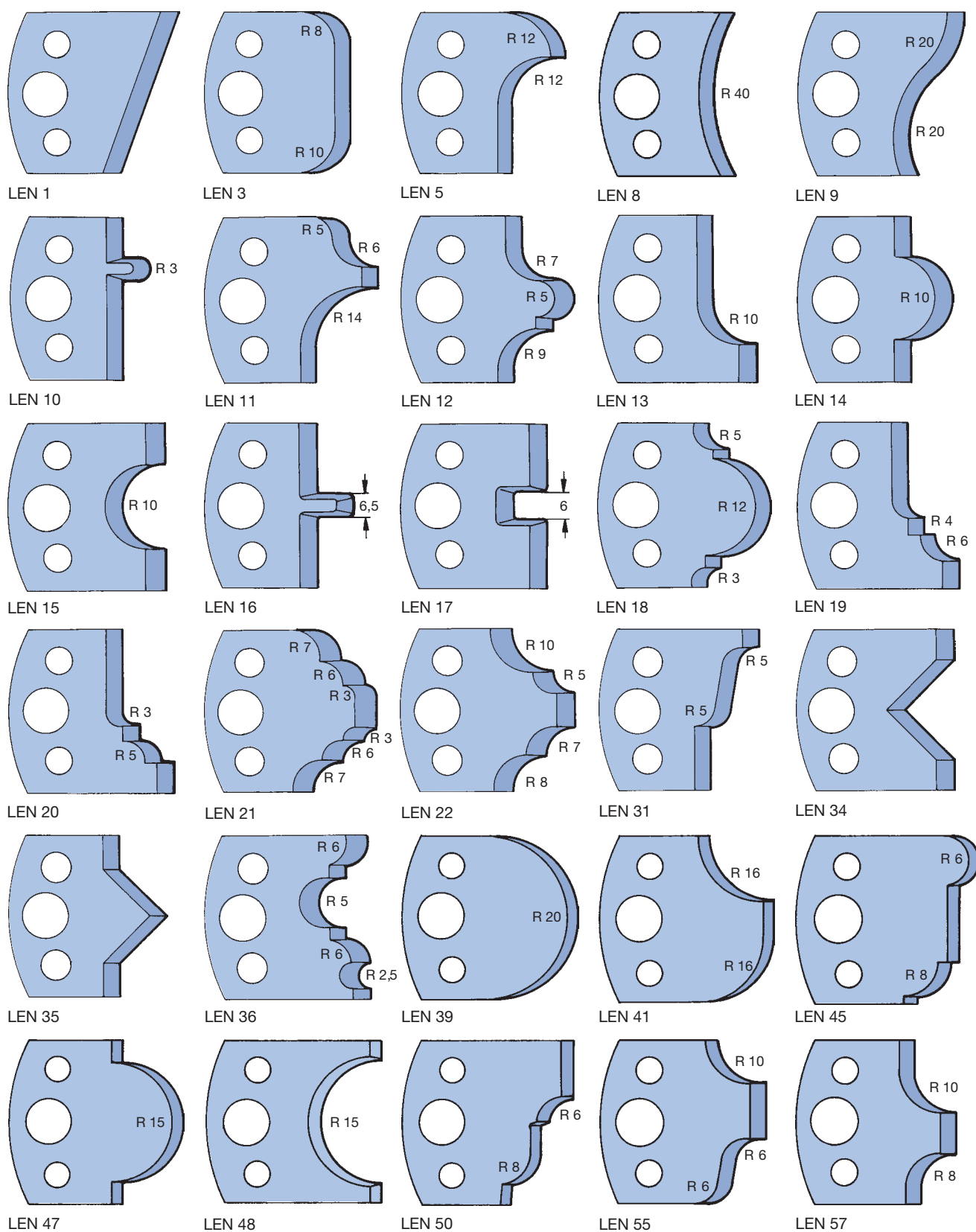
LEN-Profile	ID
1	026101 ●
3	026103 ●
5	026105 ●
8	026108 ●
9	026109 ●
10	026110 ●
11	026111 ●
12	026112 ●
13	026113 ●
14	026114 ●
15	026115 ●
16	026116 ●
17	026117 ●
18	026118 ●
19	026119 ●
20	026120 ●
21	026121 ●
22	026122 ●
31	026131 ●
34	026134 ●
35	026135 ●
36	026136 ●
39	026177 ●
41	026179 ●
45	026183 ●
47	026185 ●
48	026186 ●
50	026188 ●
55	026193 ●
57	026195 ●
58	026196 ●
66	026254 ●
68	026256 ●
75	026263 ●
76	026264 ●
83	690000 ●
84	690001 ●
91	690003 ●
97	690005 ●
127	690007 ●

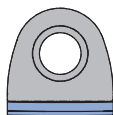
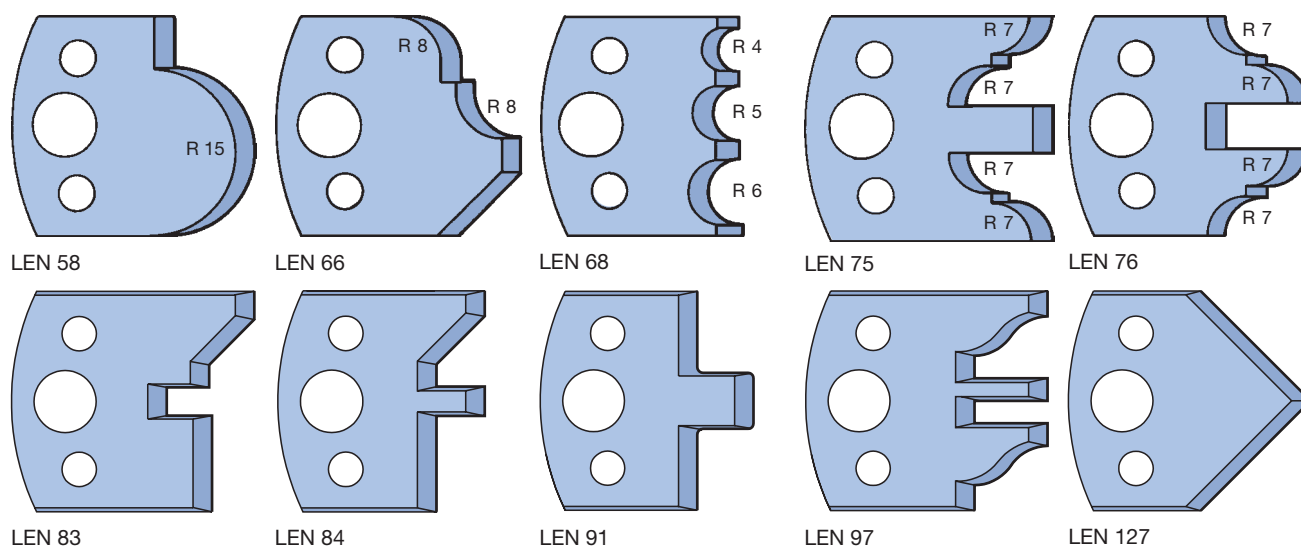
**Limitors**

TA 300 1

LEN-Profile	ID
1	026301 ●
3	026303 ●
5	026305 ●
8	026308 ●
9	026309 ●
10	026310 ●
11	026311 ●
12	026312 ●
13	026313 ●
14	026314 ●
15	026315 ●
16	026316 ●
17	026317 ●
18	026318 ●
19	026319 ●
20	026320 ●
21	026321 ●
22	026322 ●
31	026331 ●
34	026334 ●
35	026335 ●
36	026336 ●
39	026384 ●
41	026386 ●
45	026390 ●
47	026392 ●
48	026393 ●
50	026395 ●
55	026400 ●
57	026402 ●
58	026403 ●
66	026411 ●
68	026413 ●
75	026420 ●
76	026421 ●
83	695000 ●
84	695001 ●
91	695003 ●
97	695005 ●
127	695007 ●

Sold in pairs only.





### WhisperCut DP-edges for hybrid tools

WhisperCut DP-edges; suitable for the combination with the tool systems  
ProfilCut, ProFix, turnblade or HeliPlan

TM 160 0 02, TM 160 0 13

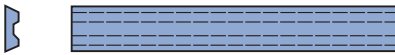
BEM	SB mm	R mm	FAW °	QAL	ID
Jointing	14			DP	091052 ●
Jointing of glued joint*	14			DP	091056 ●
Radius on bottom	14	1.0		DP	091057
Radius on top	14	1.0		DP	091058
Radius on bottom	14	1.5		DP	091059
Radius on top	14	1.5		DP	091060
Radius on bottom	14	2.0		DP	091061
Radius on top	14	2.0		DP	091062
Bevel on bottom	14		45	DP	091063
Bevel on top	14		45	DP	091064

\* = If the knife mounted has a 0° cutting area bevel, it can be used **preferably for glued joints** due to the crown.

## 8. Knives and spare parts

### 8.1 Knives and blank knives

#### 8.1.8 For portable planers and semi-stationary machines



Turnblade knife

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials, glulam

##### Cutting material:

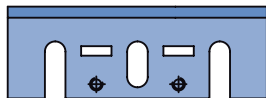
HW

#### Planer knives for portable planers

##### Turnblade knives HW

TM 410 0

Machine	SB mm	H mm	DIK mm	QAL	ID
AEG, Bosch, Festool, Haffner, Holz-Her, Mafell, Metabo, Scheer	75.5	5.5	1.1	HW	<b>005064 •</b>
Elu	80.5	5.9	1.2	HW	<b>005131 •</b>
AEG, Black & Decker, DeWalt, Elu, Mafell, Makita, Metabo	82	5.5	1.1	HW	<b>005066 •</b>



Makita

##### Cutting material:

HS / HW

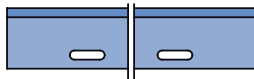
##### Planer knife HS / HW

TM 105 0

Machine	SB mm	H mm	DIK mm	ID HS	ID HW
Makita	82	29	3	<b>027530 •</b>	<b>027598 •</b>



Kity



Metabo



Scheppach

##### Workpiece material:

Softwood and hardwood, chipboard and fibre materials, glulam

##### Cutting material:

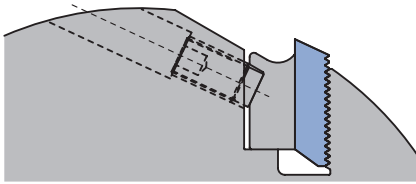
HS

#### Planer knives for semi-stationary machines

##### HS

TM 100 0, TM 105 0

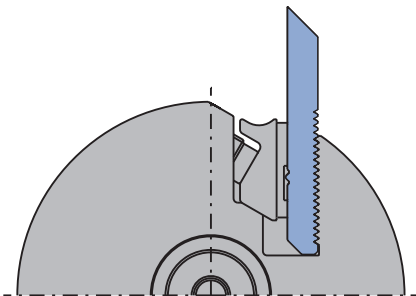
Machine	SB mm	H mm	DIK mm	QAL	ID
Kity	260	20	2.5	HS	<b>027154 •</b>
Metabo	263	20	3	HS	<b>027157 •</b>
Scheppach	260	18	3	HS	<b>027158 •</b>



#### Back-serrated profile cutterheads

Filler pieces for knife thickness 8 - 10 mm  
TD 510 0 05

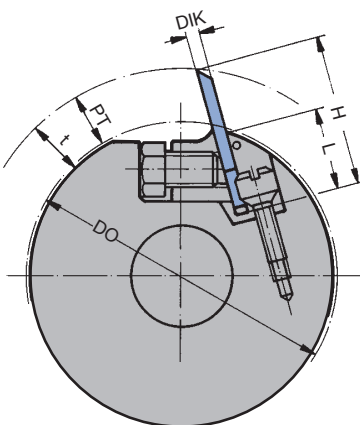
BEZ	for SB mm	ID
Filler piece	40	005305 ●
Filler piece	60	005306 ●
Filler piece	80	005307 ●
Filler piece	100	005308 ●
Filler piece	120	005309 ●
Filler piece	130	005310 ●
Filler piece	150	005311 ●
Filler piece	170	620770 ●
Filler piece	180	005312 ●
Filler piece	190	620772 ●
Filler piece	210	620773 ●
Filler piece	230	005313 ●
Filler piece	240	620771 ●
Filler piece	270	620774 ●
Filler piece	310	620775 ●



Profile cutterhead  
PKS-system

Filler pieces for profiling of PKS-system backing plates  
TF 200 0

BEZ	for SB mm	ID
Filler piece	40	008355 □
Filler piece	80	008356 □
Filler piece	130	008357 □
Filler piece	170	008358 □
Filler piece	210	008359 □
Filler piece	240	008221 ●



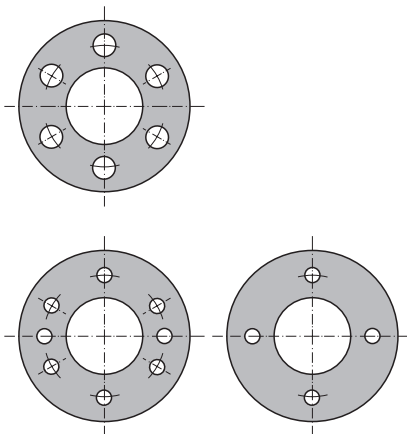
#### Profile cutterhead WM 502 2

Profile cutterhead WM 502 2  
TC 105 0

BEZ	SB mm	QAL	ID
Profile blank knife	40	SP	007601 ●
Profile blank knife	50	SP	007602 ●
Profile blank knife	60	SP	007603 ●
Profile blank knife	40	HS	007284 ●
Profile blank knife	50	HS	007285 ●
Profile blank knife	60	HS	007286 ●

**Workpiece material:**  
Softwood and hardwood

**Cutting material:**  
SP / HS

Spacers with  
6+4 pinholesSpacers with  
4 pinholes**With pinholes****Spacers with 1 pitch**  
TR 100 0

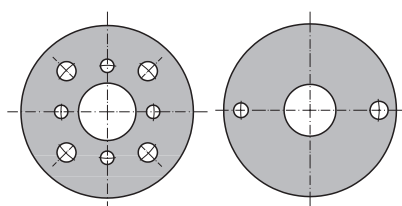
D mm	B mm	BO mm	NLA mm	ID
45	3	20	4/6/32	028088 ●
45	5	20	4/6/32	028089 ●
45	10	20	4/6/32	028090 ●
45	20	20	4/6/32	028639 ●
45	0.1	20	4/6/32	029208 ●
45	0.3	20	4/6/32	029209 ●
45	0.5	20	4/6/32	029210 ●
45	1	20	4/6/32	029211 ●
60	0.1	30	4/7/48	029237 ●
60	0.1	30	6/7/48	027914 ●
60	0.3	30	4/7/48	029238 ●
60	0.3	30	6/7/48	027915 ●
60	0.5	30	4/7/48	029239 ●
60	0.5	30	6/7/48	027916 ●
60	1	30	4/7/48	029240 ●
60	1	30	6/7/48	027917 ●
60	3	30	6/7/48	028580 ●
60	4	30	6/7/48	028581 ●
60	5	30	6/7/48	028582 ●
60	6	30	6/7/48	028583 ●
60	7	30	6/7/48	028584 ●
60	8	30	6/7/48	028585 ●
60	10	30	6/7/48	028586 ●
60	11	30	6/7/48	028587 ●
60	12	30	6/7/48	028588 ●
60	15	30	6/7/48	028589 ●
60	20	30	6/7/48	028591 ●
70	0.1	30	6/7/58	027952 ●
70	0.3	30	6/7/58	027953 ●
70	0.5	30	6/7/58	027954 ●
70	1	30	6/7/58	027955 ●
70	3	30	6/7/58	028599 ●
70	4	30	6/7/58	028600 ●
70	5	30	6/7/58	028601 ●
70	10	30	6/7/58	028605 ●
70	20	30	6/7/58	028608 ●
60	0.1	35	6/7/48	027930 ●
60	0.3	35	6/7/48	027931 ●
60	0.5	35	6/7/48	027932 ●
60	1	35	6/7/48	027933 ●
60	3	35	6/7/48	028592 ●
60	5	35	6/7/48	028594 ●
60	10	35	6/7/48	028598 ●
62	0.1	35	4/7/52	028667 ●
62	0.3	35	4/7/52	028668 ●
62	0.5	35	4/7/52	028669 ●
62	1	35	4/7/52	028670 ●
64	3	35	4/7/52	028671 ●
64	4	35	4/7/52	028672 ●
64	5	35	4/7/52	028673 ●
70	0.1	35	6/7/58	027966 ●
70	0.3	35	6/7/58	027967 ●
70	0.5	35	6/7/58	027968 ●
70	1	35	6/7/58	027969 ●
70	3	35	6/7/58	028609 ●
70	5	35	6/7/58	028611 ●
70	10	35	6/7/58	028615 ●
70	20	35	6/7/58	028616 ●
70	0.1	40	6/7/58	027978 ●
70	0.3	40	6/7/58	027979 ●
70	0.5	40	6/7/58	027980 ●
70	1	40	6/7/58	027981 ●

● available ex stock

□ available at short notice

Instruction manual visit [www.leitz.org](http://www.leitz.org)

D mm	B mm	BO mm	NLA mm	ID
70	3	40	6/7/58	028617 ●
70	4	40	6/7/58	028618 ●
70	5	40	6/7/58	028619 ●
70	6	40	6/7/58	028620 ●
70	7	40	6/7/58	028621 ●
70	8	40	6/7/58	028622 ●
70	10	40	6/7/58	028623 ●
70	12	40	6/7/58	028624 ●
70	15	40	6/7/58	028625 ●
70	20	40	6/7/58	028626 ●
76.5	0.1	50	6/7/65	028005 ●
76.5	0.3	50	6/7/65	028006 ●
76.5	0.5	50	6/7/65	028007 ●
76.5	1	50	6/7/65	028008 ●
77	3	50	6/7/65	028627 ●
77	4	50	6/7/65	028628 ●
77	5	50	6/7/65	028629 ●
77	6	50	6/7/65	028630 ●
77	8	50	6/7/65	028631 ●
77	10	50	6/7/65	028632 ●
77	20	50	6/7/65	028633 ●
90	0.1	60	6/9/75	028020 ●
90	0.3	60	6/9/75	028021 ●
90	0.5	60	6/9/75	028022 ●
90	1	60	6/9/75	028023 ●
90	3	60	6/9/75	028634 ●
90	4	60	6/9/75	028635 ●
90	5	60	6/9/75	028636 ●
90	10	60	6/9/75	028637 ●
90	20	60	6/9/75	028638 ●

Spacers with  
4+4 pinholesSpacers with  
2 pinholes

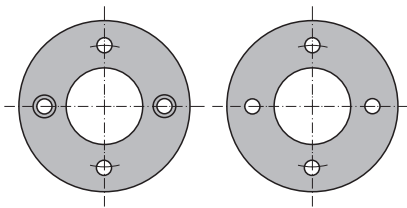
### With pinholes

#### Spacers with different pitches

TR 100 0

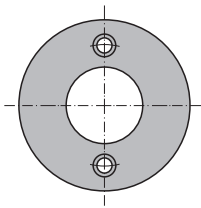
D mm	B mm	BO mm	NLA mm	ID
90	0.1	30	4/7/48	028422 ●
			4/10/60	
90	0.3	30	4/7/48	028423 ●
			4/10/60	
90	0.5	30	4/7/48	028424 ●
			4/10/60	
90	1	30	4/7/48	028425 ●
			4/10/60	
90	3	30	4/7/48	028426 ●
			4/10/60	
90	5	30	4/7/48	028427 ●
			4/10/60	
90	10	30	4/7/48	028428 ●
			4/10/60	
90	20	30	4/7/48	028429 ●
			4/10/60	
100	0.1	30	1/8.5/80	028029 ●
			1/10.5/80	
100	0.3	30	1/8.5/80	028030 ●
			1/10.5/80	
100	0.5	30	1/8.5/80	028031 ●
			1/10.5/80	
100	1	30	1/8.5/80	028032 ●
			1/10.5/80	





Spacers with  
4 pinholes (two of  
them with cylindrical  
countersink)

Spacers with  
4 pinholes



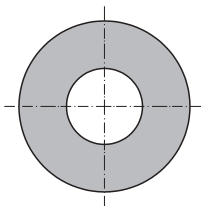
Spacers with 2 pinholes with  
cylindrical countersink

### With pinholes, aluminium

#### Aluminium spacers

TR 100 0

D mm	B mm	BO mm	NLA mm	BEM	ID
60	10	30	2/7/48	2 pinholes with cylindrical countersink	<b>029244 •</b>
64	5	35	4/7/52		<b>029246 •</b>
64	10	35	4/7/52	Cylindrical countersink pinholes	<b>029247 •</b>
64	10	35	2/7/52		<b>029248 •</b>
64	20	35	4/7/52		<b>029249 •</b>



### Without pinholes

#### Without pinholes

TR 100 0

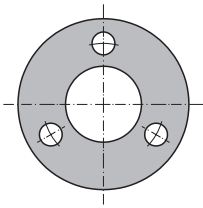
D mm	B mm	BO mm	ID
34	0.1	20	<b>028400 •</b>
34	0.3	20	<b>028401 •</b>
34	0.5	20	<b>028402 •</b>
34	1	20	<b>028403 •</b>
34	3	20	<b>028404 •</b>
34	4	20	<b>028405 •</b>
34	5	20	<b>028406 •</b>
50	0.1	30	<b>027901 •</b>
50	0.3	30	<b>027902 •</b>
50	0.5	30	<b>027903 •</b>
50	1	30	<b>027904 •</b>
50	3	30	<b>027905 •</b>
50	4	30	<b>027906 •</b>
50	5	30	<b>027907 •</b>
50	6	30	<b>027908 •</b>
50	7	30	<b>027909 •</b>
50	8	30	<b>027910 •</b>
50	10	30	<b>027911 •</b>
50	14	30	<b>027912 •</b>
50	20	30	<b>027913 •</b>
60	3	30	<b>027918 •</b>
60	4	30	<b>027919 •</b>
60	5	30	<b>027920 •</b>
60	6	30	<b>027921 •</b>
60	7	30	<b>027922 •</b>
60	8	30	<b>027923 •</b>
60	10	30	<b>027924 •</b>
60	11	30	<b>027925 •</b>
60	12	30	<b>027926 •</b>
60	15	30	<b>027927 •</b>
60	17.5	30	<b>027928 •</b>
60	20	30	<b>027929 •</b>
60	3	35	<b>027934 •</b>
60	5	35	<b>027936 •</b>
60	6	35	<b>027937 •</b>
60	7	35	<b>027938 •</b>

• available ex stock

□ available at short notice

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D	B	BO	ID
mm	mm	mm	
60	8	35	027939 ●
60	10	35	027940 ●
60	0.1	40	027941 ●
60	0.3	40	027942 ●
60	0.5	40	027943 ●
60	1	40	027944 ●
60	3	40	027945 ●
60	4	40	027946 ●
60	5	40	027947 ●
60	6	40	027948 ●
60	7	40	027949 ●
60	8	40	027950 ●
60	9	40	028449 ●
60	10	40	027951 ●
70	3	30	027956 ●
70	4	30	027957 ●
70	5	30	027958 ●
70	6	30	027959 ●
70	7	30	027960 ●
70	8	30	027961 ●
70	10	30	027962 ●
70	12	30	027963 ●
70	15	30	027964 ●
70	20	30	027965 ●
70	3	35	027970 ●
70	4	35	027971 ●
70	5	35	027972 ●
70	6	35	027973 ●
70	7	35	027974 ●
70	8	35	027975 ●
70	10	35	027976 ●
70	20	35	027977 ●
70	3	40	027982 ●
70	4	40	027983 ●
70	5	40	027984 ●
70	6	40	027985 ●
70	7	40	027986 ●
70	8	40	027987 ●
70	10	40	027988 ●
70	12	40	027989 ●
70	15	40	027990 ●
70	20	40	027991 ●
70	0.1	50	027992 ●
70	0.3	50	027993 ●
70	0.5	50	027994 ●
70	1	50	027995 ●
70	3	50	027996 ●
70	4	50	027997 ●
70	5	50	027998 ●
70	6	50	027999 ●
70	7	50	028000 ●
70	8	50	028001 ●
70	10	50	028002 ●
70	15	50	028003 ●
70	20	50	028004 ●
77	3	50	028009 ●
77	4	50	028010 ●
77	5	50	028011 ●
77	6	50	028012 ●
77	8	50	028013 ●
77	10	50	028014 ●
77	20	50	028015 ●
90	3	60	028024 ●
90	4	60	028025 ●
90	5	60	028026 ●
90	10	60	028027 ●
90	20	60	028028 ●
100	4	30	028033 ●



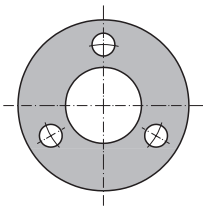
Spacers hardened and high precision for hydro and Hydro-Duo clamping sleeves to fill the clamping length.

### Spacers, hardened and high precision for hydro and Hydro-Duo clamping sleeves

Spacers, hardened and high precision for hydro and Hydro-Duo clamping sleeves

TR 100 0

D	B	BO	NLA	ID
mm	mm	mm	mm	
90	10	60	3/9/75	030684 ●
90	15	60	3/9/75	030685 ●
90	20	60	3/9/75	030686 ●



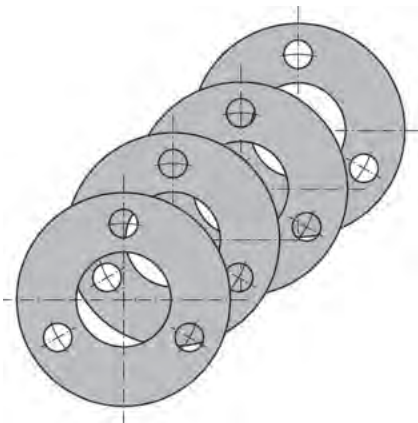
Spacers hardened and high precision for hydro and Hydro-Duo clamping sleeves to fill the clamping length.

### High precision spacers for adjusting tongue and groove cuttersets

High precision spacers for adjusting tongue and groove cuttersets

TR 100 0

D	B	BO	NLA	ID
mm	mm	mm	mm	
90	3.1	60	3/9/75	030687 ●
90	3.3	60	3/9/75	030688 ●
90	3.5	60	3/9/75	030689 ●
90	3.7	60	3/9/75	030690 ●
90	3.9	60	3/9/75	030691 ●
90	4.1	60	3/9/75	030692 ●
90	4.3	60	3/9/75	030693 ●
90	4.5	60	3/9/75	030694 ●
90	4.7	60	3/9/75	030695 ●
90	4.9	60	3/9/75	030696 ●
90	5	60	3/9/75	030697 ●
90	5.1	60	3/9/75	030698 ●



### Spacer sets

Set of standard cutter spindle spacers

AT 100 0 01

D	BO	ID
mm	mm	
50	30	028381 ●
60	40	028382 ●

AT 100 0 01

8 part spacer set with total clamping length 125 mm, surface ground face parallel, spacers black-finished, to DIN 8837

#### Set consisting of:

- 2 pieces: B 5.0 mm
- 2 pieces: B 16.0 mm
- 1 piece: B 8.0 mm
- 1 piece: B 10.0 mm
- 1 piece: B 25.0 mm
- 1 piece: B 40.0 mm

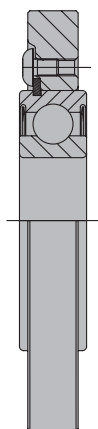


## Ball bearings

### Ball bearings

TL 510 0

BEZ	Type	D mm	D Ring mm	B mm	BO mm	ID
Ball bearing	A	62	min. 85	16	30	<b>008114 ●</b>
Ball bearing	A	62	min. 90	16	31.75	<b>008142</b> □
Ball bearing	B	80	min. 102	18	40	<b>008116 ●</b>
Ball bearing	C	90	min. 112	20	50	<b>008117 ●</b>
Ball bearing	D	110	min. 132	22	60	<b>008118</b>

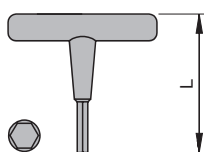


## Guide rings

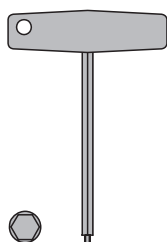
### Guide rings

TR 500 0

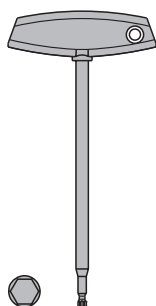
BEZ	Type	D mm	ID
Guide ring	A	85	<b>027826 ●</b>
Guide ring	A	90	<b>027799</b> □
Guide ring	A	100	<b>027800 ●</b>
Guide ring	A	105	<b>027801</b> □
Guide ring	A	110	<b>027802 ●</b>
Guide ring	A	120	<b>027803</b>
Guide ring	A	125	<b>027804 ●</b>
Guide ring	A	130	<b>027805 ●</b>
Guide ring	A	140	<b>027806 ●</b>
Guide ring	A	150	<b>027807 ●</b>
Guide ring	B	105	<b>027808</b>
Guide ring	B	110	<b>027809</b>
Guide ring	B	120	<b>027810</b>
Guide ring	B	125	<b>027811</b>
Guide ring	B	130	<b>027812</b>
Guide ring	B	140	<b>027813</b>
Guide ring	B	150	<b>027814</b>
Guide ring	C	112	<b>027815</b>
Guide ring	C	120	<b>027816</b>
Guide ring	C	125	<b>027817</b>
Guide ring	C	130	<b>027818</b>
Guide ring	C	140	<b>027819</b>
Guide ring	C	150	<b>027820</b>
Guide ring	C	160	<b>027821</b>
Guide ring	D	140	<b>027822</b>
Guide ring	D	150	<b>027823</b>
Guide ring	D	160	<b>027824</b>
Guide ring	D	170	<b>027825</b>



Hexagon key,  
L 75 - 100 mm



Hexagon key, with  
tenon



Hexagon key, for  
quick-change  
sleeve

## Hexagon allen keys

### T-handle without tenon

TH 500 0

ABM mm	L mm	ID
SW 2.5	100	005472 ●
SW 3	75	005444 ●
SW 4	75	005445 ●
SW 6	100	005447 ●

### T-handle with tenon

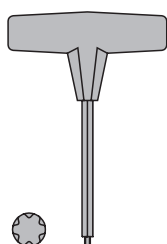
TH 500 0

ABM mm	ID
SW 5	005452 ●
SW 6	005494 ●

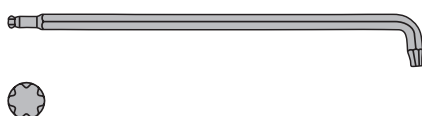
### For quick-change chuck

TH 505 0

ABM mm	L mm	ID
SW 6	240	117516 ●



Torx® key with  
T-handle



Torx® key, 90° angle

## Torx® keys

### T-handle

TH 500 0

ABM mm	L mm	ID
Torx® 8		006093 ●
Torx® 9		005463 ●
Torx® 15	100	005466 ●
Torx® 15	130	117507 ●
Torx® 20	100	006091 ●
Torx® 20	130	117503 ●
Torx® 25	100	005502 ●
Torx® 25	130	117504 ●

### 90° angle

TH 500 0

ABM mm	L mm	ID
Torx® 20	149	117511 ●



## Torque tool set

### TorqueVario®-STplus T-handle torque tool set, 11 parts

AT 199 0

BEZ	BEM	ID
TorqueVario-STplus 5-14 Nm	Bitholder 1/4 inch for bits with drive E 6.3 and C 6.3; Bits of series 7045 Torx and 7043 Hexagon in lengths 70 mm; Torx T 15 - T 20 - T 25; Hexagon SW 4 - SW 5 - SW 6 - SW 8	<b>009103 •</b>

#### Application:

Controlled tightening with predefined torque for changing knife tool systems

#### Design:

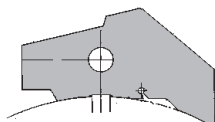
Model 5-14 Nm. Numeric torque indicator in the window scale. Steplessly controlled torque by control tool Torque Setter (included in delivery). Comfortable T-handle with soft zones for optimal torque transmission.

#### Precision:

±6%, based on national standards

#### Extra:

Delivery in stable metal box, incl. test protocol



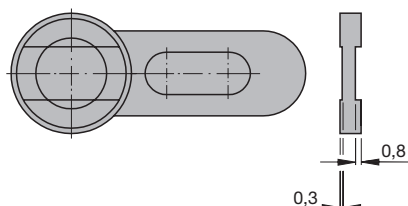
### Setting gauge for hydro planerhead / planerhead wedge-type system

VN 265 0

ABM	ID
mm	
D143	007988 ●
D163	007989 ●
D203	008002 ●

Setting gauge  
0.3/0.8 mm

Setting gauge 1 mm



Magnetic setting gauge 0.3/0.8 mm

### Setting gauge for turnblade

VN 230 0

BEZ	ABM	ID
	mm	
Setting gauge for knives	0.3/0.8	005374 ●
Setting gauge for knives	1.0	005350 ●
Magnetic setting gauge	0.3/0.8	005376 ●

### Mounting device

VN 799 0

BEZ	BEM	ID
Mounting device for SK 30/BT30 with grooves and notches	Not for Biesse	079000 ●
Mounting device for SK40		079001 ●
Mounting device for HSK-F50		079002 ●
Mounting device for HSK-E63 and HSK-F63		079044 ●
Mounting device for SCM/Morbidelli ISO30		079004 ●
Mounting device for CMS ISO30		079005 ●
Mounting device for Alberti HSK-E 40		079006 ●



#### Application:

For the assembly of shank tools in clamping chucks or tools with borehole on arbors with adaptors for automatic tool change

- Reduced risk of injury when mounting tools
- Quick clamping levers and fixing pins secure the clamped taper axially as well as against twisting





### Mounting device

#### Mounting device for tools with HSK 85 / HSK-F 63 adaptor

VN 799 0

BEZ	Machine	l mm	d mm	ID
Mounting device EASY-Hold HSK 85 WS	Weinig	30 - 310	20 - 50	<b>079010 •</b>
Mounting device EASY-Hold HSK-F 63 / HSK-E 63				<b>079009 •</b>

For quick and easy mounting of knives or tools on arbors.

#### Application:

For mounting saws, tools, tool sets and cutterheads



### Mounting device

#### Clamping device for drills with 10 mm shank and clamping flat

VN 799 0

BEZ	ID
Clamping device for drill 10 mm shank	<b>079020 •</b>

#### Application:

For clamping drills (10 mm shank with clamping flat) when altering the length adjusting screw.

#### Advantages:

- reduced risk of injury when mounting the tools
- easy and stable tool clamping during mounting



### Lifting device for large circular saw blades

#### MagneticGrip Lifting device

VZ 999 0

BEZ	BEM	ID
Lifting device	10 kg load capacity	<b>119900 ●</b>
Lifting device	22.5 kg load capacity	<b>119901 ●</b>

For optimal lifting, 2 pcs. are recommended.

#### Application:

For easy lifting of large circular saw blades by means of magnetic power

### Jointing stones for Leitz Marathon planer knife

FS 100 0, FS 199 0

BEZ	Machine	BEM	ABM mm	ID
Jointing stone (angular)	WACO	Colour: brown	20x15x60	<b>008238</b> ●
Jointing stone (round)	Weinig, Leadermac	Colour: grey	12x32	<b>008237</b> ●

Grinding wheels suitable for sharpening Marathon planer knives available on request.



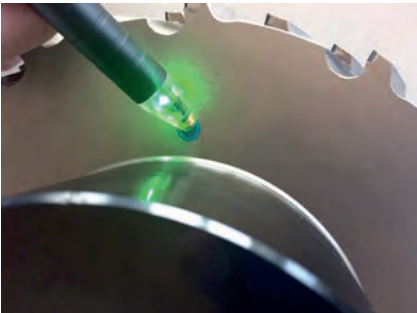
### RFID reader

FZ 999 0		
BEZ	ABM	ID
	mm	
RFID Reader	130x12	081550 ●

#### Application:

For reading data from tools with RFID data chip.

- RFID air interfaces 13,56 MHz
- Standards ISO 15693 and ISO 14443
- Operating distance 0-40 mm
- HOST Interface USB 2.0
- Cable length 1,5 m



## Key to pictograms



	Sawing, multiple cut		Sawing solid transparent plastic		Copy shaping		Slotting		Profiling		Mechanical knife clamping, adjustable - serrated		Resharpenable cutting face
	Sawing, thin kerf		Sawing hollow metal		Rebating		Spiral boring		Profiling joints		Mechanical knife clamping, adjustable - plane		Resharpenable clearance face
	Sawing, horizontal		Sawing crosscut metal		Bevelling		Non-axial boring		Mortising		Constant Mechanical knife clamping, re-sharpenable and constant diameter		Low noise
	Sawing along grain		Scoring, top and bottom		Panel raising		Plug cutting		MEC Mechanical feed		Spindle without twist protection		DFC Optimised chip flow
	Sawing across grain		Scoring, hogging		Profiling		Carving		MAN Manual feed		Spindle with anti-twist keyway		SP Alloyed tool steel
	Sawing, universal		Hogging		Profiling joints		Grooving, sizing		Solid metal tool		Spindle with anti-twist hexagon		HL High-alloyed tool steel
	Scoring, sawing		Double hogging		Profiling tongue and groove		Finish sizing		Tipped tool		Hydro clamping system - open		HS High-speed steel
	Scoring and sawing stacks		Hogging, folding		Planing		Grooving, horizontal and vertical		Heavy Special body alloy		Hydro clamping system - closed		ST Stellite™
	Sawing hollow sections		End trimming		Planing, profiling		Joining		Light Light alloy body		Hydro-Duo (bi-directional) clamping		HW Tungsten carbide
	Sawing, honeycomb panels		Edge trimming		Drilling blind holes		Copy shaping		Inter-changeable knives		Hydro clamping arbors		DP Polycrystalline diamond (PCD)
	Sawing plastic single		Grooving, horizontal and vertical		Drilling, through holes		Rebating		Mechanical knife clamping, reversible		Hydro clamping		DM Monocrystalline diamond (MKD)
	Sawing plastic stacks		Grooving honeycomb panels		Step drilling		Bevelling		Centrifugal knife clamping, reversible		Shrink-fit clamping		Marathon Carbide metal coating
	Sawing hollow transparent plastic		Joining		Counter-sinking		Panel raising		Mechanical knife clamping, non-adjustable		Quick Quick clamping system		Diamond Diamond coating

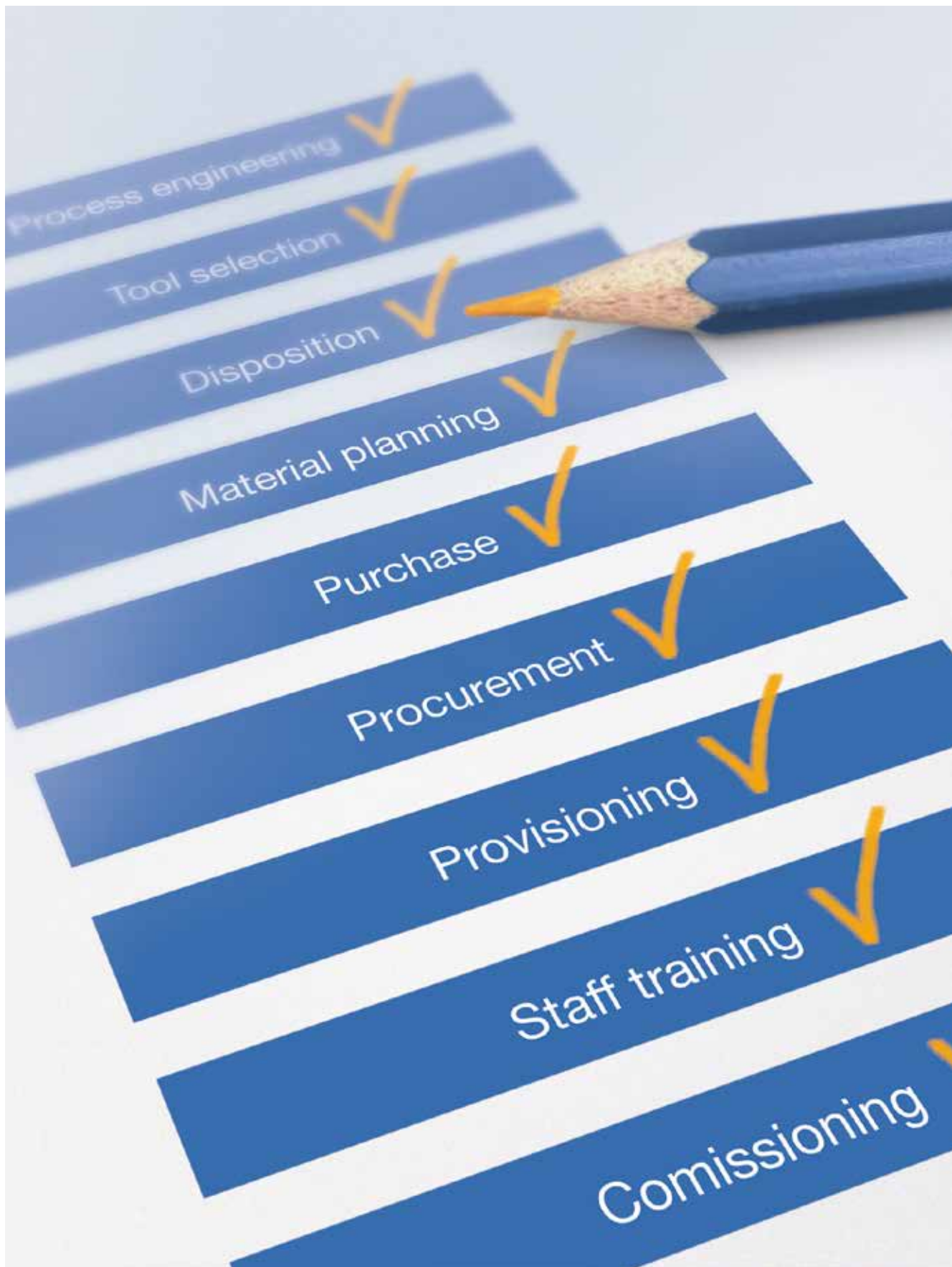


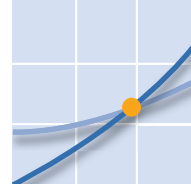
# Services

Leitz Lexicon Edition 7









## 9. Services



9.1 Sharpening of tools

2



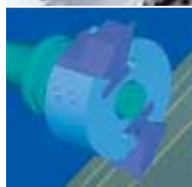
9.2 Tools with data chips

5



9.3 Leitz Tool Management

6



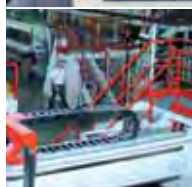
9.4 Technology and process consultancy

8



9.5 Training

9



9.6 Mounting and commissioning tools

10

#### Service in maximum precision



Tools as new – this is based on the philosophy of maximum performance and near perfect processing quality during the total life cycle of our products. Thereby, our tool service plays a decisive role. In compliance with the optimum quality standards, we have brought Leitz Service to achieve absolute precision.

#### Professional maintenance



Used tooling quite often means uneven wear. This sometimes causes damaged or even knife breakage. In this case we repair your tooling exclusively with the original spare parts and original production techniques – result being for tools as good as on the very first day!

#### Uniform quality standards



No matter where in the world you make use of our service, you can rely on our total quality standards. We develop these standards on the basis of intensive research and development in our company headquarters. Therefore we can ensure that all Leitz sites worldwide provide optimal service quality at all times.

#### Tools as new



In our service stations we use the same machinery and programs as in our tool production. Therefore our tools provide consistent top quality and efficiency – whether they are brand new directly from our production plant or resharpened from the service station.

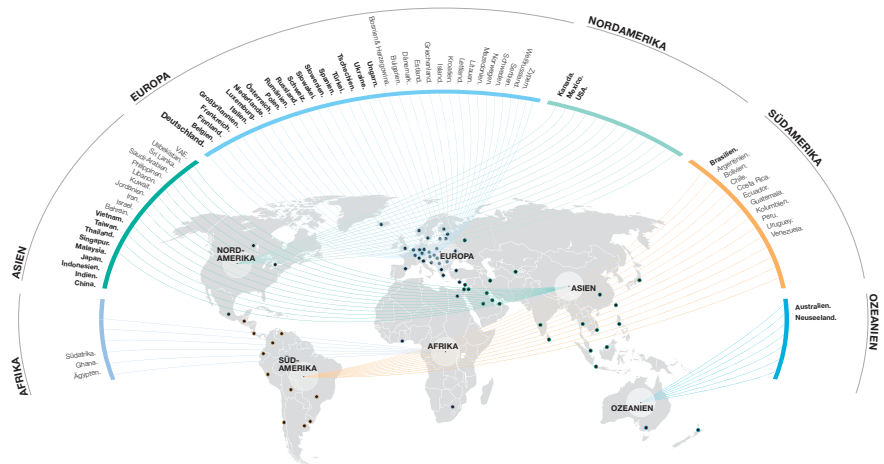


#### Service for all types of tools



Stacking all of the circular saws which we sharpen every year, we would have a tower nearly ten kilometres high. Our service stations not only accept circular saw blades, collectively more than tens of millions of further tools are serviced per year. With that, globally, we are by far the biggest service provider for tools in the wood and plastic processing sectors.

#### Extensive network



Globally we are represented in 36 countries with our own company sites. There are hardly any areas on the planet where we are not close to our customers. In all these countries, we have our own service stations also. Today, more than 100.000 customers trust in Leitz Service – become one of them.

Chip coding



A microchip in the tool or clamping interface is coded with all the relevant tool geometry and safety data. The microchip is identified and read by the machine without contact. Besides reducing set-up time, this technology also improves operating safety.

Chip-coding-hardware

Chip-coding-software and a PC work station are necessary for operation.

Description	ID
Data-transmission-package for Balluff Data chip, consisting of: Read-/write head, power pack and PC-connecting cable	081305 <input type="checkbox"/>
Balluff writing and reading head casing for HSK 63 F interfaces	081324 <input type="checkbox"/>

Chip-coding-software

For coding and decoding data chips

Description	ID
Chip-coding-software	081351 <input type="checkbox"/>

Data-chip-conversion

Description	ID
SK 40 draw bolt with data chip Balluff	081601 <input type="checkbox"/>
Chip-mounting-unit Balluff for bores Ø 12 x 6 for HSK interfaces, 511 Bytes	081309 <input type="checkbox"/>
for HSK interfaces, 2047 Bytes	081330 <input type="checkbox"/>

Data chips mounted by Leitz.

The right tool, the right quantity, the correct quality on time and on site – tasks to be monitored to keep your production running. These non-value-adding activities absorb time and resources, both would be better used on other activities.

When it comes to supplying tools, Leitz has international experience and can give you a customised tool management system. Demand for tools and the money spend on tools are reduced as the tools are easy to locate and replacement tools ordered on time through the automated systems. Controlling the tool life and run time aids tool cost control and process cost calculations.

Use Leitz Tool Management, according to requirements and complexity in different stages.

#### Leitz Tool Management Logistics



Logistics includes IT supported tool management process with Kanban- or consignment store. One of the special features is the access via internet for the customer and Leitz to a common data base. Invoicing is based on either a stock receipt or stock requisition.

**Your advantages:**

- Increased production reliability
- Detailed stock information
- Simple ordering process
- Cost optimisation



#### Leitz Tool Management Life



Life includes invoicing per service cycle and corresponding tool usage. This means a direct link between production quantities and tooling costs.

#### Your advantages:

- No capital commitment for tools
- Very low indirect tool procurement costs
- Tool costs correlate with the production quantity
- High machine availability
- History for each tool

#### Leitz Tool Management CompleteCare



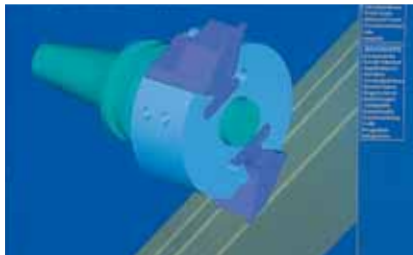
CompleteCare includes the complete package for the whole tool supply from one source. Standardised requirements in high-volume production and invoicing based on per unit produced.

CompleteCare – a package with precise costs so you can concentrate on your core business. Leitz would like to show you our skill in optimising your processes. It's a fact, tooling costs account for less than 1 % of your total costs, but not having the tools available can have a dramatic impact on costs, and these costs are much higher than those of the tools.

#### Your advantages:

- Continuous cost per invoicing period
- Fixed tool costing for the produced product
- Variable tooling costs based on production volume
- Process optimization and continuous technological improvement

CompleteCare is not a short term project but a long-term partnership offering mutual benefits. Many customers worldwide already have positive experience with CompleteCare and benefit from a partnership with us.



Every day our engineers and technicians are faced with varying production challenges. To help you meet these and be competitive in the future, we can show you how to optimise and achieve economic processing solutions. We offer you this service either on projects, specific applications or complete production processes. Of course at all times confidentiality is guaranteed, and the solutions are designed to meet your needs and requirements.

Leitz has the know-how and our engineers make for you proposals for cost and quality improvements.

We will also help raise your employees level of knowledge. Training and training workshops give you and your employees information on the latest developments in woodworking technology. Ask us for our support!



Introduction of innovative methods and tools.

Description	ID
Product workshop – window manufacturing	082200
Product workshop – parquet manufacturing	082201
Product workshop – furniture manufacturing	082202
Product workshop – woodworking	082203
Process workshop – window manufacturing	082204
Process workshop – parquet manufacturing	082205
Process workshop – furniture manufacturing	082206
Process workshop – woodworking	082207
Process optimisation – window manufacturing	082208
Process optimisation – parquet manufacturing	082209
Process optimisation – furniture manufacturing	082210
Extraction systems optimisation	082211

Charges exclude travelling and consultancy costs.



Products and technologies are becoming ever more alike because of the nature of work. Developing competitive advantages today depends more and more on knowledge and motivated employees.

Even so high-tech tools will only perform at their best if used and set up correctly. Part of the Leitz Service program is educating and training customers and their employees in tooling and tooling applications. Training can either be at Leitz or in-house.

In addition to basic information on the technical, design and metallurgical characteristics of tools, advice is given on their suitability for specific applications. Information is also given on expected performance, comparison with other types of tools and cutting materials plus instruction on how to handle and maintain tools.

Many benefits come from the operator training program. It helps them control and monitor the process conditions and parameters, identify factors detrimental to performance and faults that may arise in the process.

Description	ID
Tool application – windows	082100
Tool application – parquet flooring	082101
Tool application – furniture	082102
Tool application – woodworking	082103
Tool handling – window	082104
Tool handling – parquet flooring	082105
Tool handling – furniture	082106
Tool handling – woodworking	082107

Charges exclude travelling and consultancy costs.



There's much work in commissioning a new production line – the investment has been made and you want the return on that investment as quickly as possible.

Tools play a significant part in the success of the project.

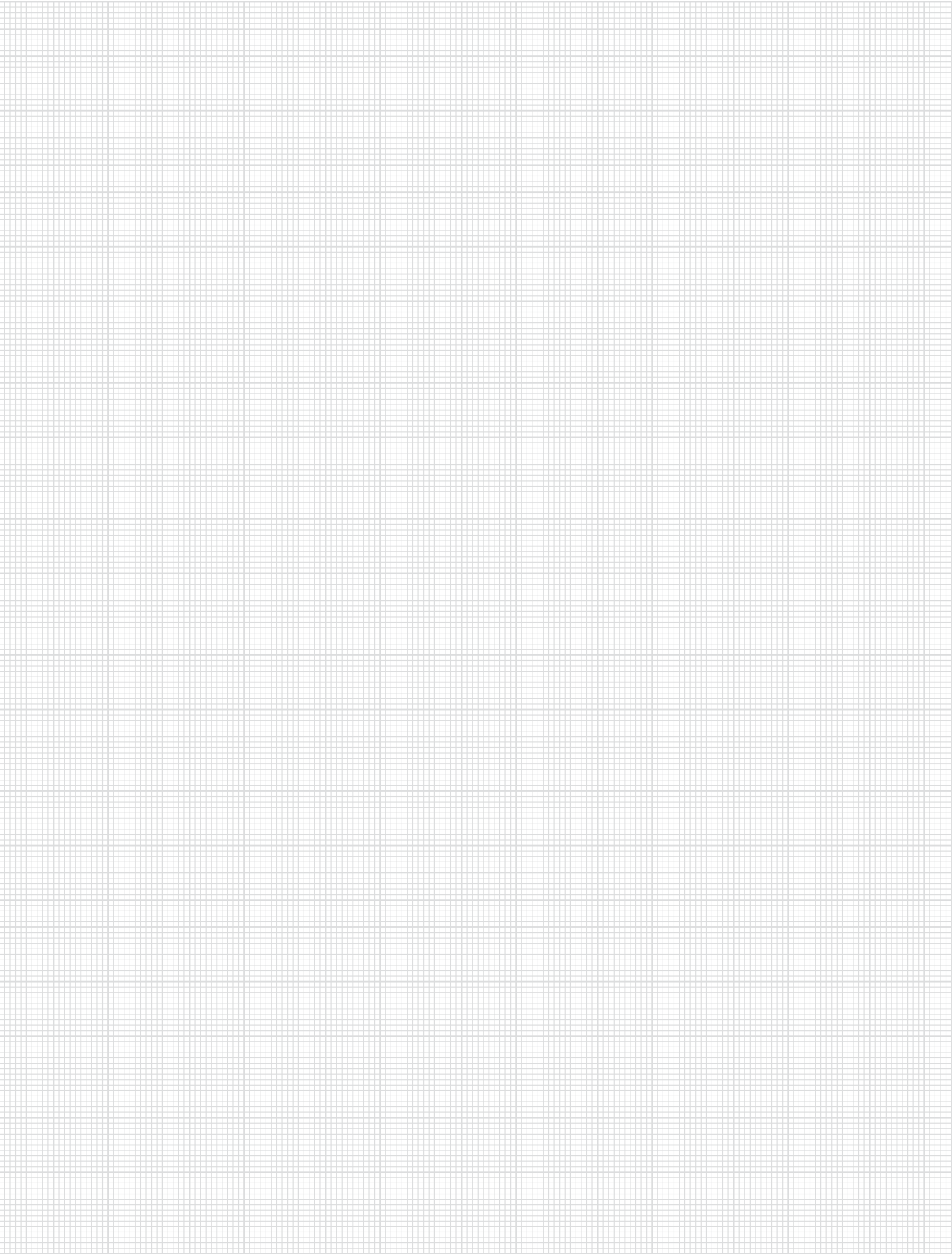
Here Leitz Service can play its part. We will have already supported you when we designed the tools and when the product or production line was run for the first time. This way we ensure you achieve your performance expectations.

You deserve only the best.

Name	ID
Mounting and putting into operation	082400

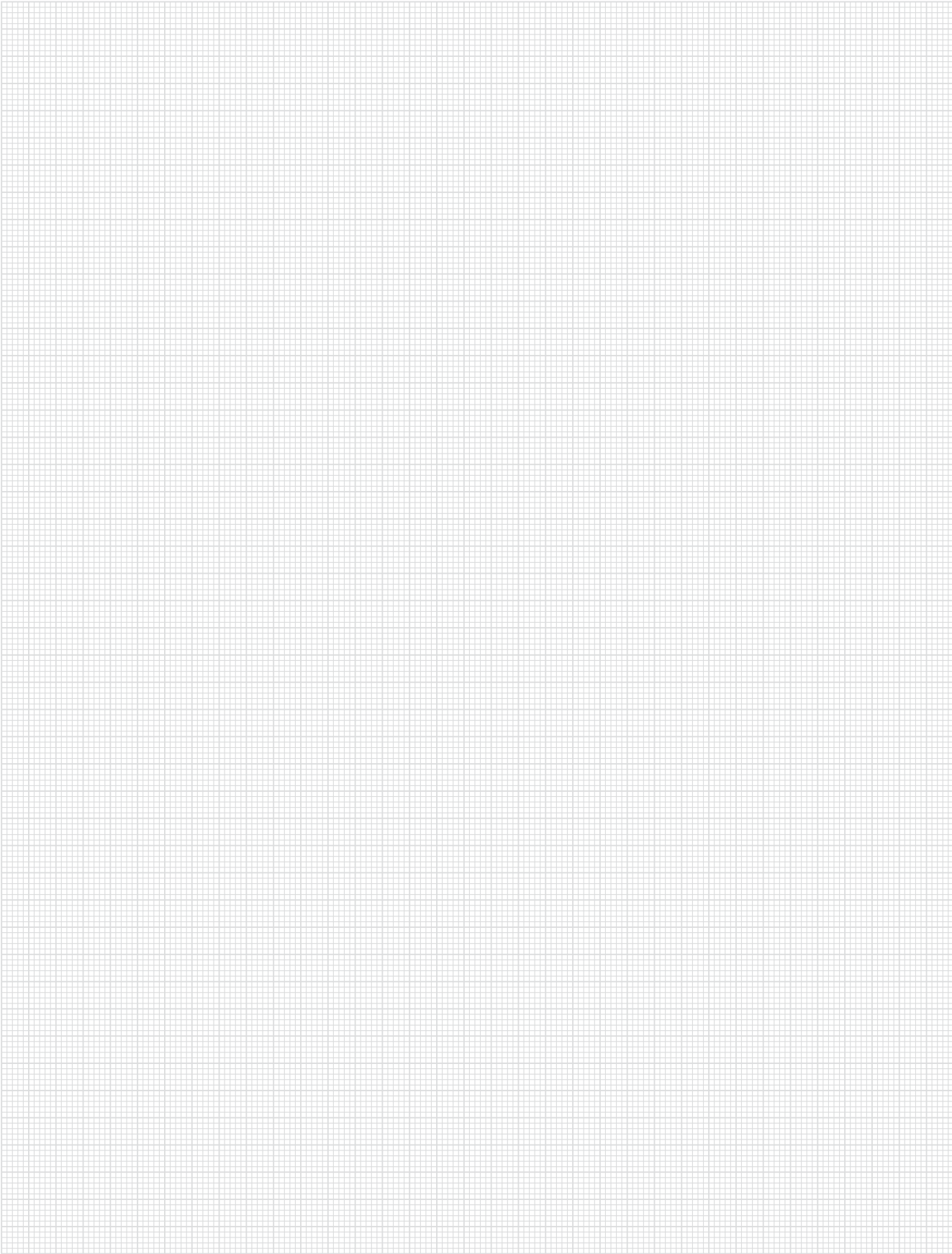
Excluding travel expenses and charges.

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# Profile tool systems

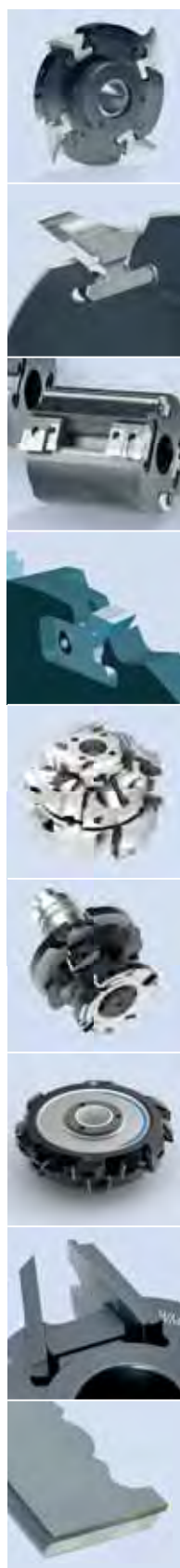
Leitz Lexicon Edition 7







## 10. Profile tool systems



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10.5	VariForm Universal profile tool systems	30
10.6	PowerKnife System PKS®	34

## 10. Profile tool systems

### 10.1 Overview of profile tool systems

#### Profiling with Leitz: The perfect solution for every application

The market requirements for profile tool systems are diverse. On one hand, high numbers of the same parts, on the other small batches of customised products. A company cannot be expected to have a complete tool set for each profile, even less if the tool service life exceeds the life of the profile. The right tools are needed for efficient production. Whether windows, doors, furniture boards or panels – Leitz provides you with the perfect solution for every application.

Field of application and features	ProFix-Plus	ProFix F	ProFix C	ProfilCut Q, ProfilCut Q Premium	ProfilCut Q Diamond	ProfilCut-Plus	Vari-Form	PowerKnife System PKS®
Preferred applications	Furniture, windows, doors, panels, glue-joint profiles	Furniture, windows, glue-joint profiles	Windows, doors	Furniture, windows, doors, panels	Advanced Materials, furniture, windows, doors, panels	Furniture, windows, doors, panels	Furniture, panels	Panels, mouldings
Prototypes, samples, small series							•	•
Small and medium series				•	•	•	•	•
Medium and large series	•	•	•	•	•	•		•
MAN feed for spindle moulders				•	•	•	•	
MEC feed for continuous feed and machining centres	•	•	•	•	•	•	•	•
Multi-purpose profiles	•	•					•	•
High-speed delivery programs for customised profiles				•			•	•
Sharpenable	•	•	•		•	•	•	•
Diameter and constant profile	•	•	•	•	•			
Set tools with staggered cut for processing suitable material	•		•	•	•	•		
Aluminium design	•	•	•	•	•	•		
Combinability with other Leitz tool systems	•	•	•	•	•	•		

#### ProFix-Plus

The high-performance profile tool system for industrial applications. Lowest operating costs for high volumes. Can be resharpened with constant profile and constant diameter. Highly precise repeatable process, hence no adjustment after knife replacement.

#### ProFix F

Combination with planing cutterhead. Free choice of axial position. Multi-purpose tool body.

#### ProFix C

Complementing the sharpenable ProFix-Plus constant tool system for slot and tenon joints and as counter profiles.

#### ProfilCut Q, ProfilCut Q Premium

Multi-functional profile tool system for a perfect finish. Standardised clamping system for profile and turnblade knives.

#### ProfilCut Q Diamond

Combination of an aluminium tool body and sharpenable diamond profile knives with constant diameter.

#### ProfilCut-Plus

Sharpenable version of ProfilCut, but not constant in profile or diameter.

#### VariForm

Modular profile tool system for all applications with excellent value-for-money-ratio. For prototype, individual or small series production.

#### PowerKnifeSystem (PKS®)

The compatible tungsten carbide knife system for multi-purpose cutterheads with serrated back knives.

## 10. Profile tool systems

### 10.2 ProFix constant tool system

#### 10.2.1 ProFix-Plus

**More efficient, more powerful,  
more multi-purpose**

ProFix-Plus is unique worldwide. A system leaving nothing to be desired.

Using the same knives in several tool bodies allows production of exactly the same profile on continuous and stationary machines. The possibility to quickly change any profile in one body enables production of repeat profiles on the same line efficiently.

The construction design principle – resharpenable knives yet with the same profile – make tool dimension measurements and machine setting adjustments unnecessary. Production instead of proving.

ProFix-Plus is a pace-setting solution of the future. Its system variability offers technical, quality and economic advantages in production of panels, doors, windows, staircases and furniture, and interior and external construction.



## 10. Profile tool systems

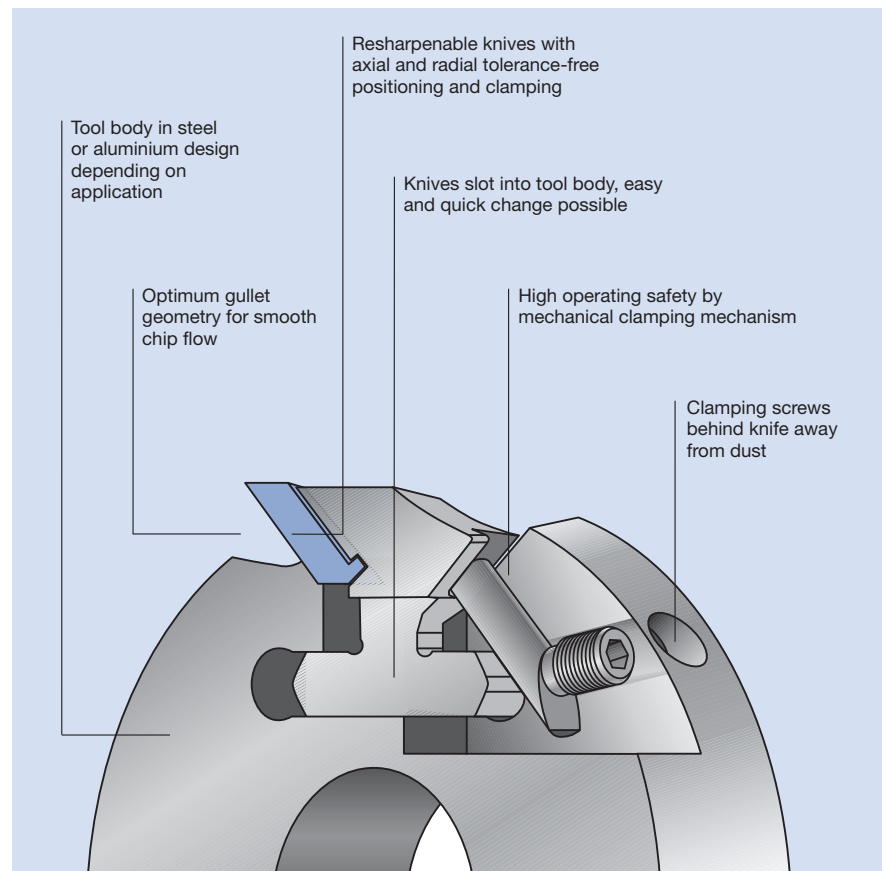
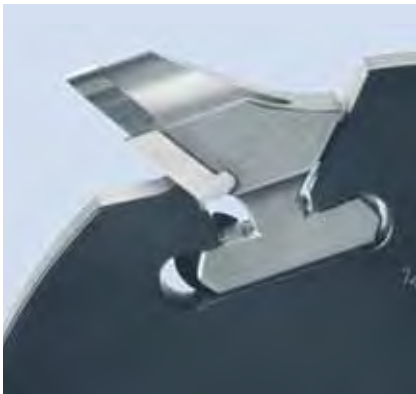
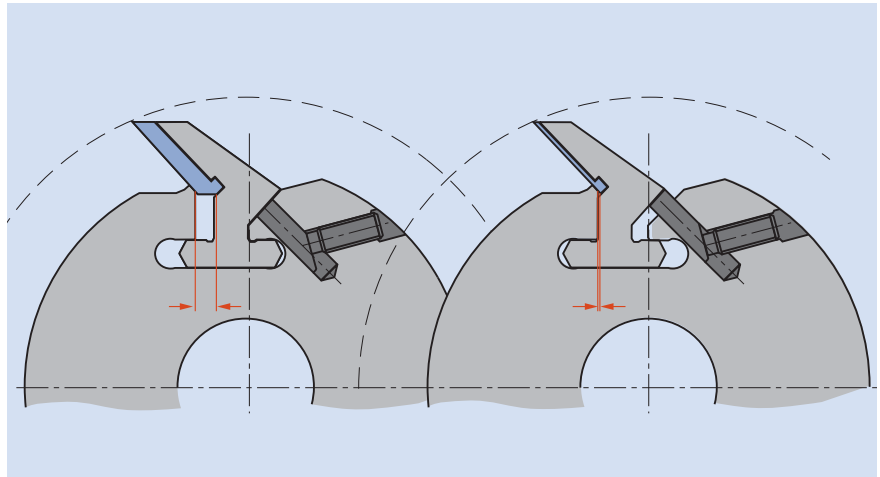
### 10.2 ProFix constant tool system

#### 10.2.1 ProFix-Plus

##### The unique construction design principle

ProFix is different from all other multi-purpose profile tools. Its unique profile and diameter precision are guaranteed, despite repeated sharpening and varying knife thicknesses from the beginning to the end of its life. The patented slot guides the knife to the face stop and is clamped in place when the sharpened knife is inserted into the tool body.

The knives are securely fixed in the tool body T-slot and clamped radially by the centrifugal force.





## 10. Profile tool systems

### 10.2 ProFix constant tool system

#### 10.2.1 ProFix-Plus

##### The exemplary variability...

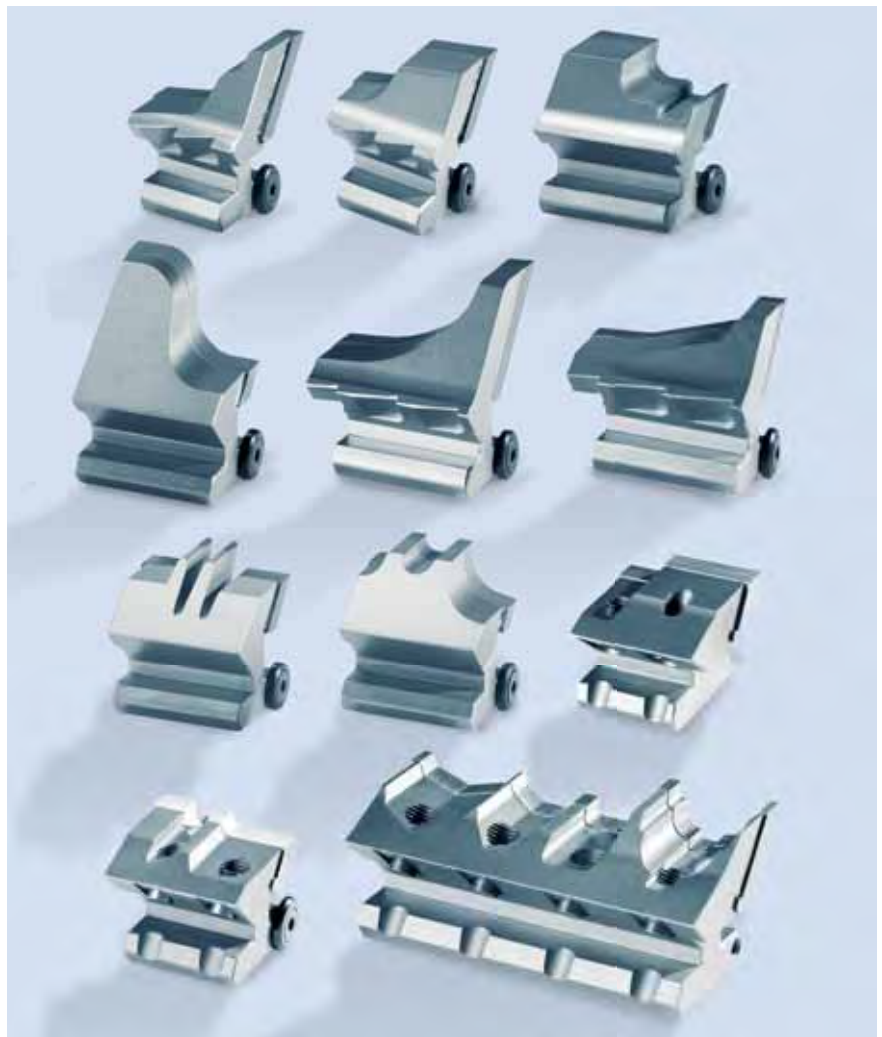
Only a small selection from the wide range of products possible with the modular Profix-Plus system. Same knives with different cutting geometries, used in several tool bodies depending on the type of machine allow for a diversity; no other tool system can offer such high efficiency. The basic principle of technology and multi-purpose and the design spectrum fulfil the customer requirements for cutting geometries and cutting materials matched to the needs of shape and specific materials.

ProFix-Plus enhances the manufacturing options and, at the same time, reduces production processes and set-up times. Last but not least, ProFix-Plus improves the processing quality and increases the overall efficiency.



ProFix knives are available as PF 20 profile depths up to 20 mm, and as PF 25 profile depths up to 25 mm. The cutting widths range from 12 mm to 120 mm. Depending on the application different cutting angles are available:

- 25° for softwood and cross grain processing
- 20° for hardwood and mixed wood processing
- 15° for panel materials and for splintery wood.



## 10. Profile tool systems

### 10.2 ProFix constant tool system

#### 10.2.1 ProFix-Plus

##### ...and easy handling

The ProFix-Plus system is characterised by ease of use and product quality! The advanced ProFix-Plus profile knives give excellent cutting quality. The special Leitz reptile ground finish, with the polished finish cutting face, produces razor-sharp cutting edges.

The knives can be resharpened. No setting gauges or special tools are required to change the knives. Machine corrections, usually necessary after resharpening, are a thing of the past. ProFix operators do not need a projector to measure the tools. Test pieces to check the workpiece dimensions are no longer necessary. Production instead of proving.

Loosen the clamping screw, remove and re-insert the knife. Tighten the clamping screw – the knife change is completed quickly and precisely.



The ProFix-Plus knife for profile depths of 20 and 25 mm. Reptile ground finish and mirror finish cutting face result in razor-sharp cutting edges.



## 10. Profile tool systems

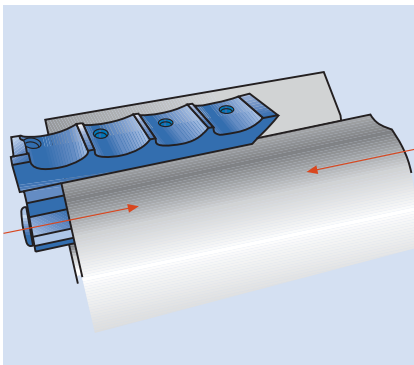
### 10.2 ProFix constant tool system

#### 10.2.1 ProFix-Plus

##### ProFix F – for greater flexibility

The supplement F means increased flexibility. New ProFix profile knives in different tungsten carbide qualities allow for varying cutting widths up to 100 mm in one tool body. Moreover, the profile knives can be positioned any place on the tool body. The profile construction based on a constant zero diameter reduces machine set-up after profile change.

ProFix F is the perfect solution for any four-sided moulder applications, double-ending tenoner or stationary overhead routers with frequently profile changes.



Knife insertion in the machine possible from left or right.



ProFix F incorporates a VariPlan moulding cutterhead, e.g. of manufacturing door frames of different widths etc.

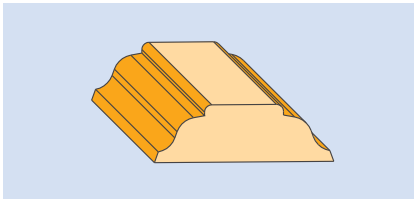
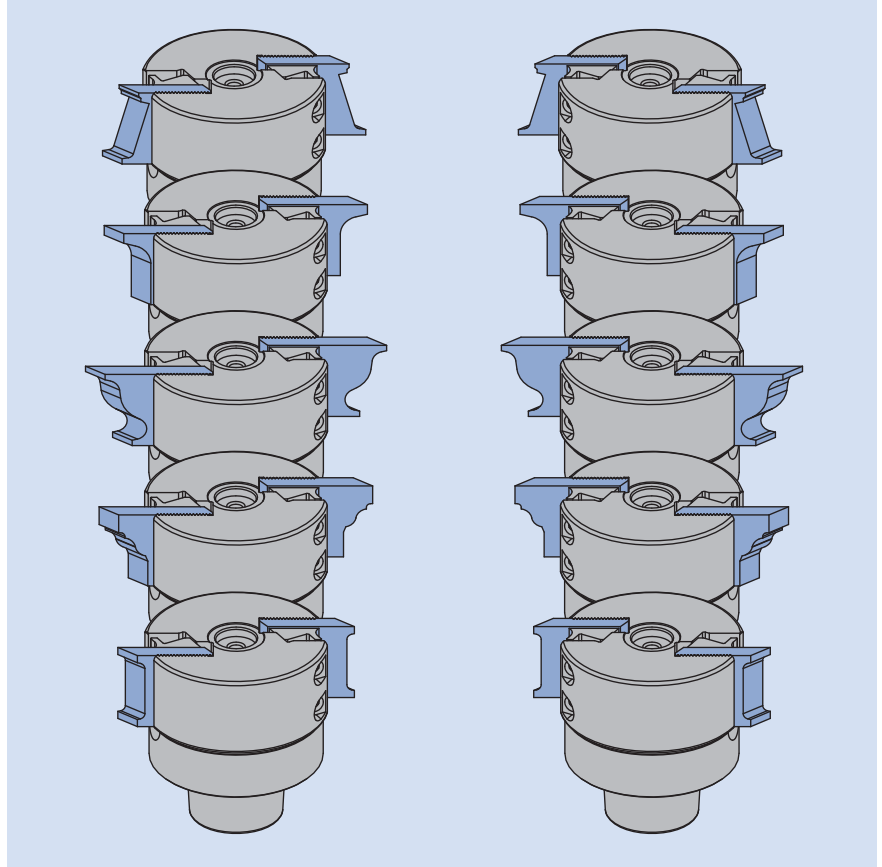
## 10. Profile tool systems

### 10.2 ProFix constant tool system

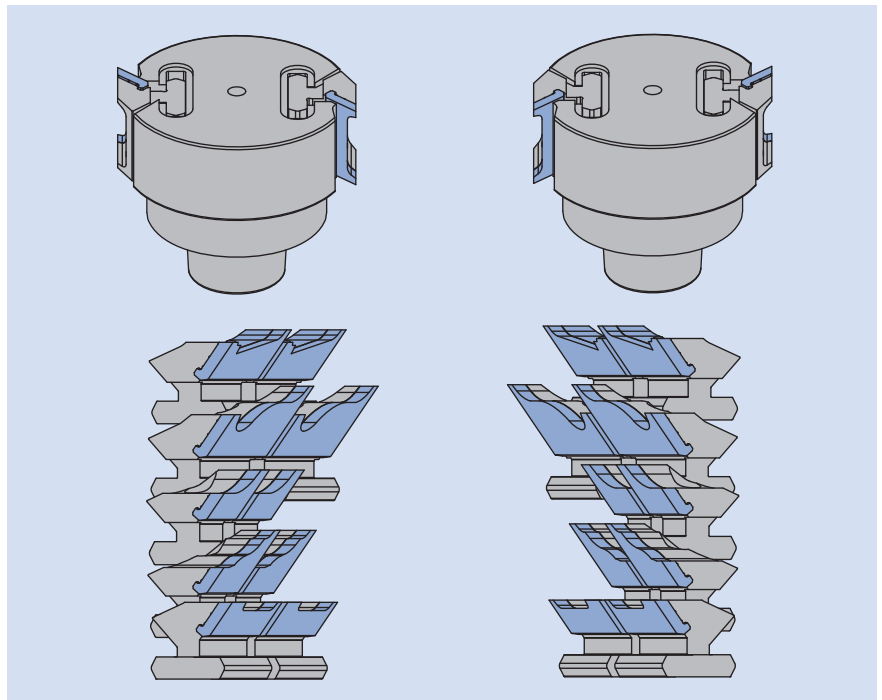
#### 10.2.1 ProFix-Plus

##### ProFix reduces the tool changer

Compared to conventional profile cutterheads made to a unique profile, ProFix reduces the number of tools in the magazine. Only profile knives instead of complete tools are required. The design allows for precise profile replacement in the tool without set-up or measuring.



Example strip production:  
Stockage of ProFix profile knives  
instead of complete profile tools.

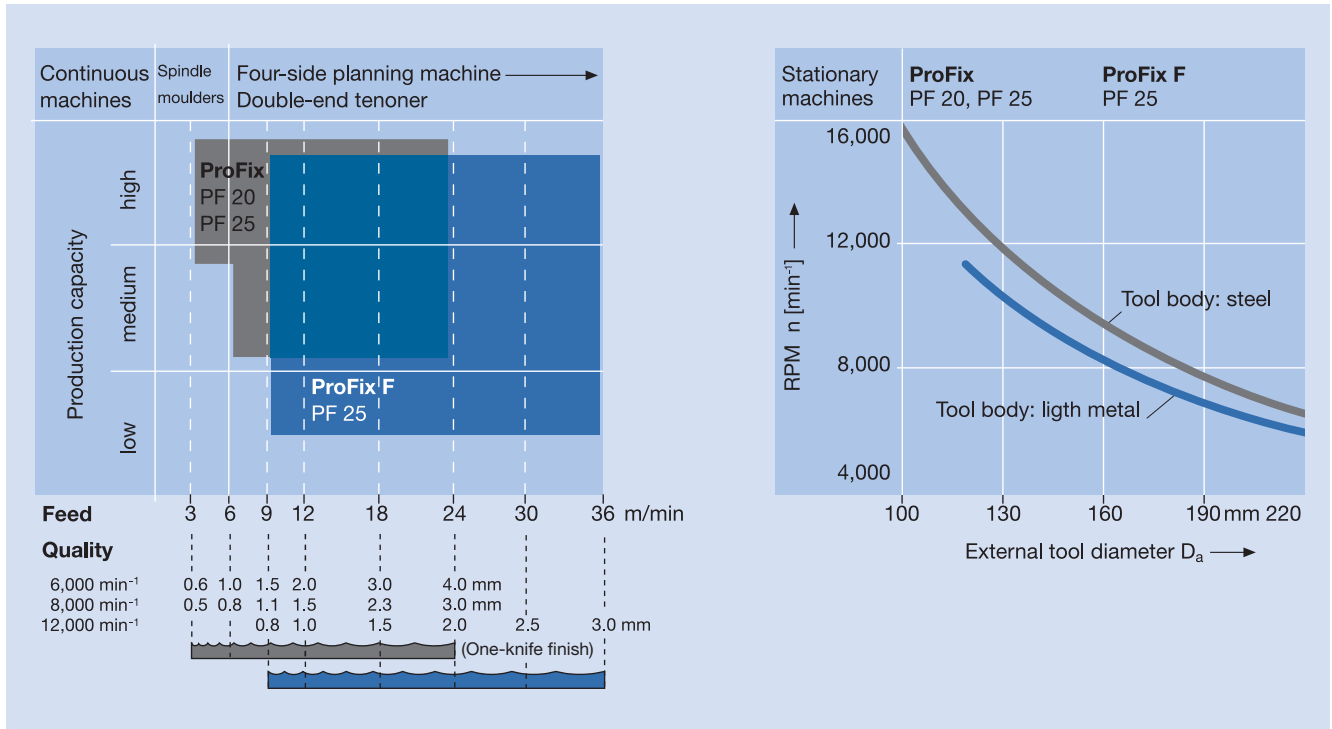


## 10. Profile tool systems

### 10.2 ProFix constant tool system

#### 10.2.1 ProFix-Plus

##### ProFix-Plus Overview



Performance data		ProFix PF 20		ProFix PF 25	ProFix F
	Unit	Tools with shank	Tools with bore	Tools with bore	Tools with bore
Profile depth max.	mm	20	20	25	25
Cutting width min./max.	mm	12-45	12-80	12-100	20-100
Sharpening range	mm	4	4	5	5
Cutting speed max.					
– steel tool body	m/s	80	80	80	80
– aluminium tool body	m/s	–	70	70	70
Concentricity	mm	0.05	0.05	0.05	0.05
Cutting angle min./max.		15°-25°	15°-25°	15°-25°	15°-25°
Shear angle from/to		0°	0°-20°	0°-25°	0°
Side relief angle		0°	0°	0°	0°
Angular knife seating		–	8°	8°	–

##### Applications

For processing all common materials, including solid wood, panels and compound materials, as well as complete synthetic materials.

For producing panels, furniture, doors, windows and staircases interior and external construction.

On all machines, CNC overhead routers and machining centres, four-sided moulders, hydro moulders, double-end tenoners.

##### Special features

Only multi-purpose tool system with resharpenable profile knives and guaranteed profile and diameter constancy.

Repeatable profile manufacture without tool measurement, test cutting or machine adjustment.

High overall efficiency.

## 10. Profile tool systems

### 10.2 ProFix constant tool system

#### 10.2.1 ProFix-Plus

##### The conclusive efficiency ...

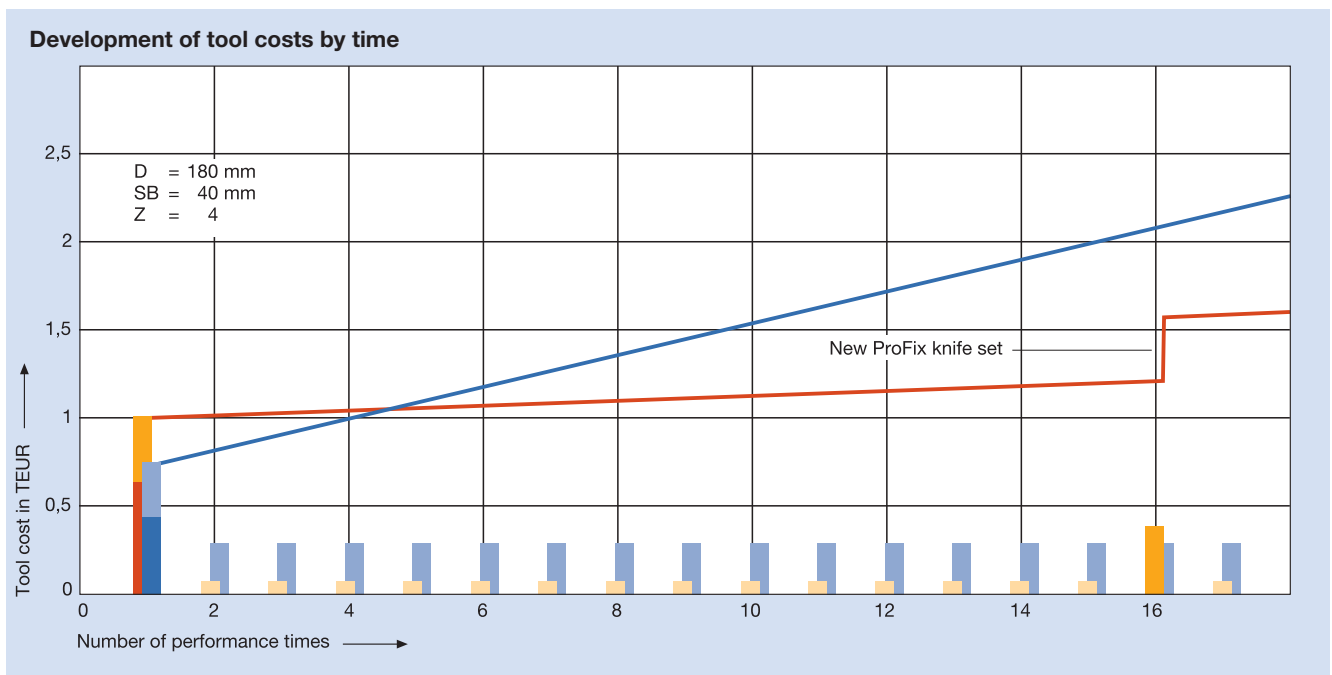
The diagram shows the efficiency of the ProFix-Plus system compared with conventional profile tools without resharpener. Basic features of both tool system are a diameter of 180 mm, a cutting width of 40 mm and 4 knives.

Whilst the conventional profile tools requires 15 replacement tips, ProFix can sharpen fifteen times in the same period. The minimum thickness of the ProFix-Plus knives is generally reached only after the fifteenth sharpening when a new set of knives are required.

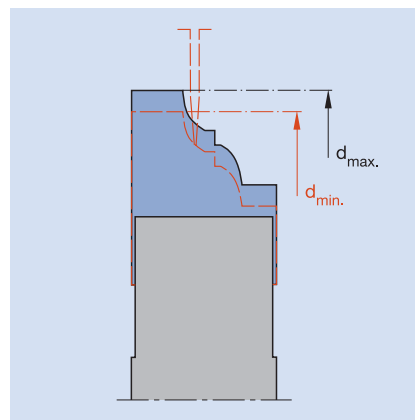
The comparison confirmed in practice, shows a cost reduction of 30 %. Given the increasing competition and pressure on costs, this represents an economic advantage clearly attributed to ProFix-Plus.

ProFix-Plus tool body  
 ProFix-Plus  
 Sharpened knives  
 ProFix-Plus sharpening

Profile cutterhead  
 Replacement profile tips

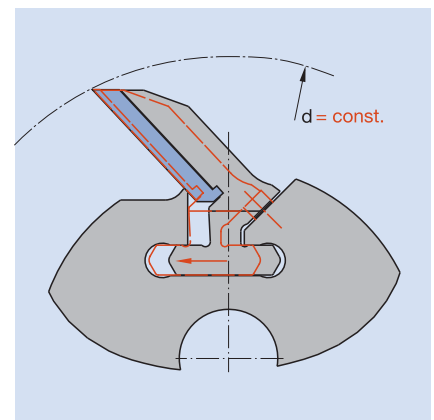


##### Reduction in set-up time with ProFix-Plus by measurement constancy



Conventional profile cutterheads change in profile and diameter after every sharpening

- unproductive set-up time
- Adjustment of spindles
- Test pieces



ProFix-Plus constant tools with memo function for profile and diameter

- measurement constancy for entire service life
- no tool measurement
- production without test pieces



## 10. Profile tool systems

### 10.2 ProFix constant tool system

#### 10.2.1 ProFix-Plus

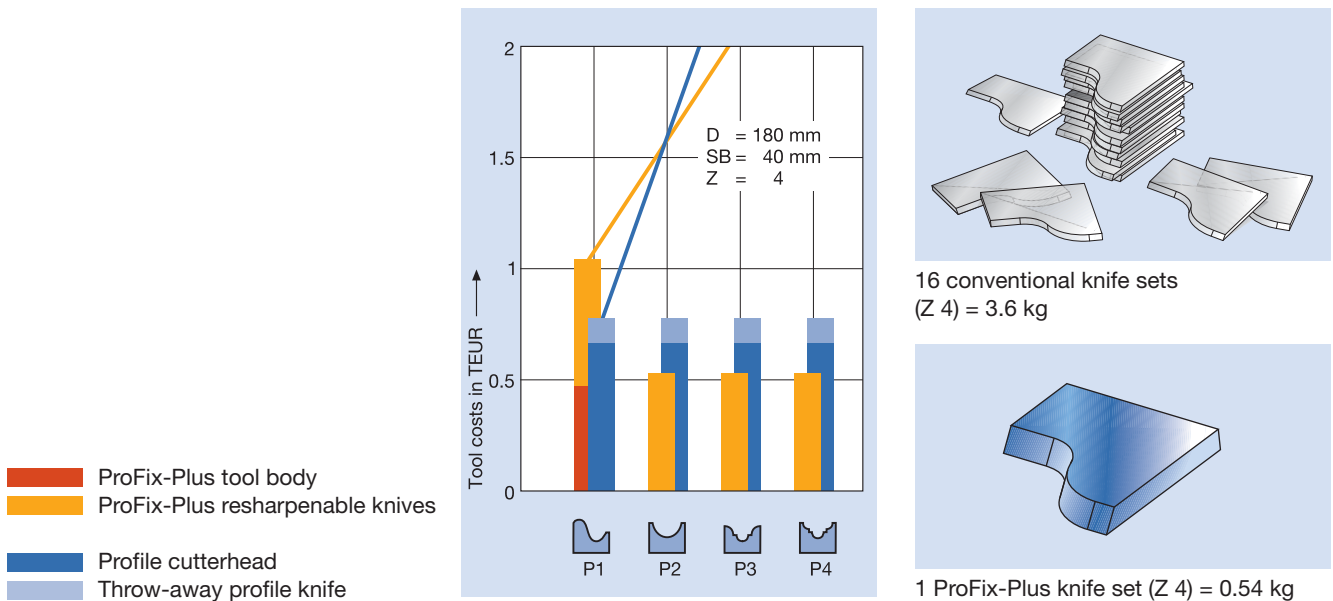
##### Relation of the profile diversity to the tool costs

The same efficiency is achieved by comparing the cost subject to increasing profile diversity. If different profiles are manufactured frequently, not only different knives, but different tool bodies are required for conventional profile tools. This results in significantly higher costs of conventional systems. Already after three different profiles, the investment savings clearly speak in favour of ProFix-Plus and against conventional tools.

##### ... and the environmental compatibility

Last but not least, a comment on the environmental impact. The consumption of high-quality cutting material used in conventional, non-resharpenable tool systems is seven times higher than ProFix-Plus.

And, moreover, if a new tool body is required for each new, non-resharpenable profile, demand for steel or aluminium material increases.



##### All-out efficient!

ProFix is combinable with the throw-away knife system ProfilCut. From this result unbeatable advantages e.g. in the window production: Main profiles with high production quantity or profile areas within a tool which require design freedom, are designed in ProFix. Low-importance profiles with low production quantity are designed in ProfilCut. Thus you don't have to make any compromises regarding to the efficiency.





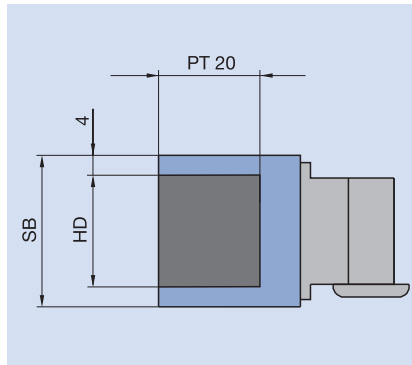
## 10. Profile tool systems

### 10.2 ProFix constant tool system

#### 10.2.2 Range of applications

#### Application information

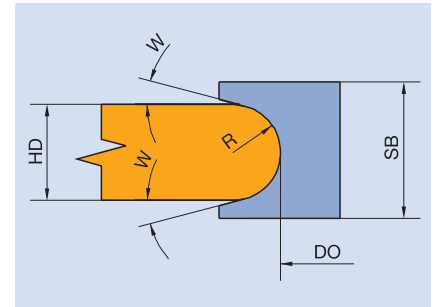
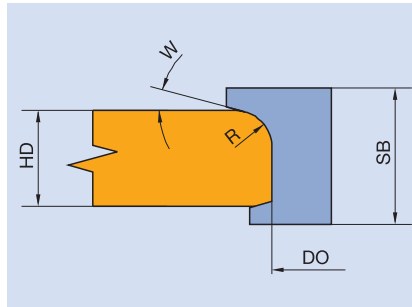
**Example: Usable profile area of ProFix PF 20**



#### Cutting angle

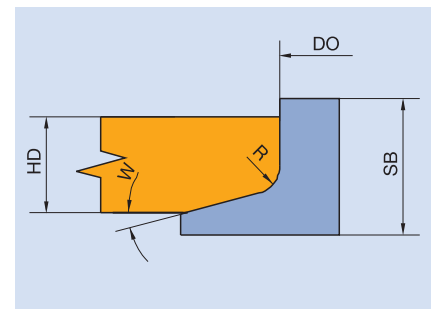
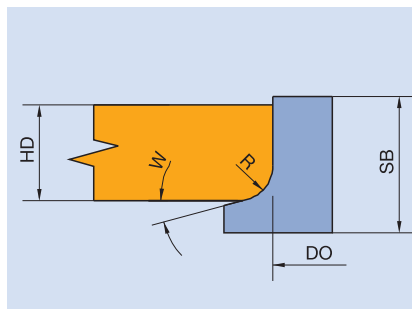
The cutting angle is chosen depending on the machining requirements and the material to be processed.  
Cutting angle 25° for softwood.  
Cutting angle 20° for hardwood.  
Cutting angle 15° for panel materials.

#### Shear angle (chip clearance relief)



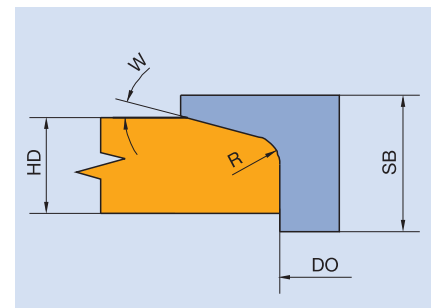
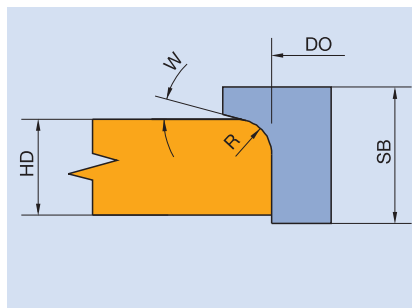
0° shear angle for all closed profiles such as e.g. round profiles, profile relief at least 10°.

#### With shear angle top cutting first



Shear angle top or bottom cutting first for all profiles open on one side with straight jointing edge and profile relief of at least 10°.

#### With shear angle bottom cutting first



## 10. Profile tool systems

### 10.2 ProFix constant tool system

#### 10.2.2 Range of applications

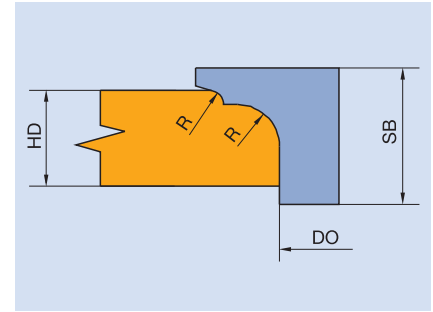
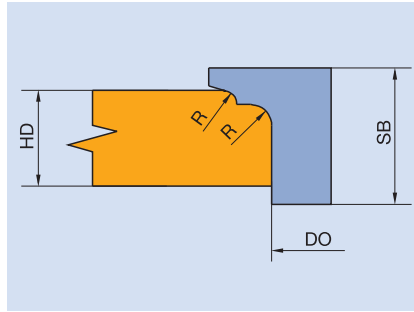
Knife seating 8° inclined,  
bottom cutting

Shear angle and knife seating 8° inclined for all profiles without profile relief.

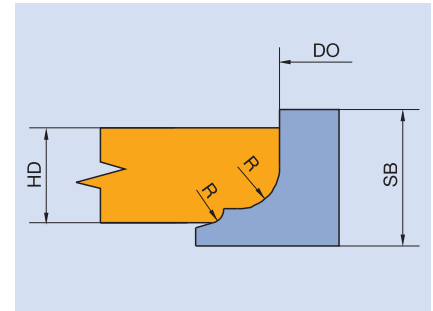
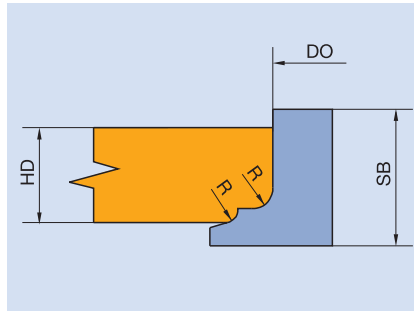
Please note:

ProFix knives do not have a radial lateral clearance angle! The knives are mounted in an inclined position for profiles without lateral profile relief. For closed profiles without profile relief the knives are mounted inclined alternately at the top and at the bottom.

One tool in Z 2 has Z 2 + 2, i.e. 4 knives on the tool periphery.



Knife seating 8° inclined,  
top cutting



Minimum zero diameter depending on  
Z 2 – Z 10

number of teeth	PF 20 with shank	PF 20	PF 25	ProFix S	ProFix F
Z 2	56 mm	80 mm	116 mm	160 mm	100 mm
Z 3		80 mm	116 mm	160 mm	100 mm
Z 4		95 mm	128 mm	160 mm	125 mm
Z 6		150 mm	180 mm	180 mm	170 mm
Z 8		240 mm	300 mm	300 mm	210 mm
Z 10		–	–	–	245 mm

The table applies for one-part tools.

The number of teeth corresponds to the cutting edges mounted in the tool.

Minimum zero diameter depending on  
the tool body bore

bore BO	PF 20	PF 25	ProFix S	ProFix F
20	80 mm	116 mm	160 mm	100 mm
25	90 mm	116 mm	160 mm	105 mm
30	95 mm	116 mm	160 mm	110 mm
40	105 mm	116 mm	160 mm	116 mm
50	120 mm	128 mm	160 mm	128 mm
60	130 mm	140 mm	160 mm	140 mm

Note: The larger of the two diameters indicated in the two tables must be used.

## 10. Profile tool systems

### 10.3 ProFix C constant tool system

#### ProFix C for counter and slot/tenon profiling

An extension to the ProFix constant tool system specially for window construction for slot : tenon and profile : counter profile joints.

The increasing popularity of profile splitting in modern window construction requires tools with constant diameters and constant profiles. As one tool is not used as frequently as another, the tools need to be refurbished at different times. In conventional window constructions with fixed tool sets, a constant slot width helps to ensure a durable long-term joint. Conventional resharpenable tools have the downside of changing diameters and profile widths. This means the machines need to be reprogrammed.

Throwaway knives are often seen as the way out of this dilemma. The new Leitz ProFix C tool system for making slot-tenon and counter profile joints is more beneficial to the resources and budget. ProFix C is resharpenable without any change in dimensions. It offers the trusted advantages of the ProFix-Plus constant tool and completes the system for all steps to profiling in wooden windows and doors.



#### ProFix C System benefits

- Constant cutting diameter and constant profile after resharpening
- Large hook and shear angles – ideal for cross grain
- Optimised gullets for large slotting depths
- Knife cutting widths 8 to 20 mm
- Slotting width  $\geq 10$  mm without spurs
- Other slotting widths possible by exchanging the knives
- Knives can be profiled – profile depth up to 12 mm
- All knife types can be supplied in RipTec design
- HW qualities for all wood types
- HW edge can be resharpened 10 to 12 times
- Used knives can be re-tipped
- Tool body can be supplied in steel or optionally in aluminium
- High rotational speeds for high production

#### ProFix C Standardisation

- Three basic types of knife seatings cover all application cases
- Modular structure with standardised knife types enables a tool structure matching the profile and direction of wood fibre

## 10. Profile tool systems

### 10.3 ProFix C constant tool system



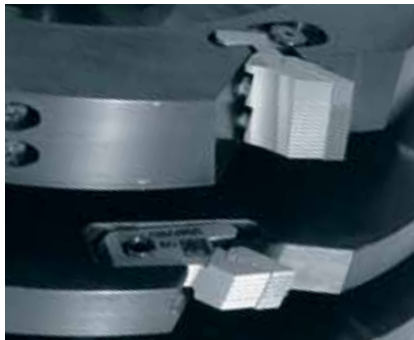
With shear angle and lateral clearance angle.



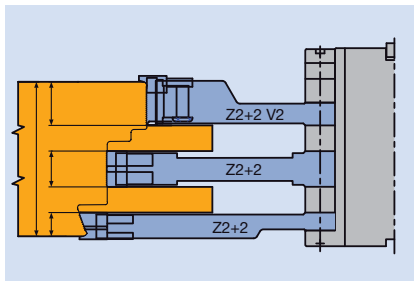
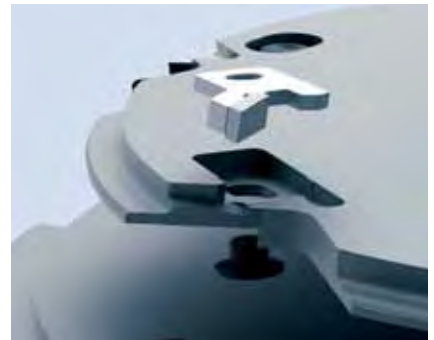
With advanced shear angle outside.



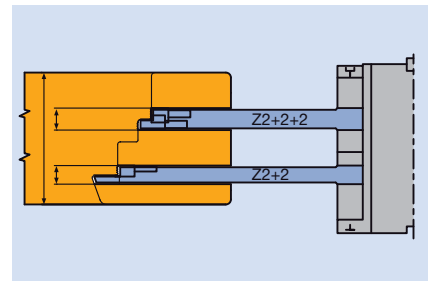
Profile knife with advanced shear angle inside.



Combination of ProFix and ProFix C knives in the same tool.  
Example: Knives with RipTec profile for improved joints.



Application example ProFix C „frame tenon for top of jambs“: Cutting edges in RipTec design for improved quality of cut in cross grain.  
Combination of ProFix knives for large cutting widths in the rail area.



Application example ProFix C „frame slot-cross“: Slot widths from 8 to 20 mm.  
No spurs are required for slot widths of 10 mm.

## 10. Profile tool systems

### 10.4 ProfilCut throwaway knives

#### 10.4.1 ProfilCut Q

**For a better performance – the system with an unbeatable variety**

When cutting quality matters, the cutter head system ProfilCut Q is setting the standard. It exceeds all expectations, even for the most extraordinary profiling requirements. ProfilCut Q delivers precision results whether in the bespoke or industrial manufacturing of windows, doors or furniture production. With many possible applications and its guarantee of reliability, companies can increase profitability and take the lead in their market sectors.

ProfilCut Q has a diameter range from 0 to 650 mm. The uniform clamping system is designed for exchangeable knives and turnblades. Its light weight is a big advantage of the system.

With a lightweight aluminium supporting body, its effectiveness at high cutting speed is always guaranteed.

The knives are positioned form-fitting in the centrifugal force direction. The tightening of the clamping screws automatically secures an axial and radial centering, resulting in a zero-tolerance fitting. ProfilCut Q is a technical innovation which delivers substantially enhanced surface-quality and reduction of rejects and rework. Matching the profile, the clamping wedges and the guiding elements conduct chip removal, which contributes to a perfect finish.

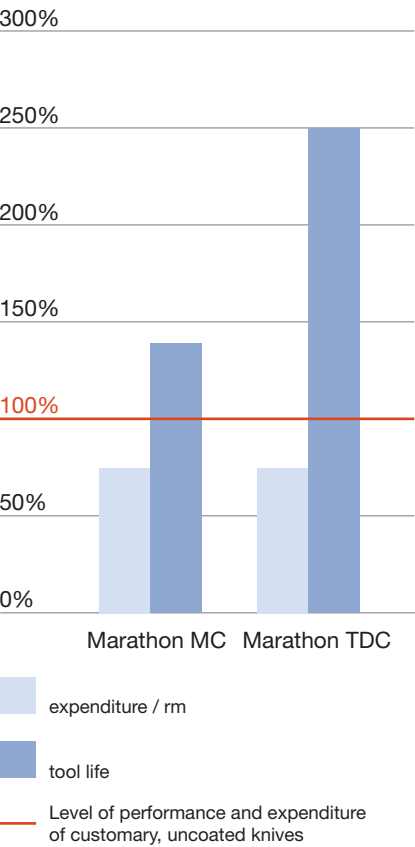
The special circular tool design with its rounded edges reduces noise. The wear parts of ProfilCut Q are built in steel. The balancing of ProfilCut Q is effectively limiting vibrations, protecting the spindle bearings and leads to a better surface-quality and prolonged performance times.



# 10. Profile tool systems

## 10.4 ProfilCut throwaway knives 10.4.1 ProfilCut Q

<b>More profitability</b>	<p>Limited production expenditures due to</p> <ul style="list-style-type: none"> <li>– longer tool life by Marathon high power coating</li> <li>– reduced maintenance</li> <li>– less machine down time</li> <li>– economy by combining standard straight and profiled throwaway knives</li> </ul>
<b>More quality</b>	<p>Minimum rejects, less rework and machined surfaces to finish quality by</p> <ul style="list-style-type: none"> <li>– extra-sharp cutting edges by polished face</li> <li>– innovative coating-technology for longer performance and cut quality</li> <li>– balanced to prevent vibration, therefore an enhanced cut quality surface finish</li> </ul>
<b>More usability</b>	<p>Short set-up times combined with user friendliness due to</p> <ul style="list-style-type: none"> <li>– automatic knife adjustment without setting gauges</li> <li>– changing the knives while the tool is in the machine is possible</li> <li>– lightweight construction of the tool body</li> <li>– clamping screws are dust-protected</li> <li>– perfect repetition accuracy, after every knife change</li> <li>– noise reducing design</li> </ul>





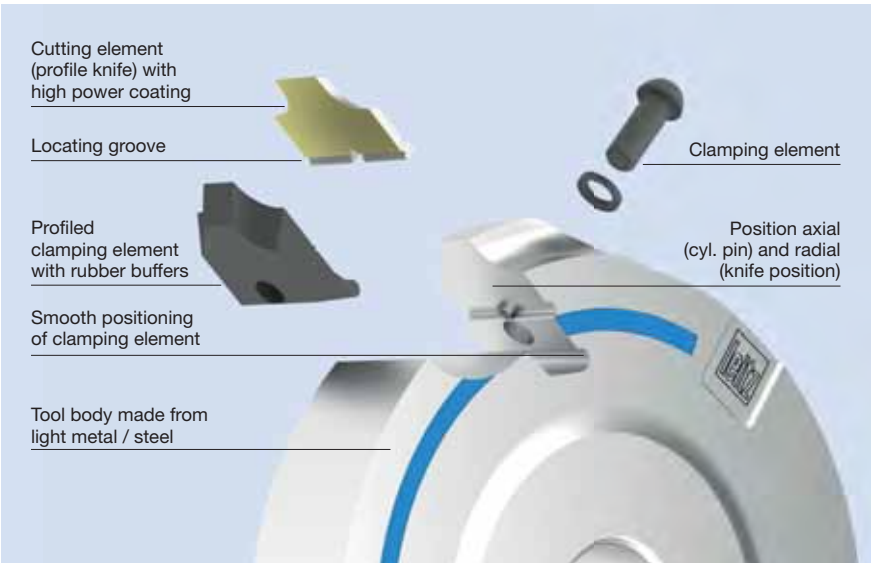
# 10. Profile tool systems

## 10.4 ProfilCut throwaway knives 10.4.1 ProfilCut Q

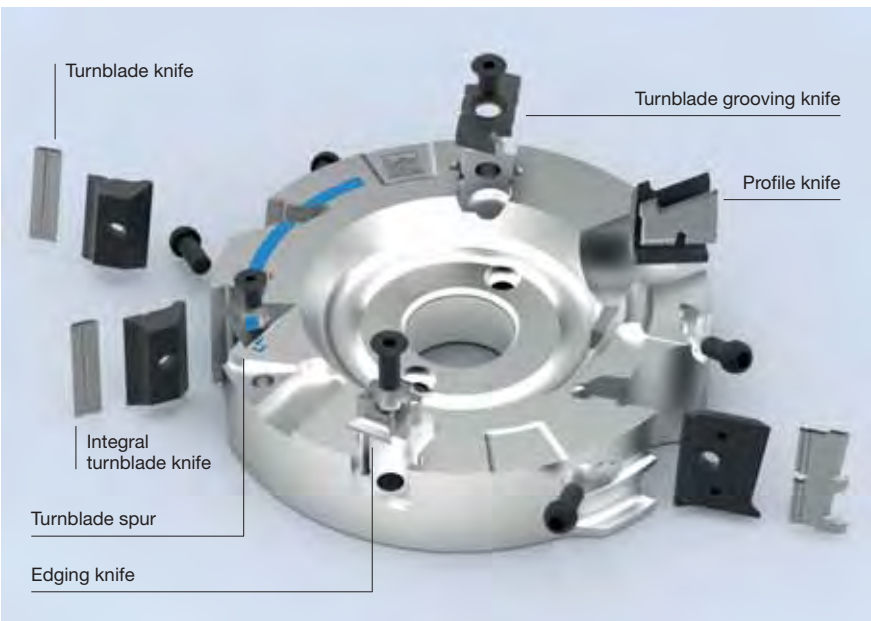
### Technical specifications

For special surface quality demands, we recommend splitting the cutting edge (2-part design instead of a 1-part design - independent of the cutting width).

<b>Radius</b>	Shank tool 0-400 mm Tools with bore 70-650 mm
<b>Cutting width</b>	8-80 mm ProfilCut Q 8-120 mm Turnblade knife
<b>Closed profiles</b>	Z 2, from zero diameter 60 mm max. number of teeth depends on diameter
<b>Tool body</b>	Aluminium / steel
<b>Number of teeth</b>	Single-sided profiles: Z 1, up to zero diameter to 40 mm Z 1/1, from zero diameter to 40 mm
<b>Profile depth</b>	PD max. 20 mm (straight tool body) PD > 20 mm (cranked tool body)



### Example for possible turnblade and throwaway knives combination





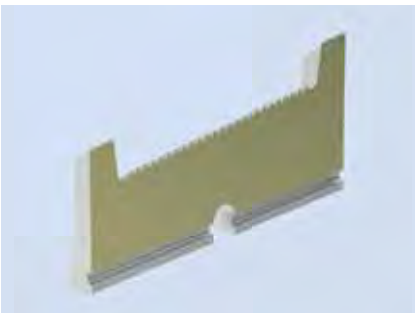
# 10. Profile tool systems

## 10.4 ProfilCut throwaway knives 10.4.1 ProfilCut Q

### Application overview



<b>Profile</b>	<ul style="list-style-type: none"> <li>– Window profiles</li> <li>– Slot and tenon profiles</li> <li>– Interior and exterior profiles</li> <li>– Glue joint profiles</li> <li>– Panel raising profiles</li> <li>– Post- and Softforming profiles</li> <li>– etc.</li> </ul>
<b>Machining processes</b>	For every profiling tasks in small, medium-sized and large-scale production with a cutting speed ( $v_c$ ) up to 90 m/s.
<b>Machine types</b>	For all conventional cutting machines with manual feed (MAN) or mechanical feed (MEC).
<b>Materials</b>	<ul style="list-style-type: none"> <li>– Hardwoods and softwoods</li> <li>– Wood derived materials such as: plywood, fibreboard, block board and chipboard</li> <li>– Polymers such as: Duro- and Thermoplastics, laminated wood based panels as well as composite materials and aluminium</li> </ul>
<b>Coating</b>	Marathon MC (Multicoating) for demanding profiling tasks. Marathon TDC (Tungsten Diamond Coating) for the processing of hardwoods, abrasive materials and for large scale production.



Marathon MC-coating – highest quality for soft woods.



Marathon TDC-coating – specialist for hard woods and abrasive materials.

## 10. Profile tool systems

### 10.4 ProfilCut throwaway knives

#### 10.4.2 ProfilCut Q Premium

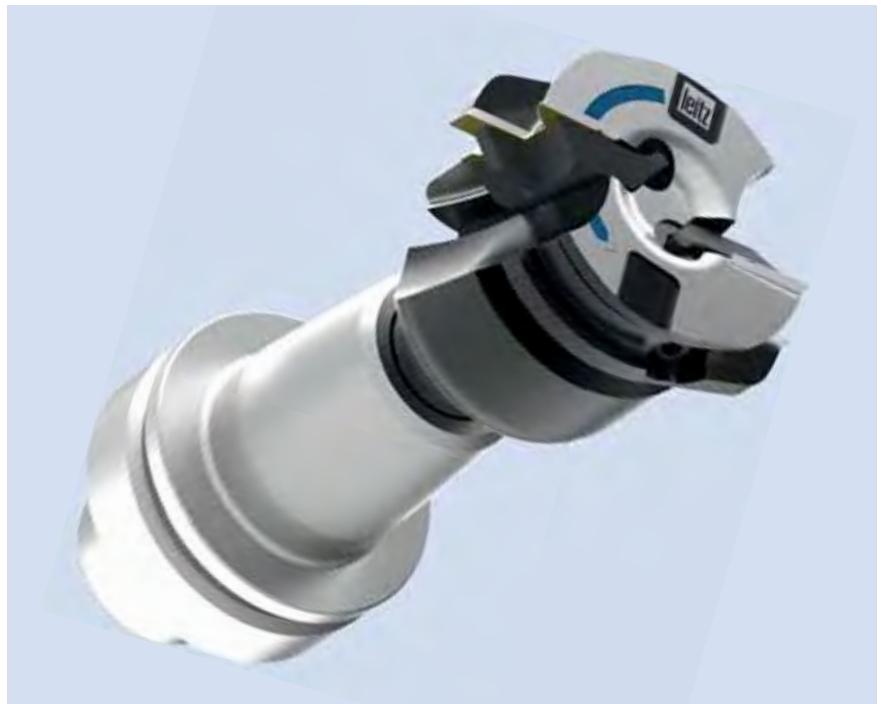
**Extraordinary performance – more quality and quantity with every cut**

The new ProfilCut Q Premium cutter head system from Leitz is the ultimate solution for companies who want to make the most from their production. With its unique tool design, ProfilCut Q Premium is the benchmark for performance, flexibility, handling, weight and durability, and manufacturing companies can rely on its extraordinary performance.

With a cutting speed up to 120 meters per second, the premium system is faster than any comparable tool, both in productivity and surface quality. Its accelerated process performance saves time and money.

The integration of Leitz technical innovations create a new standard. The latest clamping system has been designed for the highest radial speed and the unique surface coating reduces abrasion, dirt adhesion and heat build-up even more effectively. The lightweight design of the tool body maintains a greater dynamic. Additionally, changing knives is simple, fast and accurate.

A unified clamping system guarantees safe, form-fitting clamping and minimal set-up time. The knives are positioned in the centrifugal force direction. The special clamping wedges have the additional function as chip-guiding elements. This technical feature enables chip generation with reduced dust which consequently helps lead to a perfect finish. With the special contouring of the tool body, noise pollution is also reduced effectively.



## 10. Profile tool systems

### 10.4 ProfilCut throwaway knives

#### 10.4.2 ProfilCut Q Premium

##### More speed

Maximise productivity by the reduction of processing time and a significantly better surface quality due to

- innovative and secure clamping system
- unique tool body coating reduces heat generation and friction
- lightweight construction of the tool body

##### More usability

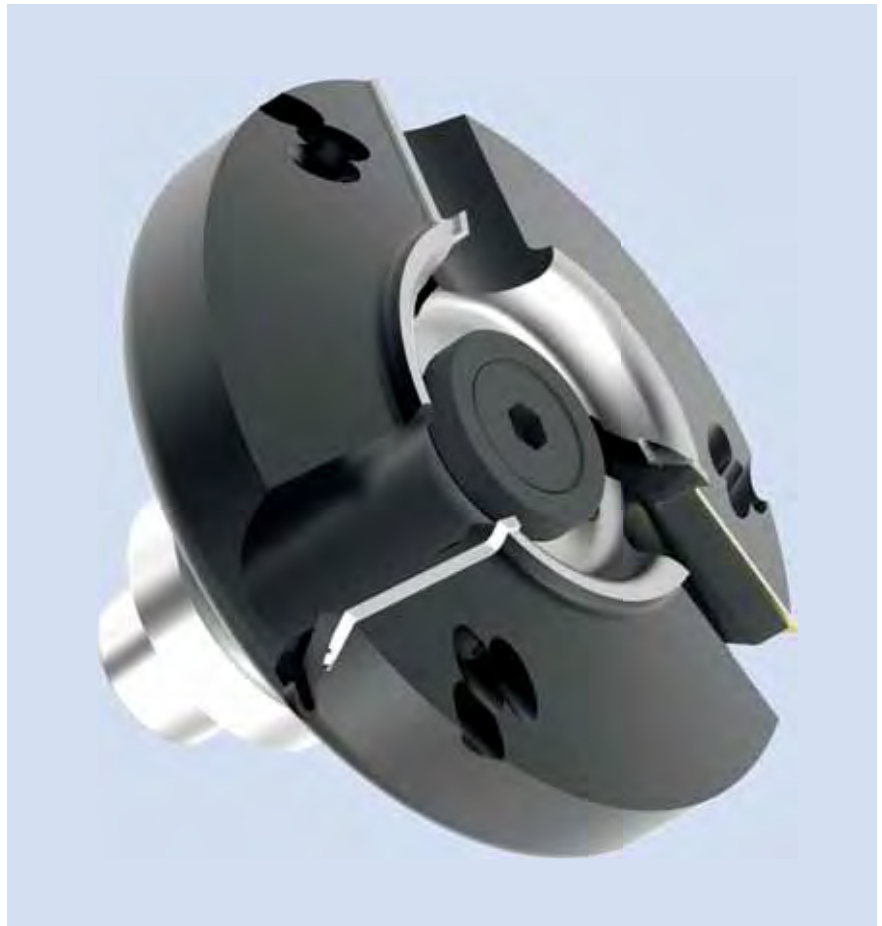
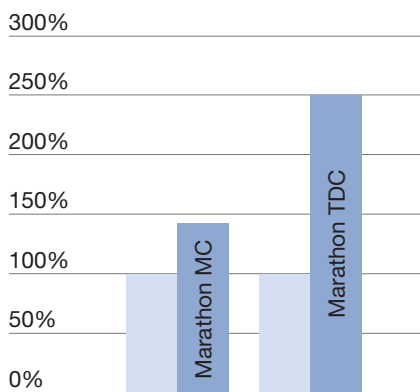
Short set-up times and best usability due to

- automatic knife adjustment without setting gauges
- changing the knives while the tool is in the machine is possible
- clamping screws are dust-protected
- perfect repetition accuracy, after every knife change
- noise reducing design

##### More endurance

Longer finish cutting quality due to

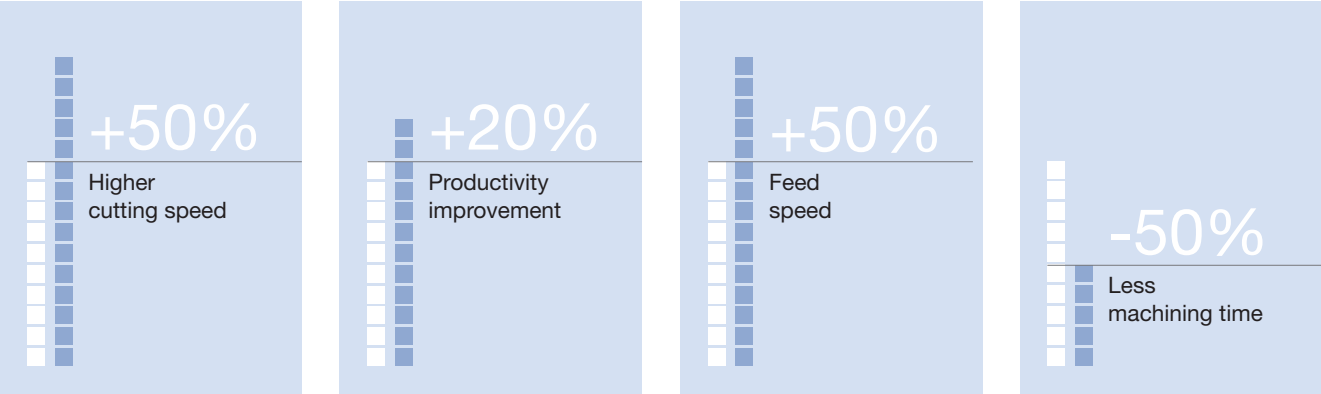
- knives with Marathon high power coating
- innovative coating technology for longer performance and cut quality
- balanced to prevent vibration, therefore an enhanced cut quality surface finish



# 10. Profile tool systems

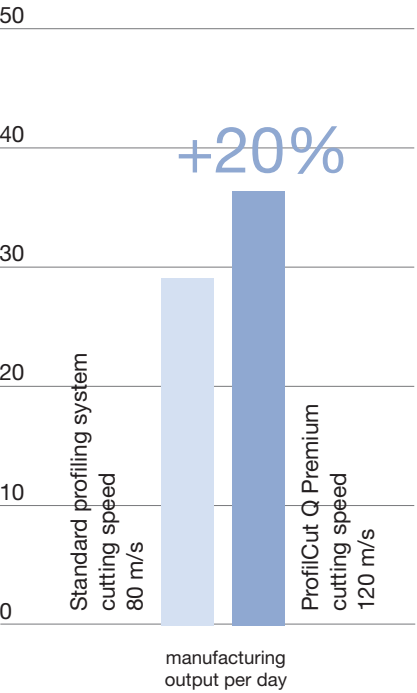
## 10.4 ProfilCut throwaway knives 10.4.2 ProfilCut Q Premium

### More profit at all levels



### Typical production sample:

- manufacturing output 30 windows per day
- average cutting time 42 % per window
- comparison from an average profile tooling system with Leitz ProfilCut Q Premium



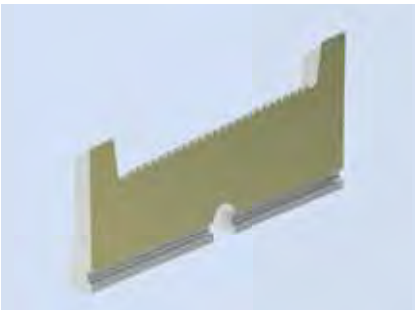
# 10. Profile tool systems

## 10.4 ProfilCut throwaway knives 10.4.2 ProfilCut Q Premium

### Application overview



<b>Profile</b>	<ul style="list-style-type: none"> <li>– Window profiles</li> <li>– Slot and tenon profiles</li> <li>– Interior and exterior profiles</li> <li>– Glue joint profiles</li> <li>– Panel raising profiles</li> <li>– Post- and Softforming profiles</li> <li>– etc.</li> </ul>
<b>Machining processes</b>	For every profiling tasks in small, medium-sized and large-scale production with extremely high cutting speeds ( $v_c$ ) up to 120 m/s.
<b>Machine types</b>	For all conventional milling machines with manual feed (MAN) and with mechanical feed (MEC). Particularly suitable for all high-performance machines in stationary technology and for systems with high part ejection or high tool performance.
<b>Materials</b>	<ul style="list-style-type: none"> <li>– Hardwoods and softwoods</li> <li>– Wood derived materials such as: plywood, fibreboard, block board and chipboard</li> <li>– Polymers such as: Duro- and Thermoplastics, laminated wood based panels as well as composite materials and aluminium</li> </ul>
<b>Coating</b>	Marathon MC (Multicoating) for demanding profiling tasks. Marathon TDC (Tungsten Diamond Coating) for the processing of hardwoods, abrasive materials and for large scale production.



Marathon MC-coating – highest quality for soft woods.



Marathon TDC-coating – specialist for hard woods and abrasive materials.

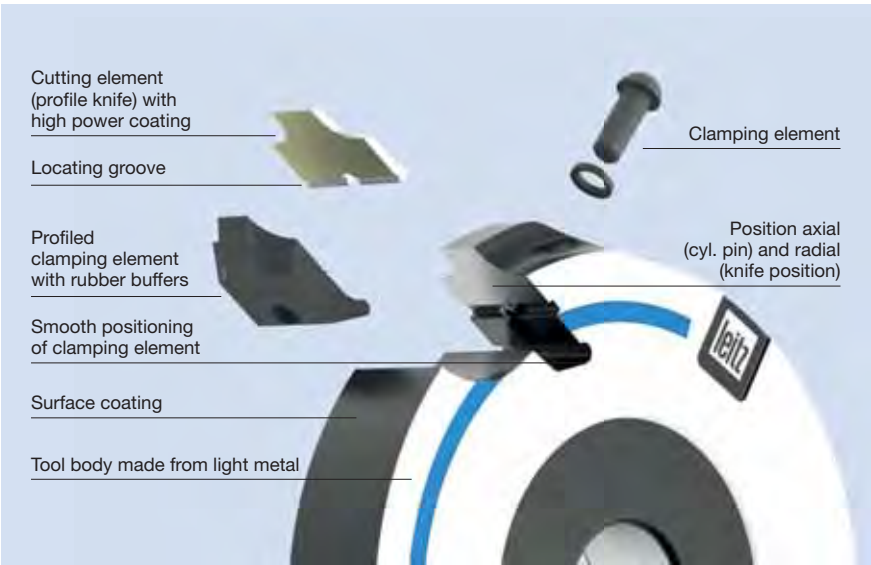
# 10. Profile tool systems

## 10.4 ProfilCut throwaway knives 10.4.2 ProfilCut Q Premium

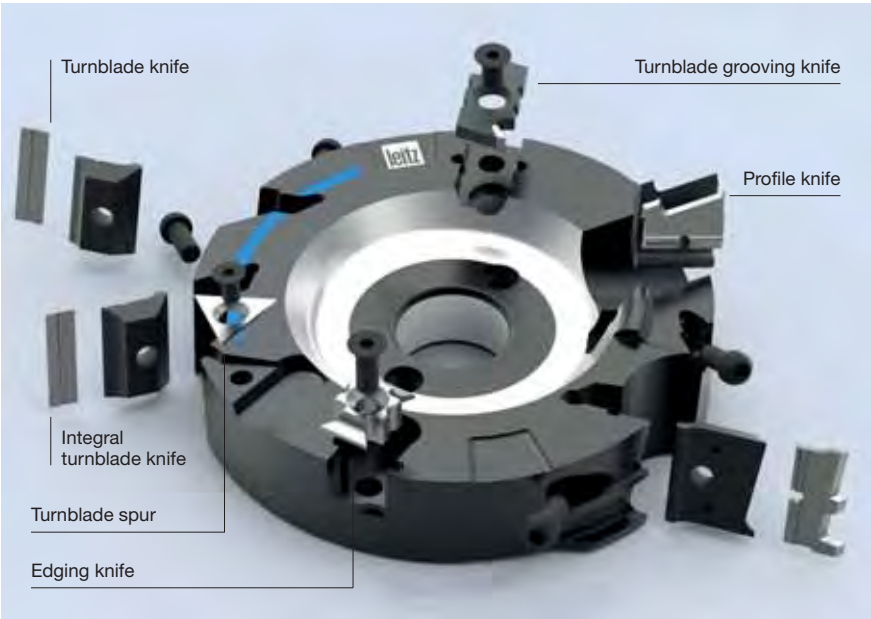
### Technical specifications

For special surface quality demands, we recommend splitting the cutting edge (2-part design instead of a 1-part design - independent of the cutting width).

<b>Radius</b>	Shank tool 0-400 mm Tools with bore 70-650 mm
<b>Cutting width</b>	8-80 mm ProfilCut Q Premium 8-120 mm Turnblade knife
<b>Closed profiles</b>	Z 2, from zero diameter 60 mm max. number of teeth depends on diameter
<b>Tool body</b>	Aluminium / steel
<b>Number of teeth</b>	Single-sided profiles: Z 1, up to zero diameter to 40 mm Z 1/1, from zero diameter to 40 mm
<b>Profile depth</b>	PD max. 20 mm (straight tool body) PD > 20 mm (cranked tool body)



### Example for possible turnblade and throwaway knives combination





## 10. Profile tool systems

### 10.4 ProfilCut throwaway knives

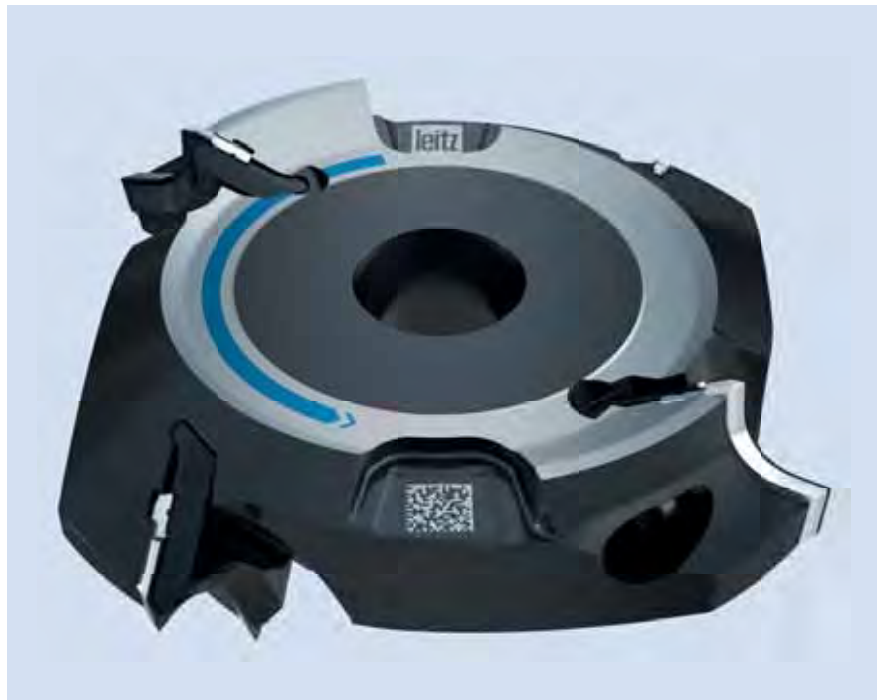
#### 10.4.3 ProfilCut Q Diamond

##### **ProfilCut Q Diamond – Diamond in a new dimension**

The new replaceable knife system ProfilCut Q Diamond sets pioneering new standards in machine processing. ProfilCut Q Diamond is a unique combination of an ultralight aluminium tool body and re-sharpenable profile knives. This enables constant diameter diamond cutting, guaranteeing higher efficiency and maximum productivity and profitability.

This advanced technical innovation begins with a new diamond cutting edge made from the hardest material on earth: polycrystalline diamond (PKD). Process high-end and abrasive materials precisely with exact repeatability and no loss of performance. After sharpening, the diameter and profile of the cutting edge remains unchanged. ProfilCut Q Diamond can be sharpened five times, and with a service life many times longer than disposable carbide systems, ProfilCut Q Diamond provides significant cost savings.

High performance continues with the dynamics of the tool body's aluminium light-weight construction, and the clamping system has been designed for maximum peripheral speed. The coating effectively reduces impact, friction and heat generation. Even at a maximum rim speed up to 120 meters per second, the system produces first-class surface quality due to reduced vibration. The increased speed also allows faster feed rates with the same number of teeth, enabling higher productivity.





## 10. Profile tool systems

### 10.4 ProfilCut throwaway knives

#### 10.4.3 ProfilCut Q Diamond

##### Work faster

Maximise productivity and reduce processing time by:

- significantly improving surface quality
- innovative clamping system for the toughest applications
- friction and heat reducing coating
- lightweight aluminium construction
- less vibration due to superior balance quality
- Diamond cutting

##### Easy to use

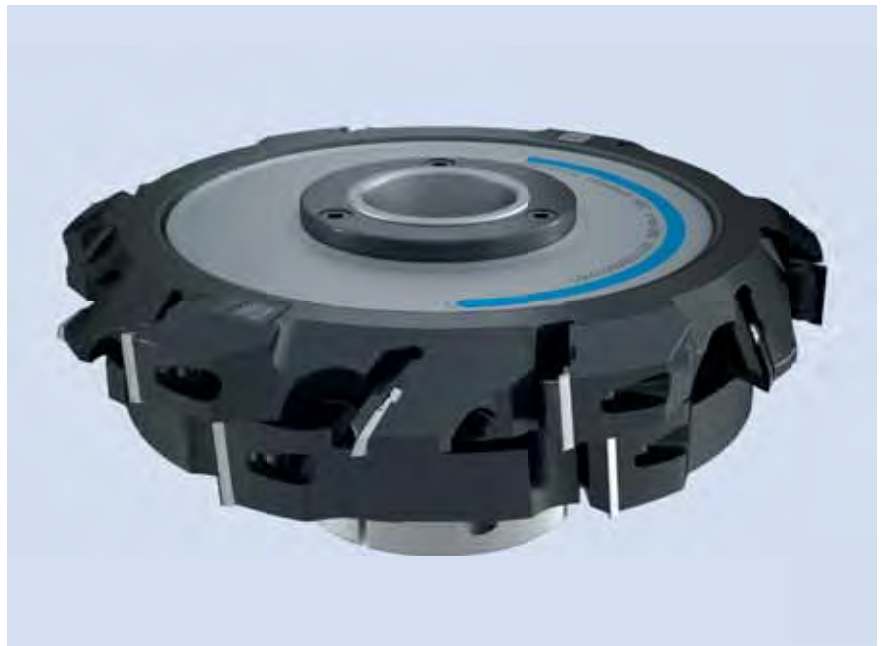
Short set-up times and easy-to-use:

- independent knife positioning without setting aids
- change knives on-site – no need to send the tool to the service centre
- knife change in the mounted set
- perfect repeatability after each knife change
- easy set-up after sharpening
- compatible with all other tooling systems
- noise-reduced design

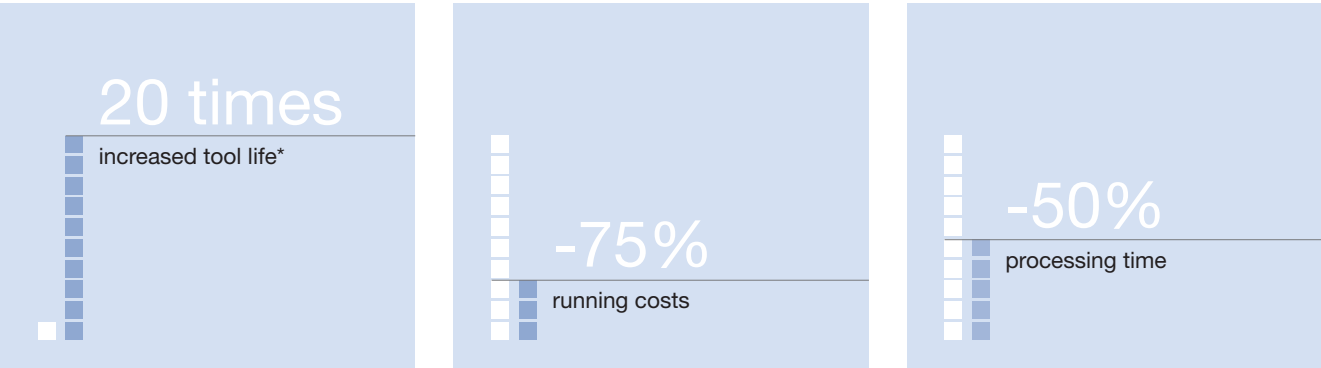
##### Sustainable operation

Save on resources, thanks to:

- reusable tool body
- replaceable knives
- sharpen knives five times
- many times longer tool life
- reduced service costs



Impressive performance –  
specialist for hardware



\* compared to average carbide tools

<b>Applications</b>	<ul style="list-style-type: none"> <li>– Versatile applications using advanced materials</li> <li>– Mouldings</li> <li>– Furniture manufacturing</li> <li>– Aluminium processing</li> <li>– Flooring manufacture</li> <li>– Diverse profiles</li> <li>– Window and door manufacturing with abrasive materials</li> </ul>
<b>Machining processes</b>	For all profiling applications in small, medium and large production and manufacturing. Suitable for highspeed cutting (HSC) machining with extremely high rim speeds.
<b>Machine types</b>	For all conventional machines with manual feed (MAN) and mechanical feed (MEC). Particularly suitable for all high-performance CNC processing centres and for systems with high output and/or high tool performance.
<b>Materials</b>	<ul style="list-style-type: none"> <li>– Particularly effective for applications using advanced materials such as aluminium, fibre reinforced or composite materials</li> <li>– All wood materials (softwood, hardwood, plywood, fibreboard, block board and chipboard)</li> <li>– All plastics (duromers, plastomers, laminate board, thermoplastics, laminated wood based panels as well as composites)</li> </ul>

## 10. Profile tool systems

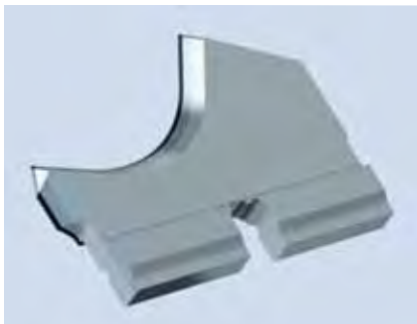
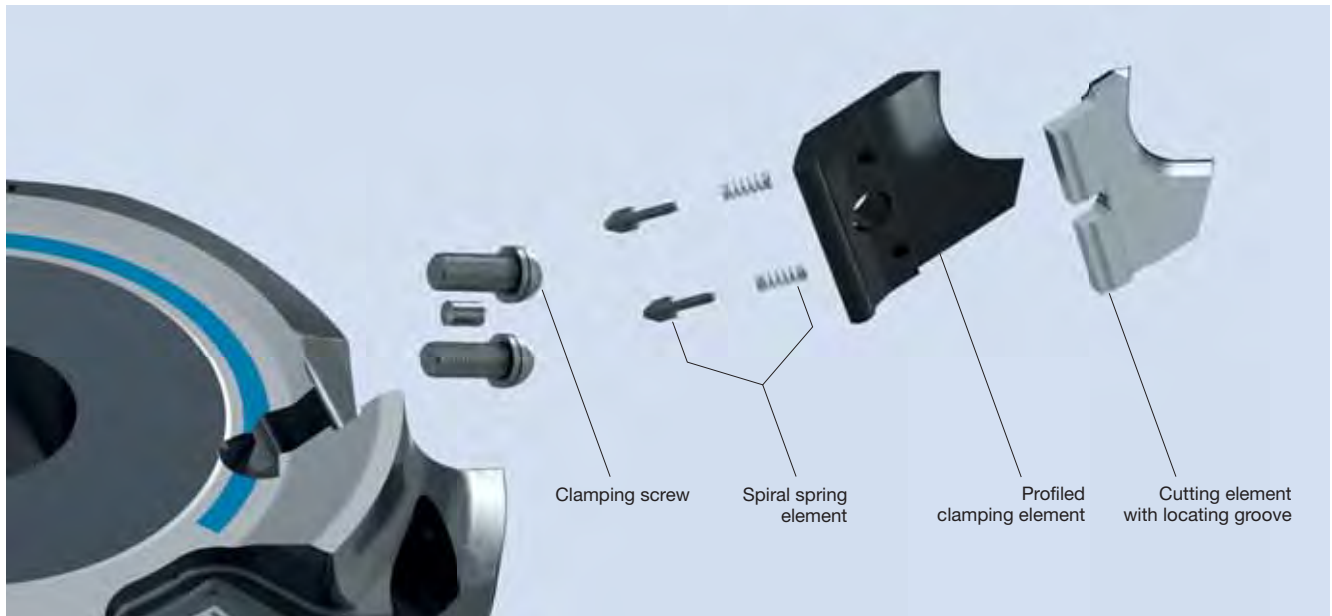
### 10.4 ProfilCut throwaway knives

#### 10.4.3 ProfilCut Q Diamond

##### Technical specifications

- sharpen knives five times
- constant profile and diameter
- many times longer tool life
- polycrystalline diamond (PKD) – the hardest material on earth

<b>Rim speed</b>	$v_c = 120 \text{ m/s}$
<b>Cutting width</b>	Max. 50 mm to profile depth 15 mm
<b>Datamatrix Code</b>	Product information available
<b>Diamond cutting edge</b>	Resharpen knives five times polycrystalline diamond (PCD)
<b>Lightweight</b>	Combined lightweight construction with diamond cutting edges
<b>Number of teeth</b>	Single-sided profiles: Z 1, up to zero diameter to 45 mm Z 1/1, from zero diameter to 45 mm



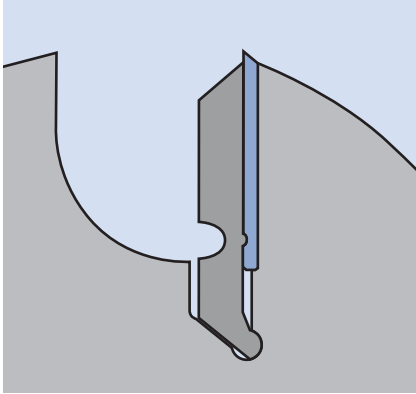
## 10. Profile tool systems

### 10.4 ProfilCut throwaway knives 10.4.4 ProfilCut Plus

#### **ProfilCut Plus – the resharpenable system supplement**

ProfilCut Plus is ideal for producing standard and special profiles, interior and exterior profiles for windows as well as post- and soft-forming profiles. The 0.3 mm sharpening zone allows repeated sharpening. For suitable applications, this considerably increases efficiency compared to a 1-life throwaway knife system.

The elastic deformation of the clamping elements guarantees uniform clamping of the resharpened knife. For safety reasons, resharpenable knives cannot be used in ProfilCut Q or ProfilCut Q Premium cutterheads.



ProfilCut Plus



## 10. Profile tool systems

### 10.5 VariForm Universal profile tool systems

**A system which is both simple and versatile**

**VariForm – variable and multi-functional**

For industrial or manual production: the VariForm tool system offers unique advantages to businesses of all sizes and gives a clear competitive edge to production and quality. Its concept is simple: a flexible tool body design, cost effective as the tools can be resharpener several times, and versatile with numerous knife profiles.

VariForm provides unlimited design opportunities with regard to profile and product form. At the same time it improves the cost effectiveness of your production.

#### Workpiece materials

Hardwood and softwood, laminated wood, chipboard and fibre material, plastics

#### Machines

- spindle moulders
- four-sided moulders
- edgebanding and sizing machines
- CNC router cutters and CNC machining centres

#### Applications

- furniture, mouldings
- prototypes, single pieces
- small and medium series
- etc.



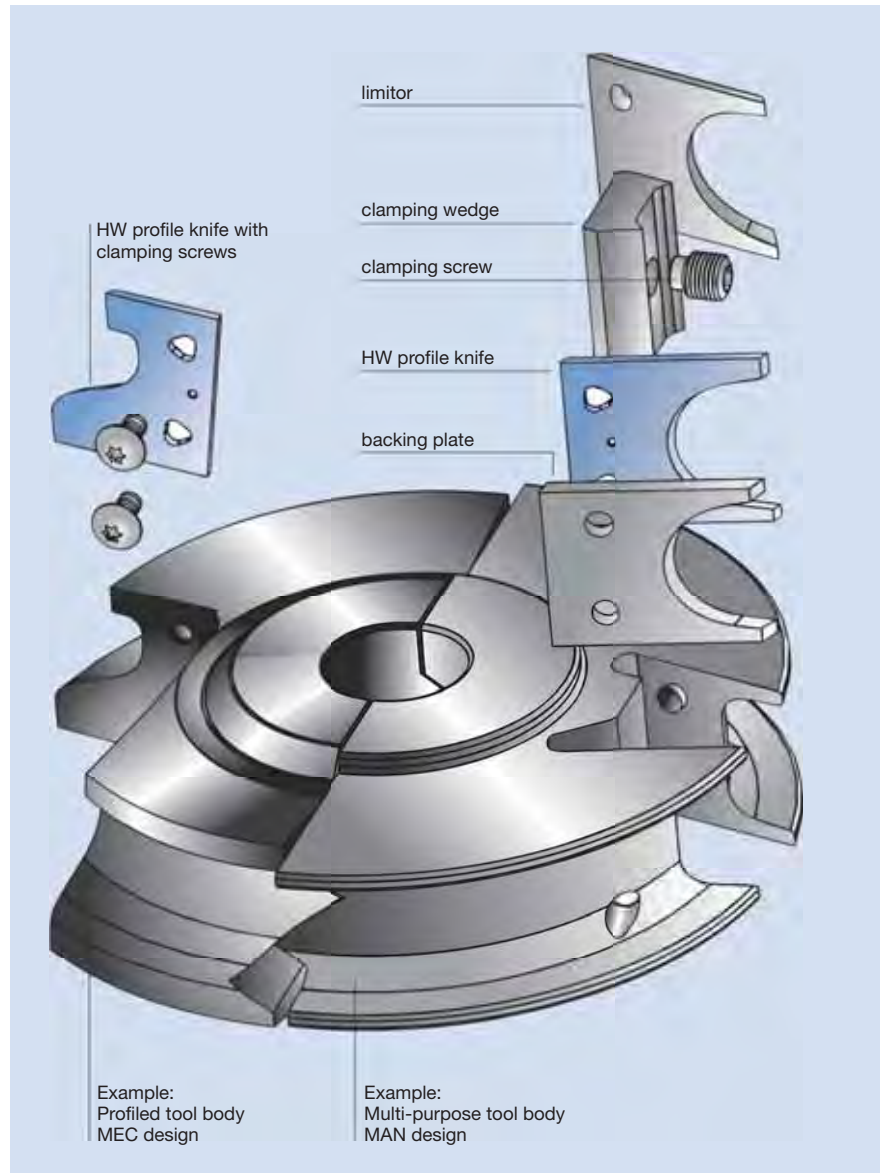
#### Easy handling

The VariForm knife clamping “overrides centrifugal force”.

3-point support, the knives are centered, clamped and positioned radially by the centrifugal force.

That means no movement at high speeds and precise and safe working at the optimum cutting speed range of 70 to 80 m/s.

Another advantage: As there are no side stops, you can profile the blank knives around the entire periphery.



#### Note:

Small tool diameters or profile depths exceeding 20 mm require profiled tool bodies.

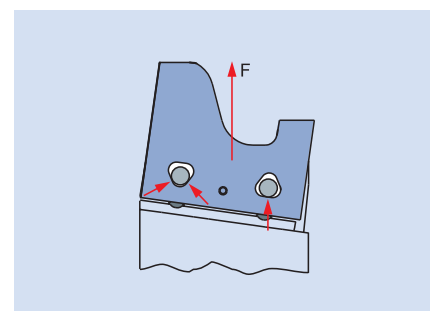
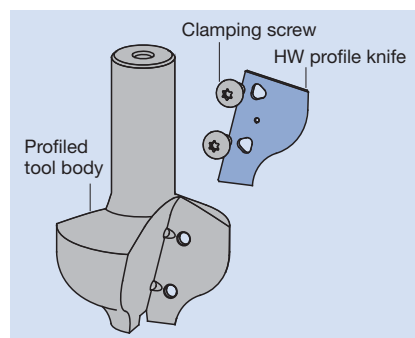


Diagram of the knife clamping.



## 10. Profile tool systems

### 10.5 VariForm Universal profile tool systems

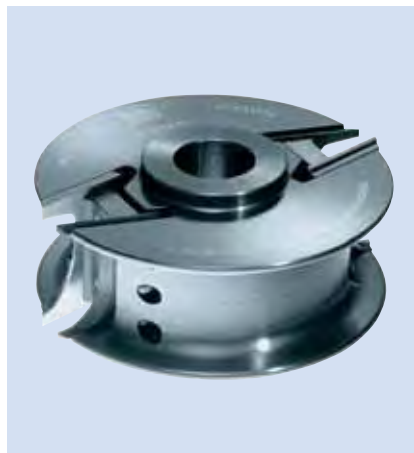
**VariForm – a first-rate tool system – made by Leitz**

**All advantages at a glance**

- Resharpenable three to four times.
- Different HW qualities for solid wood and panel materials.
- The right cutting material for every application.
- Modular system: Use the same profile knife in different tool bodies for different machines, suitable for all popular spindle diameters and for quick-clamping systems.
- Tool body designs adapted to the profile depth for a high degree of design freedom.
- Maximum precision and safety by three-point knife clamping.








**And unique customer service as well**

Over 120 Leitz service stations respond quickly, expertly and reliably to customer requests. Based on profile drawings or wood samples, special profile knives are produced accurately, quality tested and delivered at short notice to meet the customer deadlines – as standard with Leitz. As we archive the templates, resharpening and replacement are both quick and easy.





**VariForm –  
main designs and data at a glance**

Design variants	Profile depth up to 15/19 mm	Profile depth up to 20 mm	Profile depth up to 35 mm
<b>MAN feed</b> for spindle moulders	 multi-purpose tool body	 partially profiled tool body, channel	 profiled tool body, cranked ri./le.
Cutting width:	40/45 mm and 50/60 mm	40 mm to 60 mm	40 mm to 60 mm
<b>MEC feed</b> for four-side planing machines, -edgebanding and sizing machines (suitable for quick-clamping systems)		 partially profiled tool body, channel, L profile, I profile	 profiled tool body, cranked ri./le.
Cutting width:		40 mm: L-, I-Profil 40/60 mm: U-Profil	40 mm to 60 mm
<b>MEC feed (CNC)</b> for CNC router cutters and CNC machining centres	 multi-purpose tool body		 profiled tool body, cranked ri./le.
Cutting width:	40/45 mm and 50/60 mm		30 mm to 50 mm



Manufacturing profiled mouldings is important. Profiled mouldings are used, for example, at floor level as skirting boards, around doors as frame profiles, and in cabinetry as decorative mouldings. Such products are usually manufactured on four-sided moulders on through-feed machines and pose specific requirements on the tool system.

- Profile changes need to be actioned quickly by suppliers. This means the user must be able to profile and sharpen the tool system.
- The increase in MDF lining profiles requires wear-resistant tungsten carbide.
- For high production volumes, the tool system needs to be either jointable or, in the case of new machine generations, be HSC-suitable, i. e. suited to high rotation speeds up to  $n = 12000 \text{ min}^{-1}$ .
- Furthermore, the number of staff required for tool preparation must not be too high, as the staff is needed to produce the mouldings.



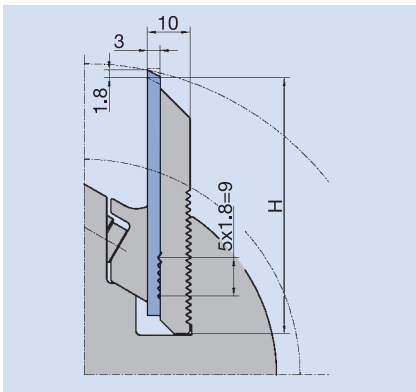
Leitz has developed a user-friendly and highly efficient knife system called PowerKnife System, or simply PKS®, specifically for the high requirements of profile moulding production.

PKS® is a development of the Leitz MicroSystem, which has provided valuable service over the years. It is compatible with all serrated back profile cutterheads with 60° serration, either with bore or HSK. The system consists of a tungsten carbide blank knife and a hardened steel backing plate. Both parts are form-fitting via a serration, but can be separated from each other. The backing plate is secured in the serration of the cutterhead by its serrated back.

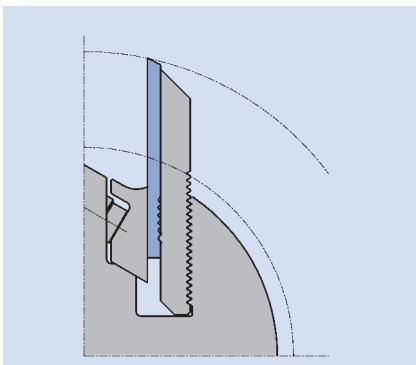
This system offers major advantages compared to tipped knives with brazed-on tungsten carbide, and other two-part knife designs:

- For the maximum concentric running, the knives are profiled or resharpened when installed in the cutterhead, machining the tungsten carbide edges and the steel backing plate separately with the appropriate grinding wheel. The backing plate is profiled only once, while the tungsten carbide edge is resharpened several times and can be replaced separately. Thanks to the single-material machining of tungsten carbide or steel, grinding wheel consumption, processing time and tool cost are reduced.
- The resharpening depth of the tungsten carbide knife is 10.8 mm, approx. 40 single average performance times.
- The adjustment area of the knife system is defined by the design. It is not possible to project the knife too far out of the tool. This ensures safe operation of the system at all settings.
- The form-fitting connection between the tungsten carbide knife and the backing plate by just one serration ensures the parts are in contact over the whole surface, enabling maximum positioning accuracy, as one serration by definition does not lead to pitch errors.
- The comparatively large increments of 1.8 mm when adjusting the tungsten carbide knife enable six to eight resharpening processes in one installed position. In relation to the overall single performance time of one knife, this reduces knife mounting and setting time.
- The two-part design allows use of more wear-resistant tungsten carbide grades compared to brazed tungsten carbide knives and significantly increased performance times.
- Only ultra-fine tungsten carbide grain grades are used. And the cutting face has a mirror finish. Combined, these give extremely sharp cutting edges and a perfect surface finish.

PowerKnife System PKS® Tungsten carbide blank knife with backing plate for serrated back profile cutterheads



PKS®: New condition



PKS®: Resharpen several times, in end position



The PowerKnife System PKS® is available as

- non-profiled blank knives with the heights 50, 60 and 70 mm for profiles to a profile depth of 33 mm
- knives with a height of 40 mm for planing or jointing. This knife height matches the tool diameters for jointing in the moulder.

Only ultra-fine grain tungsten carbide qualities are used as:

- HW-30F for solid wood, preferable hardwood
- HW-10F for wood materials such as MDF, WPC.

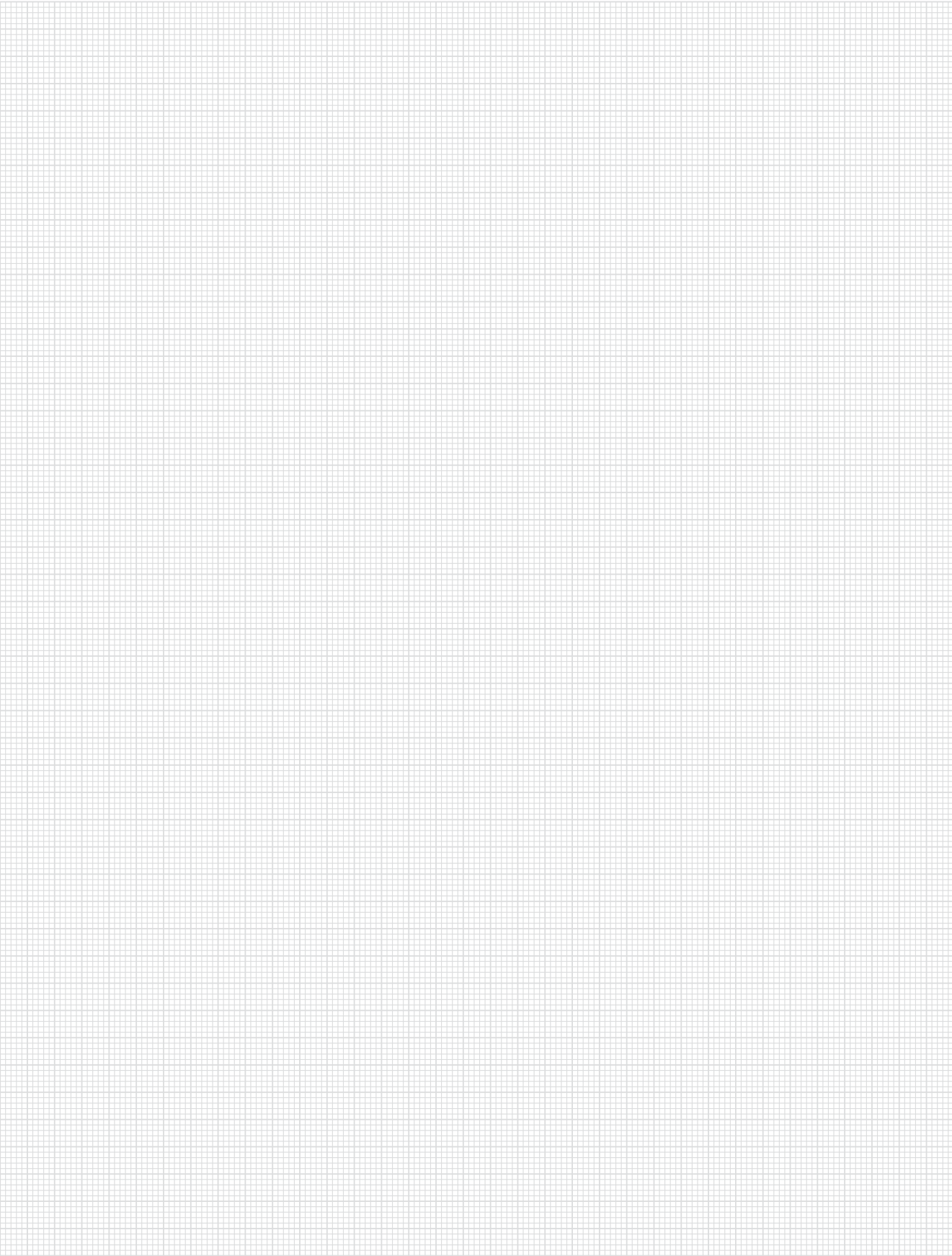


Tool example for PKS®:  
Multi-profiling of MDF mouldings

The knives can be jointed in the moulder. When used with HSK tools, experience has shown that the ground accuracy is sufficient to allow a Z2 tool at  $12000 \text{ min}^{-1}$ , e. g. in MDF to run at a feed speed of 50 m/min, and give a finish quality even without jointing. Productivity can be increased still further through parallel profiling of several mouldings and subsequent splitting. PKS® with cutting widths of up to 310 mm are available.

Even if profiled by the user, it is sometimes necessary to use the competence, expertise and equipment of a specialist to prepare the tools. Leitz, with its service centres around the world, offers this service. The tools are mounted, ground and measured. The profile specific measuring points are defined as specified by the user and the measured data documented on the accompanying tool card. The tools are returned in a reusable transport container. Your production staff can concentrate more effectively and efficiently on their actual task – producing mouldings. This service package is extended still further by integrating the user's CAD profile data in the service centre grinding programs, as well as providing a telephone hotline for urgent cases.

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# User encyclopedia

Leitz Lexicon Edition 7





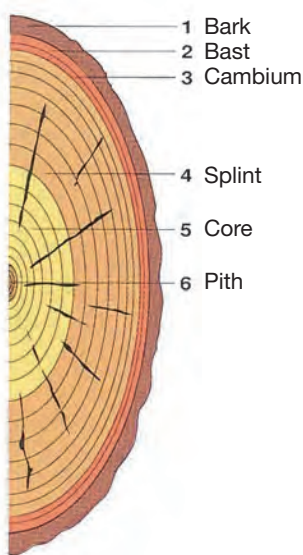


## 11. User encyclopedia

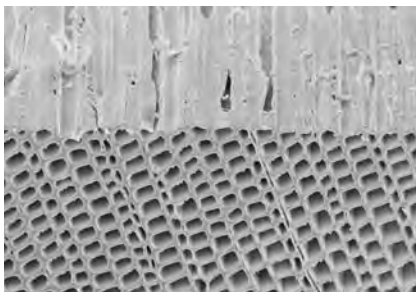
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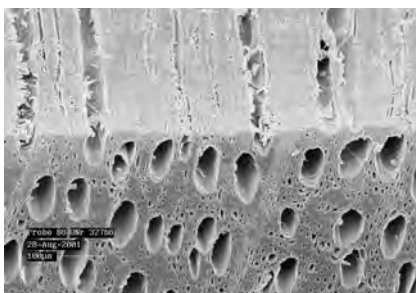
Tree



Structure of a trunk



Cross section of softwood (spruce)



Cross section of hardwood (beech)

As a renewable material, wood is a raw material which is important because of its strength and low density and because it is found all over the world. As a result, wood is used widely in support structures in timber construction and in non load-bearing areas such as building components, furniture or interior fittings. In its dry state, wood possesses low thermal conductivity properties due to its porous cell structure which means it has a certain level of heat insulation. Wood is therefore a good raw material from an energy point of view and is, for this reason, used in window frame elements or insulation panels. Wood is also used in its natural form (solid wood) or converted into wood materials.

There are several specific properties which must be considered in the selection, application and processing of solid wood. The **most important properties** are: **inhomogeneity, anisotropy, porosity, hygroscopicity and biodegradability**. The structure of wood consists of fibres stronger in a longitudinal than in a lateral direction. The fibres consist of cell walls which form the actual wood substance and of vessels (also known as „pores“). The relationship between the volume of the pores and the mass of the wood substance determines the bulk density and varies from one wood type to the next. Depending on the time of year, the pores become larger (spring, summer → **earlywood**, lower density) or smaller (autumn, winter → **latewood**, higher density). This phenomenon can be seen by taking a cross section of the wood and observing the growth rings from successive earlywood and latewood periods. With slow growing wood in cold regions, these growth rings are tight together, whereas with quick growing wood from warmer regions, the growth rings are spread out. In contrast, these differences are barely noticeable in tropical woods.

Wood develops by a process of cell growth and cell multiplication within the growth ring, or cambium. Most cells develop inwards to form the wood structure, while some grow outward, forming the bark and phloem, or inner bark. Every tree is built in layers; a cross-section through the trunk is as follows from outside to inside: bark, phloem, cambium, sapwood (medullary rays, annual rings, spring growth and summer growth, resin ducts), heartwood (without sap capillaries: this is purely structural in function) and pith.

There are two main wood types: **hardwoods and coniferous woods**. Coniferous woods are older in evolutionary terms and therefore have less complex cell structures involving two cell types. The tracheids (elongated, tapered) are strong and act as conductors. Water is exchanged between the cells through so called pits or bordered pits. The parenchyma cells (rectangular) are responsible for transporting the nutrients and storing starch and fats.

In contrast, functions are divided between the cells in hardwoods. The cells are divided into vascular tissue, ground tissue and seed tissue. The main feature which differentiates hardwoods from coniferous woods is the vessel elements (tracheids) in the vascular tissue. These can be seen as pores in a cross sectional view, and as striations in a longitudinal view. The arrangement of these wood vessels determines whether the wood is ring porous (e.g. oak, ash), semi ring porous (e.g. cherry, walnut) or diffuse porous (e.g. birch, beech, poplar).

While there is a general similarity between softwood and conifer, hardwood and broadleaf, there are exceptions such as yew – which is a hardwood – and alder, birch, lime, poplar and willow – which are softwoods. For processing and tool selection, factors such as density, strength, elasticity and hardness are important considerations. Accordingly, the categorisation of **hardwood and softwood** is important insofar as it provides a broad guide to these properties.



Sapwood (bright) and heartwood (dark)  
(example pine)

Merely the „appearance“ of the timber, lumber or planed timber can give information on the properties and on the potential level of difficulty during the woodworking process. **Sapwood and heartwood** from a tree have different properties, for example. The sap flows in the outer layers of the trunk. This leads to an outer area of sapwood with a higher level of moisture and inner areas of less moist heartwood. Sapwood and heartwood are always of varying quality. With increasing trunk diameter, the relative size of the heartwood becomes greater as the sapwood or ripewood progressively converts to heartwood. Once converted to heartwood, the material ceases further structural change. Both sapwood and heartwood are present in all types of tree, although they are more easily distinguished in the so called „heartwood trees“ – such as oak, larch, pine, cherry and ash – than in „sapwood trees“ – such as beech, fir and spruce; these may very little in colour.



Earlywood (bright) and latewood (dark)  
(example Pinus Radiata)

During wood processing and woodworking procedures it must be remembered that wood is a material with varying structures and properties. The growth rings are particularly indicative of this fact in coniferous woods. There are significant differences in hardness between the marked areas of **earlywood and latewood**. During woodworking process, these circumstances must be taken into consideration and cutting materials, cutting material geometries and process parameters must be adapted correspondingly. When processing various types of wood often a compromise for various types of wood is required.

**Bulk density** is the decisive factor for most technical properties. Bulk density is the ratio of the mass and volume (including all vessels). Depending on the type of wood, bulk density is usually between 100 kg/m<sup>3</sup> and 1200 kg/m<sup>3</sup>. Higher bulk density means that the wood is harder, firmer, tougher to process and treat and also harder to dry. Tool wear also increases in direct proportion to the bulk density of the wood. Other factors which influence cutting edge wear are wood components such as tannic acid or silicate inclusions. Natural tannic acids, such as those present in oak, lead to the chemical wear of tool cutting edges, particularly if the wood has a higher moisture content. Silicate inclusions, such as those present in tropical woods of Meranti, Teak or Mahogany, are absorbed from the ground along with nutrients and then crystallise in the vessels. They cause increased abrasive wear to the cutting edges. Large density differences between earlywood and latewood normally are a sign of strong presplitting and a tendency to splinter during processing (example: Pinus Radiata). The increasing global wood demand is the reason why trees are more and more bred in forest plantations. Those so called plantation woods are generally fast-growing species such as Radiata Pine, Eucalypts, and Poplars. These plants show rougher annual growth rings, lower density and strength in comparison with the plants grown in natural forests. Due to the stronger predisposition of trunk splitting and defibering sometimes the cutting of plantation woods presents a real challenge. It requires both special machining technology and special tool solutions. Long-fiber woods as Poplar are used as raw material for wood-based materials.

Type of wood	Bulk density [kg/m³]	Strength [N/mm²]		
		Compressive	Bending	Shearing
<b>Hardwoods</b>				
Afzelia	750 - 950	65 - 79	90 - 120	7.5 - 15.0
Maple	530 - 790	29 - 72	50 - 72	9.0 - 15.0
Balsa	90 - 260	5 - 15	12 - 23	1.1 - 2.0
Bangkirai	900 - 1100	68 - 80	125 - 140	10.0 - 15.0
Birch	510 - 830	38 - 100	147 - 155	12.0 - 14.5
Beech (Red Beech)	540 - 910	41 - 99	74 - 210	6.5 - 19.0
American Oak	550 - 980	39 - 61	89 - 130	9.0 - 14,6
European Oak	430 - 960	54 - 67	74 - 105	12.0
Alder	490 - 640	31 - 77	44 - 172	3.0 - 6.5
Ash	450 - 860	23 - 80	58 - 210	9.0 - 14,6
Eucalyptus	720 - 790	37 - 51	75 - 104	9.5
Iroko	550 - 850	52 - 81	70 - 158	9.5 - 12.5
American Cherry	525 - 615	33 - 59	59 - 98	15.0
Mahogany	450 - 620	36 - 70	50 - 130	6.0 - 9.5
Meranti, Dark Red	550 - 890	53 - 74	66 - 222	7.1 - 10,6
Meranti, Light Red	390 - 760	21 - 50	32 - 80	4.0 - 8.0
Merbau	760 - 830	60 - 85	140	13 - 17,5
Populus	410 - 560	26 - 56	43 - 94	4.0 - 8.0
Sipo	550 - 750	43 - 73	47 - 155	5.5 - 15
Teak	520 - 700	42 - 59	58 - 109	8.3 - 9.5
<b>Coniferous woods</b>				
Douglas-fir	640 - 800	43 - 68	68 - 89	7.8 - 10,2
Spruce	330 - 680	33 - 79	49 - 172	3.0 - 6.5
Pine	330 - 890	35 - 94	59 - 98	6.1 - 14,6
Larch	440 - 850	64 - 132	107	4.5 - 10,9
Radiata pine	450 - 580	36 - 65	60 - 91	6.8 - 7,6
Fir	350 - 750	31 - 59	47 - 118	3.7 - 6,3

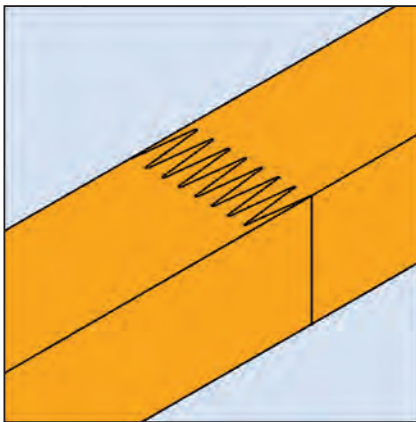
Table: Bulk densities and strength values (moisture content: 12%) for established wood types (source: Holzatlas, Wagenführ, 2007)

The Brunell **hardness** of woods is tested at 12% moisture content. The hardness parallel to the fibres will be approximately double that perpendicular to the fibres. Because of the differing cell forms and varying structures within the wood, hardness figures can only be quoted as guidelines. They are, as for density values, highly dependent upon the moisture content of the wood.

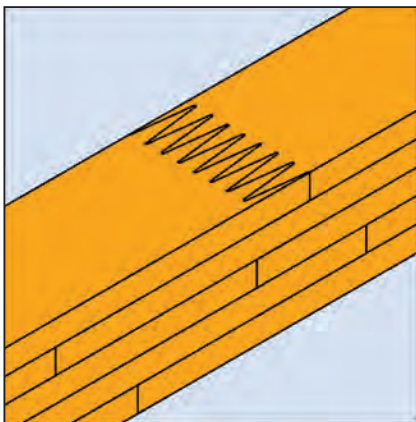


Other physical properties which are of importance when working with wood are its **elasticity and strength**. Elasticity is a measure of the ability of a solid material to return to its original configuration from a distorted state (unit: E-modulus, N/mm<sup>2</sup>). When judging the strength of timber, it should be remembered that knots, splits, spiral grain and other structural idiosyncrasies have a significant effect on this property.

**Moisture content** plays an essential role in terms of how the wood is processed and the quality of the end product. Moisture content is the percentage of water in relation to the dry mass of the wood. In freshly harvested wood, water is both bound in the cell walls as well as contained in the vessels. Moisture content can be over 100% in this case. If the water has escaped from the cell vessels and is only present in the cell walls, then the term „fibre saturation point“ is used. This varies from wood type to wood type and is usually at around 30% moisture content. Below this saturation point, the wood shrinks and swells when moisture is released or added. With kiln dried wood, moisture content is 0. In order to achieve sufficient dimensional stability, the wood should therefore be dried before the finishing process so that the moisture content corresponds with the moisture content of the environment in which it will be used. This is known as the equilibrium moisture content. Indoors, this value is somewhere in the range of 6% to 12%, and is somewhere between 8% and 16% outdoors (without direct exposure to the elements). Moisture content needs to be between 12% and 14% for the best possible woodworking conditions. Below this value, the wood has a greater tendency to split, and above this the surface roughness is increased through shrinkage during final drying.



Structural solid wood (KVH)



Laminated timber (BSH)

Due to its limited dimensions, its swelling/shrinkage and its inhomogeneity from knots and branches, solid wood is usually further refined into **semi finished products**. With structural woods, weak points such as branches or cracks are cut out. Through finger jointing on the end grain edges, components can be manufactured to be any required length. By laminating planks or boards parallel to the wood fibres, larger component cross sections can be created and strength increased. Products in this area include solid structural timber and glue laminated timber. For window frames, for example, the laminated strips can be manufactured using a wide range of wood types with a variety of properties.

#### Modified woods

A large number of modification techniques have been developed and tested over the past few years in an attempt to identify suitable methods for making woods which are available in sufficient quantities dimensionally stable and weatherproof for use outdoors. Pinus Radiata, for example, is stabilised through an acetylation process (Accoya®). Pine is treated with a pressure impregnation process (Belmadur®). Dimensional stability and weatherproofing of thermotreated wood is generated through a pyrolysis process.

Modified wood (examples)  
Accoya®, thermal beech, Belmadur®

One common factor in all of these techniques is that they do not just have an effect on areas near the surface of the wood, but on the material as a whole. These techniques have created „new types of wood“ with minimal swell/shrink behaviour, increased hardness and modified woodworking properties. Cutting forces and wear are lower than with natural woods. Brittleness and dust formation during processing are higher, but these factors do not cause any fundamental limitations.

All materials which are manufactured from wooden structural elements, such as panels, veneer, chips or fibers, are known as wood derived materials in both lay and specialist terminology. Wood derived materials started being developed in the 1920s. Then, large, flat pieces of wood with different thicknesses were bonded and pressed together with the fibres running in different directions. Plywood panels and multiple layer panels opened the way for new designs and construction opportunities.



Cross laminated timber CLT

After 1950, an independent woodchip material industry developed on a global scale from the beginnings of chipboard manufacture in the 1930s. This industry concentrated on panels or moulded parts made from the chips or fibres of hardwoods and coniferous woods, and also of lignified annual plants (such as straw or flax). In the DIN 4076 standard, wood based panels are classified by type, structure and bulk density. The manufacture of wood based panels allowed the development of furniture manufacture on an industrial scale.

Today, wood materials are roughly divided into:

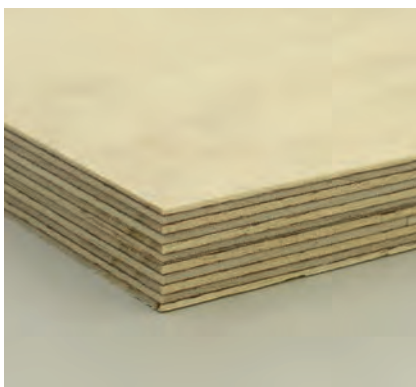
- **Solid wood and veneer materials:**  
such as laminated timber, plywood, veneer plywood or multiplex boards
- **Woodchip materials:**  
such as flat-pressed panels (chipboard), particle boards, oriented strand boards (OSB)
- **Wood fibre materials:**  
Medium-density fibreboard (MDF), high-density fibreboard (HDF), hard fibreboard or wood fibre insulation boards
- **Wood composites:**  
such as wood plastic composites (WPCs); light weight building slabs – high-strength surface layers with a soft core of foam, balsa wood or honeycombs of cardboard or plastic; synthetic resin compressed wood (armourply) – compressed materials made from beechwood veneer and synthetic resin (bulk density: 900 – 1400 kg/m<sup>3</sup>)



Block board

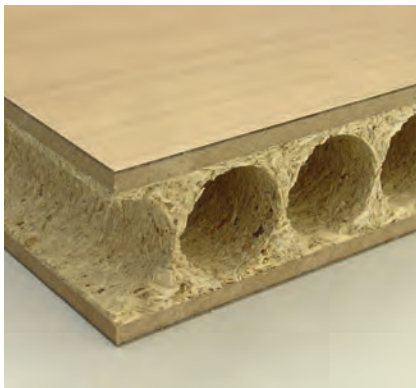
The objective with all these wood materials is to generate a material which is isotropic in at least two dimensions, despite the anisotropic properties of wood. A layer structure which is symmetrical with the midplane of the board is an important pre-requirement to guarantee warp free boards.

With **solid wood and veneer materials**, quasi-isotropic properties are obtained through the individual layers being bonded together parallel to their fibres. During the woodworking process with such materials, the tools must be configured for simultaneous processing both parallel and perpendicular to the fibre direction. The glued joints usually generate the highest tool cutting edge wear.



Multiplex plywood

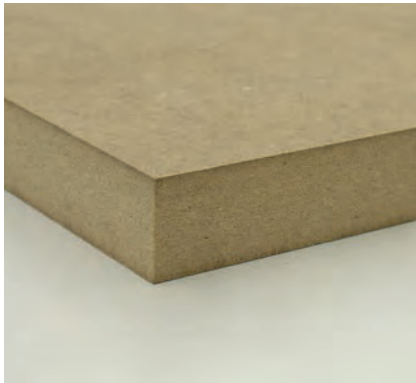




Extruded chipboard as heart of a composite material



Chipboard, plastic coated



MDF board

**Chipboards** are divided into two different categories, flat pressed panels or particle boards, depending on the pressing method used. With flat pressed panels, the woodchips are primarily oriented in the direction of the panel. A variety of layers with a variety of properties can be manufactured by changing the size of the woodchips. Usually, panels are manufactured as three layer panels. The middle layer has large woodchips whereas the two outer layers have finer woodchips giving a smooth surface. In contrast, woodchips in particle boards lie predominantly perpendicular to the direction of the panel. They have the same structure through the entire cross section.

Chipboards are classified by strength and moisture resistance to DIN EN 312-1.

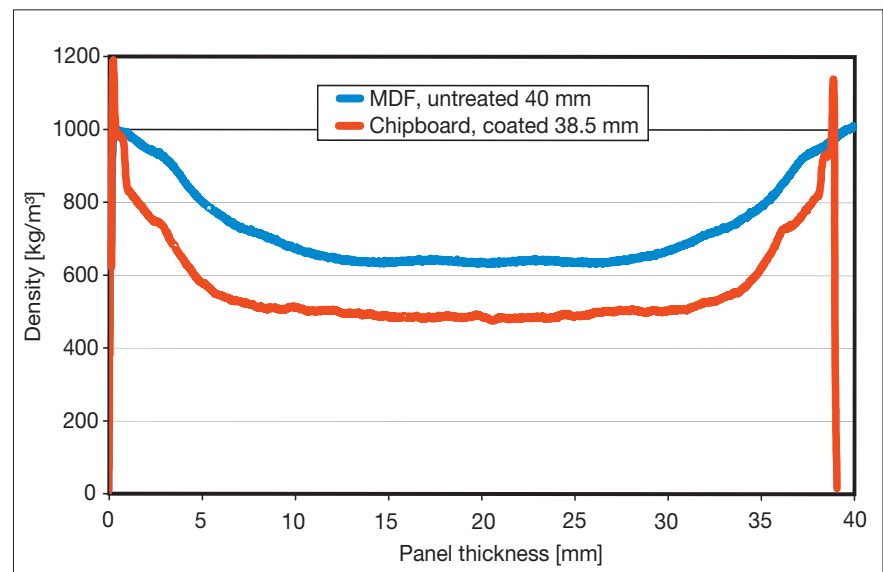
General use (non load-bearing function)	General use, also for load-bearing components	Heavy duty for load-bearing components
P1 for light panelling in dry areas	P4 dry areas	P6 dry areas
P2 for furniture and interior fittings in dry areas		
P3 in moist areas	P5 moist areas	P7 moist areas

Fungicides and flame retardants can also be added to the boards during the manufacturing process.

The most important features of chipboards are, however, their bulk density and their strength. Heavy chipboards (such as flat pressed panels), widely used in furniture and interior fittings, have a bulk density of between 450 and 750 kg/m<sup>3</sup>. During storage of the wood, non wood materials such as sand and small stones enter the manufacturing process, meaning that chipboards have a certain level of sand content. Sand content and particle size play a vital role in tool wear, which is why diamond tools are predominantly used in industrial processing. The shortage of raw materials has resulted in waste wood increasingly being processed into chipboard which means that the proportion of impurities in the wood is increasing.

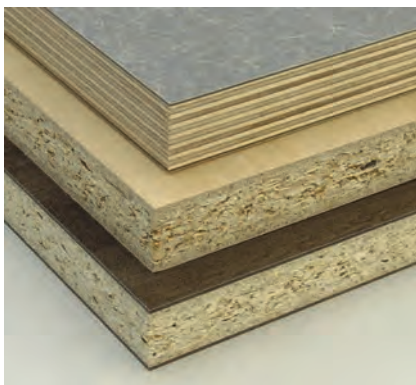
The large number of particle boards' variations depending on their composition and the related properties as lacking distortion and decorative coatings explains the frequent and versatile use in furniture manufacturing and interior fittings.

Alongside woodchip materials, **wood fibre materials** are also classified according to their composition and method of manufacture. Porous fibreboards with a bulk density above 230 kg/m<sup>3</sup> as well as medium hard, hard and extra hard fibreboards with a bulk density up to 800 kg/m<sup>3</sup> are manufactured from wood or other lignocellulose fibrous raw materials.



Density profiles of chipboard and MDF

„**Medium-density fibreboard**“ (**MDF**) became more and more important in furniture and interior fittings constructions in the 1980s as a further development of woodchip and wood fibre materials. Just like solid wood, the surfaces and edges of MDF panels can be profiled and finished as a result of their homogenous structure. They are predominantly manufactured from bark free coniferous wood which undergoes several phases of preparation to turn it into dry ultra fine fibres. This substance is then pressed together with glues which are low in harmful substances to create a panel with a roughly constant density. Bulk density is usually somewhere between  $600 \text{ kg/m}^3$  and  $1000 \text{ kg/m}^3$ . According DIN EN 316 there are three different types: HDF ( $\geq 800 \text{ kg/m}^3$ ), light MDF ( $\leq 650 \text{ kg/m}^3$ ) and ultra-light MDF ( $\leq 550 \text{ kg/m}^3$ ).



Coated panel material

When processing with machine tools, the **type of coating** must also be kept in mind alongside the physical and chemical properties of the materials. All types of wood materials are usually delivered as a finished product with some kind of coating. Surface finishes range from veneer and paint to paper and plastic of various thickness and hardness. Typical examples of the latter category are melamine resin or HPL (high-pressure laminate) coatings. The hardness and structure of the coatings mean that cutting geometries need to be adapted to ensure tear free processing. Overlays of laminate panels, which contain corundum particles to increase abrasion resistance, generate the highest levels of cutting edge wear.

Wood materials, with their wide range of specifications, have, like no other material, changed the way products are designed and the way materials are processed. Every new type of material brings with it new demands in terms of machinery and tools. Tear free cutting edges and precise profiling must be achieved with efficient manufacturing methods. Every further development with wood materials therefore leads to new and specially adapted tool designs and, if necessary, new processing methods.



Thermoplastic plastics  
(solid material)



Extruded plastic profiles



Polymer clumping in the case of  
thermoplastics (schematic diagram)



Gloss cut section on PMMA workpiece

Plastics consist of interwoven molecule chains, polymers, which in turn are composed of repeating structural units called monomers. The type of polymer bond determines the plastics properties. There are three main groups: thermoplastics, thermosets and elastomers.

Two common factors for all plastics are a low density and low thermal conductivity. The different properties of different types of plastics must be taken into account in machining work. High quality, efficiency and production security can only be achieved with tools and machining parameters specially customised to the material.

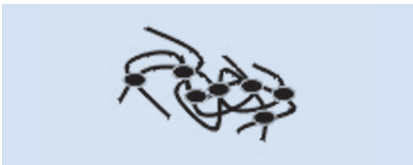
#### Thermoplastics

In thermoplastics, the molecule chains are crosslinked. A typical characteristic of thermoplastics is that they have a temperature at which they soften. Once a thermoplastic is heated above this temperature, it is soft and can be formed and shaped. Below this temperature (specific to a particular thermoplastic) thermoplastics retain their original shape. Thermoplastics can be used in a number of processes – injection moulding, extrusion and press forming.

Thermoplastic plastics also can be strengthened by fibres in order to increase density. Normally this involves short fibres so that the extrudability is continued. This technology for example is used for window profiles so that a reinforcement with steel inserts can be renounced.

The temperature at which thermoplastic starts to soften is around 60°C (depending on the specific plastic), a temperature relevant to the machining process. Exceeding the softening temperature during machining is detrimental to the machined quality. The chips melt, the tools become sticky, and both quality and production are no longer consistent. As well as specific tooth geometries and tool chip gullets, selecting the machining parameters is of utmost importance. Permitted cutting speeds are usually lower than those permitted with woodworking.

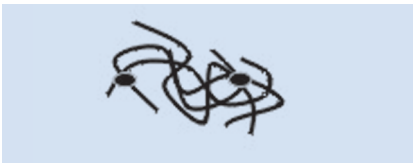
**Transparent thermoplastics** such as PC and PMMA require special processes. A transparent cutting surface is often required. This means having a totally smooth cutting edge with no visible cutter marks, a special cutting geometry and, of course, stable machinery with good clamping. A high quality cut can be achieved with polished tungsten carbide cutting tools. Monocrystalline diamond is the preferred choice for completely glossy surfaces. If these measures are not taken, the result is a matt cutting surface.



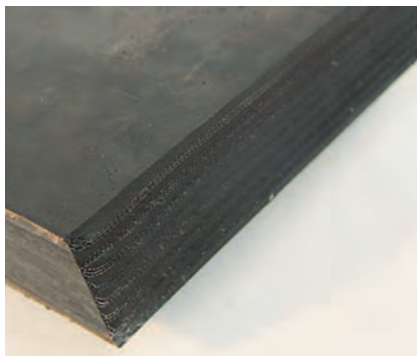
Structure of thermosets  
(schematic diagram)



Compact laminate panel



Structure of elastomers  
(schematic diagram)



Elastomer with fabric insert

### Thermosets

In thermosets, the molecule chains are irreversibly cured at cross linking sites, or nodes, through chemical bonds.

When a thermoset is heated up, the monomers begin to move. The intensity of these oscillations increases as the temperature rises. When the temperature rises above a critical point, the nodes are irreversibly broken. As a consequence, thermosets are destroyed at a temperature specific to the material – the pyrolysis temperature – which is above 150°C. Thermoset materials are usually moulded or, in the case of composites, pressed. They are usually hard and brittle.

To improve the properties of thermosets, **reinforcement materials** in the form of laminated paper, fibreglass, carbon fibre or aramid fibre are incorporated into the thermoset mass. The different combinations of these materials have been given new grade designations such as FR-2, FR-3, FR-4, CEM-1, CEM-3 etc. (for example, FR-4 is glass reinforced epoxy laminate).

Typical examples for duroplastic working materials are for example compact laminate panels or high pressure laminates (HPL laminates) of melamine - or phenolic papers, printed circuit boards (PCB) or PU-foam.

The focus is not on the temperature during the machining process. The cutting speeds are higher than those for thermoplastics. Due to the hard brittle material properties and the abrasive effect of the embedded fibres, tools used in conjunction with thermosets require different geometries and cutting materials than those used to process thermoplastics.

### Elastomers

Elastomers are soft plastics, more commonly known as „rubber“, which can be shaped and then go back their original form when released. This particular property is due to the wide meshed structure of the molecule chains. They do not soften when heated. Machining is possible, but rare. The main difficulty is clamping the workpieces.





Mineral working material

Mineral constituents are attached to board materials using a bonding agent. The materials have specific properties depending on the proportion and type of bonding agent and mineral constituents. Compared to wood materials, the cutting speed for mineral materials must be decreased.

**Polymer bonded mineral materials**

(e.g. Corian, Hi-Macs, Kerrock, Noblan, Surell, Varicor, Velstone)

Two thirds of these materials consist of natural minerals (e.g. aluminium hydroxide, feldspar) which are bonded in an acrylic polymer (PC) matrix. The material can be shaped at high temperature due to its high proportion of acrylic. The proportion of mineral materials raises the softening temperature of the plastic, which makes machining easier. These materials are mainly machined using tungsten carbide or polycrystalline diamond cutting tools. Very large mineral particles can damage diamond cutting edges so, as a result, tungsten carbide cutting edges are recommended in this case.

Polymer bonded mineral materials are available as panels with a thickness between 4 mm and 20 mm, and as moulded parts (e.g. wash basins). They are usually applied to wood based panels and can be joined by adhesion and flush trimming. Large scale components can be manufactured using this process. To obtain straight and scratch-free saw cuts, AS foil vibration damped sawblades are recommended.



Perlite panel

**Perlite-based fire protection board**

A characteristic of this material is that it has a highly abrasive action on the tool body. Circular sawblades' bodies are particularly vulnerable to this problem. The gullet is eroded and as a result, the tooth breaks away although the carbide tip has not reached the wear limit. That is the reason why the use of special tool design with wear-protected basic-bodies and jaws are recommended.

**Regular and fibre reinforced plaster board**

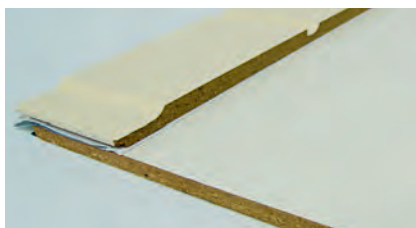
These materials are machined in dry and „wet“ condition. In the wet condition, tungsten carbide is recommended as a cutting material. Diamond is suitable as a cutting material for dry but not wet machining.



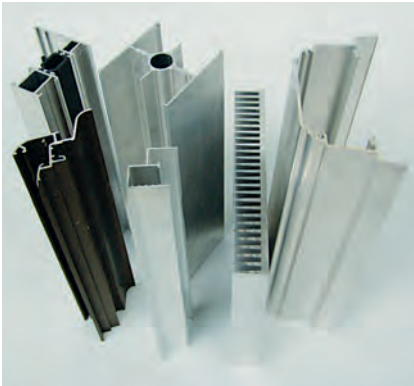
Plaster board / gypsum board

**Fibre reinforced cement slabs**

One of the special properties of fibre reinforced cement panels is their high density. If unsuitable machine parameters are chosen, sparks may occur during machining. Tungsten carbide has only a short run time; thence diamond is preferred as cutting material even by power-driven hand tools or high-volume work.



Cement fibre board



Aluminium extruded sections

Wrought aluminum alloys are the most common examples of **non-ferrous metals**. They exist as hollow or full profiles, as sheets or as surface layers or intermediate layers in wood materials.

Silicon is added to increase machinability. Si content  $\geq 12\%$  leads to increased cutting edge wear which is why diamond cutting edges are recommended. If the Si content  $\geq 12\%$ , the aluminum tends to „fuse“ to the cutting edge during machining and this quickly leads to build up on the edges. Tungsten carbide should be used, if possible, together with coolants (minimum quantity lubrication – MQL).

Tools with diamond cutting edges (PCD) are particularly suitable for dry machining. Build up on edges are avoided and better machining quality is achieved due to the extremely high thermal conductivity and low friction values of diamond. Sawblades with specially shaped teeth and small cutting angles (some negative) are employed in cutting hollow profiles to avoid the teeth hooking the thin web. Foil saws are particularly suited for scratch-free trim and mitre cuts due to their good vibration damping properties.

A **composite** consists of two or more materials which are combined to produce different material properties. Composites have different properties to the materials with which they are combined.

Essentially, there are two groups:

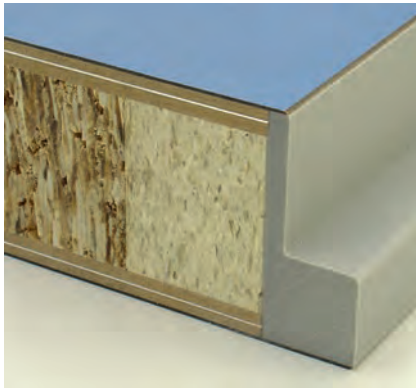
Composite layered materials, such as:

- Composite panels (e.g. plywood or wood core boards)
- Sandwich panels (stable outer layers with a soft core)
- Honeycomb panels
- Chipboards with aluminium barrier layers (vapour barrier)
- Window frames with insulation material as a middle layer
- Floor panels with a HDF core and a variety of surfaces (PVC, cork, felt®)

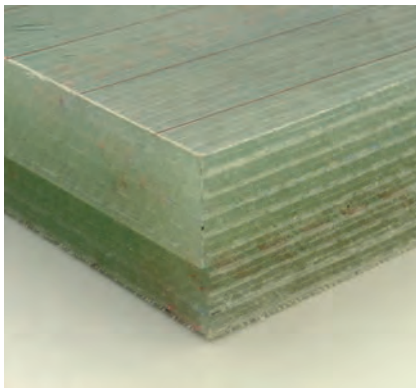
Composite fibre materials, such as:

- Carbon fibre reinforced plastic (CFRP)
- Glass reinforced plastic (GRP)
- Aramid fibre reinforced plastic
- Natural fibre reinforced plastic
- Wood plastic composites (WPC)
- Fibre cement boards

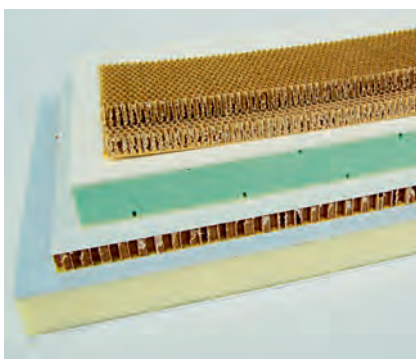
The difficulty in terms of machining is a result of the often conflicting requirements of the individual material components concerning the cutting edges, meaning the tools usually have to be specially designed for particular composites. In the case of composite layered materials, a variety of cutting materials can be employed at the same time to machine the different layers (so called hybrid tools). Because of the different strengths of the individual components, there is often the risk of delamination from the cutting forces.



Layer composite working material



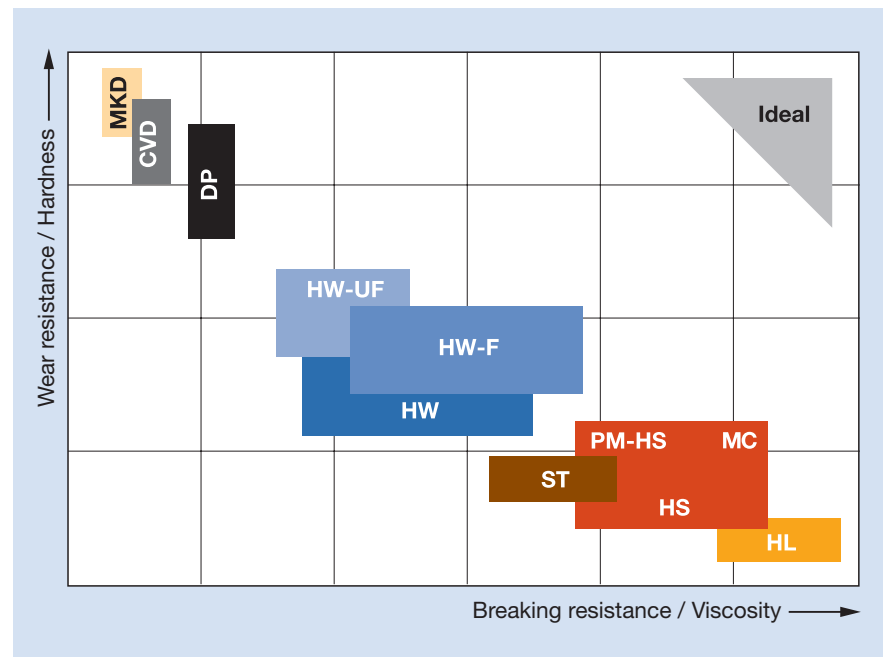
Fibre composite working material



Lightweight working material with honeycomb or foam core



Profit is made at the cutting edge! Wear resistant cutting materials with sharp cutting edges guarantee long tool life and high surface quality. The full potential of a cutting material needs the correct cutting edge geometry, and in turn, is dependent on the machining process and the properties of the material being shaped.



### Cutting materials for processing wood and plastics

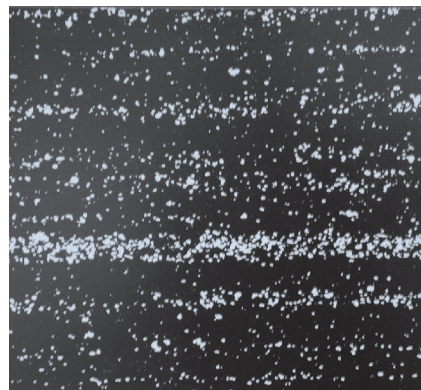
The ideal cutting material should be hard and tough at the same time, but an „all-purpose material“ of this kind simply does not exist. Today the choice of woodworking cutting materials range from tough tool steel to the hardest material in the world, diamond. The wide variety of workpiece materials and tool designs need all of these cutting materials:

**Diagram:** Classification of the tungsten carbides in cutting groups as per ISO 513

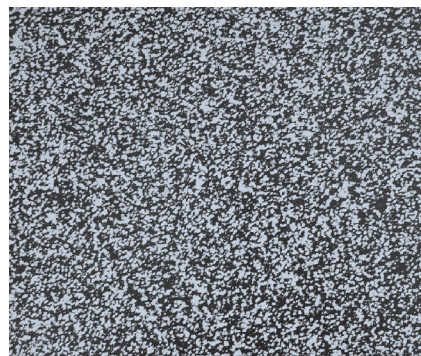
K-grade: WC + binders

P- and M-grade: Additionally with WC-TiC and WC-TaC mixed crystals for higher temperature strength

Group	Application / working material	Code	Hardness	Viscosity
P	Steel, steel casting, long-chipping, malleable iron	P01	↑	↓
		P10		
		P20		
		P30		
		P40		
M	Steel, steel casting, austenitic manganese steel, austenitic steel, free cutting steel, alloyed grey iron	M10	↑	↓
		M20		
		M30		
		M40		
K	grey iron, chilled iron, short-chipping malleable iron, hardened steel, <b>non-ferrous metals, plastics, wood, wood-derived materials</b>	K01	↑	↓
		K05		
		K10		
		K20		
		K30		
		K40		



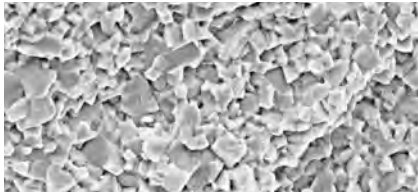
Roco-shaped structure for melting made HS steel



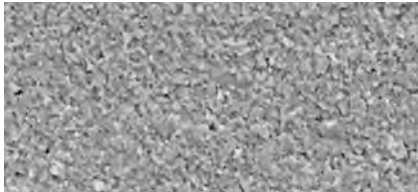
Homogenous structure for PM-HS Steel

Cutting material with abbreviation	Composition, manufacture	Characteristics and possible use
<b>SP</b> Alloy tool steel	alloy content < 5% (C > 0.6%). Few carbides, therefore only low hardness and heat resistance. Manufactured in a molten-metallurgical process.	Hardenable up to 60 HRC.  For solid wood processing in the craft sector, e.g. as a profile knife for universal cutterheads.
<b>HL</b> High-alloy tool steel	alloy content > 5% Alloy elements Cr, Mo, W and carbon form carbides which allow for hardness and wear resistance. At least 1 alloy element > 5% e.g. B 12% Cr and 2% C. Manufactured in a molten-metallurgical process.	Hardenable up to 63 HRC. Very corrosion resistant from high Cr content.  Preferably used in planing mills for soft woods, e.g. solid cutter for manufacturing tongue and groove boards at high feed speed.
<b>HS</b> High performance high speed steel (HSS)	alloy content > 12% Alloy elements W, Mo, V, Co and carbon form carbides which allow for hardness and wear resistance. Manufactured in a molten-metallurgical process, followed by machining processes - linear distribution of the carbides manufactured in a powder-metallurgical process (PM-HS) - higher alloy contents possible, homogenous distribution of carbides.	Hardenable up to 65 HRC. Preferably used for solid wood processing, mainly soft woods, e.g. planers, jointing cutters, profile blanks or tipped profile cutters.  Considerably longer tool life compared to HL steel.  The best relation between toughness and hardness is achieved with HS steel manufactured in a powder-metallurgical process (PM HS).
<b>ST</b> Cobalt-based cast alloys	Almost completely non-ferrous alloys of: Co, W, Cr.  Manufactured in a melting process.	Hardness 40 to 58 HRC. Particularly corrosion and temperature resistant, tough (small cutting angles possible).  Typical applications: Processing of fibrous or damp, acidic woods in sawmills or planing mills, and machining oak, Meranti or poplar.

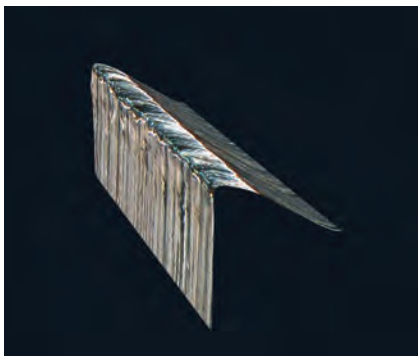




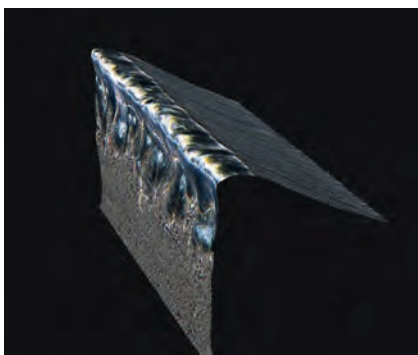
Fracture of a standard tungsten carbide.



Fracture of an UF-tungsten carbide.



Sharp-edged wear on a coated HS edge.

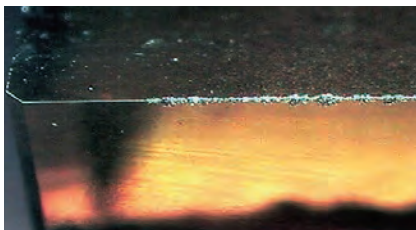


Rounding- and erosion wear on an uncoated HS edge.

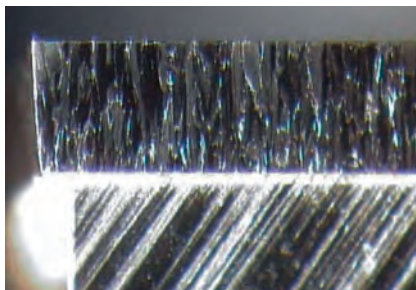
Cutting material with abbreviation	Composition, manufacture	Characteristics and possible use
<b>HW</b> Carbide metals	<p>Sintered materials composed of metal carbides and metallic binders (mainly WC + Co).</p> <p>Manufactured in a powder-metallurgical process by mixing and pressing the basic powder materials, followed by sintering at high pressures and temperatures.</p>	<p>Hardness between HV 1300 and 2500.</p> <p>Hardness and toughness can be varied over a wide range by altering the grain size and quantity of the binder in the mix.</p> <p>Universal cutting material for wood processing with wide range of application from knotty softwood with glued joints to panel materials and solid plastics. Ultra fine carbide metals allow for very sharp cutting edges as a prerequisite for paintable surfaces.</p>
<b>SC (MC)</b> Steel, coated  <b>HC</b> Tungsten carbides, coated	<p>2 – 3 µm thick hard material coating on the blade.</p> <p>Coating materials: Nitrides, carbides, carbon nitrides or oxygen nitrides from the elements Ti, Al, Cr, Zr.</p> <p>Manufactured in a vacuum coating process.</p> <p>A new cutting material is created by the coating. The substrate is no longer solely responsible for the wear resistance but assumes a supporting function for the coating.</p>	<p>Surface hardness between HV 1600 and 3500.</p> <p>The chemical and abrasive wear resistance of the substrate at the surface of the blade is significantly increased. The edges remain sharp longer and friction is reduced. Performance times can be improved five fold compared with uncoated tools. This performance is retained even after sharpening.</p> <p>Preferred applications: solid wood, thermoplastics, non-ferrous metals</p>



DP edge polycrystalline diamond layer (on top) sintered on to a tungsten carbide substrate (on bottom)

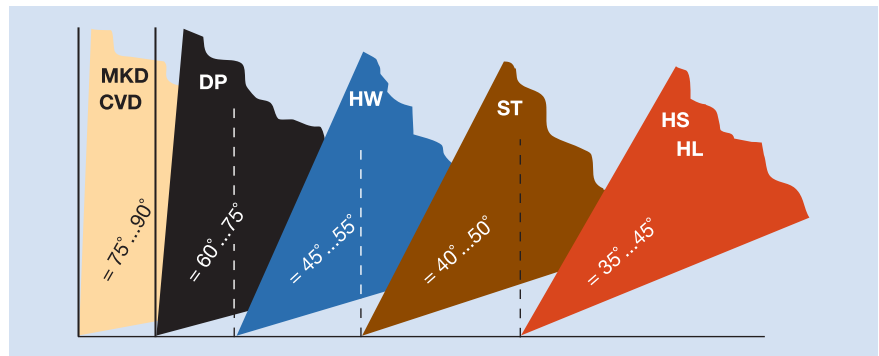


DM edge - monocrystalline synthetic diamond



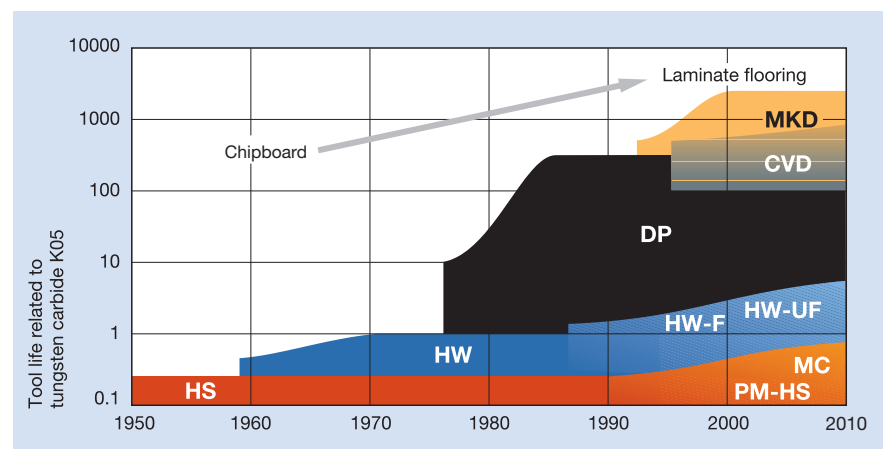
CVD diamond layer of columnar diamond crystals, soldered on tungsten carbide

Cutting material with abbreviation	Composition, manufacture	Characteristics and possible use
<b>DP</b> Polycrystalline diamond (PCD)	Sintered layer (0.3 – 0.6 mm) composed of diamond crystals on tungsten metal surface. Diamond grain size: 1 – 30 µm. Manufactured in high-pressure synthesis process. Diamond grains sinter among each other forming a layer and are combined with a tungsten carbide substrate. Due to the diffusion of Co from the tungsten carbide between the diamond grains, the diamond becomes conductive and may be processed by spark erosion.	Composed of the hardest material, wear starts at grain boundaries, very good thermal conductivity. Hardness and toughness can be varied within certain ranges by altering the grain size. The field of application of DP cutting materials ranges from solid woods, chipboards and fibre boards to very abrasive materials such as fibre cement boards, laminate floors or fibre reinforced plastics (composites). Excellent suitability for dry processing of non-ferrous metals.
<b>DM</b> Monocrystalline diamond	Diamond monocrystal (structure with grain boundaries). Manufactured in a high pressure synthesis process. Only available in dimensions of a few millimeters. Processing only possible by grinding with diamond.	Harder than DP. Very smooth cutting edges can be produced as there are no grain boundaries. Can be used for very abrasive laminate overlays or for a polished finish on plastics and non-ferrous metals.
<b>CVD</b> Polycrystalline diamond layer	0.5 mm thick diamond layer composed of columnar diamond crystals grown together, brazed on a tungsten metal support. Manufactured in a plasma CVD coating process. Due to doping with boron, conductive and erodable.	Harder than DP and DM as there is no metallic binder phase and the diamond grains with their crystal grid layer levels are positioned randomly. Used for particular laminate's overlays.



### Specific cutting material geometries

Due to the relation between hardness and toughness, there is a specific angle geometry for every cutting material to achieve optimum cutting performance. Hard, brittle cutting materials require a stable wedge angle so the edges cannot break off. Less hard, but tougher cutting materials require larger cutting angles to maintain a cutting edge. Tungsten carbides offer the highest degree of design freedom and can be used for almost every application.



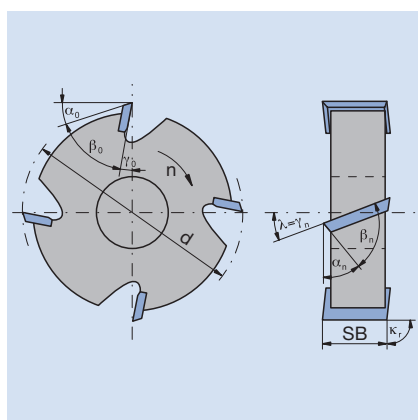
### Progress in tool life by different cutting materials

All cutting material developments are aimed at longer tool life. New work piece materials often call for new cutting materials. Chipboard led to the use of tungsten carbide and later to polycrystalline diamond, laminate flooring to monocrystalline and CVD diamond and plywoods to fine grain tungsten. In the 50 years of panel material development, tool life has increased a thousand fold.

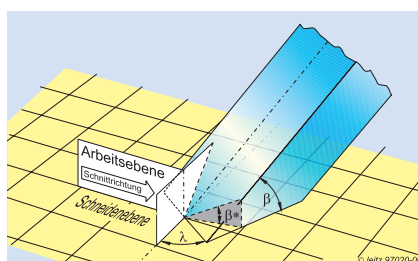


## 11.3 Fundamental cutting principles

### 11.3.1 Essential geometry elements in a cutting tool



Cutting geometry and description of angles

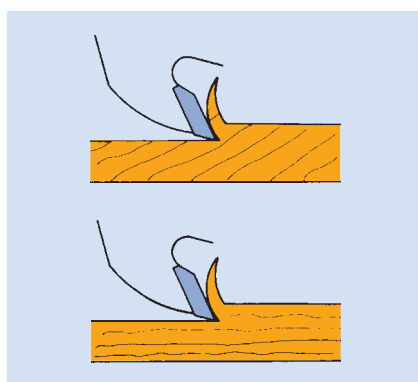


„Shear cut“ - the shear angle effectuates a reduction of the wedge angle in cutting direction

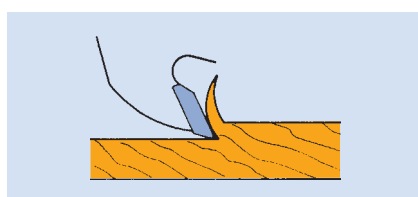
Größe	Symbol	Bedeutung
Cutting angle (Gamma)	$\gamma$	Influences cutting force and pre-splitting. For cross grain and tough materials rather large cutting angles, for hard, brittle materials rather small cutting angles.
Wedge angle (Beta)	$\beta$	Important for cutting edge stability. Cutting material specific minimum wedge angle required, so that cutting edge does not break off.
Clearance angle (Alpha)	$\alpha$	Reduces friction between blade and workpiece and resin build up.
Shear angle (Lambda)	$\lambda$	Creates a „pulling cut“. Acts as cutting angle for the leading secondary cutting edge (cutting flange). Influences the chip flow in axial direction.
Edge setting angle (Kappa)	$\kappa_r$	Enlarges the start of the cutting angle of the blade. For edge setting angles $< 10^\circ$ , almost no cutting actions can be seen (e.g. edging tools).
Secondary cutting edge angle	$\gamma_N$	Corresponds to the shear angle of the main cutting edge.
Leading edge angle	$\beta_N$	Important for the stability of the secondary cutting edge. Normally larger than the secondary wedge angle of the main cutting edge.
Secondary cutting edge clearance angle	$\alpha_N$	Reduces friction between secondary cutting edge and workpiece and resin build up.
Diameter	d	Regarding profile tools, the zero diameter (mostly the smallest diameter) sets the processing position of the tool. The maximum diameter is set by the permissible rotational speed $n_{max}$ and for collision factors.
Cutting width	SB	Determines the maximum processing width of the tool.

## 11.3 Fundamental cutting principles

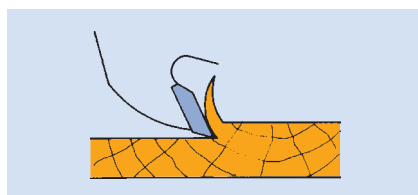
### 11.3.2 Cutting directions and procedures when cutting wood



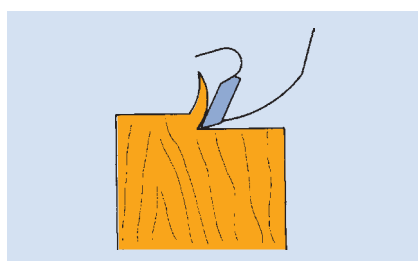
Longitudinal cut with the grain



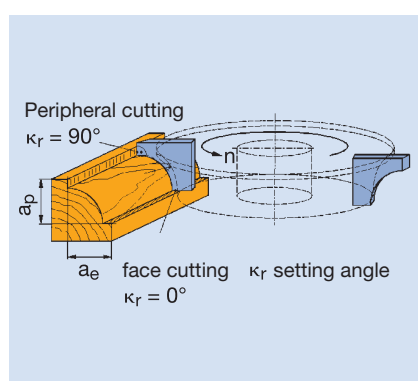
Longitudinal cut against the grain



Cross-cut



Cutting in end grain



Cutting procedure on the example of „profile cutting“

Due to the anisotropy of the wood as a naturally grown material, it can basically be divided into **three cutting directions**:

#### a) Cutting along the grain

1) With the fibres

Easy to cut. Excellent surface quality and high feed rates possible.

2) Against the fibres

Difficult to cut, as the fibres tend to lift. If possible this cutting direction should be avoided by using alternatives, for example changing the direction of rotation (against feed/with feed).

#### b) Cutting across the grain

Low cutting forces, but the surface finish is slightly rough surface as wood fibres are „peeled off“.

#### c) Cutting the end grain

The fibres are cut vertically to the fibre direction. The result are high cutting forces and slightly rough surface finishes. When the cut is completed, fibres may be torn out which is why it is cut with smaller tooth advances and using against a wood backing piece.

In the case of knotty wood and around branches, all cutting directions may occur at the same time. Due to specific cutting techniques and tool designs for pre- and finish-cutting, a continuously good processing quality is achieved.

Due to the cutting surface area there are different **cutting applications**:

#### a) Peripheral cutting

The circumference of the cutting tool machines the workpiece. The circumference of the tool is surface determining. The tool's axis of rotation and the surface of the workpiece are vertical to each other. The enclosed angle,  $\kappa_r = 90^\circ$ , is called the setting angle.

Examples: planing, jointing.

#### b) Surface planing

The face of the cutting tool machines the workpiece surface. The front face of the tool is surface determining. The tool's axis of rotation and the workpiece surface are parallel to each other. The enclosed angle (setting angle) is  $\kappa_r = 0^\circ$ .

Examples: cutting, circular saws, edging.

#### c) Profile cutting

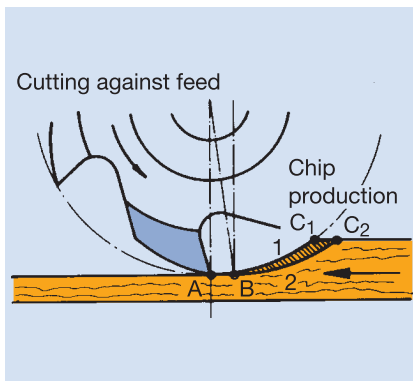
Profiling is a combination of peripheral and face cutting, irrespective of whether the tools have shanks or bores. In general, there is a smooth transition from peripheral to face cutting in profiling. Any setting angle between  $(0^\circ \leq \kappa_r \leq 90^\circ)$  can occur.

Examples: round profiles, finger profiles or any decorative profiles - but also bevelling, rebating, grooving or slotting.



## 11.3 Fundamental cutting principles

### 11.3.2 Cutting kinematics



Chip formation when running against feed

#### a) Cutting against the feed

The direction of the tool cut is opposite to the direction of workpiece feed. Initially the cut has zero thickness. Before a chip can form and move across the cutting surface, the cutting edge presses against the workpiece at the start of the cutting angle. The final workpiece surface is created during this initial phase. As the cutting action increases, the cut becomes more stable with the increasing cut thickness. The final stage of the cutting process is when the chip breaks away; this is known as pre-splitting.

AB: friction zone.

B, C1, C2: elongated chip.

#### Advantages:

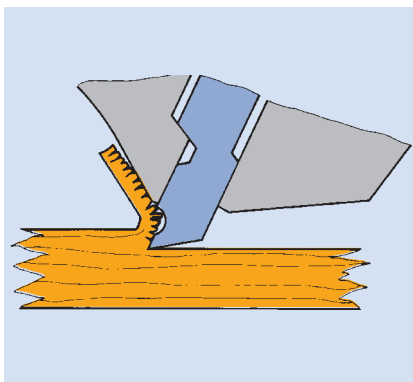
Pre-splitting can help reduce cutting forces, the required motor power, and increase tool life. A lower drive output is required.

#### Disadvantages:

If the direction of the fibres and the pre splitting direction runs from the cutting edge toward the „go” side of the workpiece, pre-splitting creates a rough surface with torn fibres.

A chip breaker ahead of the cutting edge helps form the chip earlier and reduce pre-splitting.

Since there are constantly changing fibre and feed directions during stationary machining on CNC machining centres, special cutting techniques are necessary to avoid unfavourable fibre cutting angles.



Effect of a chip breaker

#### b) Cutting with the feed

For mechanical feed only.

The tool cutting direction is the same as the direction of workpiece feed. Cutting starts at the maximum chip thickness, falling to zero by the time the cut is completed. With increasing cutting action, the chip becomes thinner and finer and with less risk of pre splitting.

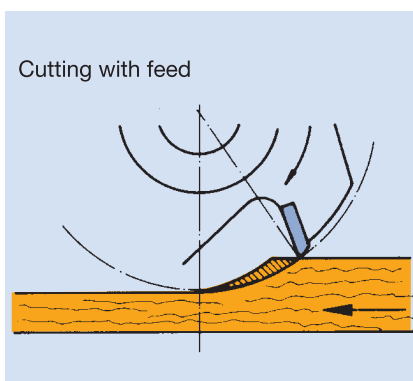
#### Advantages:

Comparatively good surfaces are obtained when there is an unfavourable fibre direction. Lower feed forces required, allowing an increase in the feed speed.

#### Disadvantages:

The cutters are subject to more severe loads and wear quicker because of the reduced pre splitting. The tool life is approximately 30% shorter compared to cutting against the feed.

There is the danger of tool kick back that means hooking of the cutting edges and acceleration of the workpiece to cutting speed. Cutting against the feed is recommended for manual feed to prevent accidents.



Chip formation when running with feed

## 11.3 Fundamental cutting principles

### 11.3.4 Processing quality

During the peripheral cutting process (e.g. planing, jointing, profiling), the workpieces's surface finish is produced by the peripheral blades. By superimposing tool rotation on the linear feed movement of the workpiece, a succession of cutting actions produce a wave effect on the surface of the workpiece. The pitch, depth and uniformity of these planing or cutter marks determine the machined surface quality. The dimensions of the cutter marks are a combination of the cutting radius, the effective number of teeth, spindle rotating speed and feed rate.

These considerations also apply to face cutting tools such as cutters or circular saw blades. The concentric run-out is replaced by the axial run-out.

Terms and formulae relations:

$v_c$	$= \pi \cdot D \cdot n / (1000 \cdot 60)$	Cutting speed [ $\text{m s}^{-1}$ ]
$n$	$= v_c / (\pi \cdot D) \cdot (1000 \cdot 60)$	Speed of rotation [ $\text{min}^{-1}$ ]
$v_f$	$= f_z \cdot n \cdot Z / 1000$	Feed rate [ $\text{m min}^{-1}$ ]
$f_z$	$= v_f / (n \cdot Z) \cdot 1000$	Tooth advance [mm]
$f$	$= f_z \cdot z = v_f / n \cdot 1000$	Feed per rotation [mm] cutter mark length of jointed tools
$f_{z\text{eff}}$	$= f_z \cdot 1 = v_f / n \cdot 1000$	Effective tooth feed visible on the workpiece [mm] (cutter mark length) [mm]
$t$	$= f_z^2 / (4 \cdot D)$	Depth of knife marks [mm]
$h_m$	$= f_z \sqrt{(a_e / D)}$	Mean cutting thickness [mm]
$a_e$	$=$	Radial cutting action, cutting depth [mm]
$a_p$	$=$	Axial cutting action, cutting width

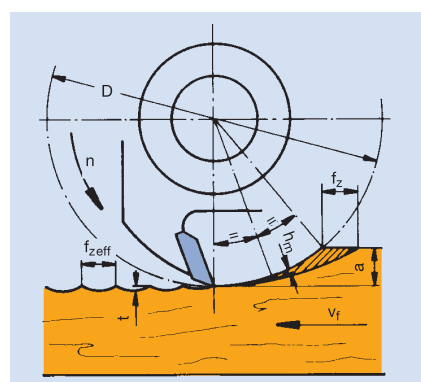
These formulae have numerical values.

All values must be entered using the units of measurement shown in the square brackets [ ].

Top quality surfaces have cutter marks at a regular pitch between 1.3 and 1.7 mm. As the cutter mark length increases, surface finish quality deteriorates but tool life increases. As the cutter mark length decreases, the mean cutting thickness  $h_m$  decreases as well. As a result, friction and wear increase and tool life decreases.

#### Single knife finish

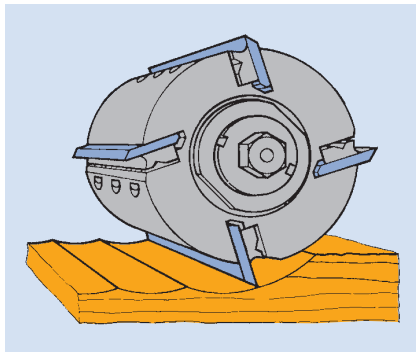
Due to the production tolerances, the cutting edges on a multi-knife tool do not all have the same cutting radius. With conventional tool clamping (clearance fit between spindle and tool), only one cutter normally creates the workpiece surface. This is known as a single knife finish. The other cutting knives contribute to the cutting process, but do not determine the finish surface quality of the workpiece. The cutter that projects farthest removes traces of the cutting action of the other cutters.



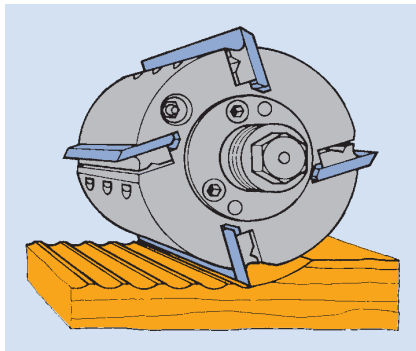
Finish formation and cutting sizes on the example of „chamfering“

## 11.3 Fundamental cutting principles

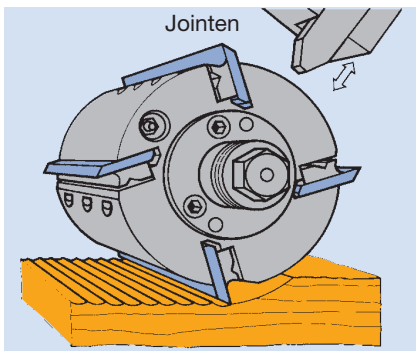
### 11.3.4 Processing quality



Finish formation for conventionally clamped tools



Finish formation for high precision tools with centering adaptor



Finish formation for jointed tools with centering adaptor



Quality criteria „waviness“

The visible cutter marks on the workpiece  $f_{z\text{eff}}$  correspond to a single knife finish ( $Z = 1$ ). As the cutter mark pitch determines the quality of the workpiece's surface, the feed rate is equivalent to  $Z = 1$  in these conditions.

$$\rightarrow f_{z\text{eff}} = v_f / (n \times 1) \times 1000 = f$$

( $f$  = feed per tool revolution)

#### Multi knife finish

Tool concentric run-out tolerance is significantly reduced by a clamping system that centres the tool on the spindle, such as a hydro clamping system, shrink-fit clamping or HSK. Hydro clamping makes the cutting action of several cutters visible on the workpiece surface. The number and spacing of these is undefined (not regular) because of the remaining run-out tolerance. If the tool is carefully balanced (G 6.3 or better), an adequate finish can be obtained for many applications from this multi knife machining process if the feed rate is high, for example for tongue and groove panel processing or the production of linear mouldings.

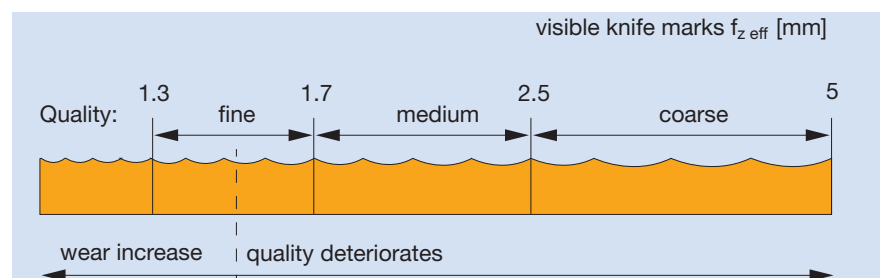
A run-out tolerance of zero can be achieved by subsequently dressing the cutting edges within the  $\mu\text{m}$  range known as jointing which is performed at full operational speed on the machine spindle. The knife marks are then at uniform intervals on the workpiece surface. This technology enables the feed rate to be multiplied by the number of cutters, with the quality is equivalent to a single knife finish.

$$\rightarrow f_{z\text{eff}} = v_f / (n \times Z) \times 1000 = f_z$$

( $f_z$  = feed per tool tooth)

#### Criteria for the processing quality

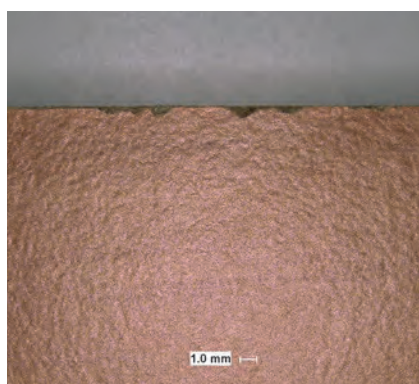
Tool parameters and tool life are measured by the processing quality. For judging surfaces, e.g. during planing, the distance and the depth of the visible cutting actions are decisive. Regarding coated panels, workpiece edges without break outs are important.



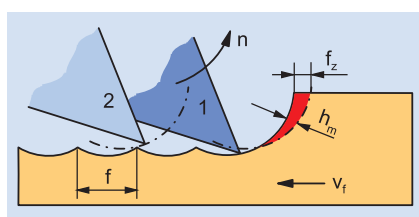
The cutting action of the highest protruding edge is responsible for the **distance of the visible cutting actions** (knife marks). The remaining blades produce chips; their start of the cutting angle does not reach the machined surface. Therefore, the jointing technique is in particular used for planing so that all edges process the planed surface to the same extent.

## 11.3 Fundamental cutting principles

### 11.3.4 Processing quality

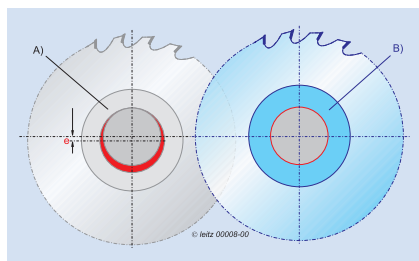


Quality criterion of „break outs“



The tooth feed rate  $f_z$  defines the mean chip thickness  $h_m$

$$f_z = \frac{V_f}{n \times Z}$$



Centering tool interface

A) conventional interface with fitting tolerance „e“

B) Centering interface without fitting tolerance

Balancing quality:  $G = e \cdot w$

The **depth of the start of the cutting angle** is determined by the tool diameter and by imbalances and vibrations.

For the quality criteria **tear outs or edge break outs**, the mean cutting thickness  $h_m$  is of particular importance. As the mean cutting thickness increases, the woodchips become more stable and tend to break and pre-split. A result is damage to the machined workpiece, that means tear outs or splinters in solid wood and edge break outs in panel materials. Therefore, tooth advance may not be increased arbitrarily. The possible tooth advance depends on the tool diameter and the start of the cutting angle of the tool cutting edges. There are specific guide values for the tooth advance  $f_z$  for each workpiece depending on the processing method such as sawing, cutting, planing, finish milling, drilling.

Imbalance and run out tolerances result in different mean cutting thicknesses on the cutting edges of a tool. The thickest woodchips limit the cutting performance. The better the concentric and the axial run-out of the tool cutting edges, the more even the mean cutting thickness of each edge and the higher the possible tooth advance  $f_z$  is. With a constant spindle speed  $n$  and tooth number  $Z$ , this means: Tools with a high imbalance and a small run-out tolerance allow for higher feed rates. At the same time, the higher feed speed is connected with enlargement of the start of the cutting angles with the side effect that further edges (even if with irregular distances) are involved in creating the surface finish. The law of the „single knife finish“ no longer applies.

**Centred mounting sleeves** such as a hydro clamping system, shrink-fit clamping or HSK eliminate the tolerance between the tool and the machine spindle and are required for low imbalance ( $G \ 6.3 \text{ mm s}^{-1}$  or better) and for accurate concentric and axial run-out of the edges ( $0.02 \text{ mm}$  or better). The tools must be sharpened mounted on this centred mounting sleeve.

If surfaces without tear outs and edges without break outs are a quality criteria and the processed surfaces are flat, then tools manufactured this way may be used for much higher feed speeds compared to a single knife finish. Examples for this include high toothed profile cutters for panel manufacture (laminate panels, tongue and groove boards) which are machined without jointing at feed speeds above  $200 \text{ m min}^{-1}$  or cutter tools for forming furniture panels which achieve speeds up to  $100 \text{ m min}^{-1}$ .

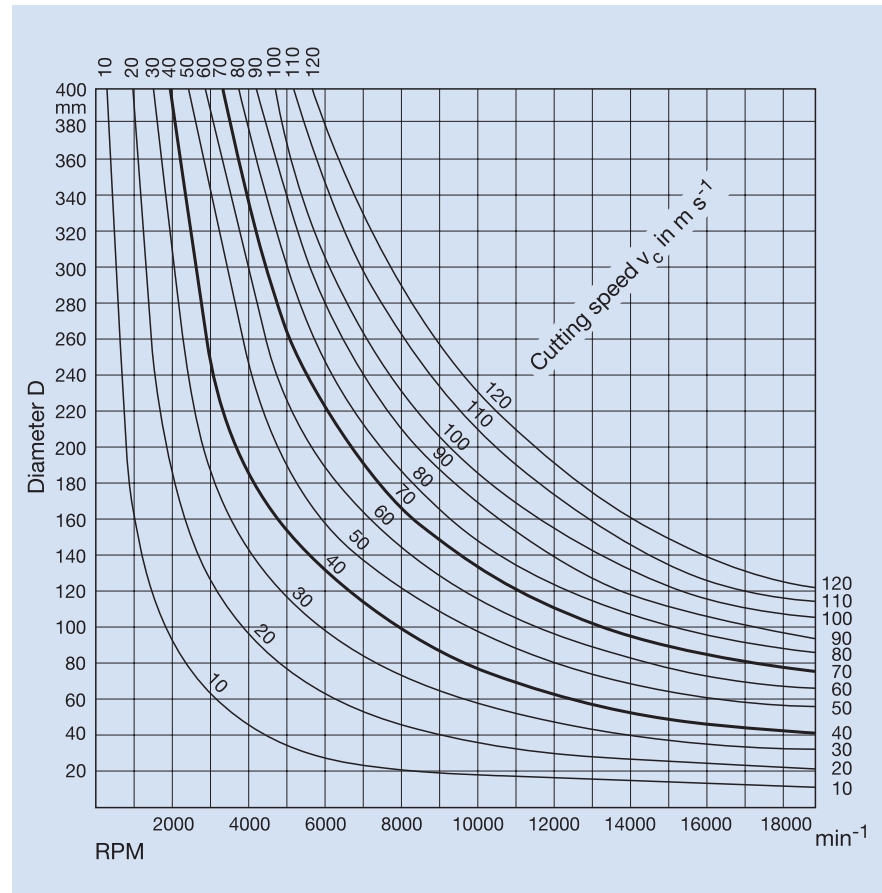
When choosing the appropriate machine tool, many interdependent factors must be considered. The goal to achieve a first-class wood surface finish, a saw cut surface without tear outs and an accurate drilling result requires that the cutting material, tool and machine operating data have been adapted to the material characteristics and to each other. Thus, the finished machine tool is the result of analysis and evaluations before the machine is built.

#### Determination of cutting speed in relation to speed of rotation and tool diameter

The graph shows the cutting speed in  $\text{m s}^{-1}$  in relation to the speed of rotation and tool diameter. The speed required can be determined if the tool diameter and cutting speed are known. Similarly, the tool diameter can be determined if the speed of rotation and cutting speed are given.

#### Reading examples:

	D mm	n $\text{min}^{-1}$	$v_c$ $\text{m s}^{-1}$
<b>Circular sawblades</b>	350	6000	110
<b>Cutting tools</b>	160	9000	76
<b>Shank router cutters</b>	52	18000	50



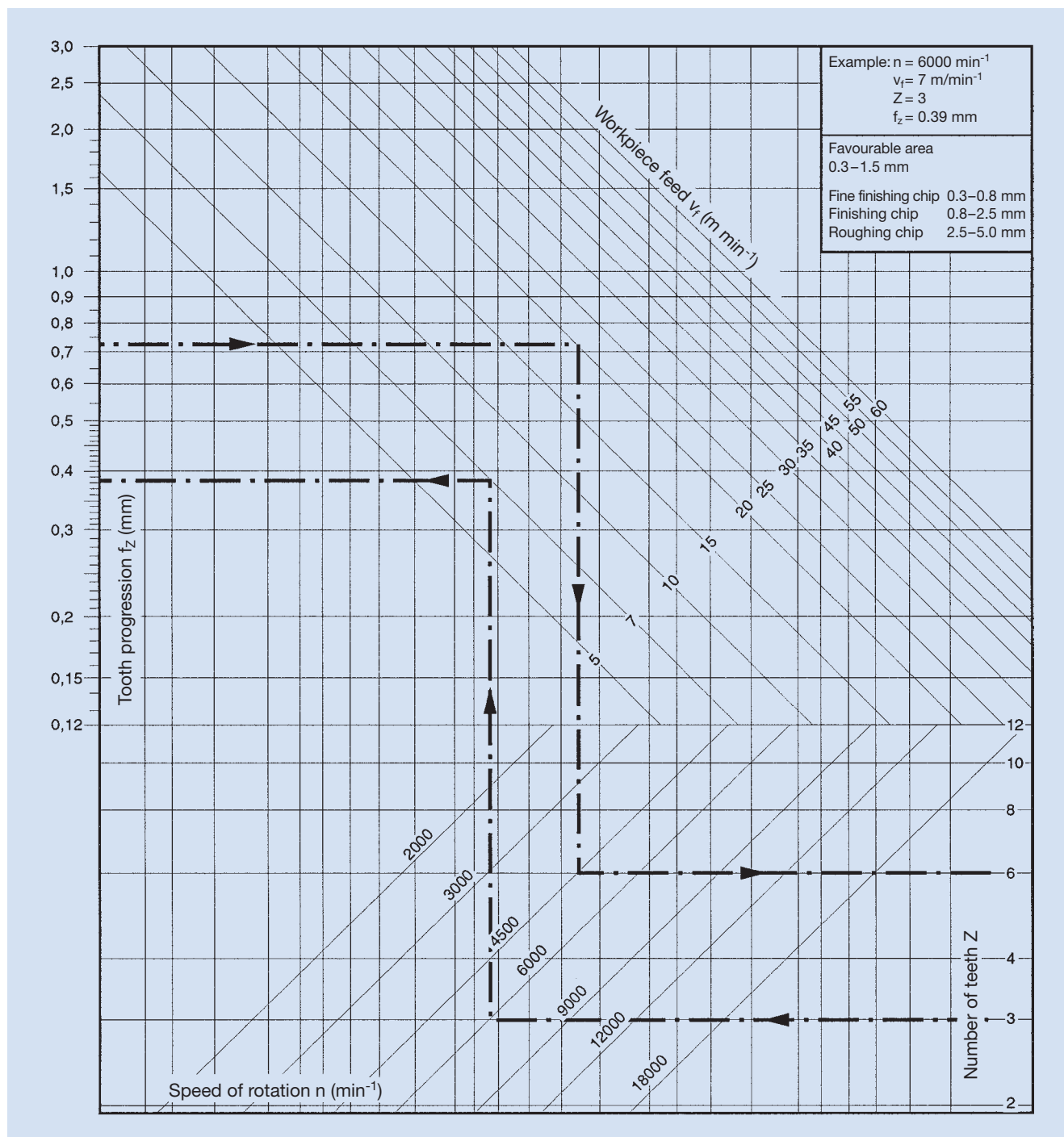
#### Cutting speed guide values $v_c$

Material	Cutting $v_c$ [ $\text{m s}^{-1}$ ]	Sawing $v_c$ [ $\text{m s}^{-1}$ ]
Softwoods	50-90	60-100
Hardwoods	50-80	60-100
Coreboards	60-90	60-100
Chipboards and fibreboards	60-90	60-90
MDF	60-90	60-90
Panel materials, coated	60-90	60-90
Thermoplastics	40-60	40-70
Thermosets	30-50	40-60
Aluminium	30-60	60-90

The guide values given here apply to tools with a diameter  $> 100$  mm. Regarding shank tools, the recommended cutting speeds are considerably lower due to the small tool diameter and the higher friction (router cutter 10 to 40  $\text{m s}^{-1}$ , drill 5 to 10  $\text{m s}^{-1}$ ).

### Parameters for cutting tools

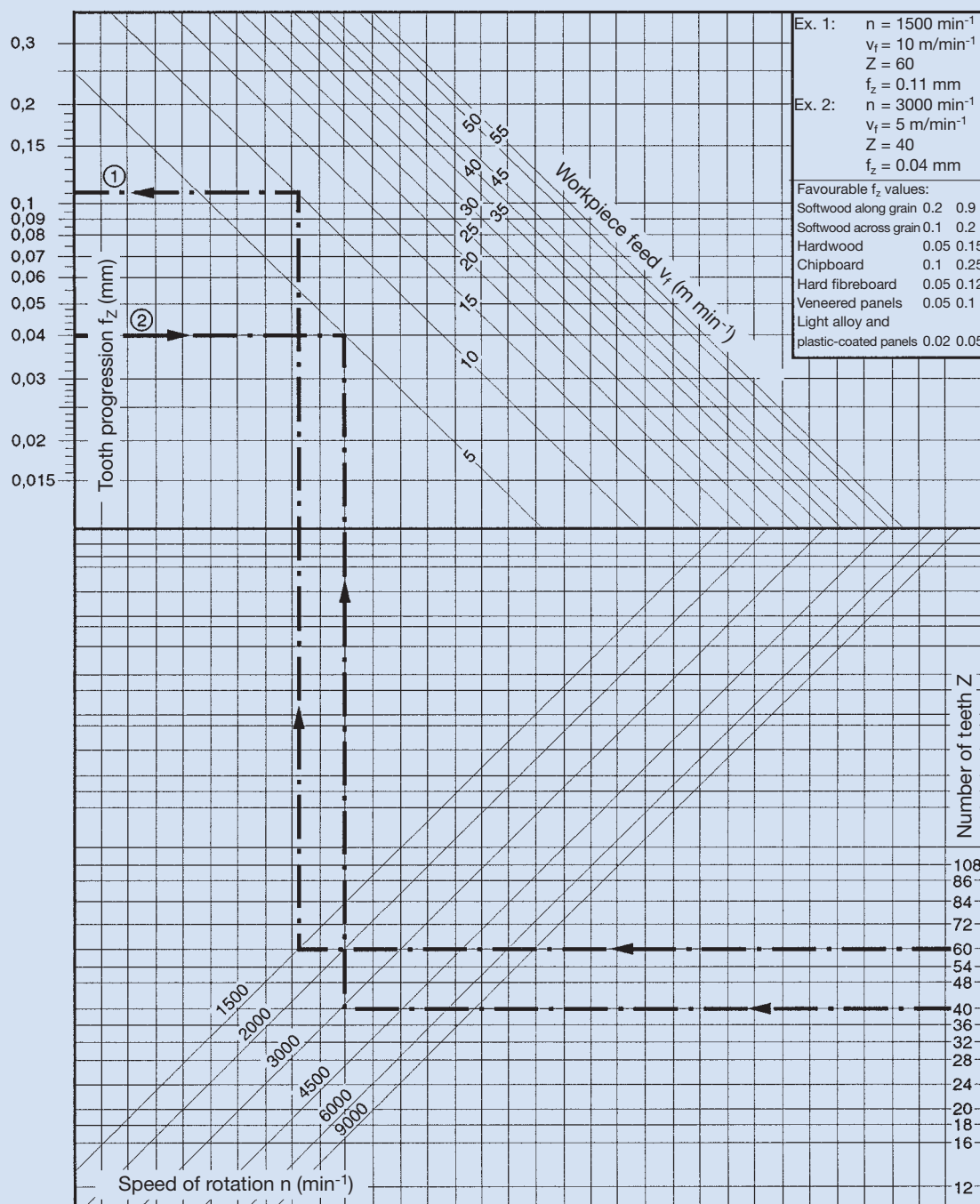
Tooth progression, feed rate, speed of rotation, number of teeth





### Parameters for circular sawblades

Tooth progression, feed rate, speed of rotation, number of teeth



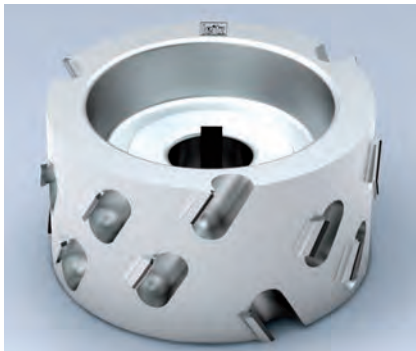




Solid tool  
Example: HL profile cutter



Solid tool  
Example: HW shank router cutter



Tipped tool  
Example: DP grooving cutter



Tipped tool  
Example: HS minifinger cutter

Regarding tool types, the machine tools are distinguished by design and construction design.

#### Single part tools / solid tools

Solid tools are made from one piece. The basic body and the edges are of the same material. Typical examples of this tool type are profile cutters of HL steel, routers and drills of HS steel or solid tungsten carbide. All have been designed as resharpenable tools.

Profile cutters of HL steel are mainly used for profiling tongue and groove boards in the primary industries. They have a high number of teeth and a very large resharpening area so economical when it comes to high running performance. The one piece design allows for a high precision concentric and axial run-out which is why they can be used for feed speeds up to  $200 \text{ m min}^{-1}$  without jointing. A key feature of these cutters is the spiral relief in the profile. The free area of the edges is convex and follows a spiral form. The cutting edges are resharpened by turning the tools around its rotational axis. This ensures the wedge angle and cutting profile remain constant.

The reasons for a one piece design of routers and drills are different. Because of the small diameters, the most important factor is stiffness which is higher with a body made of HS steel or tungsten carbide compared to tempering steel. More efficient production is also very important.

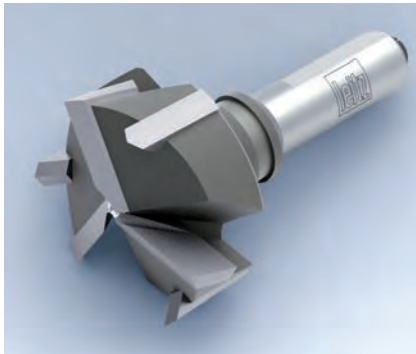
#### Tipped tools / progression tools

Regarding composite tools, the edges and basic tool body are made of different materials. They are jointed to each other by brazing or adhesive. Typical examples of this tool type are circular sawblades with tungsten carbide or diamond tips and HS, HW or DP tipped cutters as well as HW tipped drills.

Brazing is at high temperatures between  $650^{\circ}\text{C}$  and  $700^{\circ}\text{C}$ . Due to the tensions occurring when the material is cooling down, the cutting material must have a particular toughness and may not exceed a certain thickness. An adhesive joint has the advantage that it can be done at lower temperatures. In doing so, the joint has less tensions so harder and more wear resistant materials can be used, in particular for tungsten carbide tools.

Tools tipped with HS or HW edges are mostly resharpened on the cutting face. Regarding circular sawblades and grooving cutters, it is recommended to also sharpen on the top surface (relation between face and top approximately 2:1) to maximise the use of the cutting material and to achieve longer tool life. As the free surface has a straight or convex relief, the profile changes slightly when sharpening the cutting face. Regarding glue joint profiles or finger joint profiles, both tools of a pair are always resharpened to the same extent to make sure the joint profiles match each other.

This is not the case with diamond tools. Here, the DP edges with the tungsten carbide support are brazed to the panel seatings so that the thin diamond layer forms the cutting surface.



Tipped tool  
Example: HW hinge boring bit



Turnblade tool for jointing and rebating



Profile cutterhead for backserrated blank knives



Profile cutterhead with throwaway knives and turnblade spurs

Resharpener may only be done on the top. As the edges always require a certain projection from the body of the tool, this must be adjusted during sharpening. When sharpening the top, the original profile may be kept. Only the cutting angle is increased.

Closed profiles with a steep run out angle must have a lateral free angle in addition to the radial free angle so that the tool does not „burn“. Such tools change their width when being sharpened. So, two piece tool designs are practicable to compensate for the change in profile width.

#### Cutterheads / assembled tools

Assembled tools are also known as cutterheads since the cutting edges are inserted as detachable knives. It is distinguished between turnblade knives or throwaway system where the knives cannot be resharpened, and resharpenable knife head systems. All cutting materials may be used. Knife head systems with tungsten carbide cutters are most common.

The advantage of knife head systems is that the tool body design can be reused and only worn knives must be replaced. Assembly and disassembly must be done carefully and under clean conditions to ensure accurate and safe positioning of the knives in the tool. The replacement of the knives is normally by the user, who is responsible for the accuracy and safety of his tools.

The simplest form of assembled tools are the turnblade tools. Standardised tungsten carbide knives with 2 to 4 cutting edges are used as cutters. When worn, they may be turned 1 to 3 times. The main cutters are normally straight turnblades. For edge processing of rebates or grooves, spur cutters are used and for profile edges, radius or bevelling knives are used. Typical applications are jointing, rebating and grooving tools, but also simple window tools. By separating the profile into many standardised individual blades not adapted to the respective processing situation in respect to their geometry, only a medium processing quality can be achieved, in particular on rounds and profile edges.

Tools with resharpenable knives are, for example, profile cutterheads with serrated back HS or HW knives. These can be resharpened more than 30 times in the profile, keep their profile and are very economical. Furthermore, such systems are very flexible as knives with different profiles can be mounted in one basic body. A disadvantage is the change in diameter so the position of the machine spindles must be adjusted after every sharpening.

Cutterhead systems with throwaway knives do not have this disadvantage. These are normally HW blades. After changing the knives, all tool dimensions stay the same. However, this advantage is gained at the cost of a high consumption of expensive tungsten carbide so such tool systems have high operational costs. In addition, the knife profile is related to the profile of the tool body design. So as is the case with tipped tools, every profile requires a complete tool.

## 11.4 Machine tools

### 11.4.1 Tool types



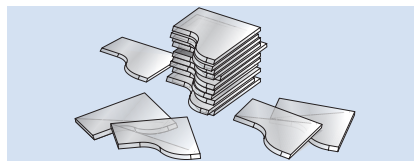
Multi purpose cutterhead with backing plates „VariForm“

A compromise are universal profile cutterheads in which the cutting plates are not support by the tool body design, but by profileable and replaceable supporting plates (example: VariForm). Such systems may be resharpened 2 to 3 times on the cutting surface if a minor change to profile and diameter is acceptable.

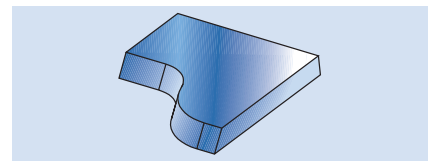
#### Resharpenable tools

It doesn't matter if cutters or cutterhead systems, resharpenable tools use the expensive and valuable cutting materials in a more efficient way as throwaway tool systems.

For example a throwaway tool system with 2 mm tungsten carbide cutting edges waste 8 to 10 times more tungsten carbide material in tool life compared to a resharpenable tool system with a 5 mm tip height. But after every resharpening the dimensions of the tool are changing and a new set up at tools and machines is necessary.



Throwaway tool System (2 mm)  
Tungsten carbide consumption by 16 tool lives.



Resharpenable tool (5 mm)

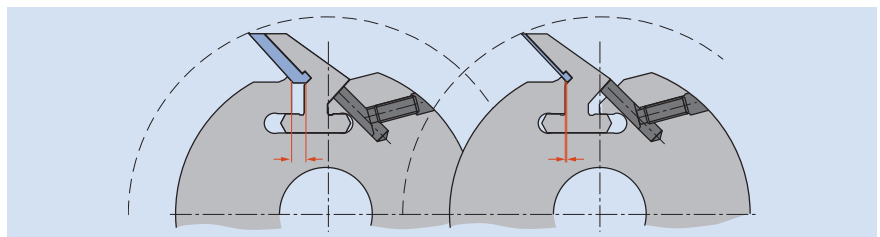
#### Constant tools

Constant tools combine cost effectiveness of resharpenable systems with the handling advantages of throwaway systems. They are always designed as a cutterhead. A slot guides the knife position parallel to the clearance angle of the profile, so the knife always comes back to the same reference point after sharpening on the cutting face. This ensures that the profile and the diameter of the tool remain constant after sharpening. Adjustment of the spindle position is not required.

Examples for such self adjusting constant tools are the Leitz systems „ProFix“ for profile processing and „VariPlan“ for planing.



Constant diameter tool  
Example: Planerhead „VariPlan“



Functional principle: ProFix Constant diameter tool



Constant diameter tool  
Example: Profile cutterhead „ProFix“

Another form of the constant tool are tools with adjustable knives. They are either adjusted to the diameter when installed (example: planing cutterhead with planer knives) or are moved to the extent of their wear before the sharpening process and then ground back to the nominal diameter (example: jointing cutterhead with cylindrical DP knife insertion).



Typical tooth shapes and applications

For special applications also sequences of various teeth can be used, combining several types of teeth (e.g. WZ/WZ/FZ). To protect the knife points against breakouts, all tooth shapes slightly can be bevelled (protecting bevel).

### Circular sawblades

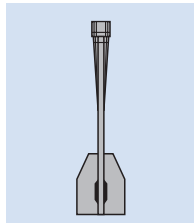
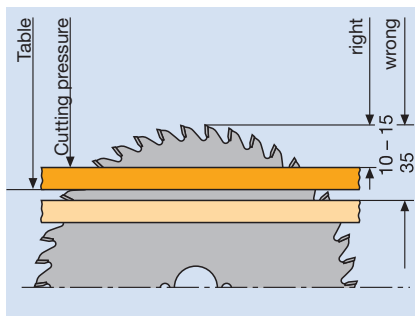
Circular sawblades for processing wood and plastics are progression tools. They consist of a saw plate with tungsten carbide or polycrystalline diamond teeth brazed to its circumference. They are used to separate workpieces. To keep the cutting loss and the cutting forces small, the aim is to keep the cutting width as small as possible. On the other hand, straight cuts free from scores require a certain blade stability; this invariably means a compromise between cutting width and saw diameter.

Depending on the material and geometry of the workpiece, the saw teeth differ in shape and geometry. Generally, positive cutting angles are used to keep the cutting forces low. For thin walled workpieces such as e.g. hollow profiles, negative cutting angles are required to prevent the saw from catching. The number of teeth depends on the requirements for cut quality. The rule of thumb is: the higher the number of teeth, the better the cut quality to be expected, and the lower the number of teeth, the smoother the saw cut.

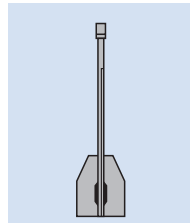
Classification of typical teeth forms and applications:

	Tooth shape	Application
	Flat FZ	Solid wood, along and across grain.
	Alternate, positive WZ	Solid wood along and across grain as well as glued, wood products uncoated, plastic coated or veneered, plywood, multiplex, composite materials, laminated material.
	Alternate, negative WZ	Solid wood across grain, hollow plastic profiles, non-ferrous metal extruded profiles and tubes.
	Square/trapezoidal, positive FZ/TR	Wood products, uncoated, plastic coated or veneered, non-ferrous metal extruded profiles and tubes, non-ferrous metals, Al-PU sandwich panels, hollow plastic profiles, polymer plastics (Corian, Varicor etc.)
	Square/trapezoidal, negative FZ/TR	Non-ferrous metal extruded profiles and pipes, hollow plastic profiles, Al-PU sandwich panels.
	Inverted V/hollow ground HZ/DZ	Wood products, plastic-coated and veneered, coated profile strips (skirting boards).
	Flat, bevelled ES	Construction industry machine saws.





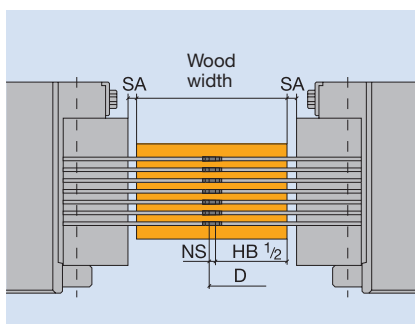
Sawblade without damping



„Foil saw“ with good noise- and vibration damping

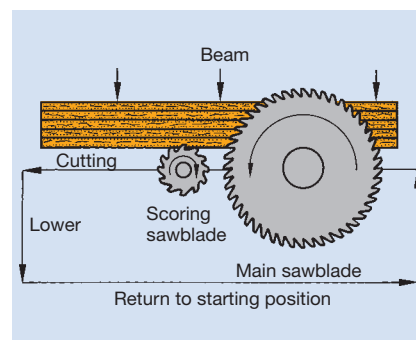


Thin kerf sawblade set to produce parquetry laminates

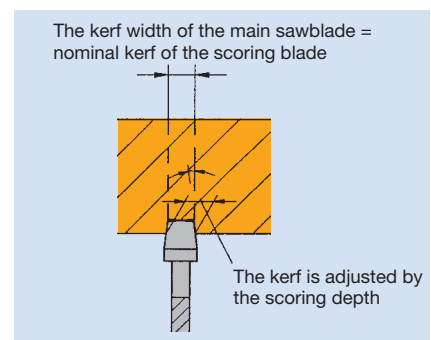


Inherent to the functional principle, the cutting edges on the tooth entry side are a better quality than the ones at the tooth exit side. By setting the projection of the teeth above the workpiece it is possible to influence the cut quality in certain areas. The point of reference here is a value of 10 to 15 mm.

With a greater projection of the teeth, the quality at the exit side suffers, with a smaller projection quality at the entry side suffers. To achieve a cut edge without tear outs on both sides it is required to use scoring saws at the exit side of the main saw. These are sawblades with a small diameter but a greater cutting width than the main saw by 0.1 to 0.2 mm, scoring the workpieces with feed to a depth of 1 to 2 mm. To adjust the cutting width to that of the main sawblade, scoring saws are designed either in two parts or with a tapered tooth shape. Special concave tooth saws have been developed for panel saws without scoring saws; these saws enable cuts without tear outs to both sides when set correctly but have a comparatively short tool life.



Panel sizing machine with scoring unit and pressure equipment

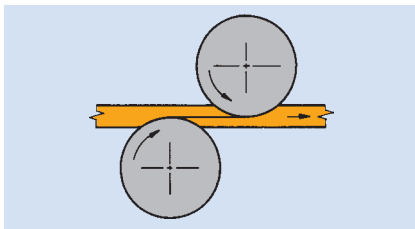


Application scheme of a conical scoring sawblade. Servicing the tools (always in sets), the cutting widths have to be machted to each other.

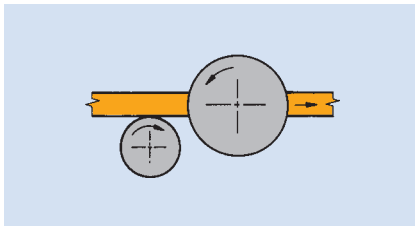
A basic prerequisite to achieve cut surfaces without scoring is a good axial saw run-out but also low vibration. For this, the sawblades are pre tensioned by roll rings so they run stead even when subject to centrifugal forces. Additionally inserted laser ornaments and applied films absorb vibration and at the same time reduce noise. The biggest effect is achieved with foil laminated saws. The noise reduction here is up to 10 dB(A), a noise reduction of half.

Special thin cut saws were developed for separating high quality wood, e.g. when manufacturing parqueting blocks. Depending on the diameter, the cutting width is within a range of 1.0 mm to 1.6 mm. The teeth protude little laterally compared to the saw plate. Their application makes special demands on the woods' drying and the workpiece guidance in the machine, in particular the separated segments.

Ideally, circular sawblades should be sharpened on face and top to maximise tool life. For this reason the saw plate must be relieved at the back. As the teeth becoming smaller, the cutting quality improves since the protrusion of the teeth becomes smaller and the tooth vibrates less. However, the gullet also becomes smaller which is why the feed speed must be adjusted.



Double-hogging



Scoring/hogging



Compact hogger  
Example: Diamaster DT



Sawblade hogger

In many countries circular sawblades are resharpened only at the face due to sharpening machine limitations. To remove the wear zone, a significantly more sharpening than when sharpening on face and top is required. So, the sawblade may not be resharpened as often.

#### Hoggers

Hogger means tools that are processing the narrow sides of panel materials with their frontal cutting edges. They are face plain cutters and are used to format panels in through feed machines. To achieve cutting edges without tears you need two tools. There are two different types: „double hogging“ and „scoring/hogging“.

In case of „**double hogging**“ a tool cuts with the feed both at the top and bottom of the panel, overlapping in the panel centre. Both tools are aligned accurately at one level and produce a smooth cutting area which may be edged later.

In case of „**scoring/hogging**“ the underside of the panel is scored 1 to 2 mm deep (depending on the decorative coating's thickness) by a scoring hogger with feed and subsequently finished by a hogger from the top against the feed. To avoid edges tearing at the hogger's blades exiting the wood, the hogger is angled by 0.1 to 0.2 mm axially so that a small step appears on the cutting surface.

In addition to processing narrow edges, the hoggers also have to completely hog the material overhang. For this, the circumference must have a certain hogging width, between 5 to 10 mm for most applications. Regarding the tool design, a distinction is made between „compact hoggers“ and „saw hoggers“. In case of compact hoggers all edges are mounted on a basic tool body. Usually diamond tipped tools. In case of saw hoggers a sawblade is screwed to the basic body process the narrow edge while flange-mounted cutters or saw segments hog the remaining material overhang. Usually diamond cutters are used for the sawblade while in most cases tungsten carbide knives are sufficient remove the material overhang.



Depending on the type of decorative coating, a distinction is made between different profile types of the hogger knives, such as e.g. radius or bevel knives or knives with a one sided tip. In recent years, a step profile has been developed (e.g. Leitz Diameter DT), significantly lowering the risk of damage to the knife from foreign matter in the chipboard. There are special shredder knives for processing veneered boards, breaking up the free veneer overhang so that the extraction is not blocked by veneer strips.



Cutter spindle „CentroStar“

#### Cutter spindles

Cutter spindles are tools permanently installed in the machine. They are found mainly in thicknessing and planing machines. They are composite tools with knife replacement always in the machine to reduce down time and ease work on the machine, centrifugal force clamping systems automatically clamp and position the knives when the spindle is run up (e.g. Leitz CentroFix).

Spiral cutter spindles with smooth knives have proven to be particularly quiet. However, such technique can only be used for HS steel knives and not tungsten carbide.

#### Planing tools

Planing tools are peripheral cutting tools with continuous straight knives. Usually they are designed as planerheads. They are used for smooth surfaces, primarily in processing solid wood. HL, HS and tungsten carbide knives are used as cutting material. The number of blades is between  $Z = 2$  and  $Z = 36$ . The cutting width ranges up to a few hundred millimeters. For precutting, planing tools with segmented edges (HeliPlan) or with ripple profile (**VariPlanPlus/RipTec**) are advantageous. They reduce the presplitting and prevent the wood from an early damage, so that considerably more even surfaces are produced during the enclosed finish planing.



RipTec - preplaning tool



Finish planed surface after conventional preplaning.



Finish planed surface after preplaning with RipTec.

Conventional planerheads have two or four knives and are connected to the machine spindle via a drilling fit. Due to tolerance one knife is decisive for the surface. The feed rates achieved range from 9 to 36 m min<sup>-1</sup>, depending on RPM. and required surface quality. Planerheads for higher feed rates have a hydraulic clamping or a HSK interface to guarantee a centering of the tool with the machine spindle free of play. For the hydraulic clamping grease-filled chambers in the wall of the tool are pressurized by a grease gun. By expanding the tool chambers, the bore shrinks, and the tool is locked on the spindle. In case of the HSK interface the centring is made by a positive taper lock axially pulled and positioned against a locating face.

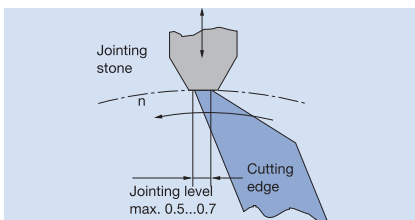




Preplaning tool „HeliPlan“ with HSK



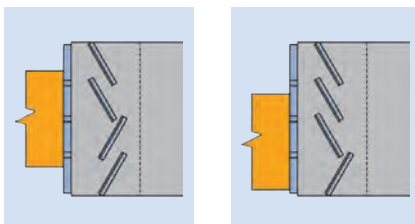
High performance planerhead „TurboPlan“



Jointing of a planerhead



DP jointing cutter



Symmetrical/asymmetrical edge arrangement

By centring a high balancing quality and best possible true knife running is achieved by truing the knives in the machine, „**jointing**“. After jointing, all knives have the same cutting circle and are equally responsible for the surface finish. Feed rates of over 400 m/min are possible.

There are other differences in the way of knife clamping. It is becoming more common for conventional planerheads to use cutting edge systems (e.g. CentroStar or VariPlan) enabling a swift replacement of knives with minimum setup, the hydro planerheads predominantly use systems with planing knives that can be adjusted and resharpened, (e.g. Leitz RotaPlan). There are also tool systems that drastically reduce the high setup effort when replacing the knives. Those include, among others, the Leitz system „TurboPlan“ in which all knives are positioned by a positive fit and are clamped simultaneously by hydraulic clamping.

#### Jointing, grooving and rebating tools

Like planing tools, **jointing tools** cut on the periphery; however, the cutting width is significantly smaller and usually under 100 mm. Jointing tools are designed as turnblade tools or milling tools and are used predominantly in panel processing. The cutting material ranges from tungsten carbide to polycrystalline diamond for industrial use. To protect the edges of the workpiece from tear outs during processing, the knives have shear angles for an angled cut usually the surface. There are **symmetrical and asymmetrical tool designs**. Asymmetrical means that the lower knife row is aligned upwards and all knife rows above it are aligned downwards. These tools are set up with the lower row of knives aligned with the bottom of the workpiece and can process variable workpiece thicknesses within their cutting width in this position. If the angles of the knife rows are aligned symmetrically to the tool's midplane, the tool must always be aligned with the workpiece centre. When changing the thickness of a workpiece, the tool position must also be adjusted. The advantage of the symmetrical design is that the jointing knives have a slightly convex design and thereby generate a defined concave cut of a few hundredth millimetres on the workpiece. This guarantees a tight glued joint on edge banding machines.

In addition to the peripheral knives, **grooving and rebating tools** have lateral knives, e.g. spurs, or the knives' sides have a clearance angle. On both sides for grooving tools, on one side for rebating tools. For grooving tools, there are two different types: one part tools (similar to circular sawblades) and two-part adjustable tools for variable groove widths and for correcting the cutting width after sharpening.



Grooving cutterhead, width adjustable



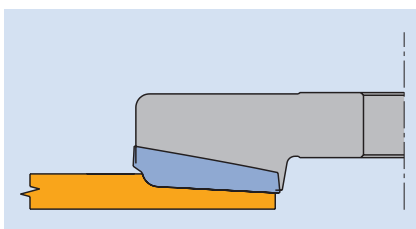
Multi purpose cutterhead „VariForm“



Multi-part ProFix tool set for window profiles



Panel raising tool



### Profile tool systems

Profiles range from simple profiles like bevels or radii to decorative profiles to highly complex jointing profiles, such as finger jointing, slot and tenon or counter profiles. Its application is a common across wood processing field. The range of cutting materials is extensive, from HL steel to polycrystalline diamond (DP). The tool types range from solid cutters to brazed tools and profile cutterheads to constant profile tools that can be resharpened.

Multi purpose cutterheads play a special role. Knives moulded in any way may be inserted in a tool body. The blanks may be profiled by a sharpening service or by the user, enabling a quick production of the required plus low tool costs for small production volumes.

For profiles, a distinction must be made between one-sided or open profiles and closed profiles with radial profile shoulders on both sides. While one clearance angle on the profile is sufficient for one-sided or open profiles, the knives must have two clearance angles on the sides for closed profiles. This has consequences in the tool design: such profile cutters must be designed in two parts so that profile changes resulting from resharpening can be compensated. However, turnblade tools that are not resharpened can be designed in one part.

To enable great profile depth it is of advantage to assemble tool sets from several different individual tools of varying diameter. Hence you can use smaller discs and achieve higher speeds. Additionally, the cut distribution can be better adjusted to the workpiece and profile. A classic example is window tools.

Panel raising tools are a special form of profile tools with profile knives arranged on the face of the tool. They are used to profile the infill panel for doors. Due to the small setting angle  $\kappa_r$ , they produce a surface almost without any plane knocks.

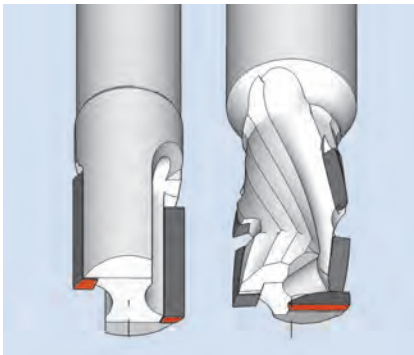
### Shank tools

Principle, these are the same tool types as for jointing, folding, bevelling, panel raising and profiling cutters but with shank as for drills; they only have a smaller diameter and can be used for higher speeds.

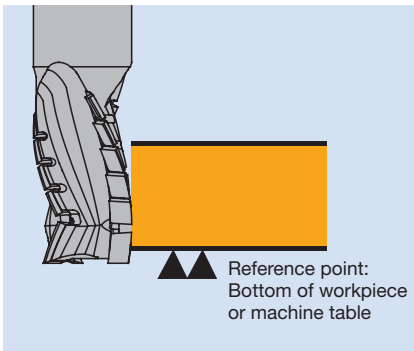
The **routers** are a special case. Usually they have a high **slenderness ratio**, e.g. they are much longer than they are wide. They are mounted in a chuck by their shaft, and the cutting part is outside the chuck. So, the tool is subject to a high bending stress and the breakage due to overstress is high. This is the reason why the **cutting marks  $f_z$**  are also significantly smaller than for drilling tools. They are less oriented towards hogging relevant values such as the mean cutting depth  $h_m$  but towards the tool's load capacity. This depends on the unsupported length and diameter. This is why, for example, the admissible feed rates for splitting or grooving are usually lower than for jointing.



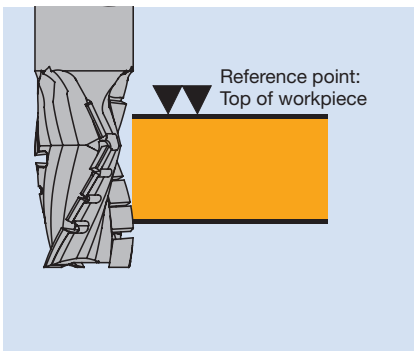
Spiral finishing router in solid tungsten carbide



DP router  
left: cutting in end grain  
right: plunging tip

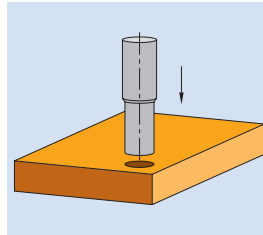


DP-shank cutter with mainly negative twist

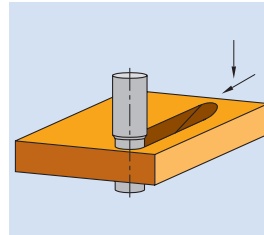


DP-shank cutter with mainly positive twist

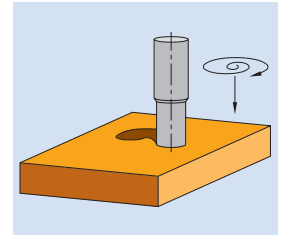
Important design features for routers are the design of the knives and the helix or shear angle. The tool is suitable for axial drilling when it has a basic knife extending to the central axis and if it is designed with a positive helix angle. **Axial drilling** should only be the exception for quality and tool stationary time reasons. It is more gentle for the tool to enter the material by **helical drilling or ramping in** at angle. In such case the requirement for the tool is only a knife front clearance angle, usually the case for routers.



Axial plunging



Plunging



Spiral shaped plunging

The **helical angle** plays another role. An upward positive helical angle favours swarf removal towards the extraction hood and prevents tears on the lower cutting edge (workpiece side at the bottom). A downward negative helical angle applies pressure to the workpiece, supports the workpiece and prevents the upper cutting edge from tearing (workpiece side on top). Routers used for sizing coated panels material have both negative twist in the upper knife and positive twist in the lower area. Hence, top and bottom of the panels are processed without any tear outs. If the proportion with negative twist prevails, the tool can process varying panel thicknesses with the same length set up. If the proportion with positive twist prevails, the dust collection is improved significantly; however, the tool must be adjusted to the relevant board thickness in its axial position.

It is normal for routers that their milling part may be programmed at will. If this results in unfavourable machining situations such as cutting contrary to the fibre direction or exiting the workpiece against the feed, the turning direction must be changed. For this reason most routers have **left hand rotation** in addition to the usual **right hand rotation**.

**Tungsten carbide (HW)** in solid, tipped, or turnblade or **polycrystalline diamond (DP)** are used as cutting materials. Tungsten carbide tools can be produced with continuous knives and are suited to solid wood processing as finishing tools. Diamond tipped routers always have segmented knives and are mostly used for coated chipboard and fibre materials. It may be that turnblade routers are inferior to solid or tipped tools regarding their feed rates but, their use is justified in cases when constant diameters are important or where it is not possible to sharpen the tools.

For fast roughing (hogging) routers have a **roughing profile**; a wavy profile that is slightly set off at each knife breaks up the chip, and the cutting force is reduced allowing higher speed rates. Special designs with a cascaded profile, the individual steps in total create a straight line, allow hogging processing almost to finish quality. This is the roughing finishing router.



Turnblade shank router



Roughing-finishing router of solid tungsten carbide



Through hole boring bit



Dowel drill

In the aim for more flexible manufacturing with smaller batch sizes, separating boards with router cutters (example: Nesting) is competing against circular saws more and more. Nesting requires small tool diameters of 10 to 12 mm and high feed rates of 20 to 30 m min<sup>-1</sup>. This makes high demands on the tool stiffness and why tungsten carbide tools are used predominately for **Nesting**.

**Resharpening** of tungsten carbide routers is usually on the cutting face, however, for diamond-tipped routers it is at the edge.

#### Drills

In principle, drills differ from routers as the knives are only at the end; the periphery is ground circular. They only produce holes with a fixed given diameter. The feed movement is axial.

A distinction is made between drills for through holes, e.g. for screws, and those for blind holes, e.g. for plugs or fittings. Through hole drills have a slim tip to produce entrance exits without tear outs by its scalloped cut. Typical features of drills for blind holes (e.g. plugs or for fittings) are spurs to avoid tear outs at the drilled edge when penetrating the panel, flutes to produce a smooth side, and a centring tip so that the drill is centred when drilling. Ideally, the spurs are formed in a way to apply pressure to the workpiece surface when penetrating and create a pulling cut. Both wood fibres and decorative coatings are cut cleanly before the flutes clear the inside of the drilled hole. Usually the diameter of the flute is reduced by a few decimillimeter right behind the drill tip to reduce friction between drill and drill hole and to help chip removal.

Essentially, drills for solid wood and board material differ with regard to cutting material, helical angle and length. Solid wood drills are manufactured from HS steel or tungsten carbide while it is mainly tungsten carbide and occasionally polycrystalline diamond that is used in drills for panel processing. Since the helical angle is the cutting angle for the drill separating the wood fibre requires a „destructive“ cutting edge, solid wood drills have higher helical angles than drills for panel material. The required drilling depths are greater for solid wood applications than for panel material, and the drills are longer. For very deep holes, single edged „Levin drills“ are used because their gullet aids chip removal. To avoid the chip choking and creating high frictional heat it may be necessary to clear the cutting space by withdrawing the drill for a short time.



## 11.4 Machine tools

### 11.4.2 Types of tools



Hinge boring bit



Levin drill



Multi purpose profile cutterhead for manual feed with limiters

When using drills in drilling units and drilling aggregates, a constant length is important so the drilling depth always remains unchanged. Drills have a screw for adjusting the length at the end of the shank to set the drill length in advance so new and resharpened drills always have the same length. Most drill aggregates have different spindle rotations for design reasons. That is why there are drills rotating left hand and right hand. To reduce the danger of confusion, the two rotations are marked with different colours; drills rotating left hand usually are marked with a red colour, right hand black.

#### Cutting tools for manual feed

Cutting tools for manual feed must be designed with kickback limitation. They are subject to limitations regarding number of teeth, knife protrusion and gullet. The tool body must either be circular or equipped with limiters restricting the knife protrusion and the cutting gap width.

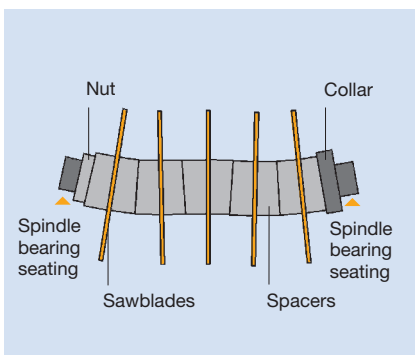
The design details vary with type of tool and are regulated in the European standard EN 847-1 „Machine-tools for the woodworking industry safety demands“. Cutting tools authorised for manual feed are marked „MAN“ on the tool.



Arbor with detachable spindle/hub connection

Tool clamping systems are the interface between tool and machine. They have an adaptor on the tool side and a mounting sleeve on the machine side. The tasks of the tool clamping system falls under three heading categories:

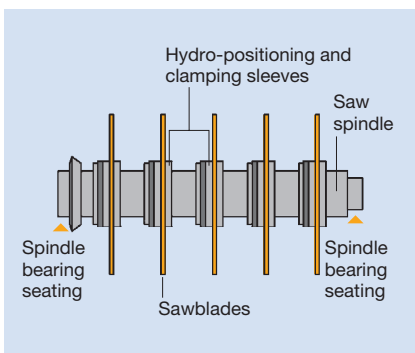
- **Torque transmission**  
The cutting forces must be received with sufficient safety, the tool must not spin.
- **Centring**  
The better a tool is centred on the machine spindle, the better the concentricity and balance quality.
- **Replacing tools**  
The tooling times are shortened by easy and fast tool replacement. Automated tool replacement is required for flexible production.



Tools on a spindle axially clamped against each other

The simplest form of tool clamping is a shank/hub connection. The tool is centred by means of a defined clearance **fit between tool bore and machine spindle**. Positive fit elements such as feather keys or drive pins transmit the torque. They are clamped by nuts at the shank end. Examples are drilling tools or flanged bushes for motor spindles with splined shank or cylindrical spindles of planing and finger jointing machines. This type of tool clamping has two important disadvantages:

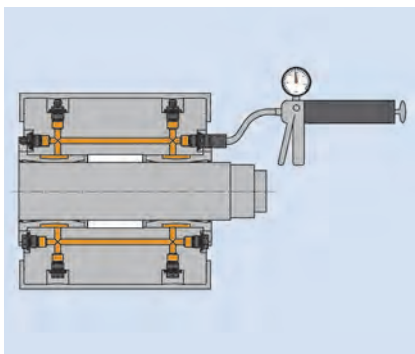
1. The tools are not centred free of play. The centre of gravity is offset by the tolerance, with a negative effect on concentricity and balance quality.
2. If several tools are clamped side by side or on top of each other, the axial run out tolerance of the bodies increases. If the body faces are not parallel. When applying axial tension at the end of the shank, the spindle may bend resulting in an increased imbalance and loading to the bearings.



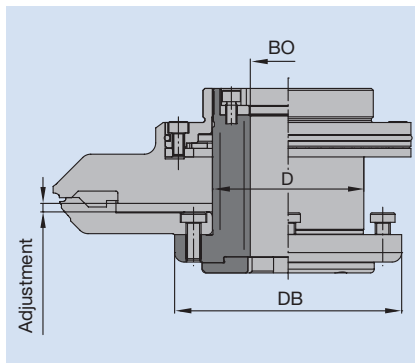
Hydraulically clamped tools on a spindle not depending on each other

Tool clamping systems that centering free of play were developed to eliminate such disadvantages. One example is **hydro tools** or **hydro clamping elements**. This clamping method consists of a ring chamber around the bore filled with grease or oil. When pressure rises in the chamber, the thin wall concentrically distorts towards the bore. The tolerance becomes zero, and the tool is clamped to the shank. The tools are clamped individually to the shank, there are no clamping forces, and the shank is not bent. Open and closed systems are defined by how the pressure is introduced.

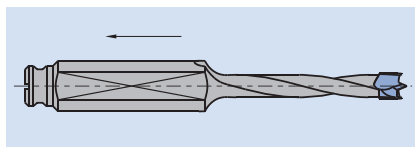
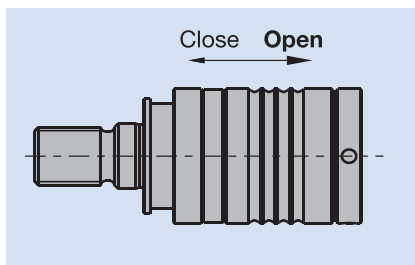
**Open systems** are filled with grease. The pressure is increased by means of a grease gun. To release the pressure, grease is let out by a bleed screw. Such systems usually can be found in the moulding, planing heads and profile tools. The required pressure of approximately 300 bar is adjusted by the volume of grease pressurised. The system can be used in a wide range of temperatures, important for planing mills.



Hydro clamping technology, open system



Hydro-Duo clamping element with two independent chambers for adjustable tool sets

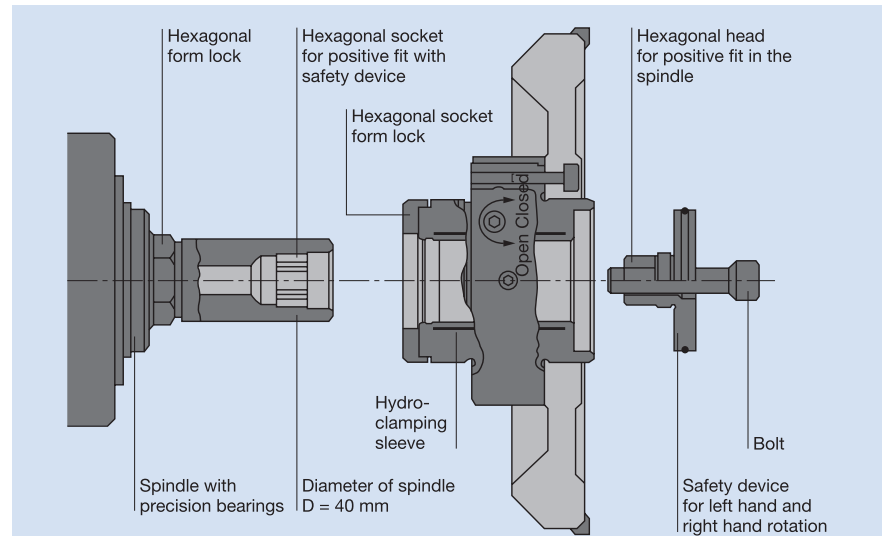


Drill quick clamping system



Tool set with HSK adaptor for automatic tool change

**Closed systems** are filled with grease or oil. Pressure is built up and released by an internal piston. The pressure is limited by the piston displacement and varies with temperature. Such systems are preferred where workpiece cleanliness is essential, e.g. in furniture, window or floor manufacturing.



Hydro-clamping element, closed system

Hydro clamping elements usually are designed as „**Hydro-Duo clamping elements**“ with bi-directionally to center the tool on the clamping element and the clamping element on the shank. Such Hydro-Duo clamping elements are ideal for adjustable two-part slot and tenon tools. When the pressure is released in the outer chamber, a tool part may be moved axially. During the subsequent build up of pressure the tool is centered and clamped again in its new position

As a safety measure against losing pressure, hydro clamping systems additionally are secured mechanically by locking mechanical collars as safety devices against twisting.

To shorten the tooling times for replacing the tools, **quick change systems** were developed for mounting on the machine shank and have a mounting tool flange clamped and loosened in seconds. Examples for this are bayonet mount systems for drilling tools that are operated mechanically or pneumatically or quick change systems that are operated totally tool free, similar to a hose coupling. Despite significantly reduced tooling down time these systems still require a manual intervention in the processing procedure.

Taper mounting sleeves between tool and machine were developed for **automated tool replacement**. Initially they were quick release tapers such as SK 40 or SK 30 but today **HSK interfaces** have expanded globally in wood processing. While initially developed for CNC processing centres, they have arrived in the through feed machine sector, in double end tenoners or planing/profiling machines. The HSK interface incorporates the advantages of both hydro and quick connect clamping systems: precision and speed.





Hydro-strain clamping chuck



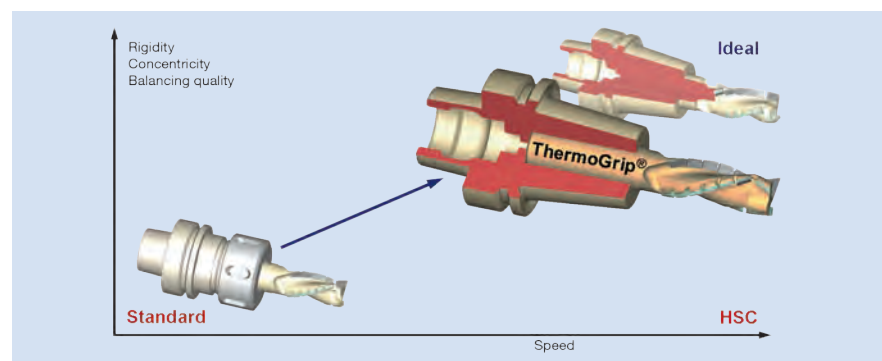
Collet chuck



Shrink-fit chuck ThermoGrip®

Ideally the HSK is designed in one part with the tool. So, the tool diameters can be reduced and speed can be increased. However, in most cases it is not possible for structural or economic reasons. This is why there are HSK adapters that are screwed to the tool. Hydro clamping systems are used again, for a removable and tool centring connection. A distinction is made between hydraulic chucks for drilling tools or multi-part tool sets in which the clamping mandrel is hydraulically opened out, and **hydro clamping chucks** for clamping shank tools.

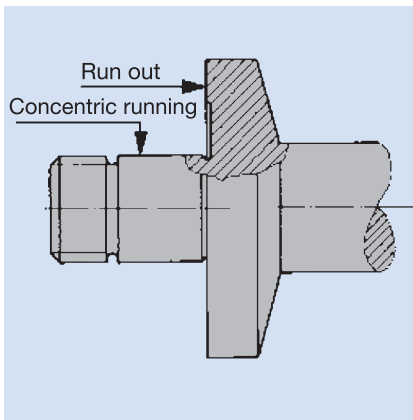
**Collet chucks** are a universal clamping system for shank tools. By using exchangeable collets, any shank diameter up to 25 mm may be clamped. The multitude of parts and wear on the collet result in moderate values of concentricity and balance quality. Tool excentricity may be up to 0.06 mm. High spindle speeds result in the nut being opened with a loss of clamping force. Consequently, high-quality collet chucks have balanced clamping nuts with an internal ball bearing to produce a higher preliminary tension. On the machine side, the collet chucks are designed with a HSK or taper interface.



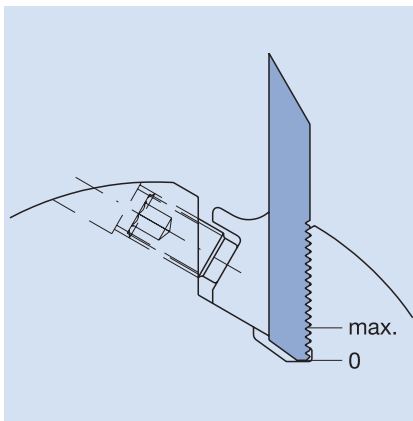
**Shrink-fit chucks** „ThermoGrip®“ were developed for high performance processing. They create a virtual monolithic connection between tool and chuck. The chuck principle is based on thermal expansion and functions without mechanically moved parts. To insert the tool shank, the clamping part of the chuck is heated. The chuck bore is manufactured undersize expands, receives the tool shank and shrinks while cooling. This way, tool and chuck are connected to each other as one piece. The chuck is heated by induction by special high frequency generators. The chuck's heat expansion is faster than that of the tool so that the tools may be shrunk out again. Shrinking chucks „ThermoGrip®“ may be used at speeds up to  $n = 36,000 \text{ min}^{-1}$ , and due to their stiffness enable 30 % higher feed rates compared to collet chucks even in the conventional speed range up to  $n = 24,000 \text{ min}^{-1}$ .

The same technique of shrinking on tools is also used for arbors for tool sets. It makes sense if the tool remains on the arbor for sharpening or changing knives. A higher balancing quality is achieved by the shrink fit connection since tools and arbor can be balanced as a unit, and the tool weight may be reduced by using light alloy tools. Both result in a considerable increase in the feed speed which increases productivity on stand alone machines, for example in window manufacturing with the wide tool sets usual in this industry.

Highest precision regarding concentric and axial run out and balancing quality is achieved if the tool is sharpened with the clamping system as a unit. This requires universal tool interfaces on the wood processing machines in production and the tool sharpening machines in service. Tools conditioned in this way may be operated at higher feed speeds and have a longer tool life.



Concentricity and run out



Note the readjustment area

**1. Measures before commissioning**

When installing a tool on the machine, please check the following points:

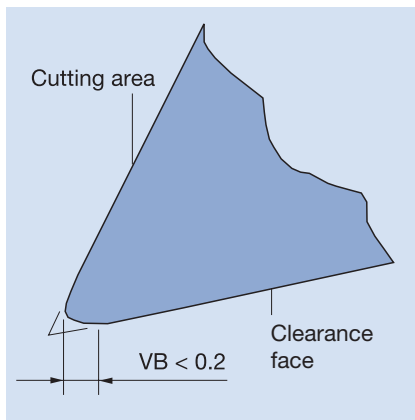
- a) **Please read the instructions before commissioning the tool.**
- b) **Clean the tool and the tool adaptor.**  
All mating surfaces, the knife seating, the interfaces between machine spindle and tool adaptor, must be free from dirt, grease and corrosion.
- c) **Clamp tools only between the intended clamping areas in the machine.** Clamping areas, such as bore, boss, conical surfaces and knife seatings must not be damaged during assembly.
- d) **The blades must not come into contact with machine parts during assembly – risk of breakage!**
- e) **Check tools for chipped or damaged blades** – in particular if the tool has collided with machine parts, such as machine table, tool clamping elements, extraction hoods. Do not use tools that have been deformed. Have damaged tools checked by an expert. Sets containing damaged or worn cutting edges, clamping elements or screws must be replaced with original parts. Tools with a damaged tool body or deformed knife seating must be removed. Repair of such tools is forbidden!
- f) **When assembling tool sets, use face ground spacers.**
- g) **Tighten all clamping screws with the correct key.** The torque specified in the operating instructions must be observed. Using of extensions or hammers not permitted.
- h) **Check tool tension and feed rate.**
- i) **Check the correct direction of rotation of the tool.**
- j) **Compare the maximum rotational speed ( $n_{\max}$ ) of the tool with the rotational speed of the machine.** The value ( $n_{\max}$ ) as stated on the tool must not be exceeded. The rotational speed ideal for the application may be below  $n_{\max}$ .

**2. Measures to be adopted/care during use**

Special care is required to maintain the quality and precision of a tool throughout its life. The following points are important for professional handling of the tools:

- a) To prevent corrosion, protect wood processing tools from humidity. If not in use for a long period, the tools should be treated with a suitable care product, such as WD-40 or Ballistol.
- b) Protect cutting edges and clamping surfaces from damage. For example, store and transport the tools in their packaging and do not place them on hard surfaces.

Tool wear and cutter condition should be checked during use to confirm the tool is serviceable, and to avoid unnecessary expense. Do not in any circumstances wait until cutter wear (blunting) has become too great or sections of the cutting edge have broken away. On many machines, checking the power consumption with an ammeter is an easy way to monitor the condition of the tool.



Maximum width of wear mark VB.

Cutting generates dust particles which, when mixed with resin or adhesive, can build up on the cutters or in the tool gullets. Such build up reduces the cutting angle, the size of the gullets, increases the power requirement, it shortens the tool life, reduces the surface quality and can, in extreme cases, even burn out motors.

Cleaning tools is not a luxury but an essential part of their use. Tools should be regularly cleaned of resin; special commercial cleaning agents are available. For tools with aluminium bodies, use only commercial cleaning agents with a pH value of between 4.5 and 8, as corrosion can destroy the alloy. Attention: Always comply with the manufacturer's instructions.

Frequent removal of any resin build up is especially important with tungsten carbide sawblades, as even small cutter projections have this problem. In some cases resin build up can lead to cracks in the sawblades.

Particles of workpiece material can damage the cutters if dust and chips are not extracted efficiently. The cutting edges can be chipped, as well as increased abrasive wear.

An extraction system with optimised extraction capacity and performance will help increase tool life.

Regular maintenance is essential for proper and safe use of tools.

Tools must be resharpened when:

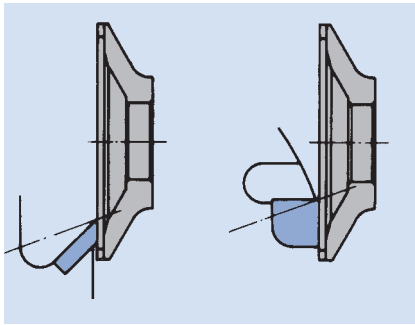
- a) workpiece surface quality is no longer satisfactory
- b) the wear mark width (VB) on the clearance face is greater than 0.2 mm
- c) the machine's power consumption is too high
- d) sections of the cutting edge have broken away.

### 3. Tool servicing/Sharpening

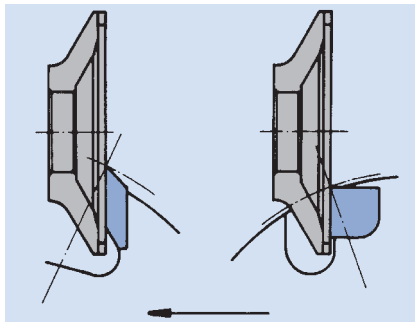
This means reinstating the cutter sharpness of blunt tools, but also other repairs, for example replacing damaged cutting edges.

Servicing differs for the various materials, namely tipped high alloy tool steel, tungsten carbide or diamond.

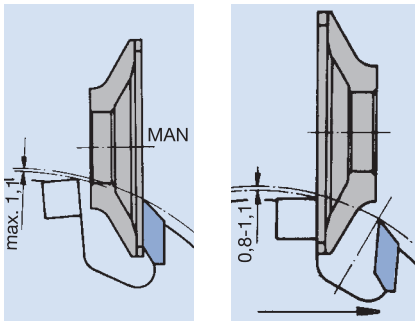
Special machining processes are necessary to minimise the temperature rise in the cutters during sharpening to ensure crack free cutting edges, a cutting geometry according to the drawing, maintenance of the original dimensions and tolerances and a sharp cutting edge.



Sharpening on the clearance face.



Sharpening on the cutting area.



MAN tools: Knife protrusion in comparison to the limiters.

When servicing tools, the following has to be observed:

- the construction of composite tools must not be altered
- tipped tools must be serviced by trained personnel
- only spare parts to the manufacturer's original parts specification are used
- tolerances to ensure precise clamping, are retained.

To avoid damaging the cutting material by overheating or stress cracking, cooling lubricants must be used when sharpening.

Attention: Dry sharpening is not recommended.

The specified tool body radius should not be changed when sharpening, to avoid the risk of fatigue stresses.

### 3.1. HL, HS, ST and HW tools (solid or tipped)

HW tools are sharpened with diamond grinding wheels. Corundum or CBN grinding wheels are used for all the other cutting materials listed above.

#### Basic rules

- clean the tools thoroughly before sharpening
- maintain concentricity tolerances – check with a dial gauge
- spur projection beyond main cutter: 0.3 to 0.5 mm
- cutting edge projection should not exceed 1.1 mm above the limiter on manual feed tools

#### Tools with radial tipping

##### a) Grooving cutter with or without spur

These tools are always sharpened on the top, so as not to change the cutting width.

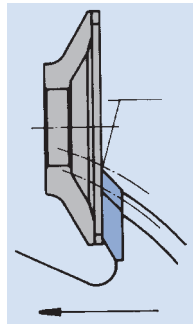
##### b) Jointing, rebating and bevelling cutter blocks

These tools are sharpened parallel to the face of the cutting edge or the spur.

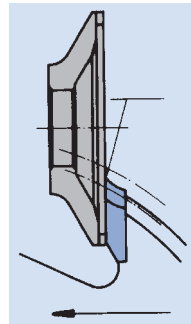
##### c) Profile cutterblocks

The shape of the tips depends on factors such as the cutting material, profile depth etc. The clearance face can be one of three types (concave, straight, or convex), depending on the purpose of the tool. Sharpening always takes place on the face of the cutter, not on the profile!

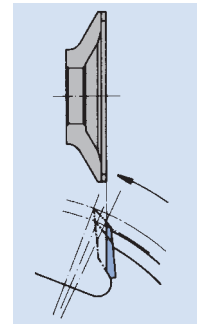
Profile cutterblocks with straight or concave clearance face are sharpened parallel to the face; profile cutterblocks with convex back relief are sharpened by rotating around the cutter axis. The maximum permissible cutting edge projection for manual feed profile cutterblocks (MAN) is 1.1 mm and must not be exceeded.



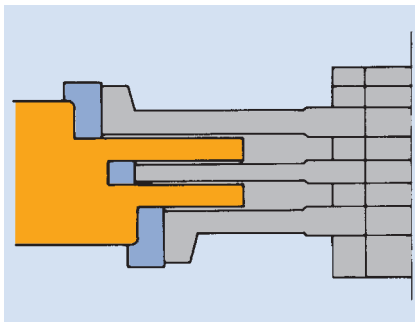
Straight clearance face.



Concave clearance face.



Convex clearance face.



Slot and tenon cutter.

### 3.2. HS and HW slot and tenon cutters

The special blade tip geometry ensures constant rebate depths if the same amount is ground away from the face of every tip and removed parallel to the tip. For manual feed tools, the maximum permissible cutting edge projection of 1.1 mm must not be exceeded. After several sharpenings, the shimming must be adjusted (with a spacer set) to maintain the profile.

### 3.3. Cutterblocks and cutter sets

Single tools are sharpened as stated in guidelines 1 and 2 above. The amount removed during sharpening depends on the most worn cutter. All cutterblocks in a cutterset have to be sharpened to the same diameter to maintain the original workpiece profile.

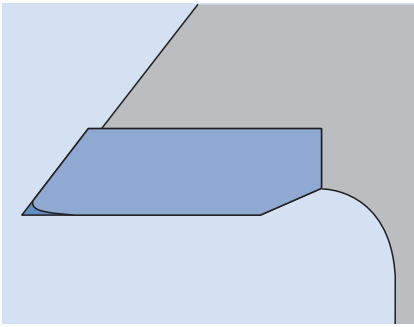
### 3.4. Diamond tipped tools (DP)

Diamond tipped tools can only be sharpened or eroded on the top, using machines with special fixtures. Sharpening can be either by grinding or by spark erosion. Special measuring equipment is needed to check the sharpened tool. Diamond tipped tools can only be serviced at Leitz service centres with the necessary special equipment, or at the Leitz production plants.

### 3.5. HW tipped circular sawblades

#### a) General information

HW tipped circular sawblades should only be sharpened on special purpose automatic sharpening machines. Manual sharpening on universal sharpening machines cannot be recommended for quality and cost reasons. Automatic sharpening machines use a plunge cut grinding principle and are designed for wet grinding. Many of these machines are capable of sharpening all the standard and special tooth forms in a single cycle on both the face and the top. Sawblades must be thoroughly cleaned before sharpening.



Wear on a HW saw tooth.

**b) Reduction of saw plate and body**

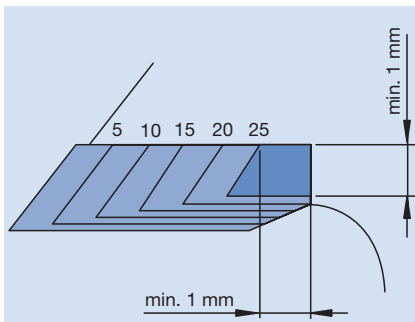
Only the tungsten carbide tips should be ground by the diamond wheel on automatic sharpening machines; the saw plate must be reduced behind the teeth and if necessary in the chip gullet as a separate operation. To avoid reducing the stability of the teeth unnecessarily, the HW tips should not project more than 0.2 mm (with SB < 3.2 mm) or 0.5 mm (with SB > 3.2 mm) above the saw body.

**c) Resharpener**

To sharpen a circular sawblade the maximum number of times, it is essential to sharpen both the face and the top of HW circular sawblades. As a rule, the removal ratio between the top and the face is 1:1 for solid wood machining and 1:2 for chipboard. Failure to remove the rounded-off areas at the tip edge completely reduces the tool life. The sharpening machine instruction manual will contain the necessary machine settings. Adjustment to the thickness of the sawblade is especially important, as teeth sharpened inaccurately will cause lateral sawblade runout.

**d) Residual tooth height and thickness at end of life**

When the tooth height measured from the tip seat is 1 mm, the sawblade is at the end of its life and should be scrapped for safety reasons.



Leitz recommendation for the remaining tooth size on the sawblade.

**e) Retipping**

All Leitz service centres offer a replacement service for individual damaged teeth on HW sawblades. The new tip is applied by induction brazing using the correct braze and flux.

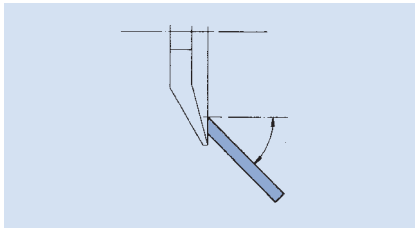
Expert knowledge of both the carbide composition and the saw body material is necessary. Users are recommended not to carry out this work themselves.

**f) Flattening and tensioning**

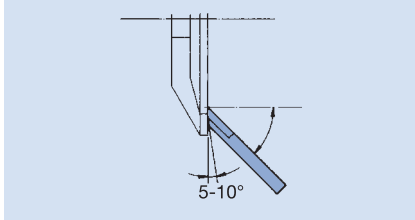
Flattening a sawblade means eliminating any twists in the plate for perfect flatness. Tensioning means stretching the saw plate at a point roughly half-way between the periphery and the centre. Flattening and tensioning are usually carried out as a single operation, and are essential for satisfactory sawblade performance. Sawblades should be checked regularly during resharpening for flatness and tension, and corrected if necessary. This is essential for multi-rip and thin-kerf sawblades, as these work in extreme conditions and can easily crack or fracture as a result. Sawblades severely discoloured by overheating should be discarded.

When in use, a sawblade should be supported by the correct flange; the flange diameter is based on the diameter of the sawblade. This relationship is laid down in German Industrial Standard DIN 8083. As a guide, the flange diameter should not be less than a quarter but preferably a third of the sawblade diameter.

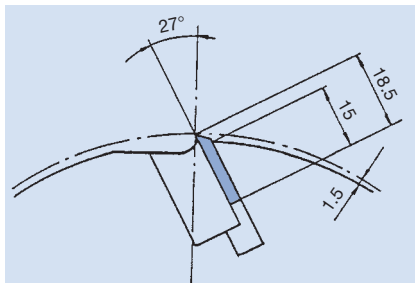
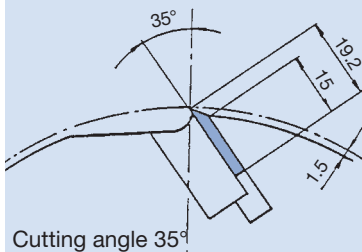




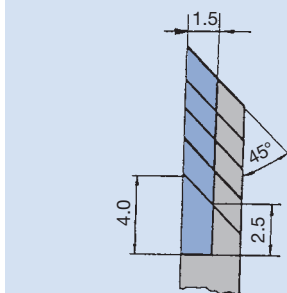
Sharpening of planer knives.



Recessing of the knife basic material of HW-tipped planer knives.

Planerhead  
Cutting angle 27°

Cutting angle 35°



HW-tipped planer knives

Allowed minimum dimensions of planer knives.

### 3.6. Hoggers

#### a) Hogging cutters

Hoggers consist of a sawblade and a hogging cutter screwed together. Hogging cutters must be ground on the top of the teeth and occasionally on the face, so that the relationship between them and the sawblade is maintained. As the teeth are of equal pitch, it is more efficient if they are sharpened on an automatic machine. The hogging cutter has to be mounted on a special fixture for this operation.

#### b) Segment hoggers

Segment hoggers consist of hogging segments and a sawblade. The saw segment can be ground either while mounted in the hogger body on a conventional cutter sharpening machine, or dismantled from the hogger body and mounted in a special fixture for an automatic sharpening machine (as used for HW circular sawblades).

#### c) Compact hoggers

A diamond compact hogger (DP) is sharpened by erosion on all three edges (side, bevel and top), on a special machine. If the tool is mounted on a hydro sleeve during operation, sharpening must be carried out with the same level of clamping to achieve high concentricity and runout accuracy.

### 3.7. Cutterheads

It is essential to follow the below when mounting planer knives:

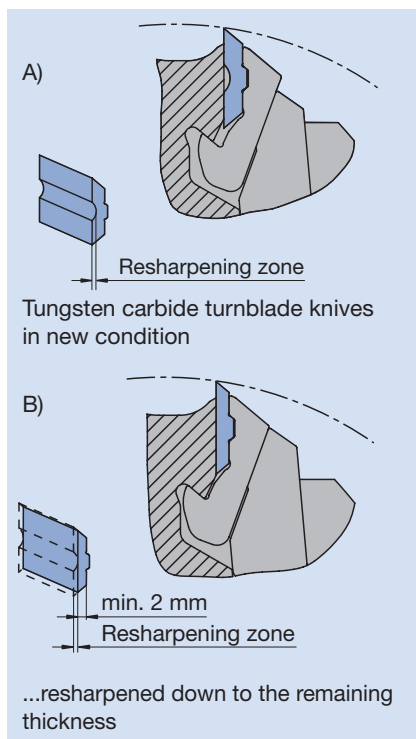
- 1) All the tool body locating faces, knives and clamping elements must be clean and undamaged.
- 2) The clamping screws should be tightened from the centre to the outside (for larger cutting widths).
- 3) The knife setting should be checked with either a dial gauge or a setting gauge (for planer knives).
- 4) Do not use an extension to the wrench or key when tightening the bolts or screws.
- 5) Spurs should sit perfectly in their seats before the screws are tightened.
- 6) Cutterheads should be mounted on a suitable spindle when tightening the bolts or screws, to avoid distorting the body.
- 7) Seats and wedges in cutterheads must not be modified in any way as they are specifically designed for maximum safety.
- 8) All knives and clamping elements should be of equal weight.
- 9) New knives and clamping elements mounted in opposed seats should have the identical weight to avoid imbalance.

#### a) Planer knives

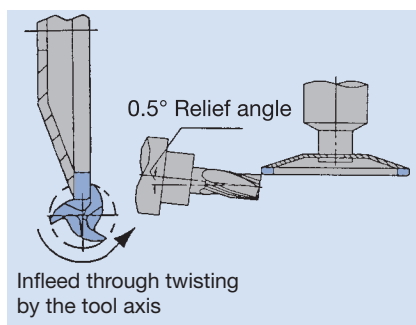
HL, HS and HW planer knives are ground only on the back to maintain the original angle. To prevent the diamond wheel from touching the tool body when resharpening the knives, the clearance from the steel backing must be 5 to 10° less than for the actual carbide tip.

Comply with the dimensional tolerances when sharpening planer knives. The minimum clamping width should not be exceeded (see the marks on the side of the tool body).





Sharpening of VariPlan knives.



Sharpening of spiral routers.

For a minimum clamping width of 15 mm and a radial knife projection of 1.5 mm, the minimum knife height is 18.5 mm for a cutting angle of 27° and 19.2 mm for a cutting angle of 35°.

Hydro cutterheads have a radial knife projection of 4 mm; for the same minimum clamping width, the minimum knife height is 21.3 mm.

Note, the minimum tip height must be at least 4 mm on HW tipped planer knives.

#### b) VariPlan planerhead

The cutter has straight, face-sharpened turnblade knives which can be sharpened. The knives have a raised trapezoidal area on the back and are mounted in a special fixture for sharpening.

The resharpener area of 1 mm is shown by the groove in the knife face. The clearance angle is matched to the clamping mechanism in such a way that after resharpener, the diameter of the tool remains constant and the clearance angle must not be changed.

#### c) Spiral planerhead

Sharpening the 1 mm thick flexible HS knives requires a special fixture supplied by the manufacturer. After sharpening, the knives are clamped in the cassette to the correct three-dimensional pattern. The user can then install the complete knife cassette in the spiral planerhead.

#### d) Profiled knives

Profiled knives are ground on the edge of the profile; the possible sharpening area and minimum knife clamping heights must be complied with.

The cutting edge quality and the life time can be improved, if one level is ground with a second clearance face, which is about 3° to 5° smaller than the main clearance face. Radial profile sectors additionally require a lateral clearance face.

### 3.8. Tools for routing

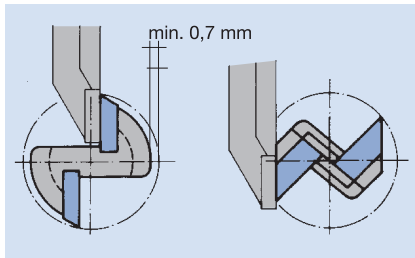
#### a) HS and HW spiral routers

These tools are manufactured in one of two designs: either as a finishing cutter with maximum chip removal of 1 to 3 mm, or as a roughing cutter for high hogging performance.

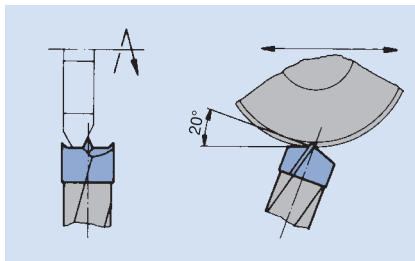
Roughing cutters are resharpened only on the face because of their special profile. Finishing cutters can also be resharpened on the clearance face.

#### b) HS and HW routers with shear angle

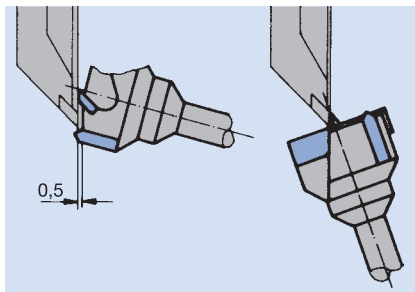
These are face ground. If the cutting edge is chipped, the back can also be ground down to the next possible nominal diameter. The body must be set back at least 0.7 mm from the knife cutting circle.



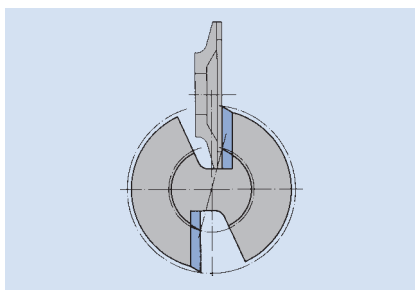
Sharpening of routers with straight edges.



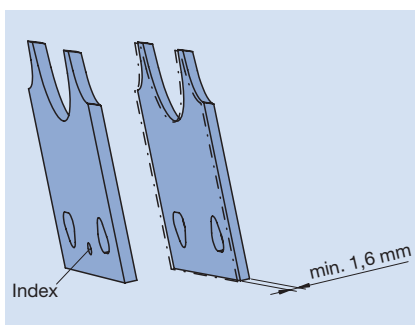
Sharpening of dowel drills.



Sharpening of hinge boring bits.



Sharpening of HW-tipped profile routers.



Sharpening of VariForm knives.

#### c) HW tipped dowel drills

Clamp the drill firmly in a collet before reshaping, to ensure high concentric running accuracy. HW tipped dowel drills are reshaped on the cutter edge, centre point and spur in one operation with a profiled diamond wheel. The projection of the centre point and spurs above the tool body must be maintained. Profile diamond grinding wheels are available for all frequently used diameters.

#### d) HW tipped hinge boring bits

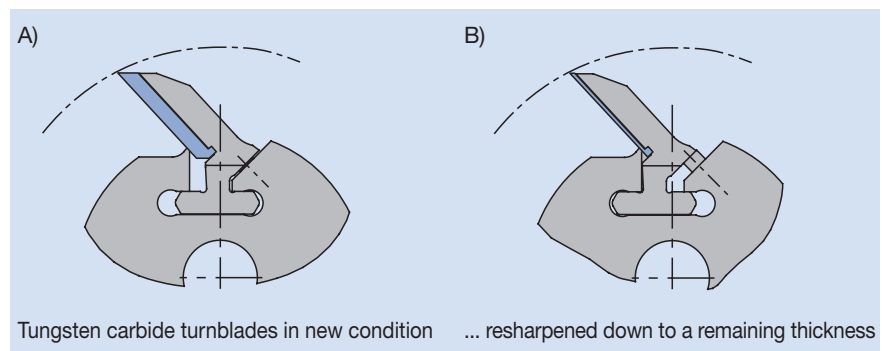
Clamp the tool firmly in a collet before reshaping. The centre point and spurs are ground in a single operation. Before sharpening the edges of the main cutters, the tool body must be set back so that it is 0.5 mm below the main cutter. The spur should project above the main cutter by 0.3 to 0.5 mm; the centre point should project by 1.5 to 2.5 mm. If there is excessive wear, the main cutter can also be sharpened on the face, but only reshaped as far back as the centre of the bit.

#### e) HW tipped profile router cutters

Profile router cutters are subject to the same sharpening guidelines as profile cutterblocks (see 3.1c). Profiled routers are clamped firmly in a collet before reshaping to maintain high concentric running accuracy. The restricted gullet geometry of MAN tools may require the use of thin, small diameter grinding wheels.

### 3.9. ProFix knives

HS and HW tipped ProFix knives are sharpened on the face after removal from the tool body and mounting in a pivoting fixture fitted to the table of the sharpening machine. This allows knives with different cutting angles (15°, 20°, 25°) to be aligned parallel to the sharpening direction. HW tips can be ground down to a minimum thickness of 0.5 mm, ensuring a high material utilisation.



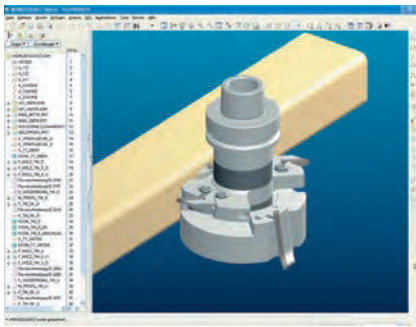
Sharpening of ProFix knives

### 3.10. VariForm profile knives

VariForm cutterheads (HW) are ground parallel with a diamond wheel over the entire front face of the knife (the cutting face).

Special grinding machine fixtures are required; these are installed at Leitz service centres.

The sharpening area is identified by a circular hole in the cutting face. Once this hole has disappeared, the knife has reached the end of its useful Index life and cannot be reshaped any thinner (minimum thickness 1.6 mm).



Modern construction methods through 3D-CAD.



Centrifugation test facility.



Labelling example of boring tools.



Labelling example of shank routers with a minimum clamping length.



Tool with integrated data chip.

Tools for woodworking machines are potentially dangerous because of their high speeds and sharp cutting edges. Always use machine guards and only use tools tested for compliance with the technical safety requirements to reduce the risk of accidents.

#### Safety at Leitz

The highest level of product safety is important to Leitz as a major tool manufacturer. All Leitz tools are designed and manufactured to EN 847 standards and take the latest safety research findings into consideration. The basis for safe tools is established at an early stage in their development, as can be seen from:

- modern CAD techniques and calculation methods such as the Finite Element Method (FEM)
- extensive testing including overspeed and reversing tests in the Leitz research department
- tool certification according to the independent industrial accident tests laid down by the Deutsche Holz-Berufsgenossenschaft (German Wood Trade Industrial Accident Insurers).

Manufacturing procedures checked and documented to DIN EN ISO 9001 and a certified quality management system guarantee the high quality and safety standards expected of tools supplied by Leitz. Support from Leitz – including local Leitz sharpening centres satisfy customers' needs and advice from technical specialists – ensures the safety of the tool throughout its life.

#### Safety in use

A tool is only as safe as how it is used by the operator. Detailed, easily understandable instructions on the safe use of the tools are just as important as their safe design. Leitz cooperated in the VDMA project to develop specimen instruction handbooks for different types of tools. These layouts are now used not only for Leitz products but are also recommended by the European woodworking industry association EUMABOIS.

Users are given the relevant safe handling information by the information etched on the tools, the maximum rotating speed, method of feed, minimal clamping length for shank tools etc.

Intelligent tools with integrated memory chips are available for CNC machining centres. These tools automatically supply the machine control system with the relevant geometry and technology data such as tool length, tool diameter, recommended running speed, direction of rotation etc. The risk of manual input errors is reduced ensuring high operating safety and process reliability.

The comprehensive safety instructions supplied by the machine manufacturer should be followed when using tools. The guards on the machine are to protect people and should not be modified or removed. Internationally accepted pictograms advise of any potential danger.



ISO 3864, U.S. ANSI Z535  
VDMA woodworking machines.



Safety labels  
Pictograms for handling, function monitoring and maintenance - woodworking machines

Important Note:  
Tools and clamping tools are not subject to machine guidelines and are not allowed to have the CE-Sign.

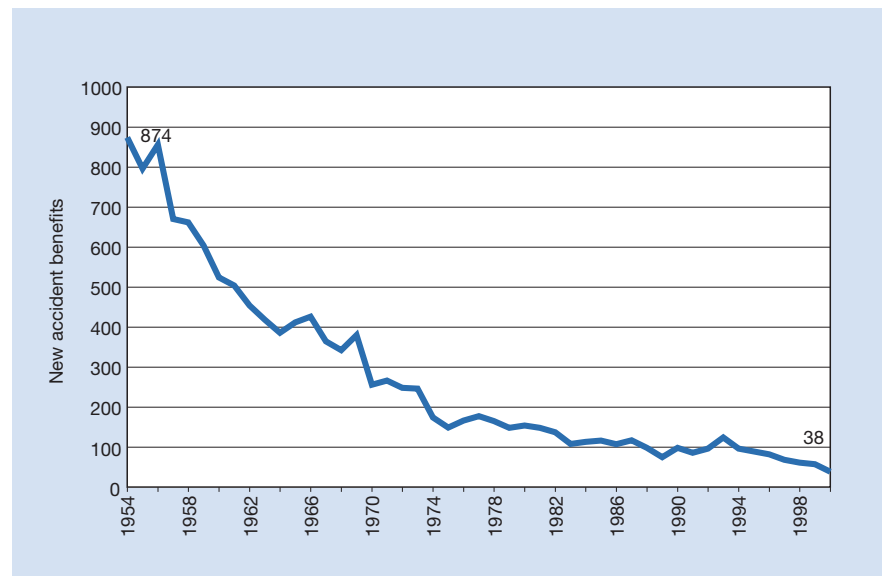
#### Safety guidelines

Leitz and the other well-known German tool and machine manufacturers are members of the Association of German Machine Manufacturers (VDMA). Leitz's long experience has contributed to national and international standards and regulations for the safe construction of woodworking machine tools and for operator safety throughout the world.

The EN 847 series of European standards, parts 1 to 3 „Machine tools for woodworking – safety requirements“ are the most important guideline for European tool manufacturers. Woodworking tools must comply to these minimum standards to be considered safe.

One of the aims of manual feed tools is to reduce kick back. The small gullet size and limited cutter edge projection reduce the severity of injuries. This is evident by the steady reduction in the number of accidents notified annually to the industrial accident insurers.

EN 847-1	Machine tools for woodworking – safety requirements Part 1: Milling and planing tools, circular sawblades
EN 847-2	Machine tools for woodworking – safety requirements Part 2: Requirements for shank milling tools
EN 847-3	Machine tools for woodworking – safety requirements Part 3: Clamping tools



Constant decrease of the „new“ accident benefit (source: Holz BG)





Tire profile with irregular pitch.



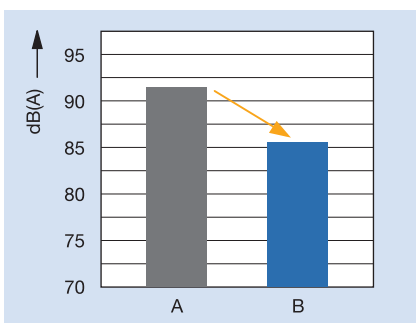
UT-hogger with irregular pitch.



A) Conventional jointing cutter  
91,5 dB(A).

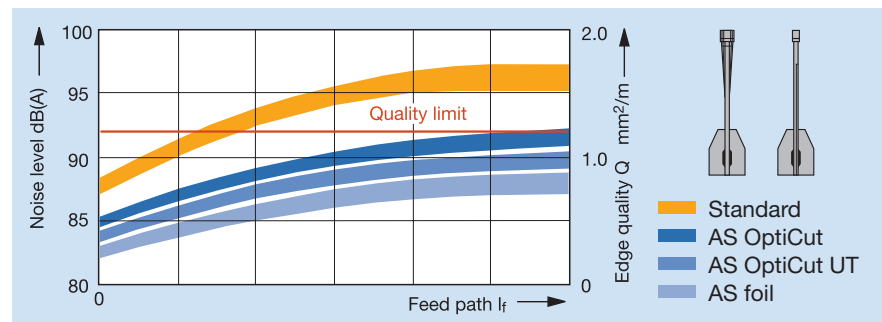


B) Jointing cutter „WhisperCut“  
86 dB(A).



Noise reduction for jointing cutters.

In addition to dust, noise is a major problem in the woodworking industry. It is important when developing new tools to reduce noise levels at source and to prevent them from increasing. If the level is lowered by 10 dB(A), the human ear perceives this as a 50% reduction in noise. The latest low noise tool systems considerably improve the users' working environment.



Axial body vibration of a plate type tool such as a sawblade causes noise radiation. The vibration amplitude can be significantly reduced by the design of the teeth, gullet geometry and by damping the saw plate. Leitz supplies a choice of designs of low noise sawblades (AS) which take into account all the criteria, the machine and the materials to be cut.

- A) AS sawblade with foil (vibration damping by friction between sawblade and foil)
- B) AS OptiCut UT sawblade (irregular pitched teeth suppress harmonic vibrations in the sawblade)
- C) AS OptiCut sawblade (laser ornaments in the sawblade body reduce natural resonance and vibration disturbing the sound waves).

Cutting edge airflow turbulence is another cause of noise as it stimulates vibration in the sawblade. When the cutting tips touch the workpiece, tool and workpiece vibrate. Varying the distance between successive cutting tips counteracts harmonic vibrations and dampens both free running and cutting noise.

The principle of irregularly pitched teeth (UT) is applied to both sawblades and profiling tools.

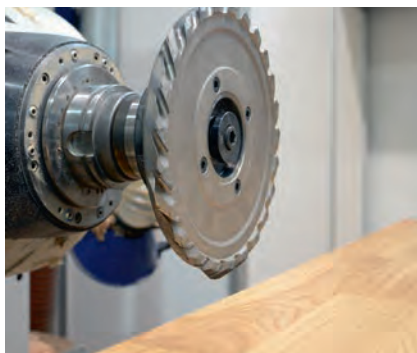
Research has also been carried out on ways to reduce the noise generated by cutting tools. A closed circular tool body shape, a profile that matches the tool body and optimised gullet geometry result in significant noise reduction. Today's diamond jointing tools with these features generate half the noise of their predecessors. But there are other, fully intentional, benefits from noise reduction. Reduced vibration means that the tool runs more smoothly, in turn leading to better cut quality and a longer tool life.



Laminate processing: Typical chip collection in the machine.



Problem: Machine wear through abrasive chips.



DFC® tool for directed chip beam.  
**DFC®-system:** Tool with adapted extraction hood. Most of the chips are collected and the wear is kept away from the machine.

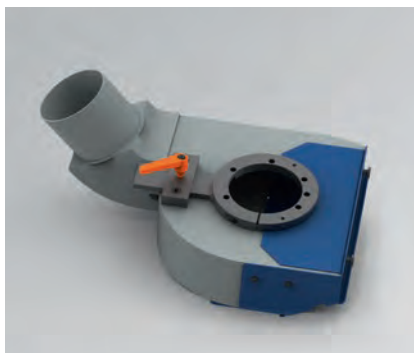
Every woodworking production process causes chips, chips to be extracted. Despite state of the art extraction systems, not all the chips are collected. Whether processing solid wood or panels, uncollected chips have a negative impact on added value. They reduce the product quality, make additional tool cleaning necessary, increase machine downtime and can cause machine breakdowns through wear. Leitz's answer to this problem is DFC® (Dust Flow Control).

#### DFC®

The philosophy behind DFC® is to control the chips by using the kinetic energy in the chip flow to direct the chips away from the workpiece and tool cutting edge into the extraction system.

This improved method of chip collection has the following advantages:

- Energy saving  
The extraction airflow no longer has to capture the chips, only transport the chips into the extraction system. This reduces the required airflow volume and, in winter, reduces heating costs, as the heated air is not being taken from the factory.
- Improved product quality  
Sensing systems are not impaired in any way by chip impairing them or glue spillage.
- Higher productivity  
Clean machines mean continuous production without stoppages. Clean workpieces do not need additional cleaning prior to packaging.
- Reduced servicing costs  
The abrasive chips are directed away from expensive machine elements and dispel their energy against replaceable wear parts such as guides or dust hoods.



Module-based DFC® extraction hood with exchangeable wear baffle plates, adjustable tool passage with secondary air supply system and detachable lid for good accessibility to the tool.



A sound-insulated design can additionally optimize the machine with regard to noise.



Example: Hogging of veneered panels with free veneer projection.



Broken splinters block the extraction hood - fire risk through friction of the rotating tool!



DFC® hogger with shredding edges shred the veneer projection on an extractable size for a complete disposal.



Splitting of worktops with DP-routers. Conventional router: Chip beam horizontally leaves the workpiece and shoots through bristle curtains or vertical blinds.

#### Applications for DFC® tools:

DFC® technology is available for hoggers, jointing cutters, profile cutters, grooving and shank tools; it is the subject of ongoing continuous development. The best results are achieved when the tool and the extraction system are matched to each other. Examples of DFC® system solutions are:

#### - *iQsystem*

Developed with the machinery manufacturers for efficient chip collection on edge banding machines – over 95% efficient.

- DFC® tools for laminate and parquet flooring production with matched extraction hoods, e.g. „i-flooring”: significant reduce wear caused by abrasive chips to the machine guides and feed systems.

DFC® tools are important in hogging; the problem of continuous high volume chip output cannot be solved simply by increasing the extraction velocity. The chips must be directed as produced in the right direction. The effect cannot be seen so easily as on CNC machining centres when sizing panel materials. Often compromises have to be made in the design of the tool, the working method and chip flow.

Chips can clog the extraction hood and a fire risk from friction with the rotating tool. Chips can also block the extraction pipes and stop production. A well known example is machining veneered panels where the coating projects over the edge of the panel. Conventional tools do not break up the weak projecting coating causing the long strips of veneer to clog the extraction system. Such blockages can cause machine fires. DFC® hoggers with shredder knives solve the problem by breaking the overhang into small, easily extracted pieces.



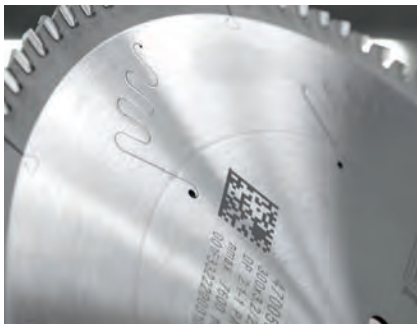
DFC® router: Chip beam is directed to the top of the extraction hood and can be extracted.







Tool with QR Code



Tool with DataMatrix Code



Tool with integrated RFID Chip



Tool with integrated NFC Chip

In the early 1990s, Leitz introduced the wood processing market to chip tools as „intelligent tools“, storing all a CNC tool machines' relevant data on integrated memory chips. This provided the machine control center with essential geometry and technology data including RPM, direction of rotation, diameter, tool length, reference points coordinates, and if the application was known, even the recommended application speed and feed speed.

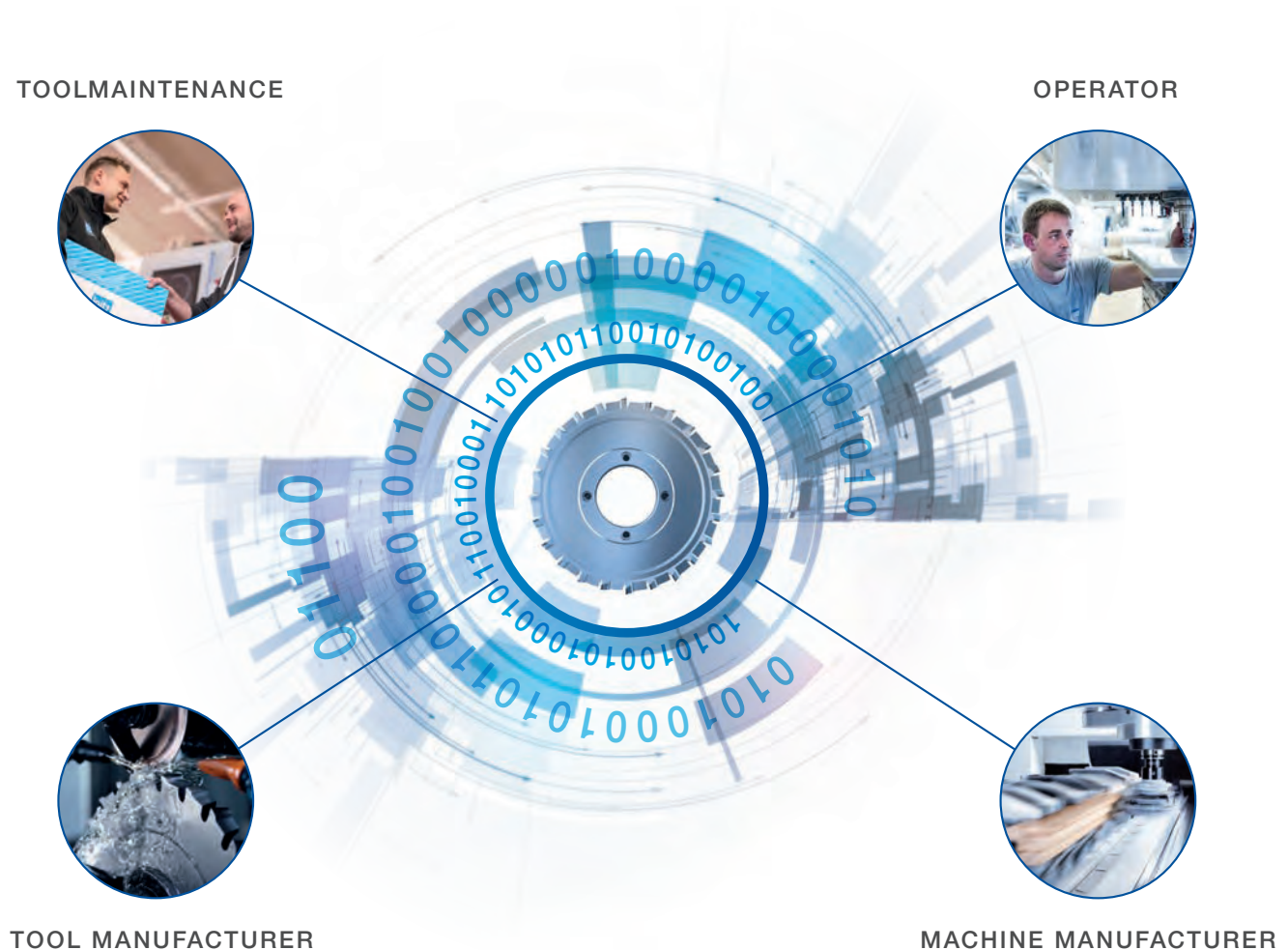
The machine transferred all this data in the tool memory device, which had the benefit of needing no calibration, reading the data straight into the machine controls. This improved process safety by preventing errors during adjustment of the machine. However, an issue was the lack of standardization of data; the tool needed to be programmed on a machine-specific basis and could not be used on machines from different manufacturers.

With the rise of digital-controlled manufacturing, cyber physical communication between all operating resources has become increasingly important. For this, tool data is stored in a central database. It is encoded with an automatically readable and unambiguous identification-number: RFID Chips or DataMatrix Codes. Access to the data takes place via this serial number. For manufacturing tool data exchange, a crucial prerequisite is a standardized data model with uniform nomenclature and uniform structure of parameters. The tool acts as knowledge mediator and consequently becomes the key factor for the optimization of the entire production processes and value chains.

The advantage of central data management is that much more information can be transferred; data can be retrieved at any time without physical access on the tool. Not only can tool data be read into the machine control but also machine data like tool life and power consumption can be assigned and written back to the individual tool. In this way a learning system is made possible that anticipates a tool replacement. Pure parameters used by the machine control as well as tool contour data can be transferred to the control unit in order to carry out process simulation and collision detection. By linking tool data with material data and application data, an expert system can be created that recommends the right tool with appropriate parameters to the customer for their machining task.

At the highest stage of networking, tool data is provided from the cloud. Access to the data can be assigned to different authorization groups or user groups. Each tool has its individual valid data record which can be updated by the Sharpening Service if tool parameters have changed as a result of reshaping or rework. Tool-related tool life data can be transferred to the tool manufacturer providing the basis for optimizing processes and for pay-per-use billing models.

Imaginable is also a hybrid type between data storage on memory chip and a cloud solution, depends on the existing IT improvement and IT firewall concepts. Here the tool is data medium for necessary safety and performance data and at once other additional information as application parameters, running time parameters or CAD data can be viewed in the cloud.



## 11.5 Wood processing machines

### 11.5.1 Through feed machines

**There are two different categories of wood processing machines with mechanical feed: through feed and stand alone machines.**



Detailed view of an edge banding machine with chain feed.



Detailed view of a four side planing and profiling machine with roller feed.

If the workpiece is guided through the machine by a feeding unit, it is called a **through feed machine**. The machining processing is made by guiding the workpiece past the tools. Several tools may be used subsequently, to fully process the workpiece. Depending on the type of feeding systems, a distinction is made between machines with chain feed and machines with roller feed.

**Machines with chain feed** are used to process the narrow sides of panel materials. The feed chain is used as the workpiece support and reference height for the process. A revolving top pressure belt clamps the workpieces to the chain and transports them through the machine. The part of the board workpieces protruding past the chain can be processed. The chain's uncoiling movement from the chain wheel, can cause minor variations in the feed; this is called the polygon effect. Such effect is counteracted structurally so that the polygon effect does not affect the processing quality. Typical examples for such machines are double end tenoners and edge banding machines for furniture components or machines for profiling laminate panels or parquet floor panels.

**Machines with roller feed** are used for four sided processing of solid wood or wood derived products. Typical examples of this machine category are multi spindle four side planing and profiling machines for manufacture of blanks, mouldings and profile panels. The workpieces are pushed along the machine table by driven feed rollers and guided along a fence. The roller feed, is smooth so the wood surfaces are ready for painting. It is also important for the processing quality that the workpieces are guided past the processing tools straight and without vibrations. The tools' zero diameter has to be set exactly to the table height and lateral guide in order to produce accurate workpiece surfaces. Constant tools save time since their zero diameter remains unchanged. Additionally sufficient support of the workpieces against the cutting pressure is important in order to avoid workpiece vibrations and rippled surfaces. The pressure shoes at each processing station must be set exactly to the workpiece dimensions. Chip extraction is also important.

**Through feed machines** enable a **high production performance** since all processing steps on one workpiece are made almost at once. These machines are designed for bigger batches since retooling is time consuming. Following the **trend towards smaller batch sizes**, elements from stand alone technology are now integrated into feed through machines: e.g. engines with HSK interface, preset tools, automatic tool changer, tracing aggregates, contour milling cutters or through feed drilling. To further increase the feed rates, dynamic linear actuators are used for the tracing aggregates.

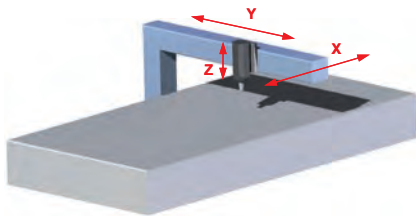


## 11.5 Wood processing machines

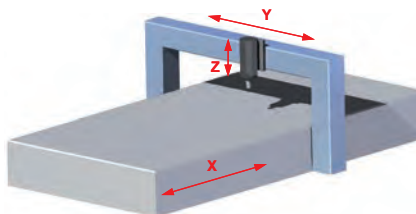
### 11.5.2 Stand alone machines



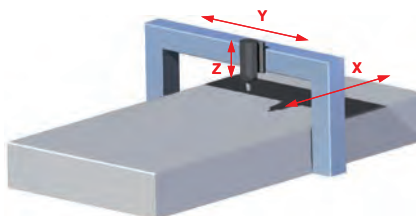
Cantilever type machining centre



Schema of a cantilever machine



Schema of a portal machine



Schema of a gantry machine

In **stand alone machines** the workpiece is clamped firmly, and the feed movement is achieved by contour controlled axis or the workpiece table. Depending on the arrangement for the moving axis, the different designs are called travelling column, portal or gantry. In the **travelling column design**, also called **cantilever**, machine spindle is situated on a mobile cantilever and executes the feeding movements in all three axis. In case of the **portal design**, the machine spindle which is mobile in Y and Z direction is situated on a fixed portal, and the feeding movement in X direction is made by the workpiece table. Such machines often are equipped with tandem tables, so one table may be loaded and unloaded by a handling system while processing is under way on the second. The **gantry design** is a **travelling portal** carrying the machine spindle. All feeding movements are achieved by the tool, similar to the travelling column design. Due to the bilateral support of the travelling portal, the gantry machines are more dynamic than the cantilever machines and often used for the nesting.

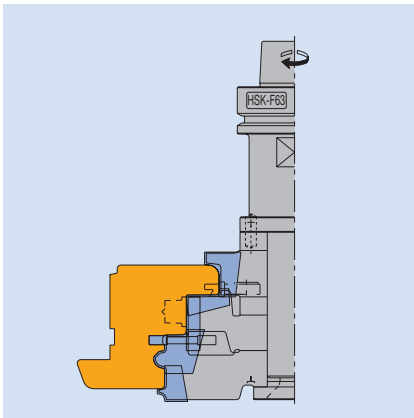
Coming from point-to-point drills and CNC routing cutters, these stand alone machines have been developed into complex **processing centres**. When equipped with drill drives and additional aggregates, they can machine the workpiece, drill it on all sides, saw and even edge band so that a component may be processed in one setting. The machines are made flexible by a tool magazine and automatic tool changer. The main spindle is usually designed to use a HSK interface; HSK-F 63 and also HSK-E 63 are common in wood processing. Since the tool diameters range between 3 mm to over 200 mm, the motor spindles are frequency controlled to a maximum speed of  $24,000 \text{ min}^{-1}$  or up to  $30,000 \text{ min}^{-1}$  for HSC machines.

CNC-controlled machines allow flexible component manufacturing with a batch size of one. The software determines what process by which tools. The process task is changed by calling up a new CNC program on the control. Despite this theoretical flexibility, the component spectrum processed on one machine depends on the **workpiece clamping technology**. Beams may be positioned freely and with vacuum extraction clamps for panel workpieces or mechanical clamping devices, for window blanks, may be positioned. Additionally there are vacuum tables for clamping of bigger boards e.g. for nesting. Mouldings without level clamping surfaces, e.g. backrests, are clamped by specially manufactured templates that are set on the beams or vacuum tables mechanically or by vacuum as an auxiliary device. The arrangement and distance of the extraction or clamping devices on vacuum table are very important for the processing result. If the distance is too great, workpiece vibrating reduces the processing quality and tool life. Bigger pieces of waste should be clamped so they do not break off, damaging the tool.

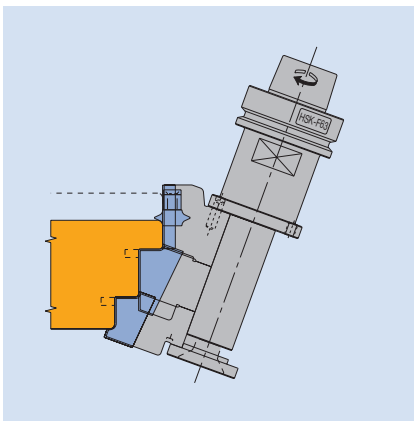
Since all operating sequences on stand alone machines run one after the other the processing times are longer than on through feed machines. On the other hand, any shape can be produced, and the components are finished. To increase productivity various methods are employed. Each machining process is sped up by smaller tool diameters and higher spindle speeds. The movement dynamics are increased by employing linear actuators. By having multiple tools on one arbor, tool changing times are reduced by placing the tool in a different working position instead of replacing it. By using several independently controlled main spindles, operating sequences occur in parallel. Moving workpiece clamping systems with part transfer enable a workpiece to be fed through the machine.

## 11.5 Wood processing machines

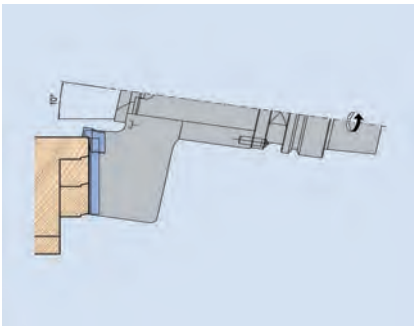
### 11.5.2 Stand alone machines



Rebating with a 3-axis machine



Rebating with swivelled spindle on a 5-axis machine



Taper-surface planing of visible surfaces, for example window profiles:  
No visible knife marks.

Another trend in stand alone technology are **5 axis machines**. For wood processing machines, the 4<sup>th</sup> and 5<sup>th</sup> axis are usually two additional spindle swivelling axis. There are two types: cartesian and gimbal 5 axis machines. Both systems have a vertical swivelling axis for the spindle as a 4<sup>th</sup> axis. In the cartesian system the motor spindle is rotatable around a horizontal axis in a „fork“. In the gimbal system the spindle swivels around an axis by 45°.

A classic application for **5-axis machines** is processing 3D moulded parts, for example model making, mould making or boat building. However, this requires a CAD/CAM interface to program the control the five axis. In wood processing, the trend to utilise the 4<sup>th</sup> and 5<sup>th</sup> axis to swivel the main spindle is more widespread. It is possible to minimise the use of aggregates since bevels, saw cuts and holes can be made with standard tools on the main spindle. Additionally the quality of rebates can be increased by the same entry conditions at both sides of the rebate by using a inclined spindle. Tool life of double rebate profiles increased as the tool profile depth is reduced and the differences of cutting speed and operating path of the knives are decreased.

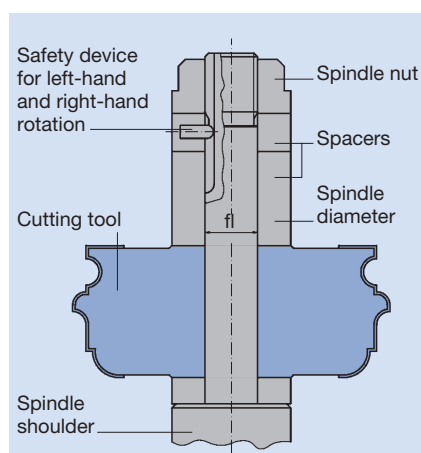
A special application is taper-surface planing, working with small adjustable angles on spindle. Efficient tool diameter can be reached through a big taper angle. This means no visible knife marks on the processed surface.

## 11.5 Wood processing machines

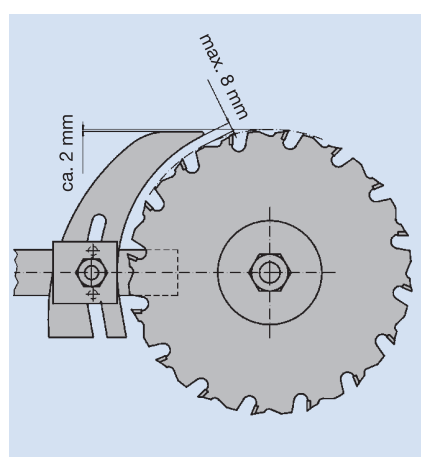
### 11.5.3 Machines for manual feed

Manual feed machines are stand alone machines and the workpiece is usually fed by hand. The machine table is the supporting surface for the workpieces. The workpieces are guided past the tool by a sliding table or fence. Workpieces with shaped edges are guided by templates. Special tools with ball bearing guide rings are required. In principle, the same variety of workpieces as on machines with mechanical feed may be manufactured on machines with manual feed. Manual feed machines for one-off products or repair parts are essential in plants for industrial mass production.

Typical examples of stand alone machines with manual feed are **circular saw benches, surface planing machines** and **vertical moulding machines**. They can be equipped with mechanical feeding devices (power feed) in addition to the manual feed but still are considered manual feed machines.



Example of a tool mounting on a spindle moulder.



Correct adjustment of the riving knife on spindle moulders

The operator creates the feeding movement and is involved in the machining process and is exposed to a higher risk than machines with mechanical feed. The highest risk is the rotating tool since the cutting area is not enclosed. The machine directive for machines with manual feed stipulates numerous protective devices. Their use is stipulated in the national accident prevention regulations, their use is the user's responsibility. Protection against touching the rotating tool, preventing workpiece kickback and dust and noise are covered by the regulations. Extraction hoods have the function of a protective device and at the same time serve as noise protection.

Important safety requirements for working with manual feed machines: Only tools marked with „MAN“ designed with particular kickback limitations to EN 847-1 may be used (except for circular sawblades). The tool mounting on spindle moulders must be effected by a safety against twisting in order to prevent an accidental opening of the tool. The free spindle length has to be filled up with spacers, so that the clamping nut can transfer the clamping power to the tool. To prevent workpiece kickback you have to work against the feed (except for scoring). Short workpieces must be fed by a push stick to keep the hands as clear as possible of the hazard area. Openings between the tool and the machine table or lateral guides must be as small as possible. For stopped straight work stoppers for a defined pivot movement of the workpieces must be attached additionally. Circular sawblades must be operated with a riving knife adjusted to the sawblade diameter and the thickness of the saw kerf to prevent the sawblade jamming in the cut and the workpiece from being thrown back. For cutting edges without tears there are special scoring aggregates scoring the bottom of the workpiece to a cutting depth of approximately 1 mm with the feed before the separating cut is made with the main sawblade. The scoring sawblades create a cutting kerf about 0.1 to 0.2 mm wider than the main sawblade.

## 11.5 Wood processing machines

### 11.5.4 Hand operated electrical tools



Swing cover saw



Plunge saw



Portable router

Typical examples for hand operated electrical tools are circular hand saws and routers. Like stand alone machines they have a „table“ as a supporting surface for the workpiece; however, it is situated above the workpiece since the machine is placed on top of the workpiece.

There are two different designs for **circular hand saws**:

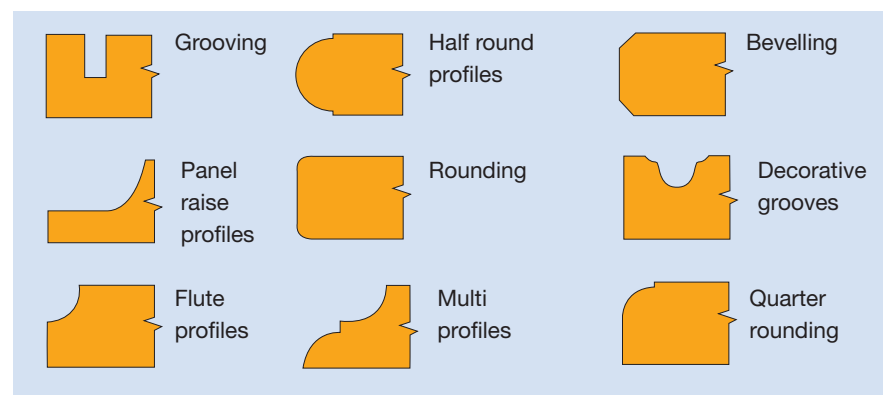
- a) Swing cover saws      b) Plunge saws

Most wide spread are **swing cover saws** that are usually available for bigger cutting depths. As the name indicates swing cover saws have a swing mounted protective cover that closes automatically after cutting. Plunge saws have a one part stationary protective cover. The complete motor and sawblade unit swivels back into the initial position after cutting so the sawblade disappears into the protective cover with these machines.

**Plunge saws** are used when it is necessary to make a plunge cut. On newer plunge saws, the splitting edge is spring loaded to allow for swivelling when making a plunge cut. There are various edge guide and guide rail systems available for circular hand saws, allowing for clean and most of all accurate saw cut. Only use under exceptional circumstances or when making a rough cut.

Usually, circular hand saw machines do not have scoring. A better cutting quality is obtained on the workpiece's underside. And to achieve a workpiece upper side without tears (teeth exit side) it is recommended to score the top at a depth of approximately 1 mm first and to make the separating cut subsequently with a lateral set off of approximately 0.1 mm.

**Hand router machines** are versatile machines with almost unlimited uses. The following illustration gives an overview over the most important processing possibilities.

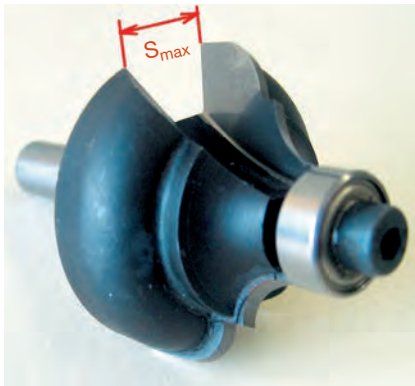


In most instances the tools for hand router machines have bearings or guide surfaces disks to guide the machine along the workpiece edge. Another method is working with templates. This means that a template is mounted in the machine table allowing an exact reproduction by following the contour. Sizing cuts or machining of grooves are best made by edge guides or guide rail systems. Round parts can be created by using a circular aid, similar to a compass.



## 11.5 Wood processing machines

### 11.5.4 Hand operated electrical tools



Cutting tool with guide ring for portable router.

Hand router machines are often used for flush milling veneer or laminates glued to sized boards with an overhang. Router tools with the knife cutting radius equalling the bearing diameter are used. Often no effective extraction is available due to the limited space on hand routers.

When grooving/profiling, chips may be extracted by an extraction pipe.

A large rectangular area filled with a fine grid of light gray lines, intended for taking handwritten notes. The grid covers the majority of the page below the header and above the footer.



