

The condensed Leitz-Lexicon

Edition 5/1



leitz



Condensed Lexicon Edition 5/1

Survival in the rapidly changing global economy requires continuous improvement in production efficiency. No company, regardless of size, can survive using the same technology, processes and manpower that has worked in the past.

In order to survive and profit, we must all focus on our core competence, and partner with vendors who can provide new technologies which improve our efficiency and productivity.

Leitz is known as a leading tooling manufacturer and service provider, but we go a step further; Leitz also provides our partner companies with full technical support, production advice and industry experience.

This catalog is the condensed "quick reference" version of the well-known and more complete Letiz Lexicon. If we do not offer standard tooling to meet your needs, our experienced sales people would be happy to create a customized solution to address your specific applicaiton. We invite you to take full advantage of our complete range of products and services--as a complete package or tailored to meet your specific application requirements.

Please refer to the back of this catalog for a complete listing of regional offices and contact information. You may also visit us on the web at www.leitztooling.com. Our full catalog (Lexicon-CD) is available upon request at 800-253-6070.

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Overview of tooth shapes



Flat Top
(=FZ)



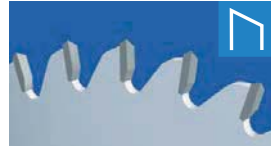
Flat Top Rip
(=FZ)



Conical / Flat
(=KON/FZ)



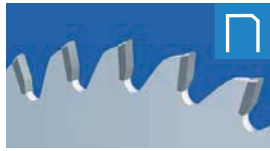
Flat with chip limiter
(=FZ)



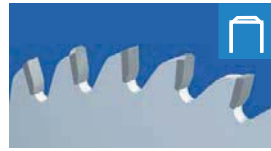
One-sided bevel, positive hook
(=ES pos.)



One-sided bevel, negative hook
(=ES neg.)



Flat / Bevelled
(=FZ/FA)



TCG / Raker positive
(=FZ/TR pos.)



TCG / Raker negative
(=FZ/TR neg.)



TCG / Raker with irregular pitch
(=FZ/TR irr.)



TCG positive
(=TR pos.)



TCG negative
(=TR neg.)



Hollow Ground
(=HZ)



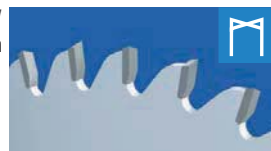
Hollow Ground with bevel
(=HZ/FA)



Hollow Ground /inverted V-teeth positive
(=HZ/DZ pos.)



Hollow Ground/ inverted V-teeth negative
(=HZ/DZ neg.)



ATB
Alternate top bevel teeth **positive**
(=WZ pos.)



ATB
Alternate top bevel teeth **negative**
(=WZ neg.)



ATB
Alternate top bevel teeth positive **with chip limiter**
(=WZ pos.)



ATB
Alternate top bevel teeth **with bevel**
(=WZ/FA)



ATB
Alternate top bevel teeth **conical**
(=KON/WZ)



ATB UT with irregular pitch
(=WZ UT)



Flat with deep tooth projection
(=FZ)



ATB plus Flat (right, left, right, left, flat) **with Raker**

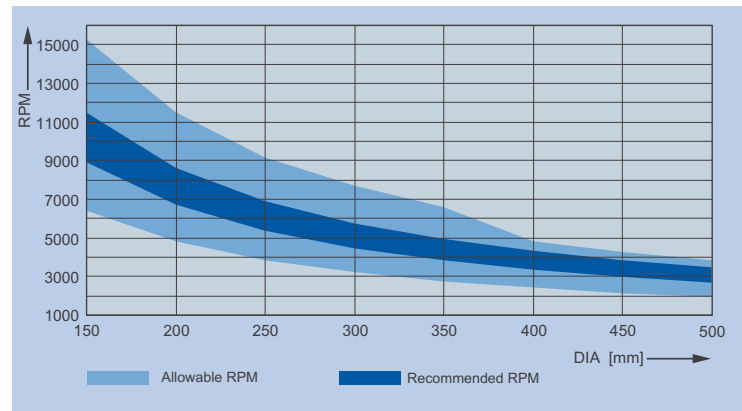
1. Sawblades

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1. Sawblades

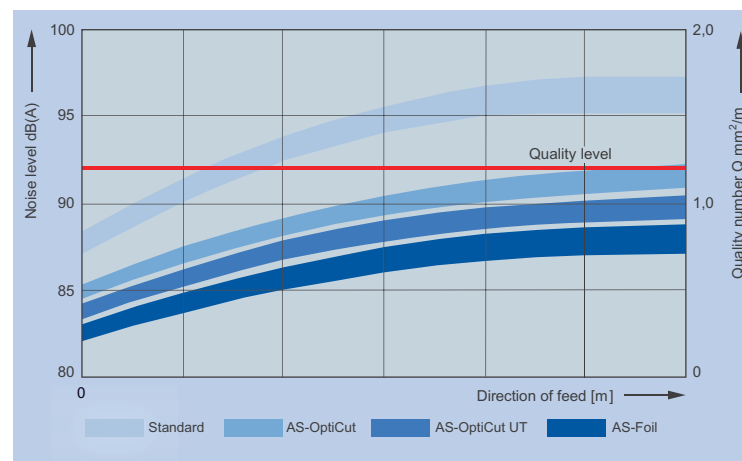
1.1 Important information and tables

RPM diagram



Low-noise sawblades

Comparison of the efficiency of noise reduction for different designs of circular sawblades and edge quality Q depending on the direction of feed.

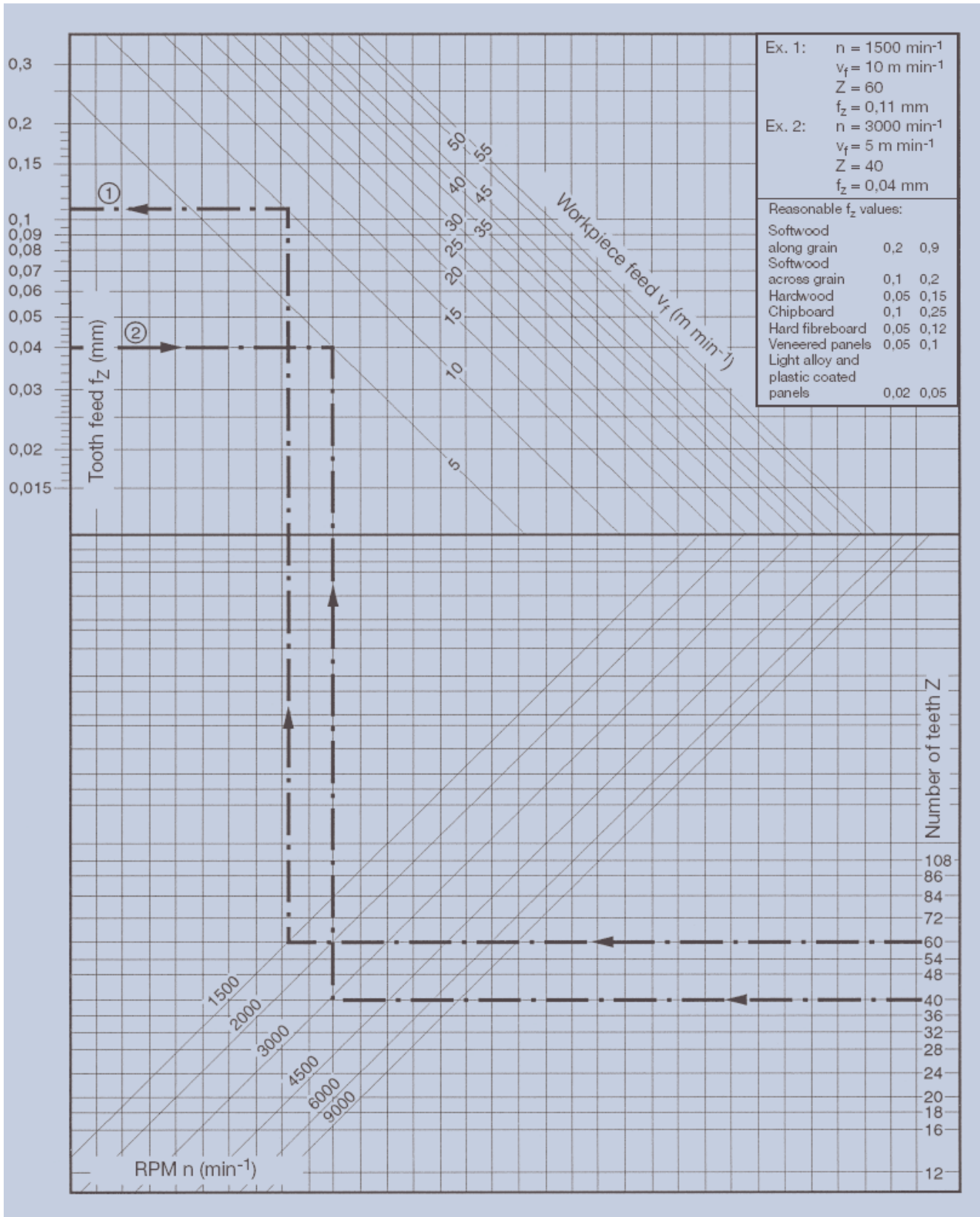


Advantages of low-noise sawblades

- Reduced noise and vibration.
- Longer run time from vibration damping.
- High cut quality, less wear and down time.
- Quiet running because of the high stability of the tool body.
- Reduced noise level of up to 10 dB(A) – 50% noise reduction – compared to standard sawblades.
- Better operator working conditions.
- Can be resharpened on all popular makes of automatic saw sharpening machines.

Recommended tooth progression fz (in mm) for panel sawblades and scoring sawblades

Material	Panel Sizing Sawblades	Scoring Sawblades
	fz	fz
Softwood cross grain		0,10-0,20
Hardwood cross grain		0,05-0,10
OSB Board	0,10-0,20	0,10-0,20
Vennerg board, block board	0,03-0,10	0,03-0,10
Plastic coated chipboard	0,03-0,06	0,03-0,06
HPL coated chipboard	0,02-0,10	0,02-0,10
Plywood	0,05-0,10	0,05-0,10
Aluminum Alloy	0,03-0,10	0,03-0,10
Fiber board	0,03-0,08	0,03-0,08
Cement compound wood derived materials	0,02-0,06	0,02-0,06
Glulam	0,02-0,06	0,02-0,06
Plaster material	0,10-0,20	0,10-0,20
Thermo plastics	0,05-0,10	0,05-0,10
Curo plastics	0,02-0,05	0,02-0,05
Aluminum castings	0,01-0,04	



- available ex stock
- available at short notice



1. Sawblades

1.2 Professional sawblades



PROFESSIONAL SERIES

DIA inch	Kerf inch	Bore inch	Teeth	Grind	ID No.	Angle	Remark	Page US catalog	Applications													
									panel sizing without scoring	panel sizing with scoring	ripping	cross cutting	fine cross cutting	hardwood	softwood	composites	man-made materials	particle board with laminate	MDF	plastics	Non-ferrous	
8"	0,11"	5/8"	48	FZ/TR	156004186	neg	8° miter- & sliding compound saw	1.2	+		+	+	+	+	+	+	+	+	+	+	+	
10"	0,125"	5/8"	30	WZ	156004202	neg	6° miter- & radial arm saw	1.2			+	+	+	+								
10"	0,125"	5/8"	24	WZ	130008535	pos	15° all purpose rip, cross cut	1.2			+	+		+	+							
10"	0,125"	5/8"	40	WZ	130010769	pos	12° general purpose, cross cut	1.2			+	+		+	+							
10"	0,125"	5/8"	50	WZ	130022637	pos	15° combination rip and cross cut	1.2			+	+		+	+							
10"	0,125"	5/8"	60	WZ	130010771	pos	12° fine cross cut	1.2					+	+	+	+	+					
10"	0,125"	5/8"	60	FZ/TR	130009697	pos	12° fine cross cut, miter- & radial arm saw	1.2					+	+	+	+	+	+	+	+	+	+
10"	0,117"	5/8"	60	FZ/TR	130022638	neg	6° fine cut, miter- & radial arm saw	1.2	+				+	+	+	+	+	+	+	+	+	+
10"	0,125"	5/8"	80	WZ	130009377	pos	8° extra fine cross cut	1.2					+	+	+	+	+	+				
10"	0,125"	5/8"	80	FZ/TR	130015419	pos	10° extra fine cut	1.2		+						+	+	+	+	+	+	+
10"	0,117"	5/8"	80	FZ/TR	130022639	neg	6° extra fine cut, miter- & radial arm saws	1.2	+				+	+	+	+	+	+	+	+	+	+
10"	0,125"	5/8"	80	WZ	156001416	neg	6° extra fine cross cut, miter- & radial arm saw	1.2	+				+	+	+	+	+	+	+	+	+	+
10"	0,125"	5/8"	80	WZ	156001215	neg	6° extra fine cross cut, miter- & radial arm saw	1.2	+				+	+	+		+					
12"	0,125"	5/8"	60	FZ/TR	156004189	neg	6° fine cut, miter- & radial arm saw	1.2	+				+	+	+	+	+	+	+	+	+	+
12"	0,142"	5/8"	96	FZ/TR	156004191	neg	6° extra fine cut, miter- & radial arm saws	1.3	+				+	+	+	+	+	+	+	+	+	+
12"	0,142"	1"	28	WZ	156004184	pos	15° general purpose ripping	1.3			+			+	+							
12"	0,142"	1"	48	WZ	156004172	pos	15° general purpose cross cut	1.3			+	+		+	+							
12"	0,142"	1"	60	WZ	156004200	pos	10° extra fine cross cut	1.3		+		+		+	+							
12"	0,142"	1"	96	WZ	156004174	pos	8° cross cut	1.3	+				+	+	+							
12"	0,142"	1"	60	FZ/TR	156004193	pos	10° fine cut	1.3		+		+		+	+	+	+	+	+	+	+	+
12"	0,142"	1"	96	FZ/TR	156004195	pos	10° extra fine cross cut	1.3		+			+	+	+	+	+	+	+	+	+	+
14"	0,158"	1"	72	WZ	156004176	pos	12° heavy duty cross cut	1.3		+		+		+	+	+	+	+	+	+	+	+
14"	0,173"	1"	84	WZ	156004178	pos	12° heavy duty cross cut	1.3					+	+	+	+	+	+	+	+	+	+
14"	0,173"	1"	84	FZ/TR	156004197	pos	10° heavy duty panel sizing	1.3		+			+	+		+	+	+	+	+	+	+
10"	0,117"	5/8"	80	WZ	156012316	pos	6° miter- & radial arm saw (OptiCutUT)	1.3					+	+	+	+						
12"	0,125"	1"	96	WZ	156012317	pos	6° miter- & radial arm saw (OptiCutUT)	1.3					+	+	+	+						

WZ = ATB
FZ/TR = TC Grind



Double-check dimensions of bore-size, pinholes (PH) and keyways (KW)!



- available ex stock
- available at short notice

1. Sawblades

1.3 Miscellaneous sawblades

**MISCELLANEOUS SAWBLADES****Ripping Sawblades**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH / KW mm	Teeth	Grind	ID No.	Page	Remark
Raimann	304,8	4,0	80	4/6/95+2/13/100	28	TR/TR	156012832		all purpose
	304,8	4,0	80	4/6/95+2/13/100	36	TR/TR	156012390		glue-line
Mereen Johnson	304,8	3,5	79,38	KN= 9,35x9,35	36	FZ/TR	156009350		glue-line
	304,8	4,0	79,38		36	FZ/TR	156007908		glue-line
Mid Oregon	305,4	3,8	152,4		36	TR	470009657		standard rip
European machinery	305	4,0	70	DKN 20,6/83	36	TR/TR	470000139		gang rip
	300	3,2	70	DKN 20,6/83	24	FZ	57304	36	

Cross- cut and optimizing sawblades

Class. Application	DIA mm	Kerf mm	Bore mm	PH / KW mm	Teeth	Grind	ID No.	Page	Remark
Cross cut	350	3,2	25,4		108	WZ	58307	52	Main
Cross cut	400	3,2	30	2/10/60	96	WZ	58387	49	Main
Cross cut	400	3,2	30	2/10/60	120	WZ	58309	52	Main
Optimizing	450	5,0	30	2/15/63	108	WZ	57524	43	Main
Midwest CT	406,4	4,4	35,4		120	FZ/TR	156015139		Main
Pistorious	305	2,9	15,88		80	WZ	470007406		Miter

Common sliding saws

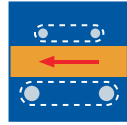
Class. Machine	DIA mm	Kerf mm	Bore mm	PH / KW mm	Teeth	Grind	ID No.	Page	Remark
Altendorf	120	2,8-3,6	20		12+12	FZ	61401	57	Score Standard
	300	3,2	30	2/10/60	72	FZ/TR	156002092		Main Standard
	300	3,2	30	2/6/42+2/10/60	96	FZ/TR	61352	56	Main Standard
	300	3,2	30	2/7/42+2/10/60	72	WZ	58384	49	Main Standard
	300	3,2	30	2/10/60	96	WZ	58311	52	Main Standard
	350	2,8	30		108	WZ	760506		Main Plastics
	350	3,2	30		84	FZ/TR	130008064		Main Standard
SCM	300	3,2	25,4	2/10/60	72	FZ/TR	182007947		Score Standard
	120	2,8-3,6	19,05		12+12	FZ	182007944		Main Standard
	120	2,8-3,6	19,05		12+12	FZ	182003115		Score
	350	3,5	25,4		84	FZ/TR	182007948		Main

Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!

- available ex stock
- available at short notice

1. Sawblades

1.4 Panel sawblades

**ANTHON**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.		Page	Remark
LN	400	4,4/3,2	30	2/10/60	72	TR/TR	(69115)	□	68a	Main RazorCut *
	180	4,4/5,5/3,5	20		30	KON/WZ	61478	●	69	Score
Porta (100)	400	4,4/3,2	60	2/11/85	72	FZ/TR	(59256)	□	64	Main *
	400	4,4/3,2	30	2/10/60	72	TR/TR	(69115)	□	68a	Main RazorCut *
	180	4,4/5,5/3,5	20		30	KON/WZ	61478	●	69	Score
LNA	430	4,4/3,2	60	2/11/85	72	FZ/TR	59576	□	64	Main
	450	4,4/3,2	60	2/11/85	72	TR/TR	69123	●	68a	Main RazorCut
	450	4,4/3,2	60	2/11/85	72	FZ/TR	59667	□	64	Main
	180	4,4/5,5/3,5	20		30	KON/WZ	61478	●	69	Score
Porta 150	500	5,2/3,5	60	2/11/85	60	FZ/TR	59577	□	64	Main
LNC, LNB (150)	700	6,2/4,2	80	1/17/110	60	FZ/TR	59375	●	65	Main
	700	6,2/4,4	80	1/17/110	60	WZ/FA	59382	●	65	Main
	180	6,0	20		30	KON/WZ	61520	●	70	Score **

* change BO from 30 to 60mm and add pinholes (2/11/85)

** high performance machine $v_f > 40\text{m/min}$

CASADEI

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.		Page	Remark
CX	300	4,4/3,0	30	2/10/60	60	TR/TR	69104	●	68a	Main RazorCut
	125	4,4/3,5	20		24	KON/WZ	61516	●	71	Score
Linea	350	4,4/3,2	80	4/9/100+2/14/110	54	FZ/TR	59271	●	64	Main
	150	4,4/3,5	30		24	KON/WZ	61486	●	69	Score
SX	400	4,4/3,2	30	2/10/60	72	FZ/TR	59256	●	64	Main
	150	4,4/3,5	30		24	KON/WZ	61486	●	69	Score

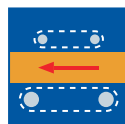
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!



- available ex stock
- available at short notice

1. Sawblades

1.4 Panel sawblades

**GABBIANI**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.		Page	Remark
Sigma 65, Galaxy 90	300	4,4/3,0	80	4/9/100+2/14/110	60	FZ/TR	59520	●	68	Main RazorCut
	200	4,4/3,5	80	2/14/110	34	KON/WZ	61542	□	71	Score
Sigma 85, 90, Impakt K, Galaxy 90, Prima	350	4,4/3,0	80	2/7/110+2/14/110	72	FZ/TR	65339	●	66	Main Foil right
	350	4,4/3,0	80	2/7/110+2/14/110	72	FZ/TR	59271	●	64	Main
	200	4,4/3,5	80	2/14/110	34	KON/WZ	61542	□	71	Score
Sigma 105KC, 105 C-Plus, 105 Impact C, Alpha 32C/D	380	4,4/3,2	65	2/9/100	72	FZ/TR	(59668)	□	68	Main RazorCut *
	200	4,4/3,5	80	2/14/110	34	KON/WZ	61542	□	71	Score
Sigma 115, 120, Galaxy 115, 125 Class, Delta 38P	400	4,4/3,2	80	4/9/100+2/14/110	80	FZ/TR	59545	●	64	Main
	200	4,4/3,5	80	2/14/110	34	KON/WZ	61542	□	71	Score
Galaxy 140, Elite	450	4,4/3,0	80	2/7/110+2/14/110	72	FZ/TR	65341	●	66	Main
	200	4,4/3,5	80	2/14/110	34	KON/WZ	61542	□	71	Score
A710	500	4,4/3,2	80	4/9/100+2/14/110	100	FZ/TR	(59456)	special		Main
	200	4,4/3,5	80	2/14/110	34	KON/WZ	61542	□	71	Score

* Re-bore to BO 80mm & add pinholes

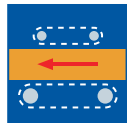
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!

- available ex stock
- available at short notice



1. Sawblades

1.4 Panel sawblades

**GIBEN**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.	Page	Remark
Fastmatic	300	3,2/2,8	75		68	FZ/TR	59310	●	68 Main
	125	3,2/2,5	45		24	KON/WZ	61533	□	69 Score
Smart (80,95,105)	320	4,4/3,2	75	3/13/95	60	FZ/TR	61362	●	67 Main
	200	4,5/3,2	50	3/13/95	44	KON/WZ	61559	●	69 Score
MK, Gamma N, ST, SE, Trend	350	4,4/3,2	75		54	WZ	59463	□	62 Main
	355	4,4/3,2	75		60	FZ/TR	59275	●	64 Main
MK 2, G2000, Starmatic	125	4,4/3,5	45		20	KON/WZ	61485	●	69 Score
	400	4,4/3,2	75	4/15/105	72	FZ/TR	59293	●	64 Main
	125	4,0/4,8	45		20+20	FZ	61407	●	69 Score
Prismatic 101	400	4,4/3,2	75	4/15/105	72	FZ/TR	59293	●	64 Main
	160	4,4/3,2	45	3/11/70	28	KON/WZ	61509	●	69 Score
Prismatic 201	400	4,4/3,2	75	4/15/105	72	FZ/TR	59293	●	64 Main
	400	4,4/3,2	75	4/15/105	72	TR/TR	69117	●	68a Main RazorCut
	430	4,4/3,2	75	4/15/105	72	FZ/TR	59277	●	64 Main
	430	4,4/3,2	75	4/15/105	72	TR/TR	69120	●	68a Main RazorCut
	215	4,4/3,2	50	3/15/80	42	KON/WZ	61508	●	69 Score
Prismatic 2,3	300	4,4/3,2	50	3/15/80	48	KON/WZ	61510	●	69 Score
	300	4,6/3,2	50	3/15/80	80	TR	68000	●	72 Postform
	470	4,4/3,2	75	4/15/105	96	FZ/TR	59584	●	64 Main
	470	4,8/3,2	75	4/15/105	84	FZ/TR	470012080	special	Main
	215	4,4/3,2	50	3/15/80	42	KON/WZ	61508	●	69 Score
Matic H150	215	4,8	50		42	WZ	470012081	special	Score
	300	4,4/3,2	50	3/15/80	48	KON/WZ	61510	●	69 Score
	300	4,6/3,2	50	3/15/80	80	TR	68000	●	72 Postform
	380	4,4/3,2	75	3/15/75	60	FZ/TR	59301	●	64 Main
	380	4,4/3,2	75	3/15/75	72	TR/TR	69113	●	68a Main RazorCut
Giben 19	550	5,0/3,5	100		72	FZ/TR	59280	●	65 Main
	565	5,0/3,5	100		72	FZ/TR	59370	●	65 Main
	180	5,0/3,5	55		30	KON/WZ	61500	●	70 Score
Giben 19	500	4,4/3,2	75		60	FZ/TR	470021826	●	Main
	127	4,4/3,5	45	1/15,88/133,35	24	KON/WZ	470003817	●	Score

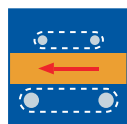
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!



- available ex stock
- available at short notice

1. Sawblades

1.4 Panel sawblades

**HÖFER**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.		Page	Remark
Höfer PS	250	3,2/2,2	30	2/7/42+2/10/60	60	TR/TR	69100	●	68a	Main RazorCut
	180	3,2/2,5	20		36	KON/WZ	61943	●	69	Score
Höfer PS	300	4,4/3,0	30	2/10/60	72	FZ/TR	59252	●	64	Main
	300	4,4/3,0	30	2/10/60	60	TR/TR	69102	●	68a	Main RazorCut
Höfer PM	180	4,4/3,5	20		30	KON/WZ	61478	●	69	Score
	350	4,4/3,2	30	2/10/60	72	FZ/TR	59252	●	64	Main
	350	4,4/3,2	30	2/10/60	72	TR/TR	69109	●	68a	Main RazorCut
Höfer PM	200	4,4/3,5	20		34	KON/WZ	61479	●	69	Score
	400	4,4/3,2	30	2/10/60	72	FZ/TR	59256	●	64	Main
	400	4,4/3,2	30	2/10/60	72	TR/TR	69115	●	68a	Main RazorCut
	200	4,4/3,5	20		34	KON/WZ	61479	●	69	Score

HOLZHER

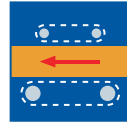
Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.		Page	Remark
6180, 6280, 8380, 5280, 6480, 6580, 6680	380	4,4/3,2	75	3/15/75	72	FZ/TR	59301	●	64	Main
	380	4,4/3,2	75	3/15/75	72	FZ/TR	59301	●	64	Main
	380	4,4/3,2	75	3/15/75	72	TR/TR	69113	●	68a	Main RazorCut
	125	4,4/3,5	45		24	KON/WZ	61518	□	71	Score
	140	4,4/3,5	45	1/8/58	24	KON/WZ	61519	●	71	Score

Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!

- available ex stock
- available at short notice

1. Sawblades

1.4 Panel sawblades

**HOMAG**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.	Page	Remark
CH3	300	4,4/3,0	75		60	FZ/TR	59309	●	64 Main
	300	4,4/3,0	75		60	TR/TR	69106	●	68a Main RazorCut
	125	4,4/3,5	45		20	KON/WZ	61485	●	69 Score
CV's	300	4,4/3,0	75		60	FZ/TR	59309	●	64 Main
	300	4,4/3,0	75		60	TR/TR	69106	●	68a Main RazorCut
	125	4,4/3,5	45		20	KON/WZ	61485	●	69 Score
CT 04/40	300	4,4/3,2	75		96	FZ/TR	61615	●	72 Postform
	300	4,4/3,0	75		60	FZ/TR	59309	●	64 Main
	300	4,4/3,0	75		60	TR/TR	69106	●	68a Main RazorCut
CH 06/10	150	4,4/3,5	45		24	KON/WZ	61530	●	69 Score
	250	4,55/3,2	45		80	WZ	61617	●	72 Postform
	350	4,4/3,2	75		72	FZ/TR	59253	●	64 Main
CH 30/06	350	4,4/3,2	75		72	TR/TR	69110	●	68a Main RazorCut
	150	4,4/3,5	45		24	KON/WZ	61530	●	69 Score
	350	4,4/3,2	75		72	FZ/TR	59253	●	64 Main
CH 04	350	4,4/3,2	75		72	TR/TR	69110	●	68a Main RazorCut
	350	4,55/3,2	75		72	FZ/TR	61613	●	72 Postform
	355	4,4/3,2	75		60	FZ/TR	59275	●	64 Main
CH 08/12	180	4,4/3,2	45		30	KON/WZ	61544	□	69 Main
	300	4,55/3,2	75		96	FZ/TR	61615	●	72 Postform
	400	4,4/3,2	75	4/15/105	72	FZ/TR	59260	●	64 Main
CHP Court 85	400	4,4/3,2	75		72	TR/TR	59117	●	68a Main RazorCut
	150	4,4/3,5	45		24	KON/WZ	61530	●	69 Score
	400	4,4/3,2	75	4/15/105	72	FZ/TR	59260	●	64 Main
CHP Court 85	400	4,4/3,2	75		72	TR/TR	69117	●	68a Main RazorCut
	350	4,55/3,2	75		72	FZ/TR	61613	●	72 Postform

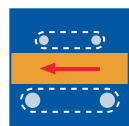
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!



- available ex stock
- available at short notice

1. Sawblades

1.4 Panel sawblades

**HOLZMA**

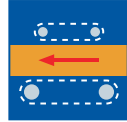
Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.	Page	Remark
HPP250	350	4,4/3,2	60	2/14/100	72	FZ/TR	69082	● 67	Main RazorCut
	200	4,4/3,5	45		36	KON/WZ	61490	● 69	Score
HPP 72	350	4,4/3,2	60	2/14/100	72	FZ/TR	69082	● 67	Main RazorCut
	180	4,4/3,5	45		36	KON/WZ	61553	● 69	Score
	280	4,55/3,2	45		84	WZ	61619	● 72	Postform
HPP 81, 91, 92 HPL 82	380	4,8/3,5	60	2/14/100	72	TR/TR	69114	● 68a	Main RazorCut
	380	4,8/3,5	60	2/14/100	72	FZ/TR	65337	● 66	Main Foil right
	380	4,8/3,5	60	2/14/100	84	TR/TR	59314	● 64	Main
	380	4,8/3,5	60	2/14/100	72	TR/TR	69114	● 68a	Main RazorCut
	420	4,8/3,5	60		84	TR/TR	59315	● 68	Main RazorCut
	180	4,8/3,5	45		36	KON/WZ	61526	● 71	Score
	200	4,8/3,5	45		36	KON/WZ	61527	● 71	Score
HFL 02, HPP 02	280	4,95/3,5	45		84	WZ	61676	● 72	Postform
	420	4,8/3,5	60		72	FZ/TR	59296	● 64	Main
	420	4,8/3,5	60		84	FZ/TR	59300	● 64	Main
	200	4,8/3,5	45		36	KON/WZ	61527	● 71	Score
	340	4,95/3,5	45		80	TR	61606	● 72	Postform
HPP 11	340	5,0/3,5	45		108	WZ	61611	● 72	Postform
	450	4,8/3,5	60	2/14/125	72	TR/TR	59316	● 64	Main
	450	4,8/3,5	60	2/14/125	72	FZ/TR	59261	● 64	Main
	450	4,8/3,6	60	2/14/125	72	TR/TR	69125	● 68a	Main RazorCut
	180	4,8/3,5	45		36	KON/WZ	61526	● 71	Score
	340	4,95/3,5	45		80	TR	61606	● 72	Postform
	340	5,0/3,5	45		108	WZ	61611	● 72	Postform
Type 21, 22	500	4,8/3,5	60	2/11/115	60	FZ/TR	59294	● 64	Main
	500	4,8	60	2/11/115	72	TR/TR	59317	● 64	Main
	200	4,8/3,5	45		36	KON/WZ	61527	● 71	Score
	340	4,95/3,5	45		80	TR	61606	● 72	Postform
	340	5,0/3,5	45		108	WZ	61611	● 72	Postform
Type 23	520	4,8/3,5	60	2/11/115+2/19/120	84	TR/TR	59658	special ● 65	Main
	200	4,8/3,5	45		36	KON/WZ	61527	● 71	Score
	340	5,0/3,5	45		108	WZ	61611	● 72	Postform
	540	4,8/3,5	60	2/11/115+2/19/120	72	FZ/TR	59659	● 65	Main
Type 33, HPP 42	540	4,8/3,5	60	2/11/115+2/19/120	84	TR/TR	59660	● 65	Main
	200	4,8/3,5	45		36	KON/WZ	61527	● 71	Score
	340	5,0/3,5	45		108	WZ	61611	● 72	Postform
	600	5,8/4,0	60	2/11/115+2/19/120	72	FZ/TR	59371	● 65	Main
HPP 42, Type 33	200	5,8/4,6	45		34	KON/WZ	61499	● 70	Score
	340	6,0	45		108	WZ	61612	special ● N/A	Postform
	670	5,8/4,2	60	2/11/148+2/19/120	42	FZ/TR	59372	● 65	Main
Type 66 (Tandem) HPP 61	730	6,2/4,2	60	2/11/148+2/19/120	60	FZ/TR	59377	● 65	Main
	200	5,8/4,6	45		34	KON/WZ	61499	● 70	Score
	200	6,2/4,2	45		36	KON/WZ	61547	● 70	Score

Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!

- available ex stock
- available at short notice

1. Sawblades

1.4 Panel sawblades

**PANHANS**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.		Page	Remark
Euro 5 SF	220	3,2/2,5	30		36	KON/FZ	61535	●	71	Score
	220	3,35/2,5	30		48	FZ/TR	61536	●	72	Postform
Euro 5	280	3,2/2,2	30	2/10/60	60	TR/TR	69101	●	68a	Main RazorCut
	125	3,2/4,3/2,5	30		24	KON/WZ	61470	●	69	Score
Euro 10, 693 / SH 70	300	4,4/3,0	30	2/10/60	60	FZ/TR	68350	●	67	Main RazorCut
	300	3,2/2,2	30	2/10/60	96	WZ	68801	●	52	Main OptiCut
	125	4,4/3,5	30		24	KON/FZ	61516	●	71	Score
	180	4,2/3,5	30		30	KON/FZ	90572	special		Score Diamond
Euro 10 SF	180	4,4/3,5	30	2/10/60	30	KON/FZ	61517	●	71	Score
	300	4,4/3,0	30	2/10/60	60	FZ/TR	68350	●	67	Main RazorCut
	250	4,3/3,5	30	2/10/60	42	KON/FZ	61537	●	71	Score
Euro 12,30	250	4,55/3,5	30	2/10/60	48	FZ/TR	61521	●	72	Postform
	350	4,4/3,2	30	2/10/60	108	WZ	68252	●	52	Main
	180	4,4/3,5	30		30	KON/FZ	90572	special		Score Diamond
Euro 12 SF	180	4,4/3,5	30	2/10/60	30	KON/FZ	61517	●	71	Score
	350	4,4/3,2	30	2/10/60	72	TR/TR	69109	●	68a	Main RazorCut
	350	4,4/3,2	30	2/10/60	72	FZ/TR	59252	●	64	Main
	280	4,4/3,0	30	2/10/60	48	KON/FZ	61540	●	71	Score
Euro 32	280	4,55/3,0	30	2/10/60	60	FZ/TR	61614	●	72	Postform
	370	4,4/3,2	30	2/10/60	72	TR/TR	69112	●	68a	Main RazorCut
	180	4,4/3,5	30		30	KON/FZ	90572	special		Score Diamond
693 / SH 110	180	4,4/3,5	30	2/10/60	30	KON/FZ	61517	●	71	Score
	400	4,4/3,2	30		60	WZ	59105	●	62	Main
	400	4,4/3,2	30	2/10/60	72	TR/TR	69115	●	68a	Main RazorCut
	400	4,4/3,2	30	2/10/60	72	FZ/TR	59256	●	64	Main
	180	4,4/3,5	30		30	KON/FZ	90572	special		Score Diamond
	180	4,4/3,5	30	2/10/60	30	KON/FZ	61517	●	71	Score

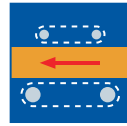
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!



- available ex stock
- available at short notice

1. Sawblades

1.4 Panel sawblades

**SCHELLING**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.	Page	Remark
FXH	300	4,55/3,2	30		72	WZ/FA	61618	● 72	Main
	300	4,4/3,0	30	2/10/60	60	FZ/TR	59250	● 64	Main
	450	4,4/3,2	30		72	FZ/TR	59553	● 64	Main
FMH	350	4,4/3,2	30		54	WZ	59102	● 62	Main
	350	4,4/3,2	30	2/10/60	72	FZ/TR	59252	● 64	Main
	350	4,4/3,2	30	2/10/60	72	TR/TR	69109	● 68a	Main RazorCut
	350	4,4/3,2	30	2/10/60	72	TR/TR	69109	● 68a	Main RazorCut
	370	4,4/3,2	30	2/10/60	72	TR/TR	69112	● 68a	Main RazorCut
	200	4,2/6,0	20		24	KON	90574	71	Score Diamond
	200	4,3/4,5	20		24	KON/WZ	61522	● 69	Score
FW, AW, AK	200	4,4/3,5	20		36	KON/WZ	61479	● 69	Score
	400	4,4/3,2	30		60	WZ	59105	● 62	Main
	400	4,4/3,2	30	2/10/60	72	TR/TR	69115	● 68a	Main RazorCut
	400	4,4/3,2	30	2/10/60	72	FZ/TR	59256	● 64	Main
	430	4,4/3,2	30	2/10/60	72	TR/TR	69119	● 68a	Main RazorCut
	200	4,2/6,0	20		24	KON	90574	71	Score Diamond
	200	4,3/4,5	20		24	KON/WZ	61522	● 69	Score
FL, AL	200	4,4/3,5	20		36	KON/WZ	61479	● 69	Score
	460	4,4/3,2	30	2/13/94	72	FZ/TR	59303	● 64	Main
	460	4,4/3,2	30	2/13/94	72	TR/TR	69126	● 68a	Main RazorCut
	480	4,4/3,2	30		72	FZ/TR	59679	● 64	Main
	480	4,4/3,2	30		72	WZ	59481	● 62	Main
	520	4,4/3,2	30	2/13/94	72	TR/TR	69128	● 68a	Main RazorCut
	200	4,2/6,0	20		24	KON	90574	71	Score Diamond
FP	200	4,4/3,5	20		36	KON/WZ	61479	● 69	Score
	220	4,0-4,8	20		24+24	FZ	61448	● 57	Postform
	530	5,2/3,5	30		60	WZ	59444	● 62	Main
	530	5,2/3,5	30		60	FZ/TR	59287	● 65	Main
	550	5,2/3,5	40	2/12/90	60	FZTR	59569	●	Main
AS	200	5,2/3,5	20		24	KON/WZ	61501	● 70	Score
	670	6,0/4,0	40	1/11/140	48	WZ	59458	● 62	Main
	670	6,0/4,0	40	1/11/140	60	FZ/TR	59373	● 65	Main
	670	6,2/4,2	40	2/17,5/140	60	FZ/TR	470000836	N/A	Main
	680	6,2/4,2	40		60	FZ/TR	59374	● 65	Main
	720	6,5/4,5	40	2/14/140+2/14/114	60	FZ/TR	59376	● 65	Main
	200	6,0/4,5	20		36	KON	61551	● 71	Score
	200	6,2/4,5	20		36	KON	61546	● 70	Score
	220	6,5/4,5	20		36	KON/WZ	61560	● 70	Score

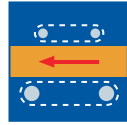
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!

- available ex stock
- available at short notice



1. Sawblades

1.4 Panel sawblades

**SCM**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.		Page	Remark
Sigma Prima 65 A	300	4,4/2,8	80	2/14/110+2/7/110	60	FZ/TR	65338	●	66	Main Foil right
	160	4,4/3,5	55	3/7/66	36	KON/WZ	61487	●	69	Score
Sigma Impact 85 K, PLM K	350	4,4/3,0	80	2/14/110+2/7/110	72	FZ/TR	65339	●	66	Main Foil right
	160	4,4/3,5	55	3/7/66	36	KON/WZ	61487	●	69	Score
Impact 105, Plus	380	4,4/3,2	60	2/9/100	72	TR/TR	59668	□ *	68	Main RazorCut
	160	4,4/3,5	55	3/7/66	36	KON/WZ	61487	●	69	Score
Sigma Plus P / 125	400	4,4/3,0	80	2/14/110+2/7/110	72	FZ/TR	65340	● **	66	Main Foil right
	450	4,4/3,0	80	2/14/110+2/7/110	72	FZ/TR	65341	● **	66	Main Foil right
	160	4,4/3,5	55	3/7/66	36	KON/WZ	61487	●	69	Score

* Re-bore to BO 80mm & add pinholes

** Original machine is equipped with D 420 mm

SELCO

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.		Page	Remark
EB 70,80,90,100	300	4,4/3,0	65	2/9/110	60	FZ/TR	59667	●	64	Main
	300	4,4/3,0	65	2/9/110	60	TR/TR	69105	●	68a	Main RazorCut
108,120	320	4,4/3,2	65	2/9/110	60	FZ/TR	59682	●	68	Main RazorCut
WN 600, WNA 600	355	4,4/3,2	80	2/9/130+4/19/120	72	FZ/TR	69111	●	68a	Main RazorCut
	360	4,4/3,2	65	2/9/110	72	FZ/TR	59683	●	68	Main RazorCut
	400	4,4/3,2	80	2/9/130+4/19/120	72	FZ/TR	59291	●	64	Main
	400	4,4/3,2	80	2/9/130+4/19/120	72	FZ/TR	69118	●	68a	Main RazorCut
	480	4,8/3,5	80	2/9/130+4/19/120	72	FZ/TR	69127	●	68a	Main RazorCut
	480	4,8/3,5	80	2/9/130+4/19/120	72	FZ/TR	59307	●	64	Main
	750	7,0/5,0	110	6/9/190	72	FZ/TR	59378	●	65	Main
	200	4,2	65	2/9/110	30	KON/FZ	90574	special	71	Score Diamond
	200	4,4/3,5	65	2/9/100+2/9/110	36	KON/WZ	61505	●	69	Score
	200	4,8/3,5	65	2/9/110	36	KON/WZ	61528	●	70	Score
	300	4,4/3,5	65	2/9/100+2/9/110	72	KON/WZ	61529	●	69	Score
	300	4,55/3,2	65	2/9/110	72	WZ/FA	59189	●	72	Postform

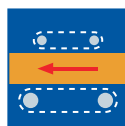
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!



- available ex stock
- available at short notice

1. Sawblades

1.4 Panel sawblades

**STRIEBIG**

Class. Machine	DIA mm	Kerf mm	Bore mm	PH mm	Teeth	Grind	ID No.	Page	Remark
Striebig	100	3,3/4,0	22		12	KON/FZ	90576	● 71	Score Diamond
	220	3,2/2,2	30	2/7/42	42	DZ/HZ	58967	● 53	Main
	250	3,2/2,2	30	2/7/42+2/10/60	60	TR/TR	69100	● 68a	Main RazorCut
	250	3,2/2,2	30	2/7/42+2/10/60	60	FZ/TR	61351	● 64	Main
	250	3,2/2,2	30	2/7/42	48	DZ/HZ	58971	● 53	Main
	250	3,2/2,2	30	2/7/42	48	DZ/HZ	58972	● 53	Main Negative
	250	3,5/2,5	30	2/7/42	48	DZ/HZ	65336	● 53	Main Foil left
	300	3,2/2,2	30	2/7/42+2/10/60	96	FZ/TR	61352	● 64	Main
	300	3,2/2,2	30	2/7/42+2/10/60	72	TR/TR	69102	● 68a	Main RazorCut
	300	3,5/2,5	30	2/7/42+2/10/60	60	TR/TR	69103	● 68a	Main RazorCut
	303	3,5/2,4	30	2/7/42+2/10/60	60	DZ/HZ	58963	● 53	Main
	303	3,5/2,4	30	2/10/60	60	DZ/HZ	68301	● 53	Main OptiCut
	303	3,2/2,2	30	2/7/42+2/10/60	60	DZ/HZ	58970	● 53	Main Negative
	303	3,2/2,4	30	2/7/42+2/10/60	68	DZ/HZ	68303	● 53	Main OptiCut
	303	3,5/2,4	30	2/10/60	54	DZ/HZ	68302	● 53	Main OptiCut
	303	3,5/2,5	30	2/7/42+2/10/60	60	DZ/HZ	65941	● 53	Main Foil left
	303	3,5/2,5	30	2/7/42+2/10/60	60	DZ/HZ	65335	● 53	Main Foil right
	305	3,2/2,6	30		96	WZ	130000607	● special	Main H/AT neg.

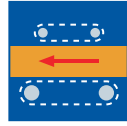
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!

- available ex stock
- available at short notice



1. Sawblades

1.5 RazorCut sawblades



RazorCut "AS OptiCut UT" (set of main blade and scoring blade)

Class. Machine	DIA mm	Kerf mm	Plate mm	Bore mm	Pinholes mm	Teeth	Grind	ID No.	Remark
Altendorf, Martin,	300	3,2	2,2	30	2/7/42+2/10/60	72	TR/TR	69102	Main
Mrozek, Panhans	100	2,8-3,6		22		10+10	FZ	61400	Score
Altendorf, Martin,	300	3,2	2,2	30	2/7/42+2/10/60	72	TR/TR	69102	Main
Mrozek	120	2,8-3,6				12+12	FZ	61401	Score
Panhans	300	4,4	3,0	30	2/10/60	60	TR/TR	69104	Main
	125	4,4	3,5	20		24	KON/FZ	61516	Score
Selco	300	4,4	3,0	65	2/9/110	60	TR/TR	69105	Main
	300	4,4	3,5	65	2/9/100	72	KON/WZ	61529	Score
Homag	300	4,4	3,0	75		60	TR/TR	69106	Main
	180	4,4	3,5	45		30	KON/WZ	61544	Score
Höfer, Schelling	350	4,4	3,2	30	2/10/60	72	TR/TR	69109	Main
	200	4,4	3,5	20		34	KON/WZ	61479	Score
Homag	350	4,4	3,2	75		72	TR/TR	69100	Main
	180	4,4	3,5	45		30	KON/WZ	61544	Score
Selco	355	4,4	3,2	80	2/9/130+4/19/120	72	TR/TR	69111	Main
	300	4,4	3,5	65	2/9/100+2/9/110	72	KON/WZ	61529	Score
Giben	380	4,4	3,2	75	3/15/75	72	TR/TR	69113	Main
	160	4,4	3,2	45	3/11/70	28	KON/WZ	61509	Score
Holzma	380	4,8	3,5	60	2/14/100	72	TR/TR	69114	Main
	180	4,8	3,5	45		36	KON/WZ	61526	Score
Höfer, Schelling	400	4,4	3,2	30	2/10/60	72	TR/TR	69115	Main
	200	4,4	3,5	20		34	KON/WZ	61479	Score
Giben	400	4,4	3,2	75	4/15/105	72	TR/TR	69117	Main
	215	4,4	3,2	50	3/15/80	42	KON/WZ	61508	Score
Selco	400	4,4	3,2	80	2/19/130+4/19/120	72	TR/TR	69118	Main
	300	4,4	3,5	65	2/9/100+2/9/110	72	KON/WZ	61529	Score

RazorCut "AS OptiCut UT"

Features

- Noise reduced design, tool body with vibration-damping laser ornaments and irregular pitched teeth.
- Cut geometry is optimized for best cut quality.

Advantages

- reduced vibrations
- better guidance in cut
- elimination of cutter marks on sides under optimum conditions
- reduced noise level

Applications

Material:

Wood derived, coated with foil or plastic

Machine:

Panel sizing machines, with scoring saw and pressure beam, sizing machines.

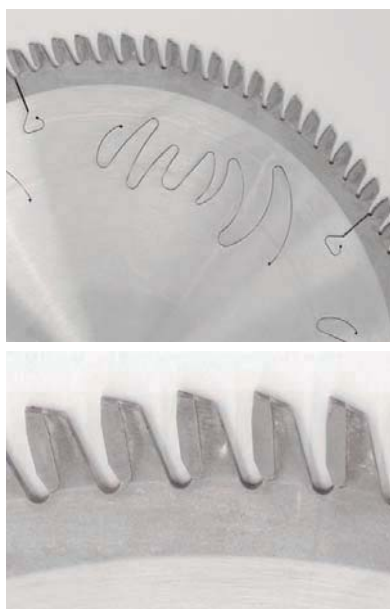
Double-check dimensions of bore-size, pinholes and keyways (PH/KW)!



- available ex stock
- available at short notice

1. Sawblades

1.6 GlossCut sawblades



With the new tooth shape and two cutting angles, minimum marks and tear-free cut edges can be achieved.

For plexiglass subsequent flame deseaming is sufficient to achieve full transparency.

Application:

For sizing and cutting to length

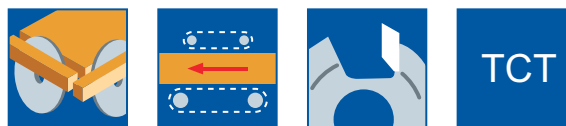
Machines:

Saw benches, sizing machines with/without pre-scoring sawblade, vertical and horizontal panel sizing machines, double circular dimension saw machines against feed from top and/or bottom.

Application:

Main sawblade against feed

For sizing in finish quality - GlossCut



Designed for sizing with perfect cut faces and tear-free cut edges. For sizing and cutting to length of transparent thermoplastics (PMMA, PC), duro plastics, plastic/alu-composite materials (Alucobond), MDF with and without coating. Vibration reduced sawplate by new laser ornaments - noise reduction whilst free running and in use.

WK 357 2

DIA mm	Kerf mm	Plate mm	Bore mm	PH1 mm	PH2 mm	Teeth mm	Grind	ID No.
300	3,0	2,4	30	2/10/60	2/7/42	60 > 20mm	FZFA/FZFA	761033 ●
300	3,0	2,4	30	2/10/60	2/7/42	96 < 20mm	FZFA/FZFA	761034 ●

Advantages:

The combination of vibration reduced saw bodies and teeth and a newly developed geometry gives a cut quality, which can be improved with a little additional work to brilliance.

In coated wooden fibre boards with a scoring sawblade a finish quality on the edges can be achieved.

Because of reduction/omission of the usually additional processing steps to the workpiece, the result is increased efficiency.

A noise reduction compared to standard sawblades of up to 4 dB(A) during the free running- and working cycle makes for more comfortable working conditions for the operator.

A significant improvement in the run time of about 200% from the tool construction compared to standard sawblades another economic tool solution.

Resharpener possible on all known sawblade sharpening machines.

4000-5000 RPM

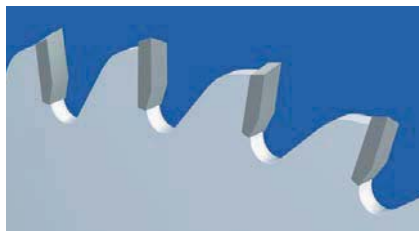
Application recommendation:

	Cutting speed	Feed per tooth
PMMA	60 - 70 m/s	0,01 - 0,02 mm
Thermoplastic	50 - 60 m/s	0,01 - 0,04 mm
Duro-plastic	40 - 70 m/s	0,02 - 0,05 mm
Aluminum / Thermoplastic composites	50 - 60 m/s	0,02 - 0,06 mm
Melamine coating - HPL coated wood fibre materials	60 - 90 m/s	0,03 - 0,10 mm

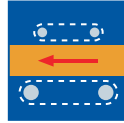
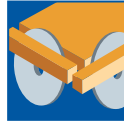
- available ex stock
- available at short notice

1. Sawblades

1.6 Cross Cut sawblades



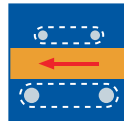
For cross cutting and sizing up to 90 mm cutting height



Designed for cutting across grain in dry solid woods and sizing uncoated timber products and laminated woods respectively up to 90 mm cutting height. For saw benches, sizing, cut-off and multi-blade saw machines.

Class.	DIA mm	Kerf mm	Plate mm	Bore mm	Bore _{max.} mm	PH mm	KW mm	FLD mm	Teeth	GrindID	No.	
*	150	3,5	2,5	30		60		80	24	WZ	058050	●
*	150	3,5	2,5	40			12/45	80	24	WZ	058051	□
*	180	3,5	2,5	30		60		80	30	WZ	058052	●
*	200	3,2	2,2	30		80		100	34	WZ	058053	●
*	250	3,2	2,2	15,88/5/8"		80		100	40	WZ	058054	●
*	250	3,2	2,2	30		80		100	40	WZ	058055	●
*	300	3,2	2,2	15,88/5/8"		80		120	48	WZ	058056	●
*	300	3,2	2,2	30			2/10/60	120	48	WZ	058057	●
*	350	3,2	2,2	25,40/1"	100			120	54	WZ	058058	●
*	350	3,2	2,2	30			2/10/60	120	54	WZ	058059	●
*	350	3,2	2,2	60				120	54	WZ	058065	●
*	400	3,8	2,8	30			2/10/60	140	60	WZ	058061	●
*	400	3,8	2,8	50				140	60	WZ	058070	●
*	450	3,8	2,8	30		100		160	66	WZ	058062	●
*	500	3,8	2,8	30		100		180	72	WZ	058063	●

For cross cutting and sizing up to 60 mm cutting height



Designed for cutting across grain in dry solid woods and sizing uncoated timber products and laminated woods up to 60 mm cutting height. For saw benches, sizing and cut-off machines.

	mm	mm	mm	mm	mm	mm	mm	mm				
*	200	3,2	2,2	30		60		80	48	WZ	058380	●
*	250	3,2	2,2	15,88/5/8"		80		100	60	WZ	058381	●
*	250	3,2	2,2	30		80		100	60	WZ	058382	●
*	300	3,2	2,2	15,88/5/8"				120	72	WZ	058383	●
*	300	3,2	2,2	30			2/7/42	120	72	WZ	058384	●
*							2/10/60					□
*	300	3,2	2,2	31,75/1 1/4"				120	72	WZ	058388	●
*	350	3,2	2,2	25,40/1"				120	84	WZ	058385	●
*	350	3,2	2,2	30			2/10/60	120	84	WZ	058386	●
*	400	3,2	2,2	30			2/10/60	140	96	WZ	058387	●

Notes:



Notes:

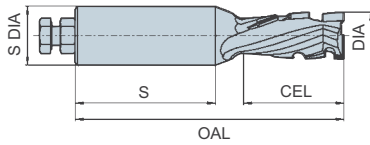
2. Cutting tools with shank

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2. Cutting tools with shank

2.1 General information

The dimensions in the table below refer to the following tool parameters:



DIA	diameter of the cutting edge
CEL	Usable cutting length with specified number of teeth,
AL	Possible working length, reached in separate steps
OAL	Total length
S DIA	Shank diameter, e.g. S25 x 60 -> Ø 25 mm
S	Shank length, e.g. S25 x 60 -> 60 mm

Application

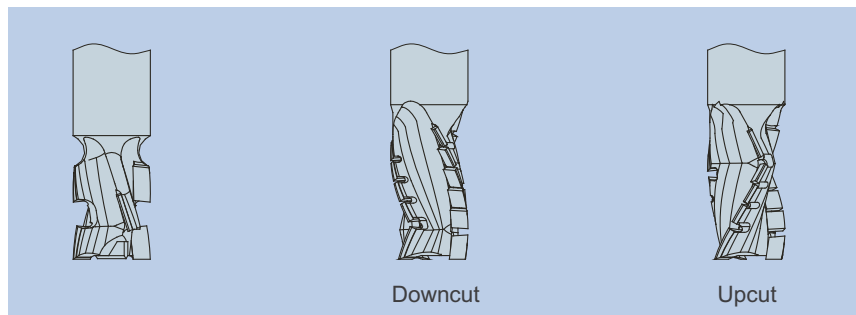
Sizing and grooving

Workpiece material (recommended cutting material)

- Soft and hardwood (SP steel softwood only, HS, TC, TC-solid).
- Chipboard and fibre materials (MDF, HF, etc.), uncoated, with plastic coating, with veneer, etc. (TC, solid TC, DP).
- Plywood (TC, solid TC, DP).
- Duro-plastics (TC, solid TC, DP).
- Thermoplastics (HS, TC, solid TC, DP).
- Polymer plastics – Corian, Varicor, etc. – (TC, solid TC, DP).
- Laminated materials – HPL, Trespa, etc. – (solid TC, DP).
- Non-ferrous metal – Aluminium, copper, etc. – (HS, TC, solid TC, DP).

Design

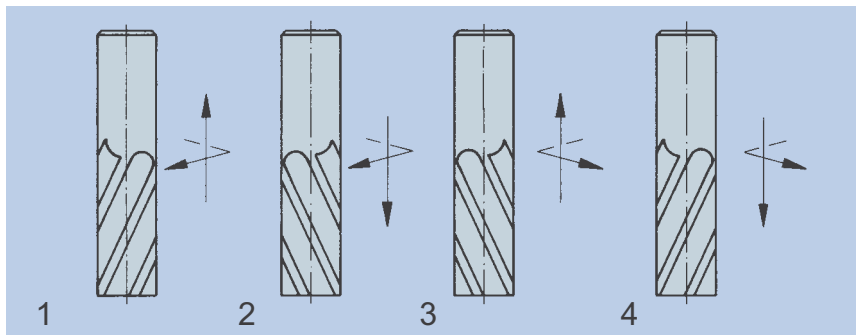
Straight cutting edge



With shear angle

With shear angle, spiral design

Spiral cutting edge



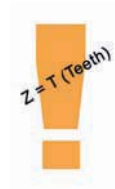
- | | |
|--------------|--|
| 1 RH-Upcut | workpiece face side to bottom, good chip flow. |
| 2 RH-Downcut | workpiece face side to top, supports the workpiece clamping. |
| 3 LH-Upcut | workpiece face side to bottom, good chip flow. |
| 4 LH-Downcut | workpiece face side to top, supports the workpiece clamping. |

2. Cutting tools with shank

2.1 General information DiaMaster

Diamond router cutters tipping heights and number of resharpenings:

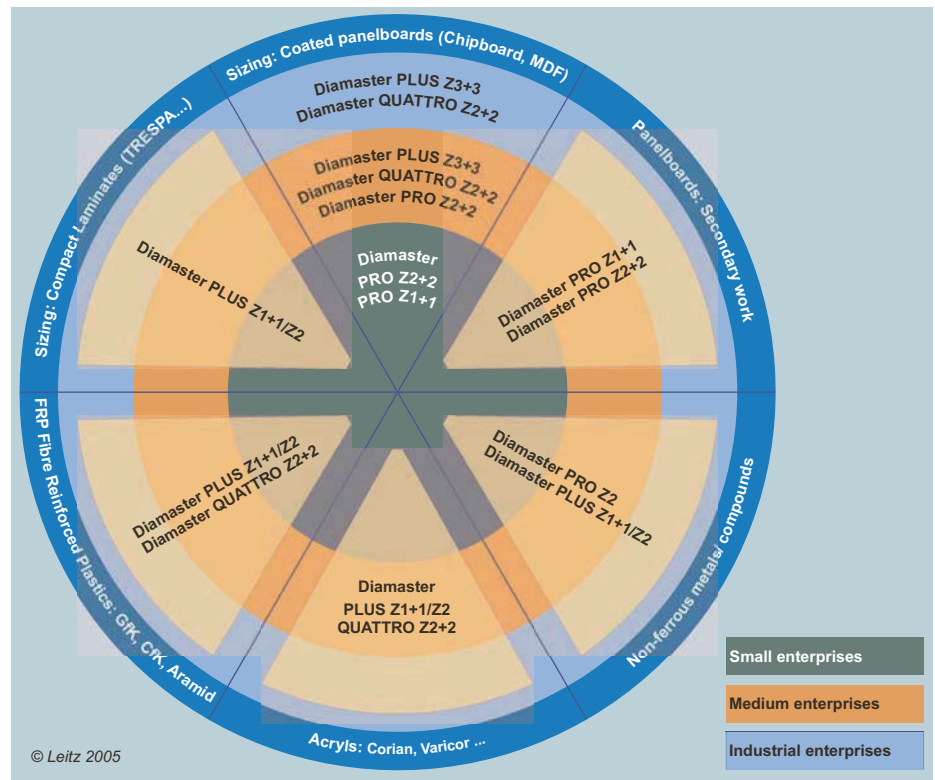
	Tipping heights	Number of resharpenings
UNO	2,5 mm	up to 2x
PRO	3,0 mm	1x to 3x
PLUS Z1+1	5,0 mm	6x to 8x
Quattro Z2+2	5,0 mm	8x to 10x
PLUS Z 3+3	5,0 mm	6x to 10x
Profile-routers	5,0 mm	3x to 6x



Diamond router cutters and their suitability:

- ✓ Suitable
- ✓✓ More suitable
- ✓✓✓ Most suitable
- ✗ Not suitable

	Small companies and handcraft	Small industrial companies	Industrial companies and batch production	Description
UNO	✗	✓	✓	Out of an economical view only recommended inf there's no service station available close to the customer
PRO	✓✓✓	✓✓	✓	Standard tool for smaller companies and for subordinate processes at industrial usage
PLUS Z1+1	✓✓	✓✓	(✓)	Perfect tool for hard to cut materials like composite and synthetic materials such as GfK, CfK, HPL, ...
Quattro Z2+2	(✓)	✓✓	✓✓✓	Tools suitable if higher output and quality is needed
PLUS Z 3+3	✗	✓✓	✓✓✓	Perfect tool for maximum output and quality at industrial production

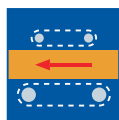
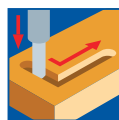


- available ex stock
- available at short notice

2. Cutting tools with shank

2.2 Diamond router cutter program

Router cutter DiaMaster PRO Z(=Teeth)1+1



Number of teeth: Z (=Teeth) 1+1
RPM: n 18000 - 36000 min⁻¹

Router cutter for sizing + pre-cutting, DP PRO-tipped, Z (=Teeth) 1+1, finishing, with TC plunging tip, suitable for small and medium sized batches.

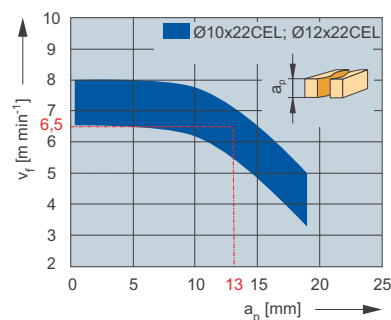


Diagram to determine feed speed v_f depending on grooving depth a_p , DIA 8 - 12 mm

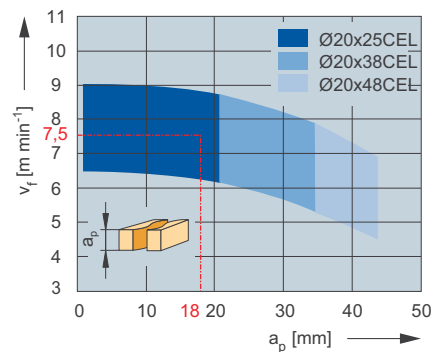


Diagram to determine feed speed v_f depending on grooving depth a_p , DIA 20 mm

Router cutter Diamaster PRO

Workpiece material:
 Chipboard plastic coated
 Operation: Sizing
 RPM: n 18000 min⁻¹
 Correction factor v_f : MDF = 0,8;
 Chipboard = 1,1; Veneer across grain = 0,7

Z(=Teeth) 1+1 WO 140-2-50 *

Class.	DIA mm	OAL mm	NL mm	S mm	ID No. LH	ID No. RH	
*	10	70	22	12x40		091264	●
*	12	70	22	12x45		091265	●
*	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	16x50		091272	●
*	16	95	35	20x50		091273	●
*	16	105	35	25x60		091274	●
*	16	115	43	25x60	091276	091275	● ●
*	18	90	28	20x50		091277	●
*	18	95	35	20x50		091278	●
*	18	105	35	25x60		091279	●
*	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	●

Z (=Teeth) 1+1 WO 140-2-50 *

Class.	DIA mm	DIA Inch	OAL mm	OAL Inch	CEL mm	CEL Inch	S DIA mm	S DIA Inch	ID No. RH	
*	12,7	1/2"	70	2 3/4"	22,23	7/8"	12,7x38	1/2"x1 1/2"	091296	●
*	19,05	3/4"	110	4 3/8"	48	1 7/8"	19,05x50	3/4"x2"	091297	●



- available ex stock
- available at short notice

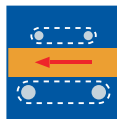
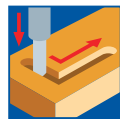
2. Cutting tools with shank

2.2 Diamond router cutter program



Number of teeth: Z (=Teeth) 2+2
RPM:
 DIA 22 mm: n 16000 - 30000 min⁻¹

Router cutter DiaMaster PRO Z(=Teeth)2+2



See
Leitz-Lexicon

Router cutter for sizing and pre-cutting, DP PRO-tipped, Z (=Teeth) 2+2, finishing, with TC plunging tip, suitable for small and medium sized batches.

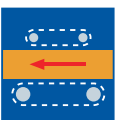
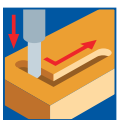
Z(=Teeth)2+2
WO 140-2-50 *

	DIA mm	CEL mm	S DIA mm	ID No. RH	
*	22	28	20x50	091222	●
*	22	28	25x60	091224	●
*	22	38	20x50	091226	●
*	22	38	25x60	091228	●
*	22	48	20x50	091230	●
*	22	48	25x60	091232	●



Number of teeth: Z (=Teeth) 1+1,
 with shear angle
RPM:
 n 16000 - 36000 min⁻¹

Router cutter DiaMaster PLUS Z(=Teeth)1+1



See
Leitz-Lexicon

Router cutter for sizing + pre-cutting, DP PLUS-tipped, Z (=Teeth) 1+1, finishing, with TC plunging tip. Alternate shear angle cutting edges for tear-free machining of veneer or plastic coated workpieces. Large resharpening area suitable for large batch production and machining of highly abrasive materials (HPL, CPL, GfK, CfK,...).

WO 140-2 *

Class.	DIA mm	OAL mm	CEL mm	S DIA mm	ROT	ID No.	
*	12	90	24	16x50	RH	090174	●
*	16	90	28	16x50	RH	090183	●
*	16	90	28	20x60	RH	090188	●
*	18	110	48	20x60	RH	091101	●
*	20	100	28	25x60	RH	090162	●
*	20	110	38	25x60	RH	090163	●
*	20	120	48	25x60	RH	090164	●
*	20	130	58	25x60	RH	090167	●

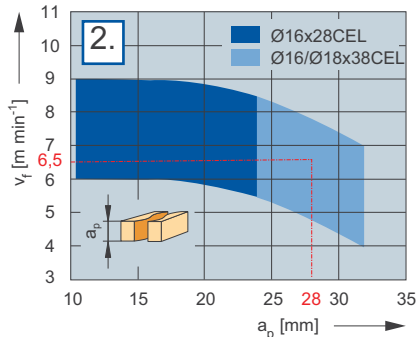
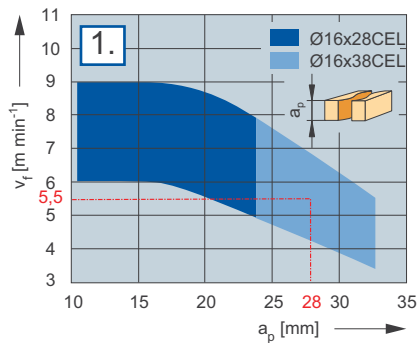
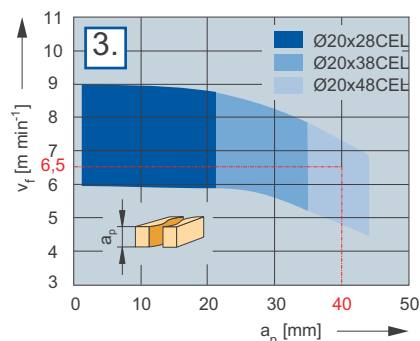


Diagram to determine feed speed v_f
 depending on grooving depth a_p ,
 DIA 16 mm, 18 mm, 20 mm



1. DiaMaster PLUS Z(=Teeth)1+1, D20

Workpiece material: Chipboard plastic coated
 Operation: Sizing
 RPM n 18000 min⁻¹

2. DiaMaster PLUS Z(=Teeth)1+1, D16-18

Workpiece material: Chipboard plastic coated
 Operation: Sizing
 RPM n 18000 min⁻¹

3. DiaMaster PLUS Z(=Teeth)1+1, D16

Workpiece material: Glulam
 Operation: Sizing
 RPM n 18000 min⁻¹

- available ex stock
- available at short notice



2. Cutting tools with shank

2.2 Diamond router cutter program



Number of teeth: Z (=Teeth) 2+2
RPM: n 16000 - 36000 min⁻¹

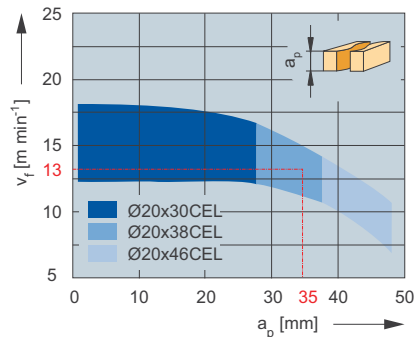


Diagram to determine feed speed v_f depending on grooving depth a_p , DIA 20 mm

Router cutter Diamaster QUATTRO, Z (=Teeth) 2+2

Workpiece material:
 Chipboard plastic coated
 Operation: Sizing
 RPM: n 18000 min⁻¹
 Correction factor v_f : MDF = 0,6;
 Paper coated = 0,8

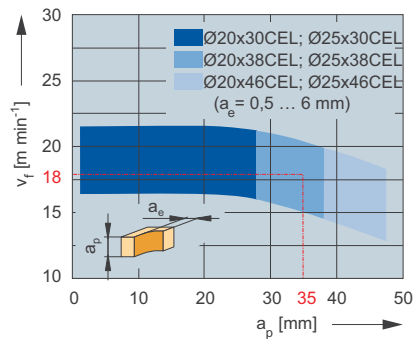
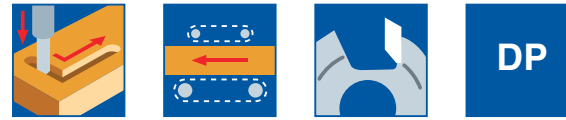


Diagram to determine feed speed v_f depending on grooving depth a_p , DIA 20 mm

Router cutter Diamaster QUATTRO, Z (=Teeth) 2+2

Workpiece material:
 Chipboard plastic coated
 Operation: Jointing
 RPM: n 18000 min⁻¹
 Correction factor v_f : MDF = 0,9;
 Paper coated = 0,8;
 Veneer across grain = 0,8

Router cutter DiaMaster QUATTRO Z(=Teeth)2+2



High performance router cutter for sizing + pre-cutting, DP PLUS-tipped, Z (=Teeth) 2+2, finishing, with TC plunging tip. Suitable for machining coated timber and composite material workpieces at high feed speeds. Higher performance than Z (=Teeth) 1+1 DP routing tools.

WO 140-2 *

Class.	DIA mm	OAL mm	CEL mm	S DIA mm	ID No. LH	ID No. RH
*	20	90	28	20x50	091234	● 091235 ●
*	20	100	28	25x60		● 091237 ●
*	20	100	38	20x50		● 091239 ●
*	20	110	38	25x60		● 091241 ●
*	20	110	48	20x50		● 091238 ●
*	20	120	48	25x60	091246	● 091247 ●
*	25	100	28	25x60		● 091249 ●
*	25	110	38	25x60	091250	● 091251 ●
*	25	110	48	20x50		● 091245 ●
*	25	120	48	25x60	091252	● 091253 ●



- available ex stock
- available at short notice

2. Cutting tools with shank

2.2 Diamond router cutter program



Number of teeth: Z (=Teeth) 3+3
RPM: n 16000 - 37000 min⁻¹

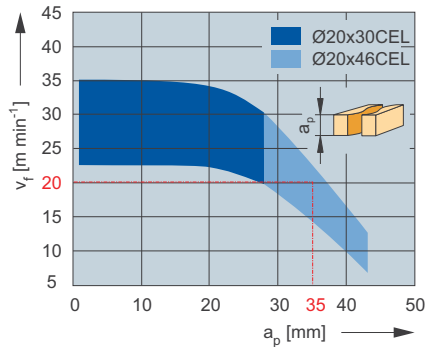


Diagram to determine feed speed v_f depending on grooving depth a_p , DIA 20 mm

Router cutter Diamaster PLUS, Z(=Teeth) 3+3

Workpiece material:
Chipboard plastic coated
Operation: Sizing
RPM: n 24000 min⁻¹
Correction factor v_f :
MDF = 0,8; Paper coated = 0,8

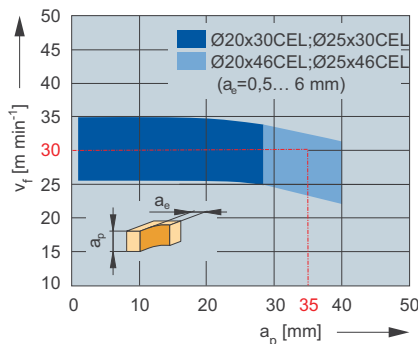


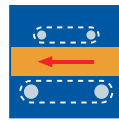
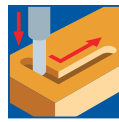
Diagram to determine feed speed v_f depending on grooving depth a_p , D 20 mm, 25 mm

Router cutter Diamaster PLUS, Z (=Teeth) 3+3

Workpiece material:
Chipboard plastic coated
Operation: Jointing
RPM: n 24000 min⁻¹
Correction factor v_f :
MDF = 0,9;
Paper coated = 0,8;
Veneer across grain = 0,8

Positioning tool relative to the workpiece

Router cutter DiaMaster PLUS Z(=Teeth)3+3



See
Leitz-Lexicon

High performance router cutter for sizing + pre-cutting, DP PLUS-tipped, Z (=Teeth) 3+3, finishing, with DP-plunging tip. Suitable for machining coated timber and composite workpieces at high feed speeds. Higher performance than Z (=Teeth) 1+1 and Z (=Teeth) 2+2 DP routing tools. Negative twist to support the clamping of small workpieces.

WO 140-2 * With negative twist

Class.	DIA mm	OAL mm	CEL mm	S DIA mm	ID No. LH	ID No. 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	110	46	20x50		091172 ●
*	20	120	46	25x60		091174 ●
*	25	100	24	25x60		091213 ●
*	25	95	30	20x50		091175 ●
*	25	105	30	25x60	091176 ●	091177 ●
*	25	110	38	25x60	091214 ●	091215 ●
*	25	120	46	25x60	091179 ●	091180 ●

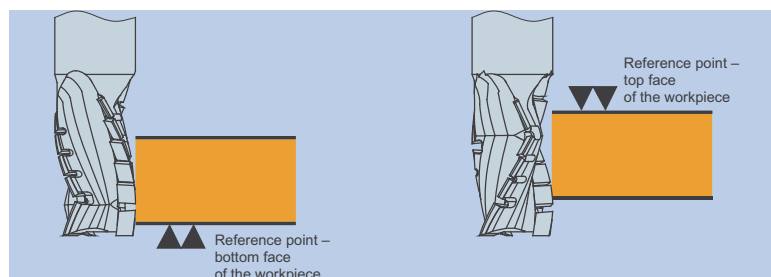
High performance router cutter for sizing + pre-cutting, DP PLUS-tipped, Z (=Teeth) 3+3, finishing, with DP-plunging tip. Suitable for machining coated timber and composite workpieces at high feed speeds. Higher performance than Z (=Teeth) 1+1 and Z (=Teeth) 2+2 DP routing tools. Positive twist for optimum chip removal into the extraction. Firm clamping necessary for small workpieces.

WO 140-2 * With positive twist

Class.	DIA mm	OAL mm	CEL mm	S DIA mm	ID No. LH	ID No. RH
*	16	100	24	20x50		091254 ●
*	25	110	38	25x60	091216 ●	091217 ●
*	25	120	46	25x60	091218 ●	091219 ●

Tools with high negative shear angle

Tools with high positive shear angle



- available ex stock
- available at short notice



2. Cutting tools with shank

2.2 Diamond router cutter program



Number of teeth: $Z (=Teeth) 2 / Z (=Teeth) 1$
RPM: $n 16000 - 36000 \text{ min}^{-1}$

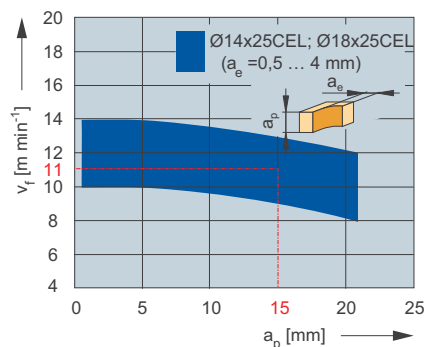


Diagram to determine feed speed v_f depending on grooving depth a_p , DIA 14 mm, 18 mm

Router cutter DiaMaster PRO $Z (=Teeth) 1, Z (=Teeth) 2$



Router cutter for line-free sizing and grooving, DP PRO-tipped, $Z (=Teeth) 1$ or for $Z (=Teeth) 2$, finishing. Negative shear angle cutting edges (D10) for tear-free cutting when grooving and to support the clamping of small workpieces. Maximum chip removal 4 mm, for larger chip removal, pre-cutting is essential. Suitable for machining MDF parts for painting or foil wrapping and for solid woods. Teflon coated tool body to reduce resin and glue build up.

WO 140-2-50 *

Class.	DIA mm	OAL mm	CEL mm	S DIA mm	T	ROT	ID No.
*	8	60	12	12x40	1	RL	090154 ●
*	10	70	12	12x40	2	RL	091158 ●
*	18	90	25	16x50	2	RL	091190 ●

Router cutter PRO, $Z (=Teeth) 2$

Workpiece material:
 Chipboard plastic coated
 Operation: Sizing
 RPM: $n 18000 \text{ min}^{-1}$
 Correction factor v_f : MDF = 0,9;
 Veneer across grain = 0,7



Number of teeth: $Z (=Teeth) 2$
RPM: for wood derived materials:
 $n 16000 - 36000 \text{ min}^{-1}$
 for plastics:
 $n 12000 - 18000 \text{ min}^{-1}$

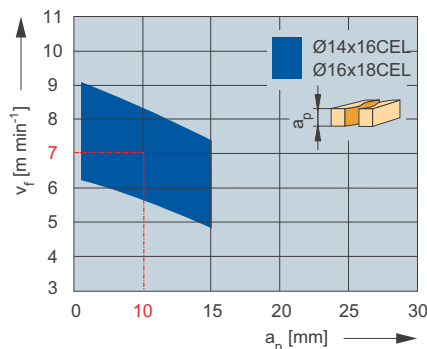


Diagram to determine feed speed v_f depending on grooving depth a_p , DIA 14 mm, 16 mm

Router cutter DiaMaster PLUS $Z (=Teeth) 2$



Router cutter for line-free sizing and grooving, DP PLUS-tipped, $Z (=Teeth) 2$, finishing. Short, stable cutting edge and suitable for grooving and sizing abrasive and hard materials (HPL, Trespa, GfK, CfK...). Negative shear angle cutting edges for tear-free cutting when grooving and to support the clamping of small workpieces. Maximum chip removal 4 mm, for larger chip removal, pre-cutting is essential. Suitable for machining MDF parts for painting or foil wrapping and for solid woods. Teflon coated tool body to reduce resin and glue build up.

WO 120-2-60 *

Class.	DIA mm	OAL mm	CEL mm	S DIA mm	T	ROT	ID No.
*	14	80	16	20x50	2	RL	091157 ●
*	16	80	18	20x50	2	RL	091156 ●

Router cutter PLUS, $Z (=Teeth) 2$

Workpiece material:
 Duromers, Laminated materials (HPL, CPL), Fibre-reinforced plastics
 Operation: Sizing
 RPM: $n 12000 - 18000 \text{ min}^{-1}$

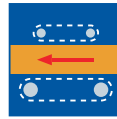
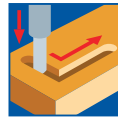


- available ex stock
- available at short notice

2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Wood Series

Wood - 100 Series



DIA	OAL	CEL	S DIA	ID No.	
1/4"	3"	1 1/4"	1/4"	737307359	●
3/8"	3"	3/4"	3/8"	737309244	●

Application: Grooving and Slotting
 Machine: CNC
 Material: Soft Wood, Hard Wood, Soft Plastic, Hard Plastic, Aluminum, Solid Surface

Wood - 110 Series

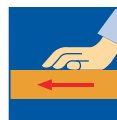
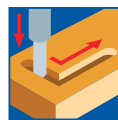


Solid Carbide Z(=Teeth)1 Flute Downcut Polished Flute

DIA	OAL	CEL	S DIA	ID No.	
1/8"	2"	1/2"	1/4"	737000127	●
1/4"	2"	5/8"	1/4"	737305858	●
1/4"	2 1/2"	7/8"	1/4"	737309062	●

Application: Grooving and Slotting
 Machine: CNC
 Material: Soft Wood, Hard Wood, Soft Plastic, Hard Plastic, Aluminum, Solid Surface

Wood - 120 Series



DIA	OAL	CEL	S DIA	ID No.	
1/8"	2 5/8"	3/8"	1/4"	737301545	●
3/16"	2 7/8"	5/8"	1/4"	737308572	●
1/4"	2 3/4"	3/4"	1/4"	737301794	●
1/4"	3 1/4"	3/4"	1/2"	737300673	●
5/16"	3"	3/4"	3/8"	737307579	●
5/16"	3 1/4"	3/4"	1/2"	737300665	●
5/16"	3 1/2"	1"	1/2"	737301797	●
3/8"	3 1/2"	1"	1/2"	737301385	●
3/8"	3 3/4"	1 1/4"	1/2"	737301799	●
3/4"	3 1/4"	1 1/4"	1/2"	737307159	●
1/2"	3"	1"	1/2"	737301386	□

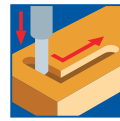
Application: Profiling or Slotting
 Machine: Manual
 Material: Soft Wood, Hard Wood

- available ex stock
- available within 2 weeks

2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Wood Series

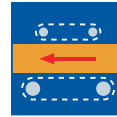
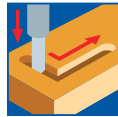
Wood - 130 Series



DIA	OAL	CEL	S DIA	ID No.	
1/8"	2 5/8"	5/16"	1/4"	737304159	●
1/4"	2 3/4"	3/4"	1/4"	737301479	●
1/4"	3"	1"	1/4"	737306168	●
1/2"	3 1/2"	1 1/2"	1/2"	737301800	●
3/4"	3 1/4"	1 1/4"	1/2"	737000566	●

Application: Profiling or Slotting
 Machine: Manual
 Material: Soft Wood, Hard Wood

Wood - 140 Series



DIA	OAL	CEL	S DIA	ID No.	
1/8"	2"	1/2"	1/4"	737000121	●
3/16"	2"	3/4"	1/4"	737000122	●
3/16"	2 1/2"	3/4"	1/4"	737300095	●
1/4"	2 1/2"	7/8"	1/4"	737000118	●
1/4"	2 1/2"	1"	1/4"	737000119	●
1/4"	3"	1 1/8"	1/4"	737000120	●
5/16"	3"	1 1/8"	5/16"	737000128	●
5/16"	3"	1 1/8"	1/2"	737000129	●
3/8"	3"	1 1/8"	3/8"	737000124	●
3/8"	3"	1 1/4"	3/8"	737000125	●
3/8"	3"	1 1/4"	1/2"	737000126	●
7/16"	3"	1"	1/2"	737302902	●
1/2"	3"	1 1/8"	1/2"	737000114	●
1/2"	3 1/2"	1 1/4"	1/2"	737300105	●
1/2"	3 1/2"	1 5/8"	1/2"	737000115	●
1/2"	4"	2 1/8"	1/2"	737000116	●
3/4"	4"	1 5/8"	3/4"	737000123	□
3/4"	4"	2 1/8"	3/4"	737300615	●

Application: Profiling or Slotting
 Machine: Manual or CNC
 Material: Soft Wood, Hard Wood, Composite Wood

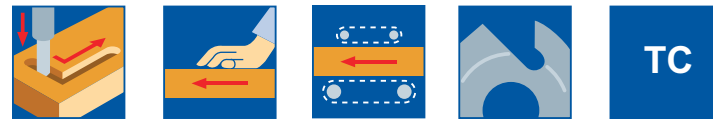
2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Wood Series

Wood - 150 Series



Solid Carbide Z(=Teeth)2 Flute Downcut Spiral



DIA	OAL	CEL	S	ID No.	
1/8"	2"	1/2"	1/4"	737000138	●
1/8"	2"	1/2"	1/4"	737300111	□
1/8"	2"	1/2"	1/8"	737304471	●
5/32"	2 1/2"	1/2"	1/4"	737308036	□
5/32"	2"	5/8"	1/4"	737306147	●
3/16"	2"	3/4"	1/4"	737000139	●
3/16"	2 1/2"	3/4"	1/4"	737307055	●
7/32"	2 1/2"	3/4"	1/4"	737000146	●
1/4"	2 1/2"	7/8"	1/4"	737000135	●
1/4"	2 1/2"	1"	1/4"	737000136	●
1/4"	2 1/2"	1"	1/4"	737000137	□
1/4"	3"	1 1/8"	1/4"	737300114	●
9/32"	2 1/2"	1"	5/16"	737301486	●
5/16"	3"	1 1/8"	5/16"	737000145	●
5/16"	3"	1 1/8"	1/2"	737300115	●
3/8"	3"	1"	3/8"	737000140	●
3/8"	3"	1 1/8"	3/8"	737000141	●
3/8"	3"	1 1/4"	3/8"	737000142	●
3/8"	3"	1 1/4"	3/8"	737300118	□
3/8"	3"	1 1/4"	1/2"	737000143	●
7/16"	3"	1"	1/2"	737300244	●
1/2"	3"	1 1/8"	1/2"	737000130	●
1/2"	3 1/2"	1 1/4"	1/2"	737000131	●
1/2"	3 1/2"	1 5/8"	1/2"	737000132	●
1/2"	3 1/2"	1 5/8"	1/2"	737000133	●
1/2"	3 1/2"	1 5/8"	1/2"	737300120	□
1/2"	4"	2 1/8"	1/2"	737000134	●
3/4"	4"	1 5/8"	3/4"	737300434	●
3/4"	4"	2 1/8"	3/4"	737300290	●

Application: Profiling or Slotting
 Machine: Manual or CNC
 Material: Soft Wood, Hard Wood, Composite Wood

Wood - 160 Series



Solid Carbide Z(=Teeth)2 Flute Heavy Duty Downcut Spiral



DIA	OAL	CEL	S DIA	ID No.	
1/4"	2 1/2"	7/8"	1/4"	737301812	●
1/2"	3"	1 1/4"	1/2"	737305557	●

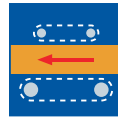
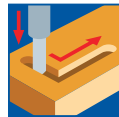
Application: Grooving and Slotting
 Machine: CNC
 Material: Soft Wood, Hard Wood, Composite Wood

- available ex stock
- available within 2 weeks

2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Wood Series

Wood - 170 Series



UPCUT SPIRAL

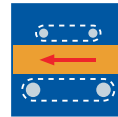
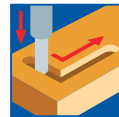
DIA	OAL	CEL	S DIA	ID No.
3/8"	3 1/2"	1 1/8"	3/8"	737300449 ●
1/2"	4"	1 5/8"	1/2"	737300297 ●
3/4"	5"	2 1/8"	3/4"	737303016 ●

DOWNCUT SPIRAL

DIA	OAL	CEL	S DIA	ID No.
3/8"	3"	1 1/8"	3/8"	737300678 ●
1/2"	1/2"	1 5/8"	1/2"	737300656 ●
3/4"	4/5"	2 1/8"	3/4"	737300720 ●

Application: Profiling or Slotting
 Machine: Manual or CNC
 Material: Soft Wood, Hard Wood, Composite Wood

Wood - 180 Series



UPCUT SPIRAL

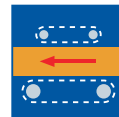
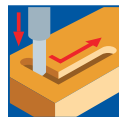
DIA	OAL	CEL	S DIA	ID No.
3/8"	3 1/2"	1 1/8"	3/8"	737300167 ●
1/2"	3 1/2"	1 1/8"	1/2"	737301365 ●
1/2"	4"	1 1/5"	1/2"	737000112 ●
3/4"	5"	2 1/8"	3/4"	737300127 ●

DOWNCUT SPIRAL

DIA	OAL	CEL	S DIA	ID No.
1/2"	3 1/2"	1 1/8"	1/2"	737300029 ●
3/4"	5"		3/4"	737300128 ●

Application: Profiling or Slotting
 Machine: Manual or CNC
 Material: Soft Wood, Hard Wood, Composite Wood

Wood - 190 Series



UPCUT SPIRAL

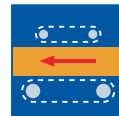
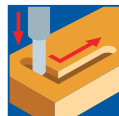
DIA	OAL	CEL	S DIA	ID No.
3/8"	3"	1 1/8"	3/8"	737302216 □
1/2"	3 1/2"	1 5/8"	1/2"	737301817 ●

DOWNCUT SPIRAL

DIA	OAL	CEL	S DIA	ID No.
1/2"	3 1/2"	1 5/8"	1/2"	737303007 ●
1/2"	4"	2 1/8"	1/2"	737306237 ●

Application: Profiling or Slotting
 Machine: CNC
 Material: Hard Wood, Composite Wood

Wood - 200 Series



DIA	OAL	CEL	S DIA	ID No.
1/4"	2 1/2"	7/8"	1/4"	737000156 ●
1/2"	3 1/2"	1 5/8"	1/2"	737000148 ●

Application: Profiling or Slotting
 Machine: CNC
 Material: Hard Wood, Composite Wood

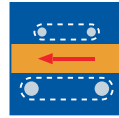
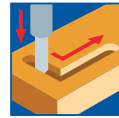
2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Wood Series

Wood - 210 Series



Solid Carbide Z(=Teeth)2+2 Compression



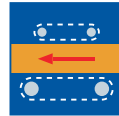
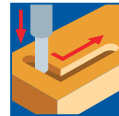
DIA	OAL	CEL	S DIA	ID No.	
1/4"	2 1/2"	7/8"	1/4"	737300493	●
3/8"	3"	1 1/8"	3/8"	737000158	●
1/2"	3"	1"	1/2"	737000150	●
1/2"	3"	1 1/8"	1/2"	737000151	●
1/2"	3 1/2"	1 3/8"	1/2"	737000152	●
1/2"	4"	1 5/8"	1/2"	737000153	●
1/2"	4"	1 5/8"	1/2"	737303106	●
5/8"	5"	2 1/4"	5/8"	737300451	●
3/4"	4"	1 7/8"	3/4"	737303258	●
3/4"	5"	2 1/2"	3/4"	737300714	●

Application: Profiling
 Machine: CNC
 Material: Hard Wood, Composite Wood

Wood - 220 Series



Solid Carbide Z(=Teeth)2+2 Chipbreaker/Finisher Compression



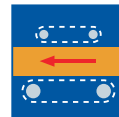
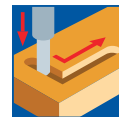
DIA	OAL	CEL	S DIA	ID No.	
3/8"	3"	7/8"	3/8"	737300472	●
3/8"	3"	1 1/8"	3/8"	737300437	●
5/8"	5"	2 1/4"	5/8"	737300660	●

Application: Profiling
 Machine: CNC
 Material: Hard Wood, Composite Wood

Wood - 230 Series



Solid Carbide Z(=Teeth)3+3 Compression



DIA	OAL	CEL	S DIA	ID No.	
3/8"	3"	1 1/8"	3/8"	737300502	●
1/2"	3"	1 1/8"	1/2"	737300185	●

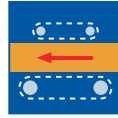
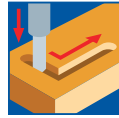
Application: Profiling
 Machine: CNC
 Material: Hard Wood, Composite Wood

- available ex stock
- available within 2 weeks

2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Wood Series

Wood - 240 Series



Z (=Teeth) 1+1 Compression

DIA	OAL	CEL	Upcut Length	S DIA	ID No.	
1/4"	2 1/2"	7/8"	0,175"	1/4"	737300197	●
3/8"	3"	7/8"	0,188"	3/8"	737300034	●

Z (=Teeth) 2+2 Compression

DIA	OAL	CEL	Upcut Length	S DIA	ID No.	
1/4"	2 1/2"	7/8"	0,188"	1/4"	737303410	●
3/8"	3"	7/8"	0,188"	3/8"	737000159	●
1/2"	3"	7/8"	0,200"	1/2"	737300036	●
1/2"	3 1/2"	1 3/8"	0,200"	1/2"	737000155	●
1/2"	3 1/2"	1 3/8"	0,200"	1/2"	737300429	●

Z (=Teeth) 3+3 Compression

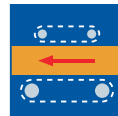
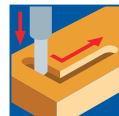
DIA	OAL	CEL	Upcut Length	S DIA	ID No.	
3/8"	3"	7/8"	0,200"	3/8"	737300427	●
1/2"	3"	7/8"	0,200"	1/2"	737300428	●
1/2"	3 1/2"	1 3/8"	0,200"	1/2"	737300411	●
3/4"	4"	2"	0,200"	3/4"	737301405	●

Z (=Teeth) 4+4 Compression

DIA	OAL	CEL	Upcut Length	S DIA	ID No.	
1/2"	3 1/2"	1 3/8"	0,200"	1/2"	737301816	●

Application: Profiling or Slotting
 Machine: CNC
 Material: Hard Wood, Composite Wood

Wood - 250 Series



Z (=Teeth) 1+1 Compression

DIA	OAL	CEL	S DIA	ID No.		
1/2"	3"	1 1/8"	1/2"	737307746	*	□

Z (=Teeth) 2+2 Compression

DIA	OAL	CEL	S DIA	ID No.	
3/8"	3"	7/8"	3/8"	737304397	● *
1/2"	3"	7/8"	1/2"	737300013	● *
1/2"	3"	1 1/8"	1/2"	737305475	●
1/2"	3 1/2"	1 1/8"	1/2"	737302096	●
1/2"	4"	1 5/8"	1/2"	737301578	●
3/4"	5"	2 1/4"	3/4"	737308644	●

Z (=Teeth) 3+3 Compression

DIA	OAL	CEL	S DIA	ID No.	
3/8"	3"	7/8"	3/8"	737301462	● *

* Mortise Compression

Application: Profiling
 Machine: CNC
 Material: Hard Wood, Composite Wood

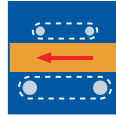
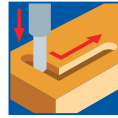
2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Wood Series

Wood - 260 Series



Solid Carbide Z(=Teeth)4+4 Compression



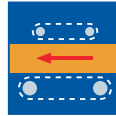
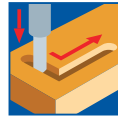
DIA	OAL	CEL	S DIA	ID No.	
1/2"	3 1/2"	1 3/8"	1/2"	737300186	●
1/2"	4"	1 5/8"	1/2"	737301519	●

Application: Profiling
 Machine: CNC
 Material: Hard Wood, Composite Wood

Wood - 270 Series



Solid Carbide Z(=Teeth)3 Flute Finisher



UPCUT SPIRAL

DIA	OAL	CEL	S DIA	ID No.	
1/4"	3"	7/8"	1/4"	737300053	●
3/8"	3"	5/8"	3/8"	737300055	●
3/8"	3"	1 1/8"	3/8"	737301815	●
1/2"	3 1/2"	1 1/8"	1/2"	737300056	●
1/2"	4"	1 5/8"	1/2"	737300062	●
3/4"	5"	2 1/8"	3/4"	737300058	●
3/4"	6"	3 1/8"	3/4"	737309240	●

DOWNCUT SPIRAL

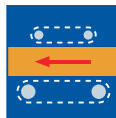
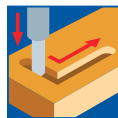
DIA	OAL	CEL	S DIA	ID No.	
1/2"	3 1/2"	1 1/8"	1/2"	737300541	●
1/2"	4"	1 5/8"	1/2"	737300024	●
1/2"	4 1/2"	2 1/8"	1/2"	737300063	●

Application: Profiling or Slotting
 Machine: CNC
 Material: Soft Wood, Hard Wood, Soft Plastic, Hard Plastic, Solid Surface

Wood - 280 Series



Solid Carbide Z(=Teeth)2 Flute Chipbreaker Finisher



DOWNCUT SPIRAL

DIA	OAL	CEL	S DIA	ID No.	
1/2"	3"	1 1/8"	1/2"	737300540	●

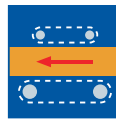
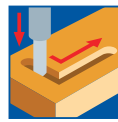
Application: Profiling or Slotting
 Machine: CNC
 Material: Hard Wood, Composite Wood

- available ex stock
- available within 2 weeks

2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Wood Series

Wood - 290 Series



UPCUT SPIRAL

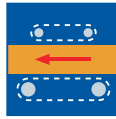
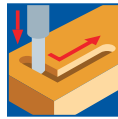
DIA	OAL	CEL	S DIA	ID No.
3/4"	4"	2 1/4"	3/4"	737300046 ●

DOWNCUT SPIRAL

DIA	OAL	CEL	S DIA	ID No.
3/8"	3"	1 1/8"	3/8"	737300679 ●
1/2"	3"	1 1/8"	1/2"	737300047 ●
1/2"	3 1/2"	1 5/8"	1/2"	737300177 ●

Application: Profiling or Slotting
 Machine: CNC
 Material: Hard Wood, Composite Wood

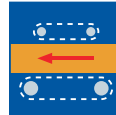
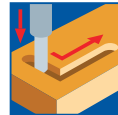
Wood - 300 Series



DIA	OAL	CEL	S DIA	ID No.
1/2"	3"	1"	1/2"	737300237 ●

Application: Profiling
 Machine: CNC
 Material: Soft Wood, Hard Wood, Composite Wood

Wood - 310 Series



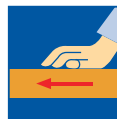
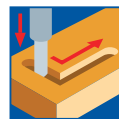
DIA	OAL	CEL	S DIA	ID No.
1/2"	4"	1 5/8"	1/2"	737307240 ●

Application: Profiling
 Machine: CNC
 Material: Soft Wood, Hard Wood, Composite Wood

2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Plastic Series

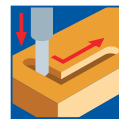
Plastic - 400 Series



DIA	OAL	CEL	S DIA	ID No.	
1/4"	2 3/8"	1"	1/4"	737301778	●

Application: Profiling or Slotting
 Machine: Manual
 Material: Soft Plastic

Plastic - 410 Series

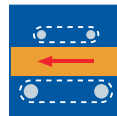
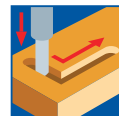


UPCUT SPIRAL

DIA	OAL	CEL	S DIA	ID No.	
1/4"	2 1/8"	3/4"	1/4"	737306661	●

Application: Profiling or Slotting
 Machine: Manual
 Material: Soft Plastic, Hard Plastic

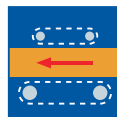
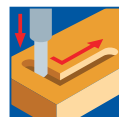
Plastic - 420 Series



DIA	OAL	CEL	S DIA	ID No.	
1/8"	2"	1/2"	1/4"	737303096	●
3/16"	2"	3/8"	1/4"	737303101	●
3/16"	2"	5/8"	1/4"	737303482	●
3/16"	4"	1"	1/4"	737307219	●
1/4"	2 1/2"	3/4"	1/4"	737300511	●

Application: Profiling or Slotting
 Machine: CNC
 Material: Soft Plastic, Hard Plastic

Plastic - 430 Series



DIA	OAL	CEL	S DIA	ID No.	
1/8"	2"	5/16"	1/4"	737304149	●
1/8"	2"	1/2"	1/4"	737300215	●
1/4"	2 1/2"	1"	1/4"	737300641	●
1/2"	4"	1 3/4"	1/2"	737302944	●

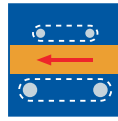
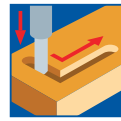
Application: Profiling or Slotting
 Machine: CNC
 Material: Soft Plastic, Hard Plastic

- available ex stock
- available within 2 weeks

2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Plastic Series

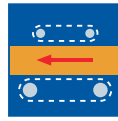
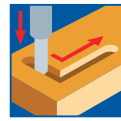
Plastic - 440 Series



DIA	OAL	CEL	S DIA	ID No.	
1/4"	2 1/2"	3/4"	1/4"	737300510	●

Application: Profiling or Slotting
 Machine: CNC
 Material: Hard Plastic

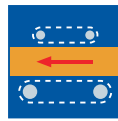
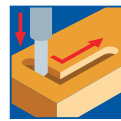
Plastic - 450 Series



DIA	OAL	CEL	S DIA	ID No.	
1/4"	2 1/2"	3/4"	1/4"	737300617	●
3/8"	3"	1"	3/8"	737300425	●
1/2"	3 1/2"	1 1/8"	1/2"	737300339	●

Application: Profiling or Slotting
 Machine: CNC
 Material: Soft Plastic, Hard Plastic

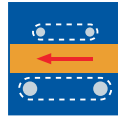
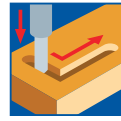
Plastic - 460 Series



HARD PLASTIC					SOFT PLASTIC				
DIA	OAL	CEL	S DIA	ID No.	DIA	OAL	CEL	S DIA	ID No.
1/4"	2 1/2"	3/4"	1/4"	737300213 ●	3/16"	2"	5/8"	1/4"	737307668 ●

Application: Profiling or Slotting
 Machine: CNC
 Material: Soft Plastic, Hard Plastic

Plastic - 470 Series



DOWNCUT SPIRAL					UPCUT SPIRAL				
DIA	OAL	CEL	S DIA	ID No.	DIA	OAL	CEL	S DIA	ID No.
1/16"	2"	1/4"	1/4"	737302022 ●	1/16"	2"	1/4"	1/4"	737300279 ●
1/8"	2"	1/2"	1/4"	737300017 ●	1/8"	2"	1/2"	1/4"	737302959 ●
3/16"	2"	5/8"	1/4"	737300200 ●	3/16"	2"	5/8"	1/4"	737300723 ●
1/4"	2 1/2"	3/4"	1/4"	737300016 ●	1/4"	2 1/2"	3/4"	1/4"	737300130 ●
1/4"	3"	1 1/4"	1/4"	737300336 ●					
3/8"	3"	1 1/8"	3/8"	737300203 ●					

Application: Profiling or Slotting
 Machine: CNC
 Material: Soft Plastic, Hard Plastic

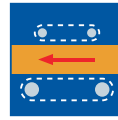
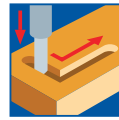
2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes Plastic Series / General Purpose

Plastic - 480 Series



Solid Carbide Z(=Teeth)2 Upcut O Flute



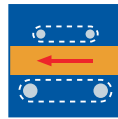
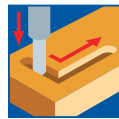
DIA	OAL	CEL	S DIA	ID No.	
1/4"	2 1/2"	3/4"	1/4"	737000227	●
1/2"	3 1/2"	1 1/8"	1/2"	737300333	●
1/2"	3 1/2"	1 5/8"	1/2"	737307529	●

Application: Grooving and Slotting
 Machine: CNC
 Material: Soft Plastic, Hard Plastic

Plastic - 490 Series



Solid Carbide Z(=Teeth)3 Flute Finisher



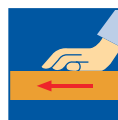
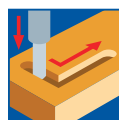
UPCUT SPIRAL					DOWNCUT SPIRAL				
DIA	OAL	CEL	S DIA	ID No.	DIA	OAL	CEL	S DIA	ID No.
1/4"	3"	7/8"	1/4"	737300053 ●	1/2"	3 1/2"	1 1/8"	1/2"	737300541 ●
3/8"	3"	5/8"	3/8"	737300055 ●	1/2"	4"	1 5/8"	1/2"	737300024 ●
3/8"	3"	1 1/8"	3/8"	737301815 ●					
1/2"	3 1/2"	1 1/8"	1/2"	737300056 ●					
1/2"	4"	1 5/8"	1/2"	737300062 ●					
3/4"	5"	2 1/8"	3/4"	737300058 ●					

Application: Profiling or Slotting
 Machine: CNC
 Material: Hard Plastic

Gen Purpose - 500 Series



High Speed Steel Z(=Teeth)1 Flute Downcut Spiral



DIA	OAL	CEL	S DIA	ID No.	
1/4"	3"	3/4"	1/4"	737305108	●

Application: Slotting
 Machine: Manual
 Material: Aluminum - Plywood Sandwich Panels

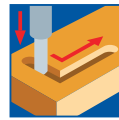
2. Cutting tools with shank

2.3 Spiral router cutter - Imperial Sizes General Purpose / Aluminum

Gen Purpose - 510 Series



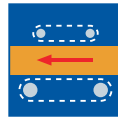
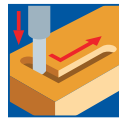
Solid Carbide Z(=Teeth)1 Flute Laminate Trim



DIA	OAL	CEL	S DIA	ID No.	Style	
1/4"	1 1/2"	1/4"	1/4"	737300422	Flush	●
1/4"	1 1/2"	1/4"	1/4"	737300264	7° Bevel	●

Application: Trimming
Machine: Manual
Material: Laminate Countertops

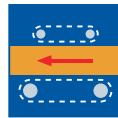
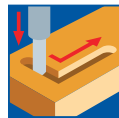
Aluminum - 520 Series



DIA	OAL	CEL	S DIA	ID No.	
1/8"	2"	1/4"	1/4"	737300624	●
1/8"	2"	1/2"	1/4"	737300546	●
3/16"	2"	5/8"	1/4"	737303051	●
1/4"	2"	3/8"	1/4"	737306803	●
1/4"	2 1/2"	3/4"	1/4"	737300515	●
1/4"	3"	1 1/4"	1/4"	737300545	●
3/8"	3"	1 1/8"	3/8"	737305360	●

Application: Grooving and Slotting
Machine: CNC
Material: Aluminum

Aluminum - 530 Series

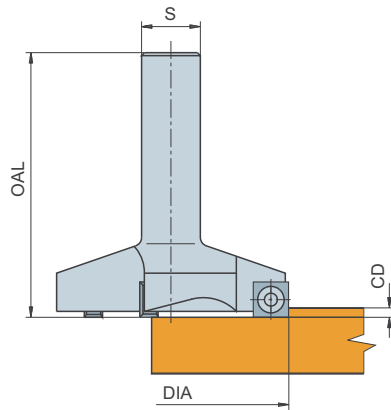
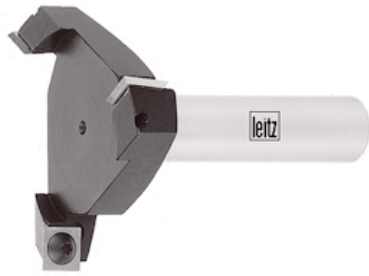


DIA	OAL	CEL	S DIA	ID No.	
1/8"	2"	1/4"	1/8"	737307706	□
3/16"	2"	3/8"	3/16"	737304289	□
1/2"	5"	5/8"	1/2"	737309263	●

Application: Grooving and Slotting
Machine: CNC
Material: Aluminum

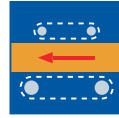
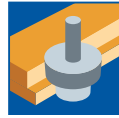
2. Cutting tools with shank

2.4 Spoilboard Planer (for Nesting applications)



Number of teeth: T 3
RPM: n 8000 - 12000 min⁻¹

Planing cutter – turnblade design



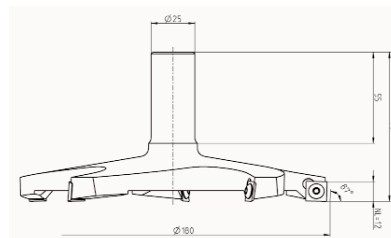
See
Leitz-Lexicon

For planing workpiece surfaces and large rebate depths in one work step. TC turnblade knives Z (=Teeth) 3, with shear. Exchangeable cutting edges for machining solid wood, MDF or plastics. Choice of TC cutting material quality to suit the workpiece.

Class.	DIA mm	OAL mm	CEL mm	S DIA mm	ROT	T	ID No.
*	80	90	12	20x50	RH	3	041550 ●
*	80	100	12	25x60	RH	3	041551 ●
*	180	90	12	25x60	RH	5	041552 ●
*	50	80	12	1/2"x60	RH	3	130033007 ●
*	100	90	12	3/4"x60	RH	3	130057336 ●

Spare Parts

ART	DIM	ID No.
Oval head screw	M4x6	006225 ●
Screw driver, Torx	T15	005457 ●
Turnblade knife	HW: 12x12x1.5	005081 ●



Number of teeth: T 5
RPM: n 8400 min⁻¹

Features

MDF Spoil board 2,50 x 1,25 m ²	Nesting Planing cutter D 180, Z5	Planing cutter D 80, Z3
Material removal	1-1,5 mm	1-1,5 mm
RPM	8400 min ⁻¹	12000 min ⁻¹
Feed rate	40 m/min	30 m/min
Planing time	36 s	97 s
Time saving / shift	up to 30 min	

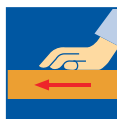
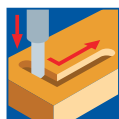
- available ex stock
- available at short notice



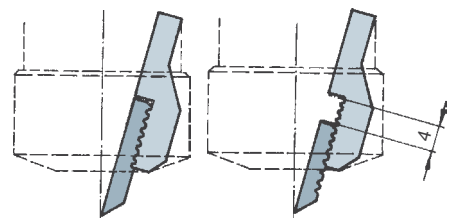
2. Cutting tools with shank

2.5 Profile router cutter Multi

Profile cutterhead end-milling system cutting



Cutterhead with re-sharpenable shear cutting edge, TC T1. Precise knife seating with ground serrations. For cutting interior profiles and decorative grooves, which can only be made with central cutting knives. Different profiles with one tool body and exchangeable profile knives. DP-tipped profile knives available on request.



Knife in new condition

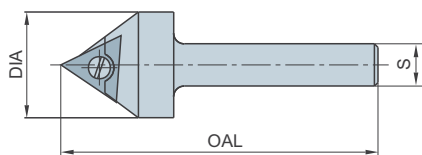
Maximum adjustment of resharpened knife

Cutting in end grain for profiles, T 1 WP 500-1 *

Class.	DIA mm	W mm	OAL mm	S DIA mm	ID No. mm
*	15	7	88,5	16x50	042930 ●
*	15	7	98,5	25x60	042931 ●

Unit consisting of cutterhead with clamping wedge and nut but without HW knife blank.

V-grooving cutter. HW turnblade Z2. V-groove 68°. Three edged turnblade knife. For finish cutting different interior profiles.



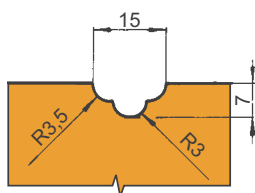
V-groove 68° in turnblade design

End milling, V-groover in turnblade design 68°, T 1 WL 300-2 *

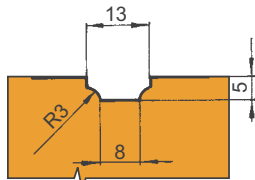
Class.	DIA mm	W mm	OAL mm	S DIA mm	ID No. mm
*	30	15	90	12x40	042932 ●

Spare parts

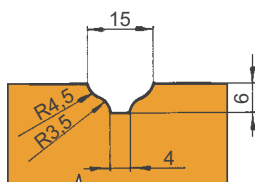
ART	DIM mm	ID No.
Serrated blank knife	9x3x21,7	007490 ●
Clamping wedge	9x7x27,4	009584 ●
Size	SW 3	005433 ●
Sickle spanner		005498 ●
Profile knife 1	9x3x21,7	006945 ●
Profile knife 2	9x3x21,7	006946 ●
Profile knife 3	9x3x21,7	006947 ●
Profile knife 4	9x3x21,7	006948 ●
Profile knife 5	9x3x21,7	006949 ●
Profile knife 6	9x3x21,7	006950 ●
Turnblade knife	19x19x2	009528 ●
Screw	M 5x5	007381 ●



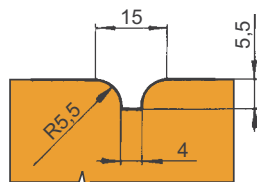
Profile 1



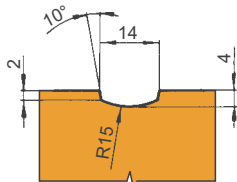
Profile 2



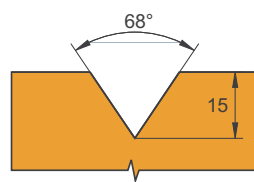
Profile 3



Profile 4



Profile 5



Profile 6



- available ex stock
- available at short notice

2. Cutting tools with shank

2.5 Profile router cutter VariForm

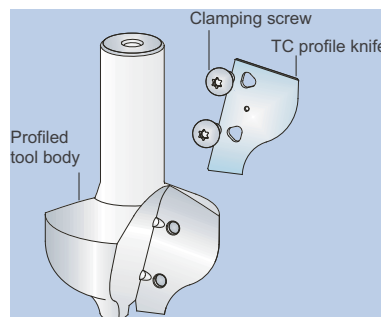
Application	Machining profiles.
Workpiece material (recommended cutting material)	Soft and hardwood (TC1). Chipboard and fibre materials (MDF, HF, etc.), uncoated, with plastic coating, with veneer, etc. (TC2). Plywood (TC2). Duro-plastics (TC2). Thermoplastics (TC1, TC2). Polymer plastics (Corian, Varicor, etc.) (TC2). Note: Two different grades of TC blanks available – TC1, TC2.
Machine	Router machines with / without CNC, CNC machining centres, Special machines with spindle for shank tools.
Operation	With and against feed, limited chip removal.
Technical features	VariForm profile cutterheads can be used for many different profile machining operations. 2 different designs available: a) with profiled tool body for single pieces and small batches production. b) with profiled cutter blanks for prototype and single piece production.

Application Data	RPM/feed speed Recommended cutting speeds v_c and feed speeds f_z for multi-purpose cutterheads.
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	Cutterhead TC v_c [m/s]		Cutterhead TC f_z [mm]
Softwood	60-90	Solid wood along grain	0,3 -0,5
Hardwood	50-80	Solid wood across grain	0,25-0,35
Chipboard/MDF	60-80	Chipboard/MDF	0,3 -0,5
Plywood	60-80	Plywood	0,25-0,35
Plastic-coated board	40-60		

Clamping the workpiece	To avoid problems of cut quality it is essential to clamp the workpiece sufficiently. Insufficient clamping will reduce both the quality of cut and tool lifetime. Panels can be held in place with vacuum clamping, but sometimes additional mechanical clamping is required (e.g. when machining TRESPA, etc). Small and arched workpieces must be clamped with special fixtures.
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General information	Many profile shapes can be made with the profiled tool body design.
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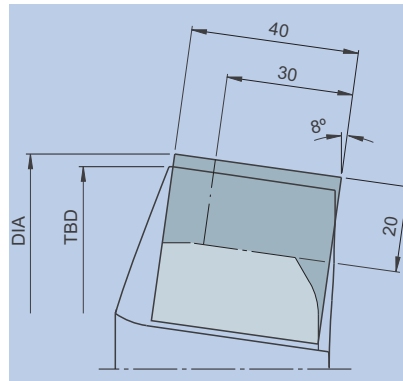
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- available at short notice

2. Cutting tools with shank

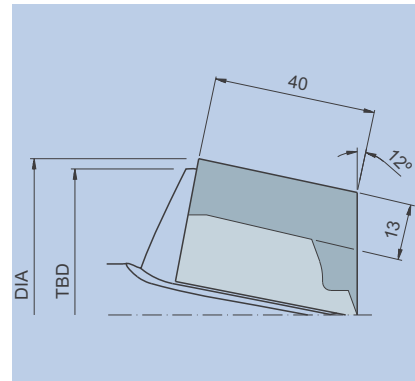
2.5 Profile router cutter VariForm

Profile area to be used

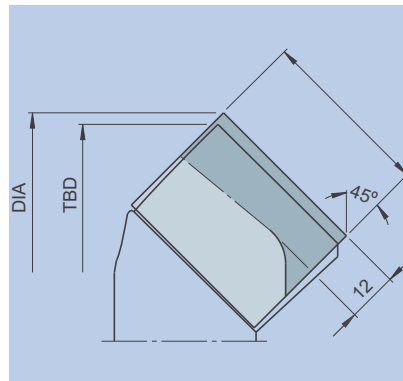
Design with tool body that can be profiled



Tool body, angled 8°, right hand rotation, large diameter to the top, SB 30-50 mm.

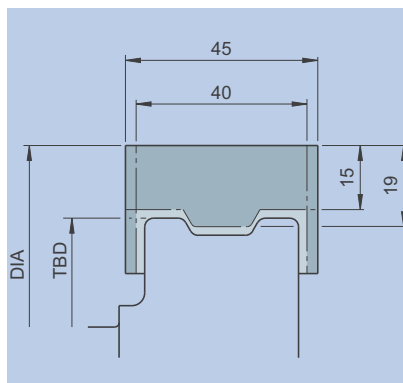


Tool body, angled 12°, right hand rotation, large diameter to the top, SB 40 mm.

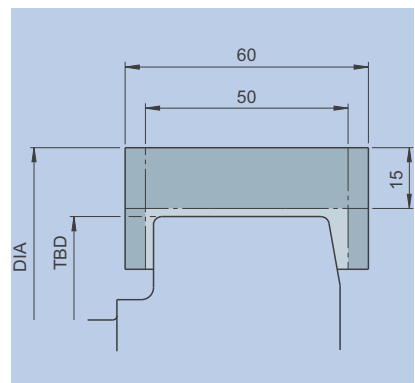


Tool body, angled 45°, right hand rotation, large diameter to the top, SB 40 mm.

Design with backing plates



Tool body SB 40/45 mm.



Tool body SB 50/60 mm.

2. Cutting tools with shank

2.5 Profile router cutter VariForm



Number of teeth: T 2

RPM:

D 105 mm: n max. 12000 min⁻¹
D 77 mm: n max. 14000 min⁻¹

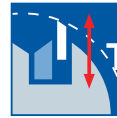
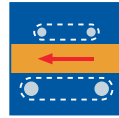
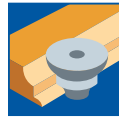
Profile area:

See page 48

VariForm-system advantages:

- Knives can be sharpened 3 to 4 times.
- The modular construction allows you to use the same profile knives in different tool bodies on different machines.
- Profile flexibility and safety by matching the tool body to the depth of the profile.
- Precision and safety from the 3-point knife location.

Profil cutterhead VariForm



See
Leitz-Lexicon

Unprofiled tool body, 8° angled, mech. feed, T2

DIA mm	TBD mm	Kerf mm	S mm	PDmax. mm	ID No. LH	ID No. RH
100	97	30/8°	25x60	20	135420 ●	135421 ●
102	99	40/8°	25x60	20	135422 ●	135423 ●
105	101	50/8°	25x60	20	135424 ●	135425 ●

Tool body profiled to required profile. Without knives.

Blanks for tool body, 8° angled, TC

Knife height mm	Kerf mm	PDmax. mm	ID No. Knives TC1	ID No. Knives TC2
40	30	20	636233 ●	636220 ●
40	40	20	636240 ●	636227 ●
40	50	20	636272 ●	636284 ●

Unprofiled tool body, 12° angled, mech. feed, T2

DIA mm	TBD mm	Kerf mm	S mm	PDmax. mm	ID No. LH	ID No. RH
77	72	40/12°	25x60	30	135428 ●	135429 ●

Tool body profiled to required profile. Without knives.

Blanks for tool body, 12° angled, TC

Knife height mm	Kerf mm	PD max. mm	ID No. Knives TC1	ID No. Knives TC2
30	40	30	636252 ●	636253 ●

Unprofiled tool body, 45° angled, mech. feed, T2

DIA mm	TBD mm	Kerf mm	S mm	PDmax. mm	ID No. LH	ID No. RH
105	101	40/45°	25x60	35	135426 ●	135427 ●

Tool body profiled to required profile. Without knives.

Blanks for tool body, 45° angled, TC

Knife height mm	Kerf mm	PDmax. mm	ID No. Knives TC1	ID No. Knives TC2
30	40	30	636238 ●	636225 ●

Spare parts

ART mm	DIM mm	ID No.
Screw	M5x10x13,5	007383 ●
Key	T 25	005502 ●

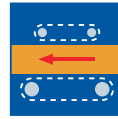
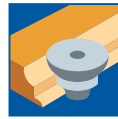
- available ex stock
- available at short notice

2. Cutting tools with shank

2.5 Profile router cutter VariForm



Profil cutterhead VariForm



See
Leitz-Lexicon

Tool body, mech. feed, T 2

DIA mm	TBD mm	Kerf mm	S mm	PDmax. mm	ID No. RH
110	76	40/45	25x60	15	135400 ●
110	76	50/60	25x60	15	135401 ●

With clamping wedges, without backing plates and knives.

Number of teeth: T 2

RPM:

D 110 mm: n max. 12000 min⁻¹

Profile area:

See page 48

VariForm-system advantages:

- Knives can be sharpened 3 to 4 times.
- The modular construction allows you to use the same profile knives in different tool bodies on different machines.
- Profile flexibility and safety by matching the tool body to the depth of the profile.
- Precision and safety from the 3-point knife location.

Blanks, TC

Knife height mm	Kerf mm	PDmax. mm	ID No. Knife TC1	ID No. Knife TC2
40	40	15	636240 ●	636227 ●
40	45	15	636244 ●	636231 ●
40	50	15	636272 ●	636284 ●
40	60	15	636276 ●	636288 ●

Backing plates

Knife height mm	Kerf mm	PDmax. mm	ID No.
40	40	15	645000 ●
40	45	15	645001 ●
40	50	15	645002 ●
40	60	15	645003 ●

Spare parts

ART mm	DIM mm	for S DIA mm	ID No.
Clamping wedge	36314,7322,8	40/45	009761 ●
Clamping wedge	44314,7322,8	50/60	009762 ●
Screw	DIN 915, M10x2		006044 ●
Key	SW 5		117506 ●

- available ex stock
- available at short notice



**Collet chuck with hollow taper shank
HSK-F 63**

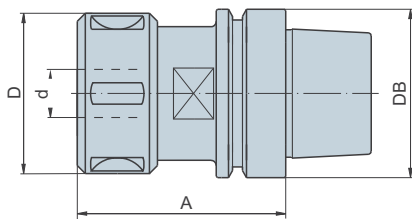
See
Leitz-Lexicon

Precision tool seating with collet for cylindrical shank tools. For shank diameters up to $d_{max.} = 25$ mm. Hollow taper design to DIN 69893. Precise centric running from hardened, ground, double slit collets. Low vibration through short design. Easy tool handling as collet opens automatically when loosening the collet nut. Ball bearing collet nut for increased clamping forces and improved running accuracy compared to a one-piece design. Tool body and collet nut fine balanced. Mounting stand VN 799-0 see section 8, adjusting devices.

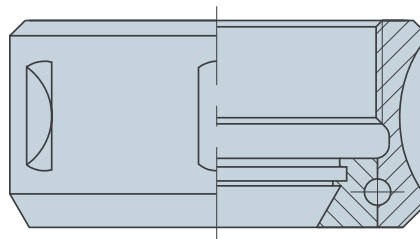
**HSK-F 63 as per DIN 69893, A = 76 mm, clamping range 6-26 mm, short design, 8° tapex angle of the collet
PM 350-0-15 ***

Class.	Fabr. Mach.	DIA mm	d mm	A mm	DB mm	Weight kg	ID No. LH	ID No. RH
*	Biesse, Morbidelli, SCM, Busellato	63	6 - 26	76	63	1,00	037971	● 037970 ●

Sales unit consists of clamping chuck with ball-bearing collet nut, without collet and sickle spanners.



Collet chuck HSK-F 63



Ball-bearing collet nut

Spare parts

ART	for d mm/Inch	DIM mm	ID No.
Collet nut, RH, ball bearing, DIA-63 mm		M 50x1,5	006639 ●
Collet nut, LH, ball bearing, DIA-63 mm		M 50x1,5	006640 ●
Sickle spanner			005458 ●
Collet	6		037926 ●
Collet	8		037927 ●
Collet	10		037928 ●
Collet	12		037929 ●
Collet	14		037930 ●
Collet	16		037931 ●
Collet	20		037932 ●
Collet	25		037933 ●
Collet	6,35 (1/4")		037934 ●
Collet	9,53 (3/8")		037935 ●
Collet	12,7 (1/2")		037936 ●
Collet	15,88 (5/8")		037937 ●
Collet	19,05 (3/4")		037938 ●
Collet	25,4 (1")		037939 ●
Data chip Balluff		HSK-F 63	081309 ●

- available ex stock
- available at short notice



2. Cutting tools with shank

2.6 Clamping Systems



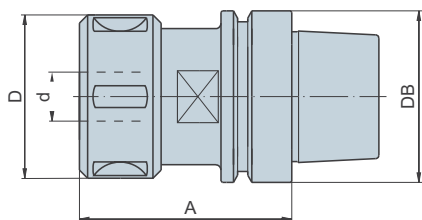
Collet chuck with hollow taper shank HSK-F 63

See
Leitz-Lexicon

Precision tool seating with collet for cylindrical shank tools. For shank diameters up to $d_{max.} = 25$ mm. Hollow taper design to DIN 69893. Precise centric running from hardened, ground, double slit collets. Low vibration from short design. Easy tool handling as collet opens automatically on loosening the collet nut. Ball bearing collet nut for increased clamping forces and improved running accuracy compared to a one-piece design. Tool body and collet nut fine balanced. Mounting stand VN 799-0 see section 8, adjusting devices.

HSK-F 63 as per DIN 69893, short design, A = 78 mm, clamping range 6-25 mm PM 350-0-06 *

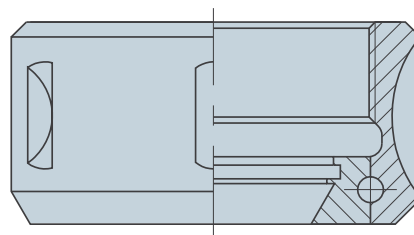
Class.	Fabr.	DIA	d	A	DB	Weight	ID No.	ID No.
	Mach.	mm	mm	mm	mm	kg	LH	RH
*	Homag, Eima, IMA from 9/94 Dubus, Weeke, Morbidelli, SCM, Biesse, MKM	60	6 - 25	78	63	1,10	037413	037412
							24K RPM Style	130049937



Collet chuck HSK-F 63

HSK-F 63 as per DIN 69893, long design, A = 105 mm, clamping range 6-25 mm PM 350-0-06 *

Class.	Fabr.	DIA	d	A	DB	Weight	ID No.
	Mach.	mm	mm	mm	mm	kg	RH
*	Weeke	60	6 - 25	105	63	1,50	037924



Ball-bearing collet nut

Spare parts

ART	for d	DIM	ID No.
	mm/Inch	mm	
Collet nut, RH, ball bearing, D-60 mm		M 48x2	005714
Collet nut, LH, ball bearing, D-60 mm		M 48x2	006632
Sickle spanner			005458
Collet	6		037429
Collet	8		037430
Collet	10		037431
Collet	12		037432
Collet	13		037433
Collet	14		037434
Collet	16		037435
Collet	18		037436
Collet	20		037437
Collet	25		037438
Collet	6,35 (1/4")		037495
Collet	9,53 (3/8")		037505
Collet	12,7 (1/2")		037496
Collet	15,88 (5/8")		037502
Collet	19,05 (3/4")		037497
Collet	25,4 (1")		037508
Data chip Balluff		HSK-F 63	081309

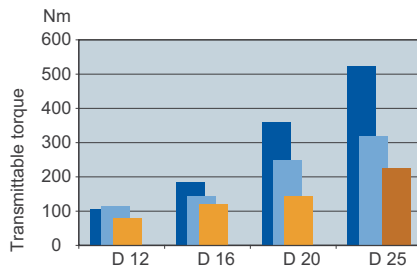
- available ex stock
- available at short notice

2. Cutting tools with shank

2.6 Clamping Systems

Shrink-fit chuck ThermoGrip®

See
Leitz-Lexicon



- ThermoGrip shrink-fit chuck
- Collet DIN 6388-B25, 75 Nm Tightening torque
- Collet DIN 6499-B32 (ER32), 75 Nm Tightening torque
- Hydro clamping chuck

The metric dimension of collets and hydro-clamping chucks includes shank tolerance g7 or h6.

Leitz ThermoGrip® chucks are designed for clamping diameters $d \leq 10$ mm for a shank tolerance h6, for clamping diameters $d > 10$ mm for a shank tolerance g6.

Tool clamping for high performance. Ideal for HSC-machining as balanced for RPMs up to 30.000 min⁻¹. Short, slim design for improved chip flow and extraction. For tungsten carbide and steel shanks. Clamping eccentricity $e = 0.01$ mm. ThermoGrip has the highest stability and rigidity of all known shank clamping systems.

HSK-F 63 as per DIN 69893 PT 300-0 *

Class.	Fabr. Mach.	DIA mm	d mm	A mm	DB mm	STO	Weight kg	ID No.
*	Homag, IMA,	20	6	75	63	h6	0,8	037713 ●
*	Weeke, MAK,	20	8	75	63	h6	0,8	037714 ●
*	Reichenbacher,	25	10	75	63	h6	0,9	037715 ●
*	SCM, MKM	28	12	75	63	g6	0,9	037712 ●
*		28	14	75	63	g6	0,9	037716 ●
*		28	16	75	63	g6	0,9	037709 ●
*		36	18	75	63	g6	1,0	037718 ●
*		36	20	75	63	g6	1,0	037710 ●
*		36	25	75	63	g6	0,9	037711 ●

HSK-F 63 as per DIN 69893 PT 300-0 * INCH Sizes

Class.	Fabr. Mach.	DIA mm	d inch	A mm	DB mm	STO	Weight kg	ID No.
*	Homag, IMA,	20	1/4"	75	63	h6	0,8	n./a. ●
*	Weeke, MAK,	25	3/8"	75	63	h6	0,8	n./a. ●
*	Reichenbacher,	34	1/2"	75	63	h6	0,9	130050520 ●
*	SCM, MKM	42	3/4"	75	63	g6	0,9	130052329 ●

SK30, DIN 69871 PT 301-0 *

Class.	Fabr. Mach.	DIA mm	d mm	A mm	Length adj. mm	STO	Weight kg	ID No.
*	MAKA, Weeke	34	12	70	7	g6	0,7	670200 □
*	Reichenbacher	34	16	70	7	g6	0,7	670201 □
*	Reichenbacher	42	20	70	7	g6	0,8	670202 □
*	Reichenbacher	42	25	80	7	g6	1,0	670210 □

Class.	Fabr. Mach.	DIA mm	d mm	A mm	Length adj. mm	STO	Weight kg	ID No.
*	Biesse	34	12	70	7	g6	0,7	670203 □
*	from 9/92	34	16	70	7	g6	0,7	670204 □
*	from 9/92	42	20	70	7	g6	0,8	670205 □
*	from 9/92	42	25	80	7	g6	1,0	670211 □

SK40, DIN 69871 PT 301-0 *

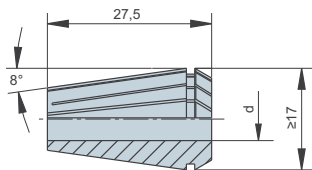
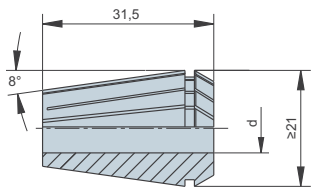
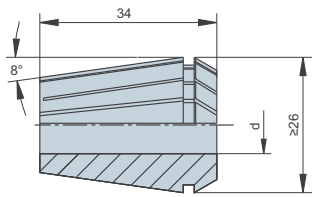
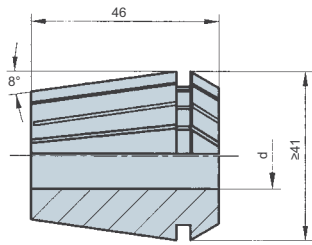
Class.	Fabr. Mach.	DIA mm	d mm	A mm	Length adj. mm	STO	Weight kg	ID No.
*	MAKA, HOMAG,	34	12	70	7	g6	1,1	670206 □
*	Reichenbacher,	34	16	70	7	g6	1,1	670207 □
*	IMA, SCM	42	20	70	7	g6	1,2	670208 □
*		42	25	80	7	g6	1,2	670209 □

- available ex stock
- available at short notice

2. Cutting tools with shank

Cross-collet reference chart

Collet Cross-Reference



DIA	ER 16	ER 20	ER 25	EOC 16	ER 32	ER 40	SYOZ25 RDO35
3mm	x	x	x		x	x	
4mm	x	x	x		x	x	
5mm	x	x	x	37473	x	x	
6mm	37972	37975	37979	37475	37439	37926	37429
8mm	37973	37976	37980	37476	37440	37927	37430
9mm	x	x	x	37477	x	x	
9,5mm				37479			
10mm	37974	37977	37981	37480	37441	37928	37431
11mm		x	x	37481		x	
12mm		37978	37982	37483	37442	37929	37432
13mm		x	37983	37485	37443	x	37433
14mm				37486	37444	37930	37434
16mm			37984		37445	37931	37435
18mm					37446	x	37436
20mm					37447	37932	37437
25mm						37933	37438
1/16"	x						
1/8"	x	x	x	x	x	x	x
3/16"	x	x	x	x	x	x	x
1/4"	x	x	x	37474	37509	37934	37495
5/16"	x	x	x	x	x	x	x
3/8"	x	x	x	37478	37510	37935	37505
7/16"	x	x	x	x	x	x	x
1/2"		x	x	37482	37511	37936	37496
9/16"			x	x	x	x	x
5/8"			x	x	37507	37937	37502
3/4"					37506	37938	37497
1"						37939	37508
Wrench	5516	5517	5518	5469	5491	5458	5458
Collet Sizes (Diameter / Length (OAL))	17/27,5	21/31,5	26/34	25,5/40	33/40	41/46	20/34 35,05/52

Style	DIA	Length
ER 16	17	27,5
ER 20	21	31,5
ER 25	26	34
EOC 16	25,5	40
ER 32	33	40
ER 40	41	46
SYOZ/25	35,05	52

- available ex stock
- available at short notice



Notes:



Notes:

3. Drilling

	Selection overview	57
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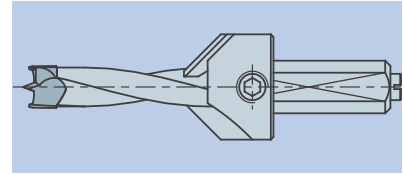
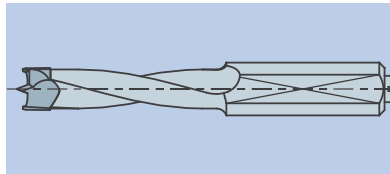
3. Drilling

3.1 General information Dowel drills

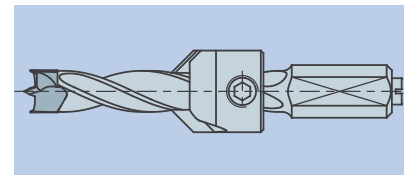
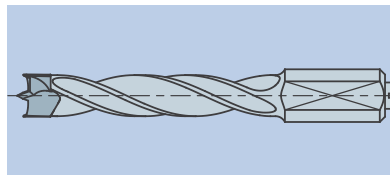
Application	To drill tear-free dowel holes and blind holes.
Workpiece material	Soft and hardwood. Chipboard and fibre materials (chipboard, MDF, HF, etc.), without coating, with plastic coating, with veneer etc. Glulam (plywood, etc.). Thermoplastics.
Machine	Through-feed boring machines, Point-to-point boring machines, CNC-machining centres, Hinge boring machines, Special boring machines.

Design Two designs of dowel drill are available:

1. Design without heel
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.

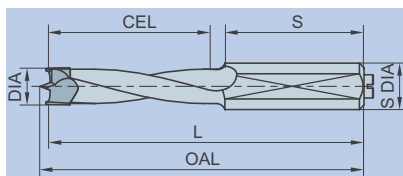


2. Design with heel
Dowel drills with heel are used to bore holes in solid wood and for machines with insufficient guidance during the boring and return stroke. The boring bit is better guided during the exit stroke to prevent tear-outs at the edge of the hole when the boring bit leaves the workpiece. A loose countersink can be clamped on the shank.



Shank Dowel drills usually have a shank diameter $d = 10$ mm. Boring machines with only a small pitch between the boring spindles may use dowel drills with a shank diameter $d = 8$ mm.
Additionally, it is possible to mount the dowel drills directly into the boring spindles with a threaded adaptor. Adaptors are available with different combinations of threads and either cylindrical or tapered seatings.

Technical features The dimensions listed in the tool tables refer to the following tool parameters:



DIA	Hole-diameter.
S DIA	Shank-diameter.
S	Shank length.
CEL	Working length = possible boring depth.
OAL	Total length of the boring bit including the projection of the centre-point.
L	Total length of the boring bit excluding the projection of the centre-point.

3. Drilling

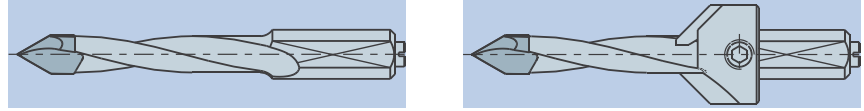
3.1 General information Through-hole drills

Design

Two designs of through-hole drills are available:

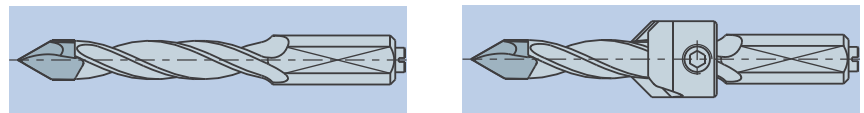
1. Design without heel

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.



2. Design with heel

Dowel drills with heel are used to bore holes in solid wood and for machines with insufficient guidance during the boring and return stroke. The boring bit is better guided during the exit stroke to prevent tear-outs at the edge of the hole when the boring bit leaves the workpiece. A loose countersink can be clamped on the shank.

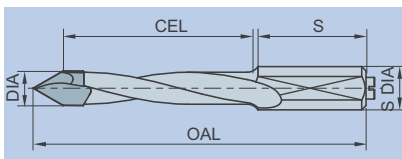


Shank

Through-hole drills usually have a shank diameter $d = 10$ mm. Boring machines with a small pitch between the boring spindles may use drills with a shank diameter $d = 8$ mm.

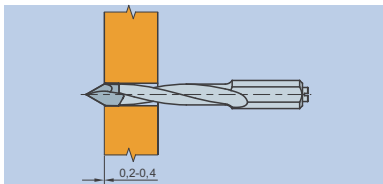
Technical features

The dimensions listed in the tool tables refer to the following tool parameters:



DIA	Hole-diameter.
S DIA	Shank-diameter.
S	Shank length.
CEL	Working length = possible boring depth.
OAL	Total length of the drill to the end of the centre-point.

Application recommendation



The boring quality in brittle or low-adhesive surfaces can be improved if the feed speed is reduced just before the drill breaks through the workpiece.

Leitz dowel drill program

	Standard bit	Marathon bit	Solid carbide bit
Application	Drilling of invisible holes in the craft industry	Drilling in industrial use, visible holes, difficult materials	Drilling in industrial use, visible holes, difficult materials
Design	Steel shank and body, HW-brazed tip, conventional design	Steel shank and body, HW-brazed tip, Marathon desing	HW-drill, heat shrunk shank, Marathon design
Perform. Ratio	1	10	15

3. Drilling

3.1 General information Hinge boring bits

Design

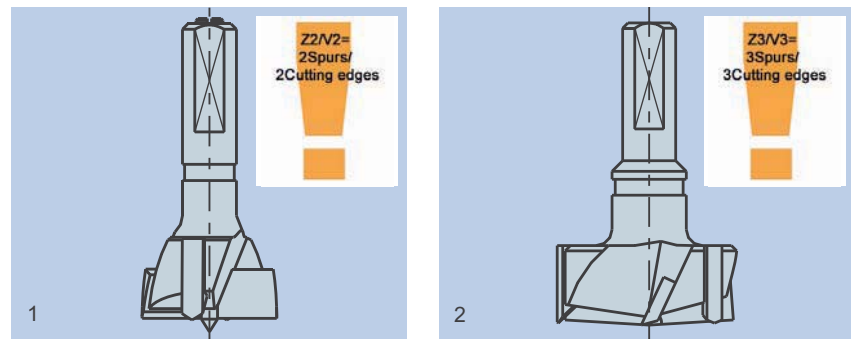
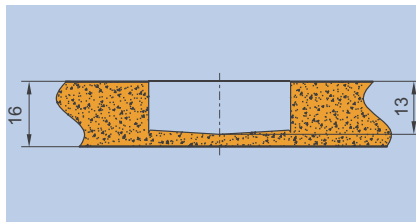
Two designs of hinge boring bits are available:

1. Design with center-point, 2 spurs and 2 spiral cutting edges (Z2/V2).

These boring bits are optimised for machining standard panels in the furniture industry.

2. Design without center-point, 3 spurs and 3 spiral cutting edges ground to a V-point (Z3/V3).

Recommended when there is the risk of the centre-point marking or breaking through the back of the panel e.g. boring a 13 mm deep hole in a 16 mm thick workpieces.



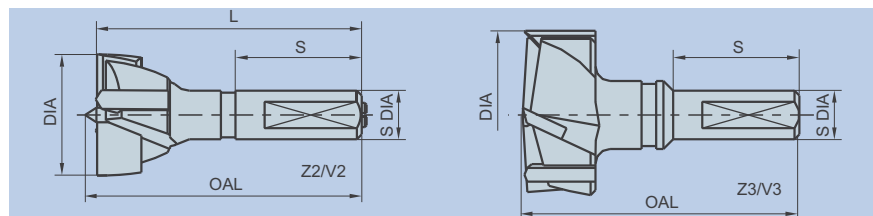
Shank

Hinge boring bits usually have a shank diameter S DIA = 10 mm. Internally threaded shanks are used in hand routing machines with the appropriate spindle adaptors.

Technical features

The dimensions listed in the tool tables refer to the following tool parameters:

DIA	Hole-diameter.
S DIA	Shank-diameter.
S	Shank length.
L	Total length of the hinge boring bit excluding the projection of the centre-point.
OAL	Total length of the hinge boring bit including the projection of the centre-point.



Application Data

RPM feed speeds

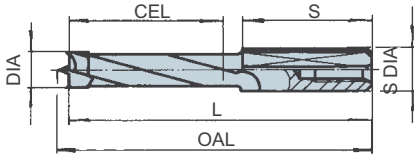
The optimum RPM and feed speeds are detailed in the diagrams attached to the tool tables.

3. Drilling

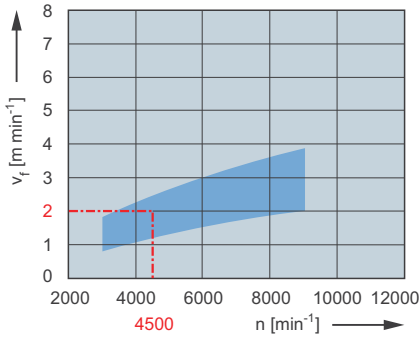
3.2 Dowel drills



No. of teeth: Z2/V2
RPM: n = 3000-9000 min⁻¹



Design without heel



TCT-Dowel boring bit Z2/V2
WB 120-0-xx

Workpiece material:
Chipboard with coating



Operation:
Boring

Correction factor for v_f:
Veneered = 0,8
Paper coated = 0,8
MDF, solid wood = 0,7
Chipboard, without coating = 1,3

Shank 10 mm



See
Leitz-Lexicon

Boring bit designed for machining panels in the furniture industry. Minimal friction and feed forces as the flute has a smaller diameter. A loose countersink can be clamped on the shank WB 701-0-02.

Without heel
WB 120-0-12 *

GL (Total length) = 57,5 mm

Class.	DIA mm	OAL mm	L mm	CEL mm	S mm	ID No. LH	ID No. RH
*	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	033674	● 033675 ●
*	5,2	57,5	56	25	10x27	033676	● 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 ●
*	8,1	57,5	55,5	25	10x27	033684	● 033685 ●
*	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 ●
*	14	57,5	55,5	30	10x22	033694	● 033695 ●
*	15	57,5	55,5	30	10x22	033696	● 033697 ●
*	16	57,5	55,5	30	10x22	033698	● 033699 ●
*	3,18	57,5	56	25	10x27	033700	● 033701 ●
*	6,35	57,5	56	25	10x27	033702	● 033703 ●
*	9,53	57,5	55,5	25	10x27	033704	● 033705 ●
*	12,7	57,5	55,5	25	10x22	033708	● 033709 ●

Without heel
WB 120-0-10 *

GL (Total length) = 70 mm

Class.	DIA mm	OAL mm	L mm	CEL mm	S mm	QAL	ID No. LH	ID No. RH
*	5	70	68	35	10x30	HS	033458	● 033459 ●
*	6	70	68	35	10x30	HS	033460	● 033461 ●
*	8	70	68	35	10x30	HS	033464	● 033465 ●
*	10	70	68	35	10x30	HS	033466	● 033467 ●
*	4	70	68,5	35	10x30	TCT	033476	● 033477 ●
*	5	70	68,5	35	10x30	TCT	033440	● 033441 ●
*	6	70	68,5	35	10x30	TCT	033442	● 033443 ●
*	7	70	68,5	35	10x30	TCT	033444	● 033445 ●
*	8	70	68	35	10x30	TCT	033446	● 033447 ●
*	9	70	68	35	10x30	TCT	033478	● 033479 ●
*	10	70	68	35	10x30	TCT	033448	● 033449 ●
*	11	70	68	35	10x30	TCT	033480	● 033481 ●
*	12	70	68	35	10x30	TCT	033450	● 033451 ●
*	13	70	68	35	10x30	TCT	033452	● 033453 ●
*	14	70	68	35	10x30	TCT	033454	● 033455 ●
*	16	70	67,5	35	10x30	TCT	033456	● 033457 ●

Spare parts

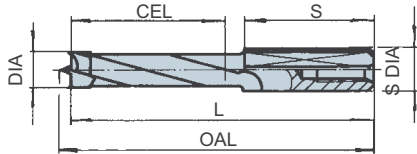
Description	DIM	Remark	ID No.
Screw	M 5x10	Length adjustment	005802 ●

- available ex stock
- available at short notice

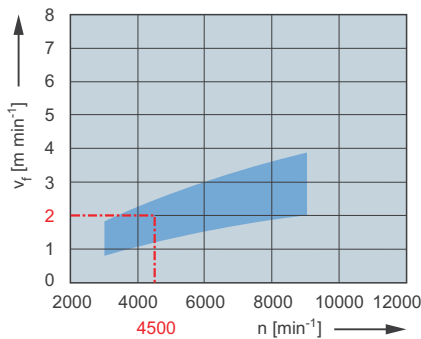




No. of teeth: Z2/V2
RPM: n = 3000-9000 min⁻¹



Design without heel



TCT-Dowel drill, Marathon-design Z2/V2
WB 120-0-29, WB 120-0-30

Workpiece material:
Chipboard with coating



Operation:
Boring

Correction factor for v_f:
Veneered = 0,8
Paper coated = 0,8
MDF, solid wood = 0,7

Marathon-design



Multiple performance compared to standard drills, Z2/V2. The round spur profile with shear cut, suitable for boring tear-free holes at high feed speeds. Ideal for machining panel materials coated with difficult surface coatings (e.g. thin decorative paper). High wear-resistant HW-quality, suitable for hardwood and wooden materials. Excellent chip clearance when deep boring from friction reducing tool body coatings. A loose countersink can be clamped on the shank WB 701-0-02.

Without heel

Shank 10 mm
WB 120-0-29 *

OAL (Total length)= 57,5mm

Class.	DIA mm	OAL mm	L mm	CEL mm	S mm	ID No. LH	ID No. RH
*	4	57,5	56	25	10x27	033714	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

Without heel

Shank 10 mm
WB 120-0-30 *

OAL (Total length) = 70 mm

Class.	DIA mm	OAL mm	L mm	CEL mm	S mm	ID No. LH	ID No. 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

Spare parts

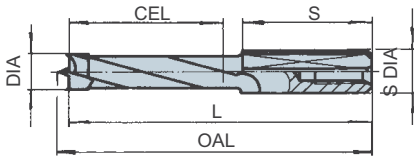
Description	DIM	Remarks	ID No.
Screw	M 5x10	Length adjustment	005802 ●

3. Drilling

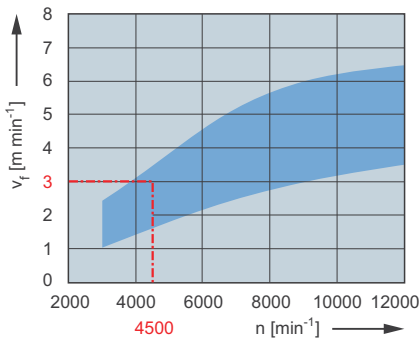
3.2 Dowel drills



No. of teeth: Z2/V2
RPM: n = 3000-12000 min⁻¹



Design without heel



TC-Dowel boring bit Z2/V2
WB 120-0-32, WB 120-0-33

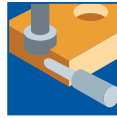
Workpiece material:
Chipboard with coating,
abrasive wood, composites



Operation:
Boring

Correction factor for v_f :
Veneered = 0,8
Paper coated = 0,8
MDF, solid wood = 0,7
Chipboard, without coating = 1,3

Shank 10 mm, solid carbide



See
Leitz-Lexicon

Design Z2/V2 in solid tungsten carbide for extremely large regrinding area and increased feed speed, marathon design grind. Ideal for machining abrasive wood and composite materials as the solid tungsten carbide is more wear-resistant. Z3-design for higher feed speeds than Z2-design.

Without heel

WB 120-0-11 *, WB 130-0-01 **, WB 120-0-32 ***, WB 120-0-33 ****
OAL (Total length) = 57,5 mm / OAL (Total length) = 70 mm

Class.	DIA mm	OAL mm	L mm	CEL mm	S mm	T	ID No. LH	ID No. RH
**	5	57,5	56	25	10x26	3	034124	034125
*	3	57,5	56	16	10x34	2	033610	033611
***	5	57,5	56	25	10x27	2	033728	033729
***	6	57,5	56	25	10x27	2	033730	033731
***	8	57,5	56	25	10x27	2	033732	033733
****	5	70	68,5	35	10x27	2	033496	033497
****	6	70	68,5	35	10x27	2	033498	033499
****	8	70	68,5	35	10x27	2	033500	033501

Spare parts

Description	DIM	Remarks	ID No.
Screw	M 5x10	Length adjustment	005802
Screw for S 10x27	M 5x10	Length adjustment	006378

- available ex stock
- available at short notice

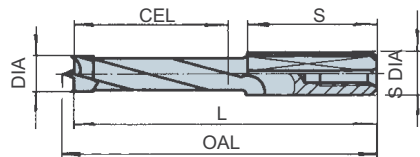


3. Drilling

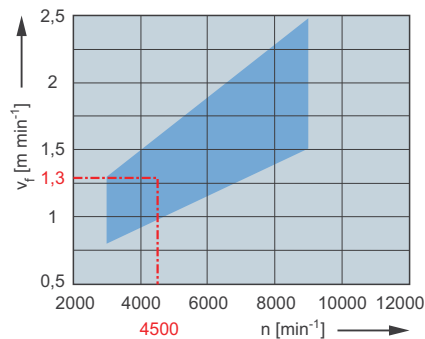
3.3 Through-hole drills



No. of teeth: $Z(=Teeth)2$
 RPM: $n = 3000-9000 \text{ min}^{-1}$



Design without heel



TCT-Through-hole boring bit
WB 101-0-xx

Workpiece material:
 Chipboard with coating

Operation:
 Boring

Correction factor for v_f :
 Veneered = 0,8
 MDF = 0,7
 Chipboard, without coating = 1,3

Shank 10 mm, without heel



Optimised boring bit for machining panels in the furniture industry. Minimal friction and feed forces as the flute has a smaller diameter. A loose countersink can be clamped on the shank WB 701-0-02.

Without heel
WB 101-0-02 *

OAL (Total length) = 57,5 mm

Class.	DIA mm	OAL mm	CEL mm	S mm	ID No. LH	ID No. RH
*	5	57,5	25	10x24	034000	● 034001 ●
*	5,1	57,5	25	10x24	034004	● 034005 ●
*	6	57,5	25	10x24	034008	● 034009 ●
*	8	57,5	25	10x24	034002	● 034003 ●

Without heel
WB 101-0-07 *

OAL (Total length) = 70mm

Class.	DIA mm	OAL mm	CEL mm	S mm	ID No. LH	ID No. RH
*	5	70	35	10x24	034074	● 034075 ●
*	8	70	35	10x24	034076	● 034077 ●

Without heel
WB 101-0-03 *

OAL (Total length) = 77 mm

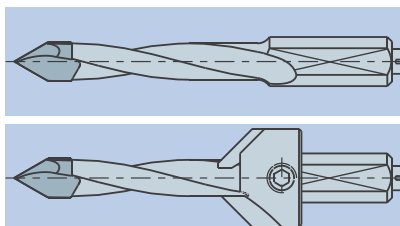
Class.	DIA mm	OAL mm	CEL mm	S mm	ID No. LH	ID No. RH
*	5	77	44	10x24	034060	● 034061 ●
*	6	77	44	10x24	034068	● 034069 ●
*	8	77	44	10x24	034062	● 034063 ●
*	10	77	44	10x24	034070	● 034071 ●
*	12	77	44	10x24	034072	● 034073 ●

Spare parts

Descriptions	DIM	Remarks	ID No.
Screw	M 5x10	Length adjustment	005802 ●

Design without heel

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.



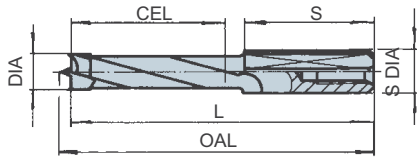
- available ex stock
- available at short notice

3. Drilling

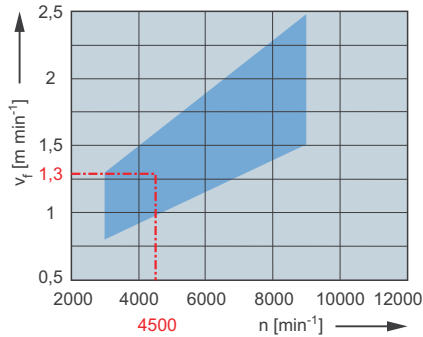
3.3 Through-hole drills



No. of teeth: $Z(=Teeth)2$
 RPM: $n = 3000-9000 \text{ min}^{-1}$



Design with heel



TCT-Through-hole boring bit
WB 101-0-xx

Workpiece material:
 Chipboard with coating

Operation:
 Boring

Correction factor for v_f :
 Veneered = 0,8
 MDF = 0,7
 Chipboard, without coating = 1,3

Shank 10 mm



See
 Leitz-Lexicon

Optimised boring bit when there is insufficient spindle guide (by centering the boring bit during the exit stroke to prevent tear-outs at the edge of the hole when the boring bit leaves the workpiece) and for machining hard and softwood. A loose countersink can be clamped on the shank WB 701-0-03.

With heel
WB 101-0-05 *

OAL (Total length) = 57,5 mm

Class.	DIA mm	OAL mm	CEL mm	S mm	ID No. LH	ID No. RH
*	5	57,5	25	10x24	042630	● 042631 ●
*	5,1	57,5	25	10x24	042632	● 042633 ●
*	6	57,5	25	10x24	042636	● 042637 ●
*	8	57,5	25	10x24	042638	● 042639 ●

With heel
WB 101-0-06 *

OAL (Total length) = 77 mm

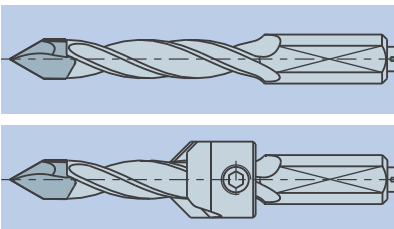
Class.	DIA mm	OAL mm	CEL mm	S mm	ID No. LH	ID No. RH
*	5	77	44	10x24	042640	● 042641 ●
*	5,1	77	44	10x24	042642	● 042643 ●
*	5,2	77	44	10x24	042644	● 042645 ●
*	6	77	44	10x24	042646	● 042647 ●
*	8	77	44	10x24	042648	● 042649 ●
*	10	77	44	10x24	042650	● 042651 ●
*	12	77	44	10x24	042652	● 042653 ●

Spare parts

Description	DIM	Remarks	ID No.
Screw	M 5x10	Length adjustment	005802 ●

Design with heel

Dowel drills with heel are used to bore holes in solid wood and for machines with insufficient guidance during the boring and return stroke. The boring bit is better guided during the exit stroke to prevent tear-outs at the edge of the hole when the boring bit leaves the workpiece. A loose countersink can be clamped on the shank.

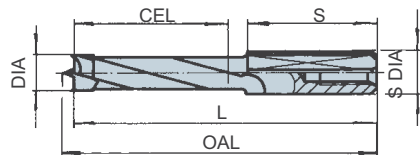


- available ex stock
- available at short notice

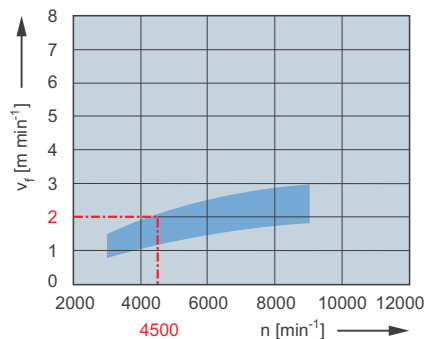




No. of teeth: $Z=(\text{Teeth})^2$
 RPM: $n = 3000-9000 \text{ min}^{-1}$
 (recommended
 $n = 4500-9000 \text{ min}^{-1}$)

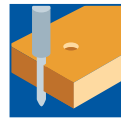


Design without heel



No. of teeth: $Z=(\text{Teeth})^2$
 RPM: $n = 3000-12000 \text{ min}^{-1}$

Marathon-design, shank 10 mm



See
Leitz-Lexicon

Marathon-design for higher performance time and better cut quality compared to standard design. Special V-point-ground with 2 bevels. Shank 10 mm, Z2, OAL = 57,5 mm or 70 mm.

WB 101-0-10 * OAL (Total length) = 57,5 mm

Class.	DIA mm	OAL mm	CEL mm	S mm	ID No. LH	ID No. RH
*	5	57,5	25	10x25	033960 ●	033961 ●
*	8	57,5	25	10x25	033962 ●	033963 ●

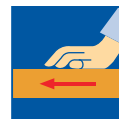
WB 101-0-10 * OAL (Total length) = 70 mm

Class.	DIA mm	OAL mm	CEL mm	S mm	ID No. LH	ID No. RH
*	5	70	35	10x25	033964 ●	033965 ●
*	8	70	35	10x25	033966 ●	033967 ●

Spare parts

Descriptions	DIM	Remarks	ID No.
Screw	M 5x10	Length adjustment	005802 ●

Solid tungsten carbide, shank 10 mm



See
Leitz-Lexicon

Design in solid tungsten carbide for extremely large regrinding area and increased feed speed, marathon design grind. Ideal for machining abrasive wood and composite materials as the solid tungsten carbide quality is wear-resistant.

Without heel

WB 101-0-02 *, WB 101-0-07**

OAL (Total length) = 57,5 mm / OAL (Total length) = 70 mm

Class.	DIA mm	OAL mm	CEL mm	S mm	T	ID No. LH	ID No. RH
*	5	57,5	25	10x27	2	034018 ●	034019 ●
*	6	57,5	25	10x27	2	034020 ●	034021 ●
*	8	57,5	25	10x27	2	034022 ●	034023 ●
**	5	70	25	10x27	2	034100 ●	034101 ●
**	6	70	25	10x27	2	034102 ●	034103 ●
**	8	70	25	10x27	2	034104 ●	034105 ●

Spare parts

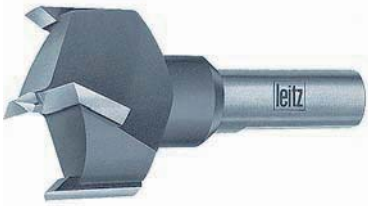
Description	DIM	Remarks	ID No.
Screw	M 5x8	Length adjustment	006378 ●



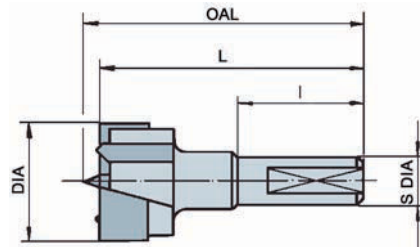
- available ex stock
- available at short notice

3. Drilling

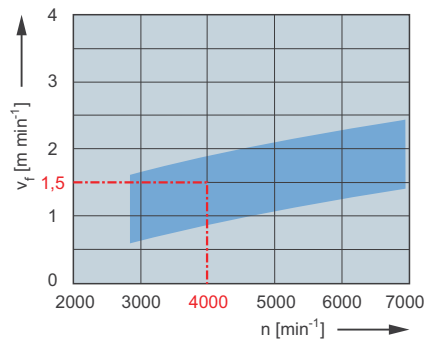
3.4 Hinge boring bits



No. of teeth: Z2/V2
RPM: n = 2800-7000 min⁻¹



Z2, V2 with centre-point, projection 2,5 mm past cutting edge



HW-Hinge boring bit Z2/V2
WB 310-0-04

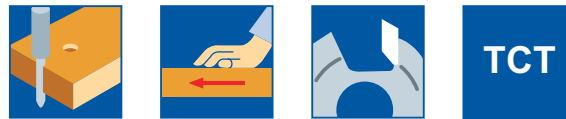
Workpiece material:
 Chipboard with coating



Operation:
 Boring

Correction factor for v_f:
 Veneered = 0,8
 Paper coated = 0,8
 MDF, solid wood = 0,7

Drill HW, Z2 / V2



Design Z2/V2, OAL = 57 mm. Ideal for solid wood because of the projecting centre-point.

WB 310-0-04 *

OAL (Total length) = 57 mm

Class.	DIA mm	OAL mm	L mm	S mm	ID No. LL	ID No. RL
*	15	57	54,5	10x26	034630	034631
*	16	57	54,5	10x26	034632	034633
*	18	57	54,5	10x26	034634	034635
*	20	57	54,5	10x26	034636	034637
*	22	57	54,5	10x26	034638	034639
*	24	57	54,5	10x26	034640	034641
*	25	57	54,5	10x26	034642	034643
*	26	57	54,5	10x26	034644	034645
*	28	57	54,5	10x26	034646	034647
*	30	57	54,5	10x26	034648	034649
*	35	57	54,5	10x26	034650	034651
*	40	57	54,5	10x26		034677

Design Z2/V2, OAL = 70 mm. Ideal for solid wood because of the projecting centre-point.

WB 310-0-04 *

OAL (Total length) = 70 mm

Class.	DIA mm	OAL mm	L mm	S mm	ID No. LH	ID No. RH
*	15	70	68	10x26	034663	034664
*	18	70	68	10x26		034678
*	20	70	68	10x26	034665	034666
*	24	70	68	10x26		034679
*	25	70	68	10x26	034667	034668
*	30	70	68	10x26	034669	034670
*	35	70	68	10x26	034671	034672

Spare parts

Descriptions	DIM	Remarks	ID No.
Screw	M 5x10	Length adjustment	005802

- available ex stock
- available at short notice

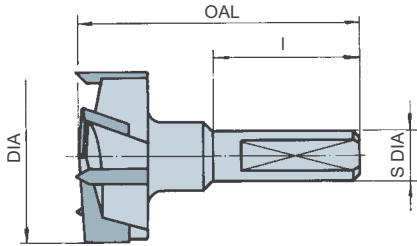


3. Drilling

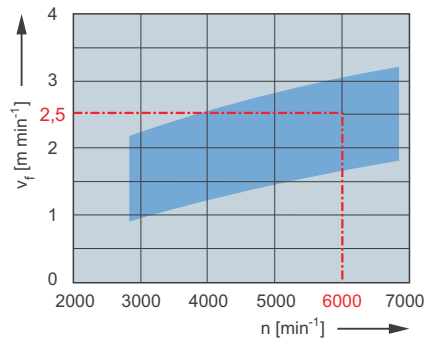
3.4 Hinge boring bits



No. of teeth: Z3/V3
RPM: $n = 2800-7000 \text{ min}^{-1}$



Z 3, V 3 with V-shaped cutting edge, without centre-point



Z3/V3 =
3Spurs/
3Cutting edges

Drill HW, Z3 / V3



See
Leitz-Lexicon

Design Z3/V3, OAL = 57 mm. For high feeds compared to Z2/V2. Design without projecting centre-point. For boring workpieces near the bottom surface layer without marking or piercing the surface. Not suitable for solid wood.

WB 322-0 *

OAL (Total length) = 57 mm

Class.	DIA mm	OAL mm	L mm	ID No.	
				LH	RH
*	25	57	10x26	034750 ●	034751 ●
*	26	57	10x26		034753 ●
*	30	57	10x26		034755 ●
*	34	57	10x26		034757 ●
*	35	57	10x26	034758 ●	034759 ●
*	38	57	10x26		034761 ●
*	40	57	10x26		034763 ●

Spare parts

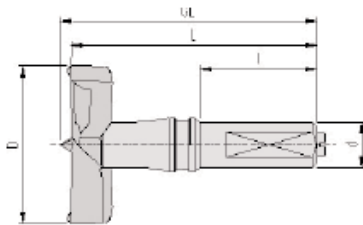
Description	DIM	Remarks	ID No.
Screw	M 5x10	Length adjustment	005802 ●

3. Drilling

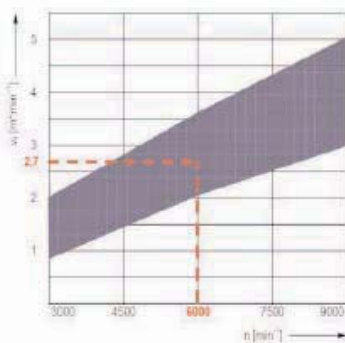
3.4 Hinge boring bits



Number of teeth: Z2/V2
RPM: n = 3000-9000 min⁻¹



Z2/V2 with centre point



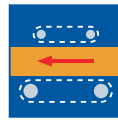
**Hinge boring bit - solid carbide Z2/V2
 WB 310-0-04**

Material:
 Plastic coated chipboard

Operation:
 Boring

Correction factor for v_f:
 veneered = 0,8
 paper coated = 0,8
 MDF, solid wood = 0,7
 chipboard without coating = 1,3

High performance hinge boring bit - solid carbide



See
 Leitz-Lexicon

Optimised for boring coated chip- and fibreboards. Ideal for machining solid wood due to spurs with an extreme shear cut. Significant improvement of quality and performance compared to brazed tip design.

WB 310-0 04
OAL (Total length) = 57 mm and 70 mm

Class.	DIA mm	OAL mm	S mm	ID No.		
				LH	RH	
*	15	57	10x26	34800	34801	●
*	20	57	10x26	34802	34803	●
*	25	57	10x26	34804	34805	●
*	30	57	10x26	34808	34809	●
*	35	57	10x26	34810	34811	●
*	15	70	10x26	34812	34813	●
*	20	70	10x26	34814	34815	●
*	25	70	10x26	34816	34817	●
*	30	70	10x26	34820	34821	●
*	35	70	10x26	34822	34823	●

Spare parts

Descriptions	DIM	Remarks	ID No.	
screw	M 5x10	length adjustment	005802	●

Advantages compared to standard design:

Wear resistant carbide

- 2 to 3 times better performance
- rugged during application even under extreme conditions

Marathon geometry

- better cutting edges
- lower feed forces
- 30 % higher feed speeds

Open construction

- better chip clearance

Service friendly

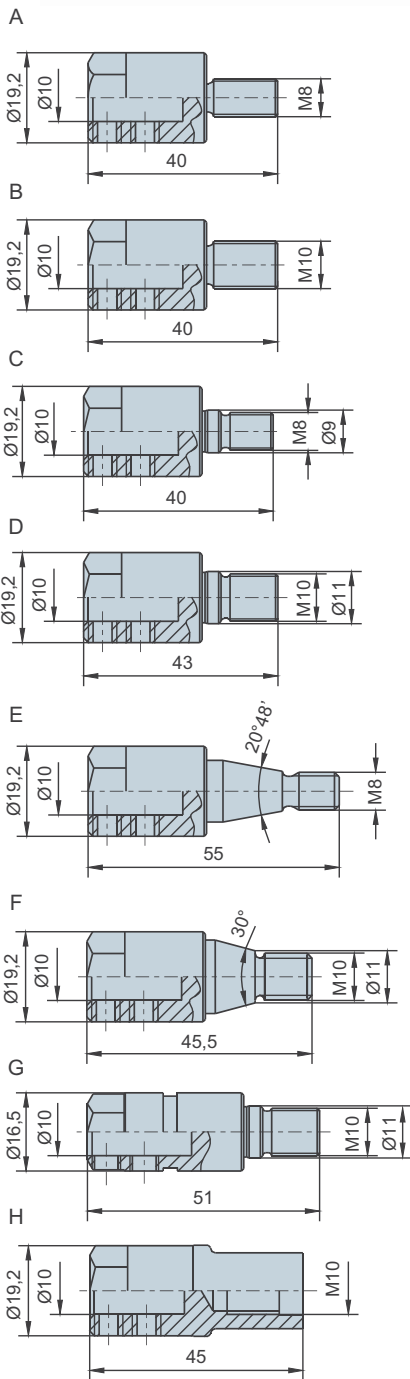
- spur and cutting edge can be sharpened in one step
- 6x resharpenable

- available ex stock
- available at short notice



Conventional bore clamping systems

Precise clamping from two clamping screws with ring shaped, notched pressure zone. Smallest possible pitch with 10 mm shanks – 21 mm. For smaller pitches use 8 mm shank adaptors.



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 *****

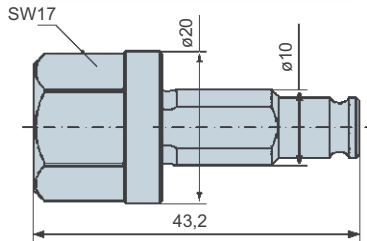
Class.	Machine	OAL mm	S	ID No. LH	ID No. RH
*	Lehbrink, Nottmeyer (new machine type)	40	C	033080	033081
**	Lehbrink, Nottmeyer (new machine type)	52	C	033082	033083
***	Bilek, Knoevenagel	55	E	033084	033085
****	Alberti, Balestrini, Biesse Böttcher & Gessner Busellato, Goma, Grotefeld Hüllhorst, Holz-Her, Koch Morbidelli, Reimall, Torwegge Vitap (after year 4/91), Weeke	43	D	033086	033087
****	Nottmeyer (old machine type)	40	A	033088	033089
*****	Alberti, Balestrini, Bilek Busellato, Dubus, Goma Grotefeld, Ompec, Reimall SCM, Schleicher, Tanzani Viciani, Vitap (before year 4/91) Weingärtner	45,5	F	033090	033091
*****	Ayen, Brandt, Holzma Knoevenagel Mayer Reichenbacher Torwegge Zubiola	40	B	033092	033093
*****	Morbidelli	51	G	033094	033095
*****	Scheer	45	H	033096	033097

Spare parts

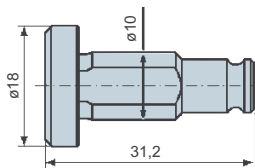
Description	DIM	ID No.
Key	SW3	005433
Screw	M 6x5	005836

- available ex stock
- available at short notice

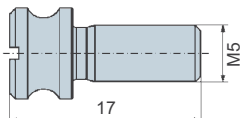




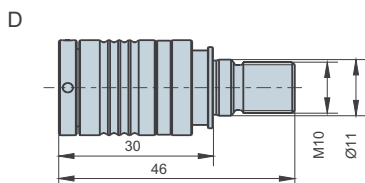
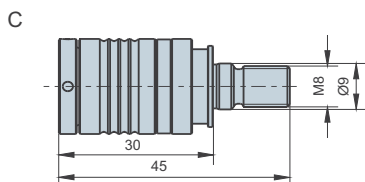
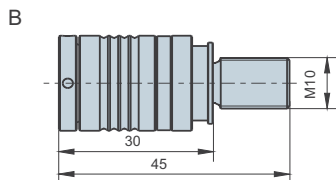
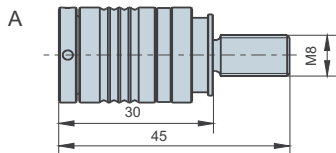
Fitting tool



Dust cover



Clamping + adjusting screw



Quick-change drill adaptor

The drills are clamped in the chuck by a special length setting screw (Id. 7408). Quick-change drill adaptors are ideal for quick and individual adjustment of the boring pattern. To protect the empty quick clamping chucks, seal with the dust cover. Note: to work correctly, the shanks need the correct shank and clamping flat tolerances. Only drills from the Leitz-programme guarantee reliability. RPM up to 12000 min⁻¹ (quick-change drill adaptor without drills must be sealed with the dust cover Id. 115521 to prevent unbalance.

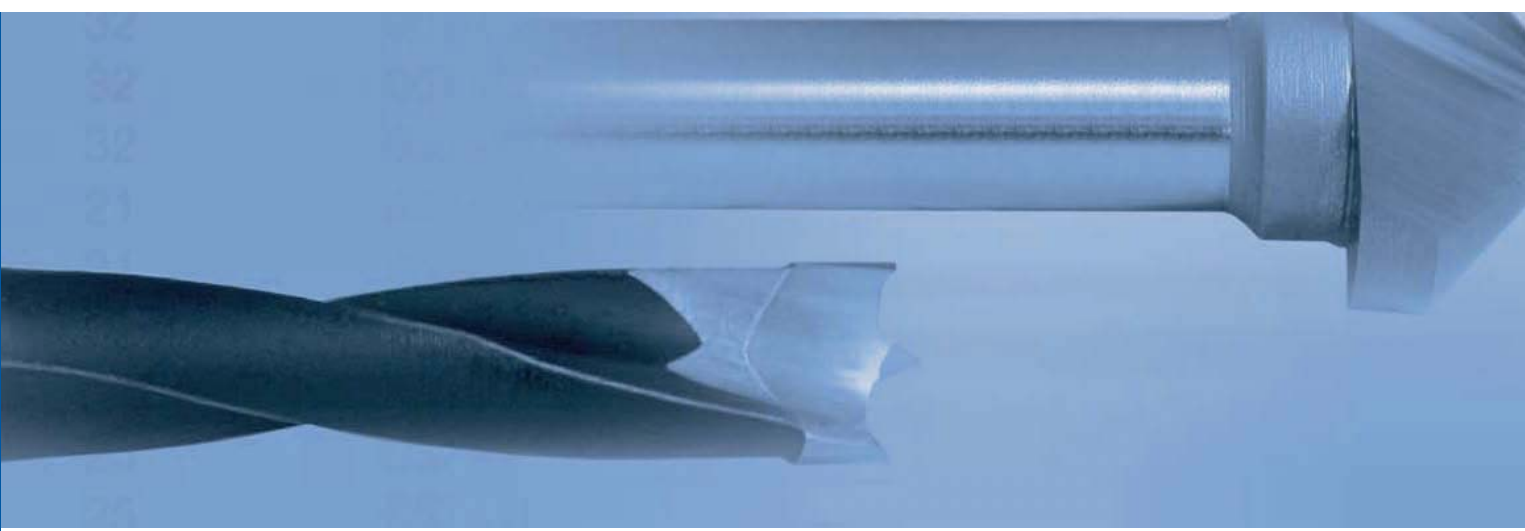
PM 320-0-55 *, **PM 320-0-56 ****, **PM 320-0-57 *****, **PM 320-0-58 ******

Class.	Machine	OAL mm	S	ROT	ID No.	
*	Nottmeyer (new machine type)	45	A	LH	033098	●
*	Nottmeyer (new machine type)	45	A	RL	033099	●
**	Alberti, Balestrini, Biesse Böttcher & Gessner Busellato, Goma, Grotefeld Hüllhorst, Holz-Her, Koch Morbidelli, Reimall, Torwegge Vitap (after year 4/91), Weeke	46	D	LH	033100	●
**	Alberti, Balestrini, Biesse Böttcher & Gessner Busellato, Goma, Grotefeld Hüllhorst, Holz-Her, Koch Morbidelli, Reimall, Torwegge Vitap (after year 4/91), Weeke	46	D	RH	033101	●
***	Lehbrink, Nottmeyer (old machine type)	45	C	LH	033102	●
***	Lehbrink, Nottmeyer (old machine type)	45	C	RH	033103	●
****	Ayen, Brandt, Holzma Knoevenagel Mayer Reichenbacher Torwegge Zubiola	45	B	LH	033104	●
****	Ayen, Brandt, Holzma Knoevenagel Mayer Reichenbacher Torwegge Zubiola	45	B	RH	033105	●

Accessories

Description	DIM	ID No.	
Fitting tool	d10/D20/L43,2/SW17	115522	●
Dust cover	d10/D18/L31,2	115521	●
Clamping + adjusting screw	M 5x17	007408	●

- available ex stock
- available at short notice



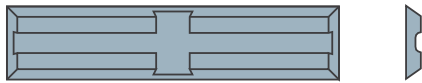
Notes:

4. Knives

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4.5	Spurs and turnblade knives	94

4. Knives

4.1 Insert knives for cutterheads and router cutters



Turnblade knife for router cutter WL 100-1

Workpiece material:
Soft and hardwood

Cutting material:
TC

Knife height up to 5,5 mm

See
Leitz-Lexicon

Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.	
*	20	4,1	1,1	WL 100-1	TC	10	005186	●
*	20	5,5	1,1	WL 100-1	TC	10	005187	●
*	25	5,5	1,1	WL 100-1	TC	10	005188	●
*	30	5,5	1,1	WL 100-1	TC	10	005189	●
*	40	5,5	1,1	WL 100-1	TC	10	005190	●
*	50	5,5	1,1	WL 100-1	TC	10	005191	●



Turnblade knife TC

Workpiece material:
Soft and hardwood

Cutting material:
TC fine grain quality (=TC-F)

Knife height 8 mm

Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.	
*	7,7	8	1,5	WP 8/8	TC-F	10	005068	●
*	9,7	8	1,5	WP 8/10	TC-F	10	005197	●
*	11,7	8	1,5	WP 8/12	TC-F	10	005069	●
*	14,7	8	1,5	WP 8/15	TC-F	10	005070	●
*	19,7	8	1,5	WP 8/20	TC-F	10	005071	●
*	25	8	1,5	WP 8/25	TC-F	10	005198	●
*	30	8	1,5	WP 8/30	TC-F	10	005072	●
*	35	8	1,5	WP 8/35	TC-F	10	005073	●
*	40	8	1,5	WP 8/40	TC-F	10	005074	●
*	45	8	1,5	WP 8/45	TC-F		007679	□
*	50	8	1,5	WP 8/50	TC-F	10	005075	●
*	60	8	1,5	WP 8/60	TC-F	10	005076	●
*	70	8	1,5	WP 8/70	TC-F		007680	□
*	80	8	1,5	WP 8/80	TC-F	10	005077	●
*	100	8	1,5	WP 8/100	TC-F		005184	●
*	120	8	1,5	WP 8/120	TC-F		005185	●



Turnblade knife TC

Workpiece material:
Soft and hardwood

Recommendation:
Cutting edges with Microfinish for high surface quality and cutting efficiency

Cutting material:
TC fine grain quality (=TC-F)

Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.	
*	7,7	8	1,5	WP 8/8 MF	TC-F	10	007517	●
*	9,7	8	1,5	WP 8/10 MF	TC-F	10	007518	●
*	11,7	8	1,5	WP 8/12 MF	TC-F	10	007519	●
*	14,7	8	1,5	WP 8/15 MF	TC-F	10	007520	●
*	19,7	8	1,5	WP 8/20 MF	TC-F	10	007521	●
*	25	8	1,5	WP 8/25 MF	TC-F	10	007522	●
*	30	8	1,5	WP 8/30 MF	TC-F	10	007523	●
*	35	8	1,5	WP 8/35 MF	TC-F	10	007524	●
*	40	8	1,5	WP 8/40 MF	TC-F	10	007525	●
*	45	8	1,5	WP 8/45 MF	TC-F		007683	□
*	50	8	1,5	WP 8/50 MF	TC-F		007526	●
*	60	8	1,5	WP 8/60 MF	TC-F		007527	●
*	70	8	1,5	WP 8/70 MF	TC-F		007684	□
*	80	8	1,5	WP 8/80 MF	TC-F		007528	●
*	100	8	1,5	WP 8/100 MF	TC-F		007529	●
*	120	8	1,5	WP 8/120 MF	TC-F		007530	●

PU = Packaging Unit

4. Knives

4.1 Insert knives for cutterheads and router cutters



Turnblade knife TC

Workpiece material:

For abrasive timber products and plastics

Cutting material:

TC

Knife height 8 mm

See
Leitz-Lexicon

Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.	
*	7,7	8	1,5	WP 8/8 B	TC	10	005053	●
*	9,7	8	1,5	WP 8/10 B	TC	10	005054	●
*	11,7	8	1,5	WP 8/12 B	TC	10	005055	●
*	14,7	8	1,5	WP 8/15 B	TC	10	005056	●
*	19,7	8	1,5	WP 8/20 B	TC	10	005057	●
*	25	8	1,5	WP 8/25 B	TC	10	005058	●
*	30	8	1,5	WP 8/30 B	TC	10	005059	●
*	35	8	1,5	WP 8/35 B	TC	10	005400	●
*	40	8	1,5	WP 8/40 B	TC	10	005401	●
*	45	8	1,5	WP 8/45 B	TC		007681	●
*	50	8	1,5	WP 8/50 B	TC	10	005402	●
*	60	8	1,5	WP 8/60 B	TC	10	005403	●
*	70	8	1,5	WP 8/70 B	TC		007682	●
*	80	8	1,5	WP 8/80 B	TC		005404	●
*	100	8	1,5	WP 8/100 B	TC		005405	●
*	120	8	1,5	WP 8/120 B	TC		005406	●



Turnblade knife TC

Workpiece material:

For abrasive timber products and plastics

Recommendation:

Cutting edges with Microfinish for high surface quality and cutting efficiency

Cutting material:

TC UF-Ultra-fine grain quality (=TC-UF)

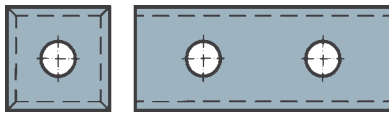
Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.	
*	19,7	8	1,5	WP 8/20 D	TC-UF	10	601001	●
*	30	8	1,5	WP 8/30 D	TC-UF	10	601002	●
*	40	8	1,5	WP 8/40 D	TC-UF	10	601003	●
*	50	8	1,5	WP 8/50 D	TC-UF	10	601004	●

PU = Packaging Unit

- available ex stock
- available at short notice

4. Knives

4.1 Insert knives for cutterheads and router cutters



Turnblade knife

Workpiece material:

Solid woods, timber products

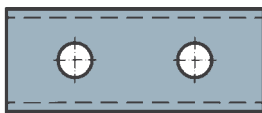
Cutting material:

TC

Knife height 12 mm

See
Leitz-Lexicon

Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.	
*	7,5	12	1,5	WP 12/7,5	TC	10	005080	●
*	9	12	1,5	WP 12/9	TC	10	005158	●
*	12	12	1,5	WP 12/12	TC	10	005081	●
*	15	12	1,5	WP 12/15	TC	10	005082	●
*	20	12	1,5	WP 12/20	TC	10	005083	●
*	30	12	1,5	WP 12/30	TC	10	005084	●
*	40	12	1,5	WP 12/40	TC	10	005085	●
*	50	12	1,5	WP 12/50	TC	10	005086	●
*	60	12	1,5	WP 12/60	TC	10	005087	●



Turnblade knife

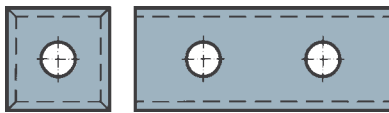
Workpiece material:

For abrasive timber products and plastics

Cutting material:

TC fine grain quality (=TC-F)

Class.	CEL mm	W mm	Thickn. mm	QAL	PU pieces	ID No.	
*	20	12	1,5	TC-F	10	006904	●
*	30	12	1,5	TC-F	10	006905	●
*	50	12	1,5	TC-F	10	006906	●



Turnblade knife

Workpiece material:

For abrasive timber products and plastics

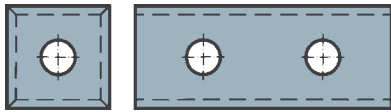
Cutting material:

TC ultra fine grain quality (=TC-UF)

Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.	
*	12	12	1,5	WB 12/12 D TC-UF		10	602000	●
*	20	12	1,5	WP 12/20 D TC-UF		10	602001	●
*	30	12	1,5	WP 12/30 D TC-UF		10	602002	●
*	40	12	1,5	WP 12/40 D TC-UF		10	602003	●
*	50	12	1,5	WP 12/50 D TC-UF		10	602004	●

4. Knives

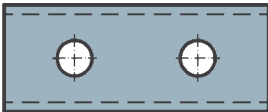
4.1 Insert knives for cutterheads and router cutters



Turnblade knife, sharpened 4-edges

Workpiece material:
Solid woods, timber products

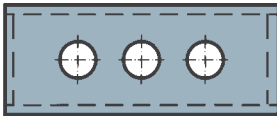
Cutting material:
TC



Turnblade knife, sharpened 4-edges

Workpiece material:
For extremely abrasive timber products and plastics

Cutting material:
TC UF-ultra fine grain quality (=TC-UF)



Turnblade knife, sharpened 4-edges and 3 holes

Workpiece material:
TC for Solid woods, timber products
TC-UF for extremely abrasive timber products and plastics

Cutting material:
TC/TC-UF
TC UF-ultra fine grain quality (=TC-UF)

Knife height 12 mm (sharpened 4-edges)

See
Leitz-Lexicon

Class.	CEL mm	W mm	Thickn. mm	QAL	PU Pieces	ID No.	
*	30	12	1,5	TC	10	005161	●
*	50	12	1,5	TC	10	006506	●

PU = Packaging Unit

Class.	CEL mm	W mm	Thickn. mm	QAL	PU pieces	ID No.	
*	30	12	1,5	TC-UF	10	602005	●
*	50	12	1,5	TC-UF	10	602006	●

PU = Packaging Unit

Class.	SB mm	H mm	DIK mm	QAL	VE pieces	ID No.	
*	50	12	1,7	TC	10	007668	●
*	50	12	1,5	TC-UF	10	602007	●

PU = Packaging Unit

- available ex stock
- available at short notice

4. Knives

4.2 Planer knives

Cutting material recommendation	ST tipped
Solid wood dry	◆
Solid wood wet	◆
Hardwood dry	◆
Hardwood wet	◆
Glulam	
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	
WPC (Wood-Plastic-Compounds)	

◆ suitable ◆ partly suitable



Cross section of planing knife

Cutting material:
ST (Stellite)

Cutting material recommendation	HS
Solid wood dry	◆
Solid wood wet	◆
Hardwood dry	◆
Hardwood wet	◆
Glulam	
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	◆
WPC (Wood-Plastic-Compounds)	◆

◆ suitable ◆ partly suitable



Cross section of planing knife

Wedge angle:
40°

Cutting material:
HS

Knife height 30 mm, ST

See
Leitz-Lexicon

Class.	CEL mm	W mm	Thickn.	QAL	ID No.	
*	60	30	3	ST	027181	●
*	80	30	3	ST	027182	□
*	100	30	3	ST	027183	●
*	110	30	3	ST	027184	□
*	120	30	3	ST	027185	□
*	130	30	3	ST	027186	●
*	150	30	3	ST	027187	●
*	170	30	3	ST	027188	●
*	180	30	3	ST	027189	●
*	190	30	3	ST	027193	□
*	210	30	3	ST	027190	●
*	230	30	3	ST	027191	●
*	240	30	3	ST	027194	□
*	260	30	3	ST	027192	●

Knife height 30 mm, HS

See
Leitz-Lexicon

Class.	CEL mm	W mm	Thickn.	QAL	ID No.	
*	60	30	3	HS	027101	●
*	80	30	3	HS	027102	●
*	100	30	3	HS	027103	●
*	120	30	3	HS	027105	●
*	130	30	3	HS	027106	●
*	150	30	3	HS	027107	●
*	170	30	3	HS	027108	●
*	180	30	3	HS	027109	●
*	190	30	3	HS	027144	●
*	210	30	3	HS	027110	●
*	230	30	3	HS	027111	●
*	240	30	3	HS	027134	●
*	260	30	3	HS	027112	●
*	110	30	3	HS	027104	●
*	250	30	3	HS	027161	●
*	270	30	3	HS	027162	●
*	310	30	3	HS	027113	●
*	360	30	3	HS	027114	●
*	400	30	3	HS	027115	●
*	410	30	3	HS	027116	●
*	460	30	3	HS	027130	●
*	500	30	3	HS	027117	●
*	510	30	3	HS	027118	●
*	600	30	3	HS	027119	●
*	610	30	3	HS	027120	●
*	630	30	3	HS	027125	●
*	640	30	3	HS	027121	●
*	710	30	3	HS	027122	●
*	810	30	3	HS	027123	●

- available ex stock
- available at short notice

4. Knives

4.2 Planer knives

Cutting material recommendation	HS Marathon
Solid wood dry	◆
Solid wood wet	◆
Hardwood dry	◆
Hardwood wet	◆
Glulam	◇
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	◆
WPC (Wood-Plastic-Compounds)	◆

◆ suitable ◇ partly suitable



Cross section of planing knife

Wedge angle:

40°

Cutting material:

HS Marathon coated

- New HS knife programme, to meet the demands of planing mills, significantly improved performance over standard HS-knives.
- Significantly improved tool life compared to regular HS-knives, increased productivity and service life.
- Resistance to chemical and abrasive wear; suitable for both wet and dry wood.
- Low friction between chip and cutting edge; smoother cut and better work-piece surfaces.
- Less cleaning required because of reduced resin build-up.
- Sharpening and profiling by existing machines, fixtures and grinding wheels.

Knife height 30 mm, Marathon-Design

See
Leitz-Lexicon

Class.	CEL mm	W mm	Thickn.	QAL	ID No.	
*	60	30	3	HS	605700	●
*	80	30	3	HS	605701	●
*	100	30	3	HS	605702	●
*	110	30	3	HS	605703	●
*	120	30	3	HS	605704	●
*	130	30	3	HS	605705	●
*	150	30	3	HS	605706	●
*	170	30	3	HS	605707	●
*	180	30	3	HS	605708	●
*	190	30	3	HS	605709	●
*	210	30	3	HS	605710	●
*	230	30	3	HS	605711	●
*	240	30	3	HS	605712	●
*	250	30	3	HS	605713	□
*	260	30	3	HS	605714	●
*	270	30	3	HS	605715	●
*	280	30	3	HS	605742	□
*	300	30	3	HS	605743	□
*	310	30	3	HS	605716	●
*	330	30	3	HS	605727	
*	360	30	3	HS	605729	
*	400	30	3	HS	605730	
*	410	30	3	HS	605731	
*	460	30	3	HS	605732	
*	500	30	3	HS	605733	
*	510	30	3	HS	605734	
*	550	30	3	HS	605728	
*	600	30	3	HS	605735	
*	610	30	3	HS	605736	
*	630	30	3	HS	605737	
*	640	30	3	HS	605738	
*	710	30	3	HS	605739	
*	810	30	3	HS	605740	

- available ex stock
- available at short notice

4. Knives

4.2 Planer knives

Cutting material:
TCT

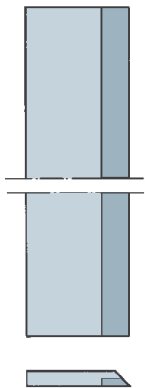
Knife height 30 mm, TCT

See
Leitz-Lexicon

Cutting material recommendation	TC K40 tipped
Solid wood dry	◆
Solid wood wet	
Hardwood dry	◆
Hardwood wet	
Glulam	◆
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	◆
WPC (Wood-Plastic-Compounds)	◆

◆ suitable ◆ partly suitable

Planing knife



Cross section of planing knife

Wedge angle:

40°

Class.	CEL mm	W mm	Thickn. mm	QAL	ID No.	
*	60	30	3	TCT	027277	●
*	80	30	3	TCT	027278	●
*	100	30	3	TCT	027279	●
*	110	30	3	TCT	027280	●
*	120	30	3	TCT	027281	●
*	130	30	3	TCT	027282	●
*	150	30	3	TCT	027283	●
*	170	30	3	TCT	027284	●
*	180	30	3	TCT	027285	●
*	190	30	3	TCT	027322	●
*	210	30	3	TCT	027286	●
*	230	30	3	TCT	027287	●
*	240	30	3	TCT	027323	●
*	260	30	3	TCT	027288	●
*	310	30	3	TCT	027289	●
*	320	30	3	TCT	027290	□
*	330	30	3	TCT	027291	□
*	360	30	3	TCT	027292	●
*	410	30	3	TCT	027293	●
*	450	30	3	TCT	027294	□
*	460	30	3	TCT	027295	●
*	510	30	3	TCT	027296	●
*	610	30	3	TCT	027297	●
*	630	30	3	TCT	027298	●
*	640	30	3	TCT	027299	●
*	710	30	3	TCT	027300	●
*	740	30	3	TCT	027301	□
*	810	30	3	TCT	027302	●

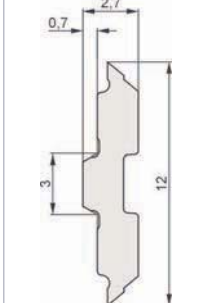
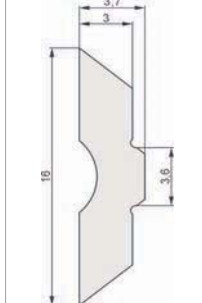
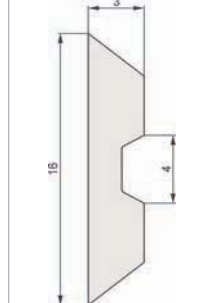
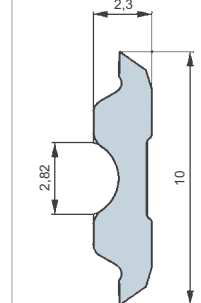
- available ex stock
- available at short notice

Insert knives for various planerhead systems

Cutting material recommendation	Centro Star		VariPlan		CentroLock		Tersa®	
	HS	TC	HS	TC	HS	TC	HS TriTec	TC MicroTec
Solid wood dry	◆		◆		◆		◆	
Solid wood wet			◆		◆		◆	
Hard wood dry		◆		◆		◆		◆
Hard wood wet		◆		◆		◆		◆
Glulam		◆		◆		◆		◆
Chipboard		◆		◆		◆		◆
MDF		◆		◆		◆		◆

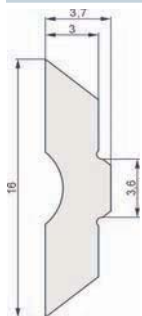
◆ suitable

◆ partly suitable

CentroLock insert knives for Weinig planer head type 530

Cutting material recommendation	HS	TC
Soft wood	◆	
Hard wood	◆	◆
Glued wood		◆
MDF		◆



Turnblade knife CentroLock

Cutting material:
 TC
 HS

To be used for:
 Weinig planer heads Type 530

CEL mm	W mm	Thickn. mm	QAL	ID No.		CEL mm	W mm	Thickn. mm	QAL	ID No.	
20	16	3	HS	613512	●	20	16	3	HW	612512	●
60	16	3	HS	613500	□	60	16	3	HW	612500	□
80	16	3	HS	613513	●	80	16	3	HW	612513	●
100	16	3	HS	613501	●	100	16	3	HW	612501	●
130	16	3	HS	613502	●	130	16	3	HW	612502	●
150	16	3	HS	613503	●	150	16	3	HW	612503	□
170	16	3	HS	613504	●	170	16	3	HW	612504	●
180	16	3	HS	613505	●	180	16	3	HW	612505	□
190	16	3	HS	613506	●	190	16	3	HW	612506	●
230	16	3	HS	613507	●	230	16	3	HW	612507	●
240	16	3	HS	613508	●	240	16	3	HW	612508	●
260	16	3	HS	613509	●	260	16	3	HW	612509	□
270	16	3	HS	613510	●	270	16	3	HW	612510	●
460	16	3	HS	613511	●	460	16	3	HW	612511	●

- available ex stock
- available at short notice

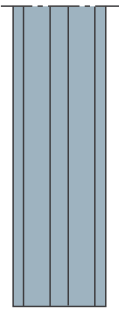


**Turnblade knives for planerhead systems
CentroStar, CentroFix, QuickFix**

See
Leitz-Lexicon

Cutting material recommendation	HS	TC
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Chipboard		◇
MDF		◇
Thermoplastics (PE, PP, PVC, etc.)		
WPC (Wood-Plastic-Compounds)		

◆ suitable ◇ partly suitable



Turnblade knife CentroFix

Cutting material:

HS
TC fine grain quality (=TC-F)

Class.	CEL mm	W mm	Thickn. mm	QAL	PU pieces	ID No.	
**	100	12	2,7	HS	4	610203	●
**	120	12	2,7	HS	4	610204	●
*	124,6	12	2,7	HS	4	610244	●
**	130	12	2,7	HS	4	610205	●
**	136	12	2,7	HS	4	610206	●
**	150	12	2,7	HS	4	610208	●
**	170	12	2,7	HS	4	610210	●
**	180	12	2,7	HS	4	610211	●
**	186	12	2,7	HS	3	610247	●
**	190	12	2,7	HS	4	610212	●
**	210	12	2,7	HS	4	610213	●
**	230	12	2,7	HS	4	610214	●
**	240	12	2,7	HS	4	610215	●
**	260	12	2,7	HS	4	610017	●
**	310	12	2,7	HS	4	610018	●
**	400	12	2,7	HS	4	610022	●
**	410	12	2,7	HS	4	610023	●
**	410	12	2,7	HS	3	610043	●
**	420	12	2,7	HS	4	610024	●
**	430	12	2,7	HS	4	610025	●
**	500	12	2,7	HS	4	610028	●
**	510	12	2,7	HS	4	610029	●
**	520	12	2,7	HS	4	610030	●
**	530	12	2,7	HS	4	610031	●
**	540	12	2,7	HS	4	610032	●
**	610	12	2,7	HS	4	610034	●
**	630	12	2,7	HS	4	610036	●
**	640	12	2,7	HS	4	610038	●
**	710	12	2,7	HS	4	610040	●
**	810	12	2,7	HS	4	610042	●

Class.	CEL mm	W mm	Thickn. mm	QAL	PU pieces	ID No.	
**	100	12	2,7	TC-F	2	610606	●
**	120	12	2,7	TC-F	2	610610	●
**	130	12	2,7	TC-F	2	610612	●
**	136	12	2,7	TC-F	2	610614	●
**	150	12	2,7	TC-F	2	610616	●
**	170	12	2,7	TC-F	2	610620	●
**	180	12	2,7	TC-F	2	610621	●
**	190	12	2,7	TC-F	2	610625	●
**	210	12	2,7	TC-F	2	610627	●
**	230	12	2,7	TC-F	2	610629	●
**	240	12	2,7	TC-F	2	610631	●
**	400	12	2,7	TC-F	1	612016	●
**	410	12	2,7	TC-F	1	612017	●
**	420	12	2,7	TC-F	1	612018	●
**	430	12	2,7	TC-F	1	612019	●
**	500	12	2,7	TC-F	1	612022	●
**	510	12	2,7	TC-F	1	612023	●
**	520	12	2,7	TC-F	1	612024	●
**	530	12	2,7	TC-F	1	612025	●
**	540	12	2,7	TC-F	1	612026	●

PU = Packaging Unit



- available ex stock
- available at short notice

4. Knives

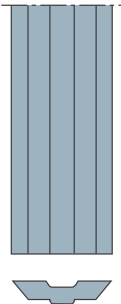
4.2 Planer knives

Turnblade knives for VariPlan planerhead

See
Leitz-Lexicon

Cutting material recommendation	HS	TC
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Chipboard		◇
MDF		◇
Thermoplastics (PE, PP, PVC, etc.)		
WPC (Wood-Plastic-Compounds)		

◆ suitable ◇ partly suitable



Turnblade knife VariPlan

Cutting material:

HS

TC fine grain quality (=TC-F)

PU = Packaging Unit

Class.	CEL mm	W mm	Thickn. mm	QAL	PU pieces	ID No.	
*	50	16	3,7	HS	2	610500	□
*	60	16	3,7	HS	2	610501	□
*	80	16	3,7	HS	2	610502	□
*	100	16	3,7	HS	2	610504	●
*	120	16	3,7	HS	2	610505	□
*	130	16	3,7	HS	2	610506	●
*	136	16	3,7	HS	2	610508	□
*	150	16	3,7	HS	2	610509	●
*	170	16	3,7	HS	2	610511	●
*	180	16	3,7	HS	2	610512	●
*	190	16	3,7	HS	2	610514	●
*	210	16	3,7	HS	2	610515	●
*	230	16	3,7	HS	2	610516	●
*	240	16	3,7	HS	2	610518	●
*	400	16	3,7	HS	2	610526	□
*	410	16	3,7	HS	2	610527	□
*	410	16	3,7	HS	3	610528	□
*	420	16	3,7	HS	2	610529	□
*	430	16	3,7	HS	2	610530	□
*	500	16	3,7	HS	2	610533	□
*	510	16	3,7	HS	4	610562	□
*	520	16	3,7	HS	4	610563	□
*	530	16	3,7	HS	2	610536	□
*	540	16	3,7	HS	2	610537	□
*	600	16	3,7	HS	2	610538	□
*	610	16	3,7	HS	2	610539	□
*	630	16	3,7	HS	2	610541	□
*	640	16	3,7	HS	4	610564	□
*	50	16	3,7	TC-F	2	610700	●
*	60	16	3,7	TC-F	2	610701	●
*	80	16	3,7	TC-F	2	610702	●
*	100	16	3,7	TC-F	2	610704	●
*	120	16	3,7	TC-F	2	610705	□
*	130	16	3,7	TC-F	2	610706	●
*	136	16	3,7	TC-F	2	610708	□
*	150	16	3,7	TC-F	2	610709	●
*	170	16	3,7	TC-F	2	610711	●
*	180	16	3,7	TC-F	2	610712	●
*	190	16	3,7	TC-F	2	610714	●
*	210	16	3,7	TC-F	2	610715	●
*	230	16	3,7	TC-F	2	610716	●
*	240	16	3,7	TC-F	2	610718	●
*	400	16	3,7	TC-F	2	610726	□
*	410	16	3,7	TC-F	2	610727	□
*	420	16	3,7	TC-F	2	610729	□
*	430	16	3,7	TC-F	2	610730	□
*	500	16	3,7	TC-F	2	610733	□
*	510	16	3,7	TC-F	4	610762	□
*	520	16	3,7	TC-F	4	610763	□
*	530	16	3,7	TC-F	2	610736	□
*	540	16	3,7	TC-F	2	610737	□
*	600	16	3,7	TC-F	2	610738	□
*	610	16	3,7	TC-F	2	610739	□
*	630	16	3,7	TC-F	2	610741	□
*	640	16	3,7	TC-F	4	610764	□

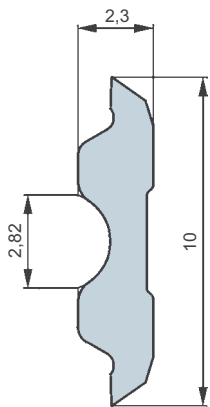
- available ex stock
- available at short notice

4. Knives

4.2 Planer knives

Cutting material recommendation	HS	TC
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Chipboard		◇
MDF		◇
Thermoplastics (PE, PP, PVC, etc.)		
WPC (Wood-Plastic-Compounds)		

◆ suitable ◇ partly suitable



Turnblade knife TriTec

Cutting material:

HS

To be used for:

Planerheads

For surface planing and thickening machines (e.g. SCM, SAC, Panhans, Martin).

Planerheads

For four side planing machines (e.g. Weinig, SCM, Leadermac).

Turnblade planing knives TriTec – Quality HS

See
Leitz-Lexicon

Spare knives for centrifugal clamping systems, quality HS

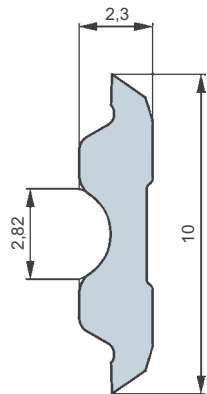
Class.	CEL mm	W mm	Thickn. mm	QAL	ID No.	
*	60	10	2,3	HS	610900	□
*	80	10	2,3	HS	610901	□
*	100	10	2,3	HS	610902	□
*	110	10	2,3	HS	610903	□
*	120	10	2,3	HS	610904	●
*	130	10	2,3	HS	610905	●
*	140	10	2,3	HS	610906	●
*	150	10	2,3	HS	610907	□
*	170	10	2,3	HS	610908	●
*	180	10	2,3	HS	610909	●
*	190	10	2,3	HS	610910	●
*	200	10	2,3	HS	610911	●
*	210	10	2,3	HS	610912	□
*	220	10	2,3	HS	610913	●
*	230	10	2,3	HS	610914	●
*	240	10	2,3	HS	610915	●
*	250	10	2,3	HS	610916	□
*	260	10	2,3	HS	610917	●
*	265	10	2,3	HS	610918	●
*	270	10	2,3	HS	610919	●
*	300	10	2,3	HS	610920	□
*	310	10	2,3	HS	610921	●
*	350	10	2,3	HS	610922	□
*	360	10	2,3	HS	610923	□
*	400	10	2,3	HS	610924	●
*	410	10	2,3	HS	610925	●
*	420	10	2,3	HS	610926	□
*	430	10	2,3	HS	610927	●
*	450	10	2,3	HS	610928	□
*	460	10	2,3	HS	610929	□
*	500	10	2,3	HS	610930	●
*	510	10	2,3	HS	610931	●
*	520	10	2,3	HS	610932	●
*	530	10	2,3	HS	610933	●
*	600	10	2,3	HS	610934	□
*	610	10	2,3	HS	610935	●
*	630	10	2,3	HS	610936	●
*	640	10	2,3	HS	610937	●
*	660	10	2,3	HS	610938	□
*	710	10	2,3	HS	610939	□
*	740	10	2,3	HS	610940	□
*	810	10	2,3	HS	610941	●

PU (Packaging Unit) = 4 pieces

4. Knives

4.2 Planer knives

Cutting material recommendation	HS	TC
Solid wood dry	◆	
Solid wood wet	◇	
Hardwood dry		◆
Hardwood wet		◆
Glulam		◆
Chipboard		◇
MDF		◇
Thermoplastics (PE, PP, PVC, etc.)		
WPC (Wood-Plastic-Compounds)		
◆ suitable	◇ partly suitable	



Turnblade knife MicroTec

Cutting material:
TC

To be used for:

Planerheads

for surface planing and thickening machines (e.g. SCM, SAC, Panhans, Martin).

Planerheads

for four side planing machines (e.g. Weinig, SCM, Leadermac).

Max. production length: 560 mm
Longer knives are unitised.

Turnblade knives MicroTec – Quality TC

See
Leitz-Lexicon

Spare knives for centrifugal clamping systems, quality TC

Class.	CEL	W	Thickn.	QAL	ID No.	
	mm	mm	mm			
*	60	10	2,3	TC	610950	□
*	80	10	2,3	TC	610951	□
*	100	10	2,3	TC	610952	●
*	110	10	2,3	TC	610953	□
*	120	10	2,3	TC	610954	●
*	130	10	2,3	TC	610955	●
*	140	10	2,3	TC	610956	●
*	150	10	2,3	TC	610957	●
*	170	10	2,3	TC	610958	□
*	180	10	2,3	TC	610959	□
*	190	10	2,3	TC	610960	□
*	200	10	2,3	TC	610961	●
*	210	10	2,3	TC	610962	□
*	220	10	2,3	TC	610963	□
*	230	10	2,3	TC	610964	●
*	240	10	2,3	TC	610965	●
*	250	10	2,3	TC	610966	□
*	260	10	2,3	TC	610967	□
*	265	10	2,3	TC	610968	□
*	270	10	2,3	TC	610969	□
*	300	10	2,3	TC	610970	□
*	310	10	2,3	TC	610971	□
*	350	10	2,3	TC	610972	□
*	360	10	2,3	TC	610973	□
*	400	10	2,3	TC	610974	□
*	410	10	2,3	TC	610975	●
*	420	10	2,3	TC	610976	□
*	430	10	2,3	TC	610977	□
*	450	10	2,3	TC	610978	□
*	460	10	2,3	TC	610979	□
*	500	10	2,3	TC	610980	□
*	510	10	2,3	TC	610981	□
*	520	10	2,3	TC	610982	□
*	530	10	2,3	TC	610983	●
*	600	10	2,3	TC	610984	□
*	610	10	2,3	TC	610985	□
*	630	10	2,3	TC	610986	□
*	640	10	2,3	TC	610987	□
*	660	10	2,3	TC	610988	□
*	710	10	2,3	TC	610989	□
*	740	10	2,3	TC	610990	□
*	810	10	2,3	TC	610991	□

PU (Packaging Unit) = 2 pieces

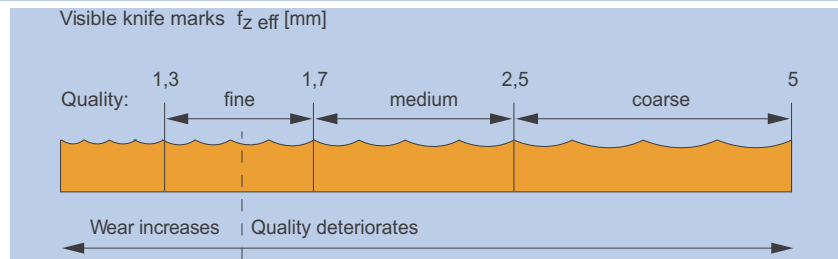
Further dimensions available on request.

- available ex stock
- available at short notice

Process

Serrated back cutterheads are the most used tools for special and standard profiles. This chapter details tools suitable for producing different types of profiles. It covers all the different profiling tasks in industry and craft. There are many different applications and the individual product pages list the tool applications and possible materials.

Relationship between surface quality and length of knife marks f_z eff



Blank knives suitable for many workpiece materials

HS-solid blanks for soft- and hardwood.
 Thickness 5; 6; 8 mm for profile depths up to 30 mm.
 Tungsten carbide tipped blanks for hardwood.
 Thickness 10 mm for profile depths 10 and 18 mm.
 Micro-serrated blank knives with backing plates for hardwood and MDF or HDF panel materials.
 Thickness 10 mm for profile depths up to 30 mm.

Profile depths and tool diameter

The maximum profile depth depends on the knife thickness and height. The table below details the maximum profile depth and the tool cutting circle diameter for the different blanks.

These are maximum diameters and should not exceeded at the deepest part of the profile.

	HS	HS	TC	ST	HS	TC	HS	ST
Knife thickness	5	8	10	10	8	10	8	10
Knife height	45	50	50	55	60	60	70	70
Profile depth	10	15	10	15	20	18	30	27
D max. bei TD								
135		174	174	184	194	194	214	214
145		184	184	194	204	204	224	224
150		189	189	199	209	209	229	229
165		204	204	214	224	224	244	244
170		209	209	219	229	229	249	249
190	220	229	229	239	249	249	269	269

Machines

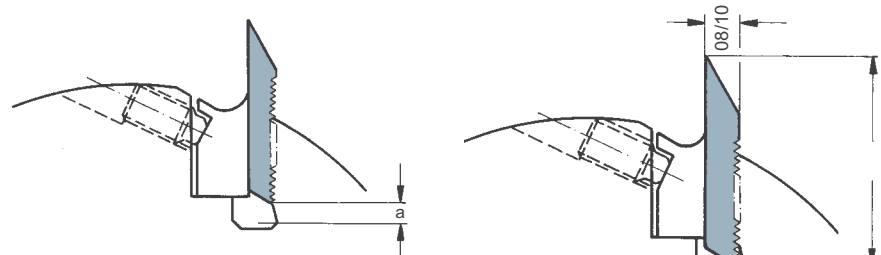
Four-side moulders with or without high-precision spindles.
 Four-side moulders with HSK 85 seating.

Type of application

Profiling along the grain.

**Resharpener area/
Setting area of the knives**

The resharpener area is 6,4 mm when using the full profile depth.
 The knives can be moved out a maximum of 4 serrations



Only for solid and tipped knives –
 not for TC-blanks with backing plates.



- available ex stock
- available at short notice

4. Knives

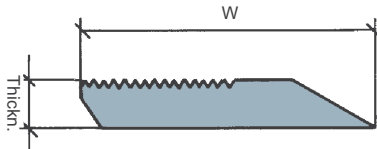
4.3 Knives and blanks

Serrated blanks without shear angle

Cutting material recommendation	HS
Solid wood dry	◆
Solid wood wet	◇
Hardwood dry	◇
Hardwood wet	◇
Glulam	
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	◆
WPC (Wood-Plastic-Compounds)	◇

◆ suitable ◇ partly suitable

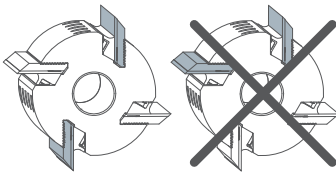
Cutting material: HS



Serrated blank knives for profile cutterheads with precision serration, angle 60°, pitch 1,6 mm

W mm	QAL	PD mm
50	HS	15
60	HS	20
70	HS	30
50	TC	10
60	TC	18
55	ST	15
70	ST	27

Table for max. profile depth (=PD)



Attention:

For safety reasons, always use knives and backing plates (PU = Packaging Unit) with same weight in opposite seatings.

See
Leitz-Lexicon

HS blanks for profile cutterheads and hydro profile cutterheads

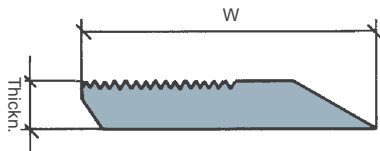
Class.	PDmax. mm	CEL mm	W mm	Thickn. mm	QAL	ID No. PU 2 pieces
*	5	60	45	6	HS	007300 ●
*	5	40	45	6	HS	007299 ●
*	5	80	45	6	HS	007301 ●
*	15	40	50	8	HS	007251 ●
*	15	60	50	5	HS	007320 ●
*	15	60	50	8	HS	007252 ●
*	15	80	50	8	HS	007253 ●
*	15	100	50	8	HS	007254 ●
*	15	130	50	8	HS	007255 ●
*	15	150	50	8	HS	007256 ●
*	15	170	50	8	HS	007333 ●
*	15	180	50	8	HS	007309 ●
*	15	190	50	8	HS	007339 ●
*	15	210	50	8	HS	007340 ●
*	15	230	50	8	HS	007257 ●
*	15	240	50	8	HS	007334 ●
*	15	260	50	8	HS	007258 ●
*	15	270	50	8	HS	007341 □
*	15	310	50	8	HS	007342 ●
*	15	600	50	8	HS	007294 ●
*	15	635	50	8	HS	007306 ●
*	18	40	55	6	HS	007329 ●
*	18	60	55	6	HS	007330 ●
*	18	80	55	6	HS	007331 ●
*	20	40	60	8	HS	007259 ●
*	20	60	60	8	HS	007260 ●
*	20	80	60	8	HS	007261 ●
*	20	100	60	8	HS	007262 ●
*	20	130	60	8	HS	007263 ●
*	20	150	60	8	HS	007264 ●
*	20	170	60	8	HS	007335 ●
*	20	180	60	8	HS	007310 ●
*	20	190	60	8	HS	007343 ●
*	20	210	60	8	HS	007321 ●
*	20	230	60	8	HS	007265 ●
*	20	240	60	8	HS	007336 ●
*	20	260	60	8	HS	007266 ●
*	20	270	60	8	HS	007344 □
*	20	310	60	8	HS	007345 ●
*	20	600	60	8	HS	007295 ●
*	20	635	60	8	HS	007307 ●
*	30	40	70	8	HS	007267 ●
*	30	60	70	8	HS	007268 ●
*	30	80	70	8	HS	007269 ●
*	30	100	70	8	HS	007270 ●
*	30	130	70	8	HS	007271 ●
*	30	150	70	8	HS	007272 ●
*	30	180	70	8	HS	007273 ●
*	30	170	70	8	HS	007337 ●
*	30	190	70	8	HS	007346 ●
*	30	210	70	8	HS	007347 ●
*	30	230	70	8	HS	007274 ●
*	30	240	70	8	HS	007338 ●
*	30	260	70	8	HS	007275 ●
*	30	270	70	8	HS	007348 □
*	30	310	70	8	HS	007349 ●
*	30	600	70	8	HS	007296 ●
*	30	635	70	8	HS	007308 ●

- available ex stock
- available at short notice

HS Marathon blanks for profile and hydro profile cutterheads

Cutting material recommendation	HS Marathon
Solid wood dry	◆
Solid wood wet	◆
Hardwood dry	◆
Hardwood wet	◆
Glulam	◇
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	◆
WPC (Wood-Plastic-Compounds)	◆

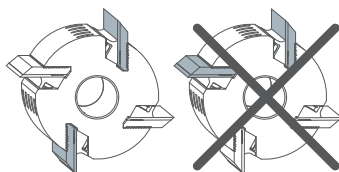
◆ suitable ◇ partly suitable



Serrated blank knives for profile cutterheads with precision serration, angle 60°, pitch 1,6 mm

W mm	QAL	PD mm
50	HS	15
60	HS	20
70	HS	30
50	TC	10
60	TC	18
55	ST	15
70	ST	27

Table for max. profile depth (=PD)



Attention:

For safety reasons, always use knives and backing plates (Packaging Unit = PU) with same weight in opposite seatings.

Class.	PDmax. mm	CEL mm	W mm	Thickn. mm	QAL	ID No. PU 2 pieces
*	12	40	60	8	HS	635115 ●
*	15	40	50	8	HS	635107 ●
*	15	60	50	8	HS	635108 ●
*	15	80	50	8	HS	635109 ●
*	15	100	50	8	HS	635110 ●
*	15	130	50	8	HS	635111 ●
*	15	150	50	8	HS	635112 ●
*	15	170	50	8	HS	635132 ●
*	15	180	50	8	HS	635133 ●
*	15	190	50	8	HS	635134 ●
*	15	210	50	8	HS	635135 ●
*	15	230	50	8	HS	635113 ●
*	15	240	50	8	HS	635136 ●
*	15	260	50	8	HS	635114 □
*	15	270	50	8	HS	635137 □
*	15	310	50	8	HS	635138 ●
*	20	60	60	8	HS	635116 ●
*	20	80	60	8	HS	635117 ●
*	20	100	60	8	HS	635118 ●
*	20	130	60	8	HS	635119 ●
*	20	150	60	8	HS	635120 ●
*	20	170	60	8	HS	635139 ●
*	20	180	60	8	HS	635140 ●
*	20	190	60	8	HS	635141 ●
*	20	210	60	8	HS	635142 ●
*	20	230	60	8	HS	635121 ●
*	20	240	60	8	HS	635144 ●
*	20	260	60	8	HS	635122 □
*	20	270	60	8	HS	635145 □
*	20	310	60	8	HS	635146 ●
*	30	40	70	8	HS	635123 ●
*	30	60	70	8	HS	635124 ●
*	30	80	70	8	HS	635125 ●
*	30	100	70	8	HS	635126 ●
*	30	130	70	8	HS	635127 ●
*	30	150	70	8	HS	635128 ●
*	30	170	70	8	HS	635147 ●
*	30	180	70	8	HS	635129 ●
*	30	190	70	8	HS	635148 ●
*	30	210	70	8	HS	635149 ●
*	30	230	70	8	HS	635130 ●
*	30	240	70	8	HS	635150 ●
*	30	260	70	8	HS	635131 □
*	30	270	70	8	HS	635151 □
*	30	310	70	8	HS	635152 ●

- New HS knife programme, to meet the demands of planing mills, significantly improved performance over standard HS-knives.
- Significantly improved tool life compared to regular HS-knives, increased productivity and service life.
- Resistance to chemical and abrasive wear; suitable for both wet and dry wood.
- Low friction between chip and cutting edge; smoother cut and better workpiece surfaces.
- Less cleaning required because of reduced resin build-up.
- Sharpening and profiling by existing machines, fixtures and grinding wheels.



● available ex stock
□ available at short notice

4. Knives

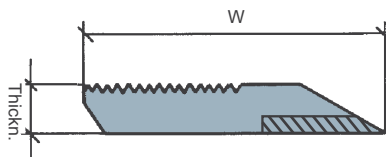
4.3 Knives and blanks

Serrated blanks without shear angle

Cutting material recommendation	TCT K40
Solid wood dry	◆
Solid wood wet	
Hardwood dry	◆
Hardwood wet	
Glulam	◆
Chipboard	
MDF	
Thermoplastics (PE, PP, PVC, etc.)	◆
WPC (Wood-Plastic-Compounds)	◆

◆ suitable ◆ partly suitable

Cutting material:
TCT K40



Serrated blank knives for profile cutterheads with precision serration, angle 60°, pitch 1,6 mm

W mm	QAL	PD mm
50	HS	15
60	HS	20
70	HS	30
50	TC	10
60	TC	18
55	ST	15
70	ST	27

Table for max. profile depth (PD)

TCT blanks for profile cutterheads and hydro profile cutterheads

See
Leitz-Lexicon

Class.	CEL mm	W mm	Thickn. mm	QAL	ID No.
*	40	50	10	TCT	007451 ●
*	60	50	10	TCT	007452 ●
*	80	50	10	TCT	007453 ●
*	100	50	10	TCT	007454 ●
*	130	50	10	TCT	007455 ●
*	150	50	10	TCT	007456 ●
*	170	50	10	TCT	009448 ●
*	180	50	10	TCT	007457 ●
*	230	50	10	TCT	007458 ●
*	40	60	10	TCT	007459 ●
*	60	60	10	TCT	007460 ●
*	80	60	10	TCT	007461 ●
*	100	60	10	TCT	007462 ●
*	130	60	10	TCT	007463 ●
*	150	60	10	TCT	007464 ●
*	170	60	10	TCT	009449 ●
*	180	60	10	TCT	007465 ●
*	230	60	10	TCT	007466 ●

HS corrugated knife stock for profile cutterheads and planer heads

Class.	PDmax. mm	CEL mm	W mm	Thickn. mm	QAL	ID No.
*	0	635	38,1	8	HS	130 038 841 ●
*	5	635	45	8	HS	130 038 842 ●
*	15	635	50	8	HS	130 038 843 ●
*	20	635	60	8	HS	130 038 844 ●
*	30	635	70	8	HS	130 038 845 ●

- available ex stock
- available at short notice

9. Knives and spare parts

9.1 Knives and blank knives

9.1.3 Blank knives

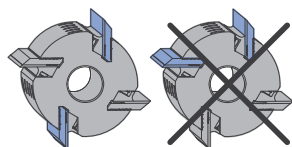
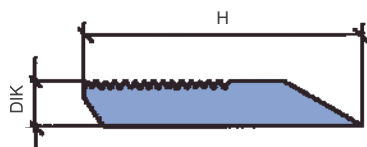
Cutting material recommendation	HS	MC	HW
Solid wood dry	"	"	!
Solid wood wet	!	"	
Hardwood dry	!	"	"
Hardwood wet	!	"	
Glulam		!	!
Thermoplastics (PE, PP, PVC, etc.)	"	"	!
WPC (Wood-Plastic-Compounds)	!	"	!

Blank knives with 60° serrated back

HS and MC blank knives for cutting to individual cutting widths
TC 110-0, TC 110-0-01

SB mm	H mm	DIK mm	PT _{max.} mm	ID HS	ID MC
400	50	8	15		635156 ●
400	60	8	20		635158 ●
400	70	8	30		635160 ●
650	50	8	15	635000 ●	635157 ◻
650	60	8	20	635001 ●	635159 ◻
650	70	8	30	635002 ●	635161 ◻

ID = 1 piece



Cutting material:
HS / MC

Warning:
For safety reasons, always mount knives
(VE) of the same weight opposite each
other.

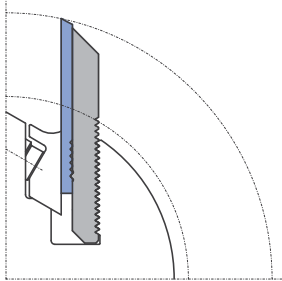
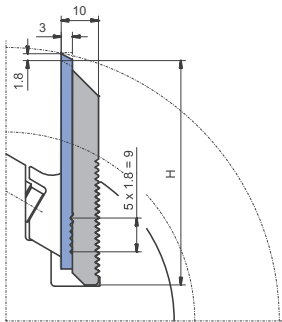
9. Knives and spare parts

9.1 Knives and blank knives

9.1.3 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-Compounds)	"	"

" suitable ! partly suitable



Cutting material:
HW-30F / HW-10F

Attention:
Maximum edge projection above the backing plate 4 mm. For safety reasons, only mount knives and backing plates (VE) of same weight in opposite seatings.

PowerKnife System PKS® blank knives/backing plates

For profile and hydro profile cutterheads, PT 15 mm
TC 110-0-16, TE 601-0-16

SB mm	H mm	DIK mm	PT _{max.} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set w. backin 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.

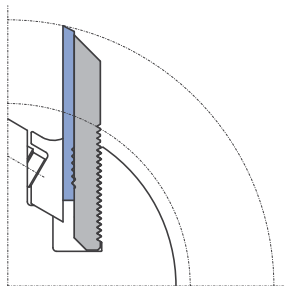
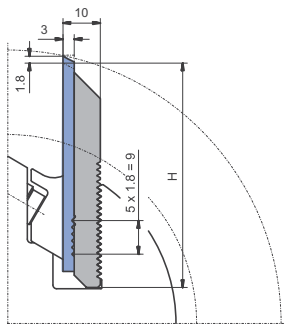
Set of the same weight.

- Blank knives with polished face for maximum cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps)
- Knives supported by profiled backing plates
- Resharpener area 10.8 mm when using max. profile depth.

- available ex stock
- ◻ available at short notice

Cutting material reccommendation	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-Compounds)	"	"

" suitable ! partly suitable



Cutting material:
HW-30F / HW-10F

Attention:
Maximum edge projection above the backing plate 4 mm. For safety reasons, only mount knives and backing plates (VE) of same weight in opposite seatings.

PowerKnife System PKS® blank knives/backing plates

For profile and hydro profile cutterheads, PT 20 mm
TC 110-0-16, TE 601-0-16

SB mm	H mm	DIK mm	PT _{max.} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set w. 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 face for maximum cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps)
- Knives supported by profiled backing plates
- Resharpening area 10.8 mm when using max. profile depth.

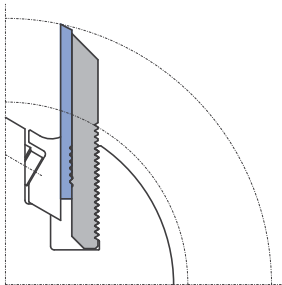
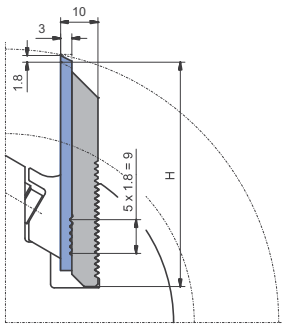
9. Knives and spare parts

9.1 Knives and blank knives

9.1.3 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-Compounds)	"	"

" suitable ! partly suitable



Cutting material:
HW-30F / HW-10F

Attention:
Maximum edge projection above the backing plate 4 mm. For safety reasons, only mount knives and backing plates (VE) of same weight in opposite seatings.

PowerKnife System PKS[®] blank knives/backing plates

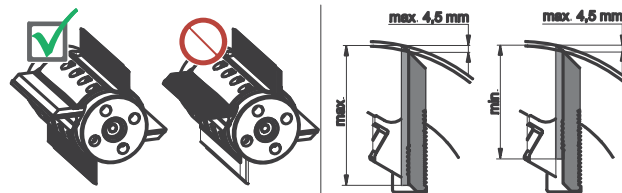
For profile and hydro profile cutterheads, PT 30 mm
TC 110-0-16, TE 601-0-16

SB mm	H mm	DIK mm	PT _{max.} mm	SET PCS	QAL	ID Blank knife set	ID Blank knife set w. 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 face for maximum cutting edge quality.
- Solid tungsten carbide - profile knives, adjustable (1.80 mm steps)
- Knives supported by profiled backing plates
- Resharpener area 10.8 mm when using max. profile depth.



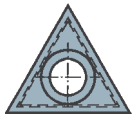
- available ex stock
- available at short notice

See
Leitz-Lexicon

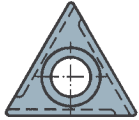
Turnblade knives



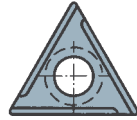
Turnblade spurs
VS 1



Turnblade spurs
VS 2



Turnblade spurs
VS 3R



Turnblade spurs
VS 3L



Turnblade spurs
VS 4

Cutting material:
TC fine grain quality (=TC-F)

Workpiece material:
Solid woods, timber products

Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.
*	14	14	2	VS 1	TC-F	10	005099 ●
*	14	14	1,2	VS 4	TC	10	005130 ●
*	15	15	2		TC		005100 ●
*	19		2	VS 2	TC-F	10	005115 ●
*	19		2	VS 3R	TC-F		005116 ●
*	19		2	VS 3L	TC-F		005159 ●



Softline RL on top



Softline RL on bottom

PU = Packaging Unit

Turnblade knives



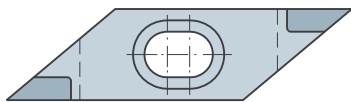
Lamello turnblade knives

Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	PU pieces	ID No.
*	18	18	1,95	WP 18/1,95	TC	10	005114 ●
*	18	18	2,5	WP 18/2,5	TC	10	005195 ●

PU = Packaging Unit

Cutting material:
TC

Rhomboid turnblade knives (RMA)

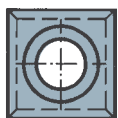


Rhomboid turnblade knives (RMA)

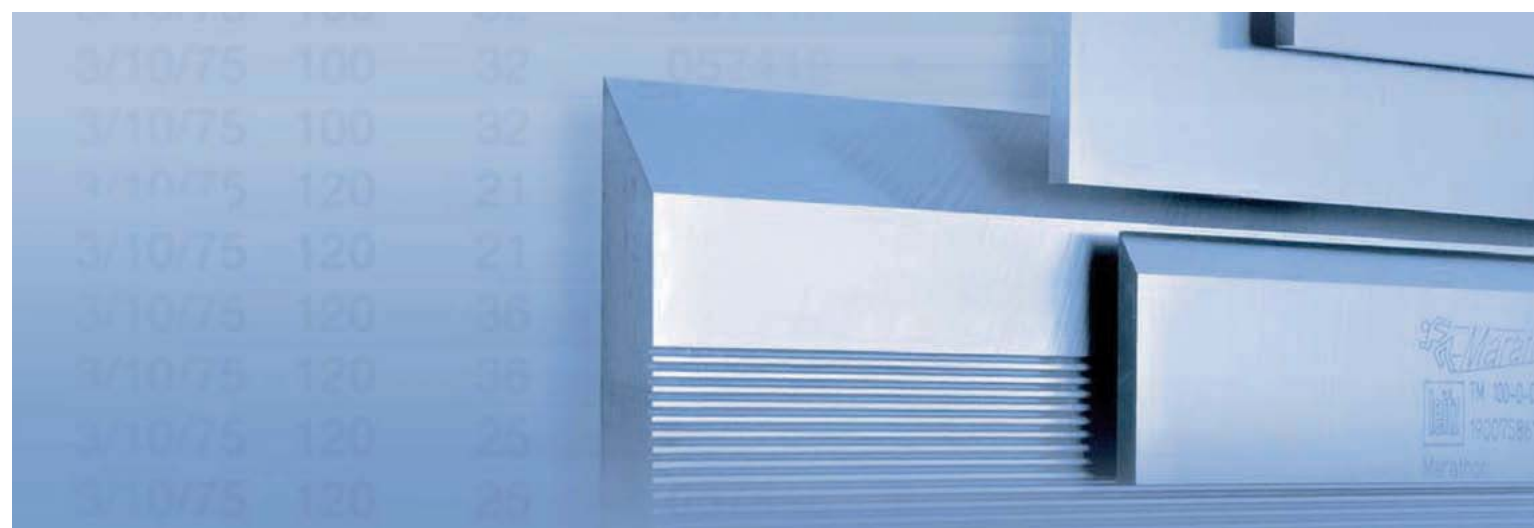
Class.	CEL mm	W mm	Thickn. mm	Abbrev.	QAL	ID No.
*	45,416	12	5,6	RMA 5,6	TC-F	008329 ●
*	45,416	12	6,6	RMA 6,6	TC-F	008330 ●

Cutting material:
TC fine grain quality (=TC-F)

Turnblade knives



Description	QAL	DIM	PU pieces	ID No.
Turnblade knives	TC	15x15x2,5	10	009535 ●



Notes:

3/10/75	100	32
3/10/75	100	32
3/10/75	120	21
3/10/75	120	21
3/10/75	120	36
3/10/75	120	36
3/10/75	120	25
3/10/75	120	25



Notes:

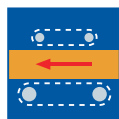
- available ex stock
- available at short notice

5. Cutterheads

	Selection overview	97
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5.2	Segmental hogger	99
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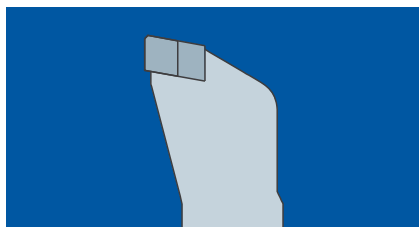
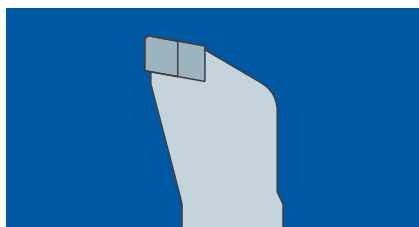


DiaMaster DT



For hogging timber products, with/without coating, as well as light construction panels. Integrated tooth shape for a tear-free middle layer and break-out-free edges recommended for timber products with a high contaminant share. Tip height 6 mm; Regrinding area 4 mm.

For mounting on Hydro-clamping sleeve, flanged or quick change clamping sleeve: tooth shape decreasing – optimised for machining along and across grain.



HZ 210-2 *

Class.	DIA mm	CW mm	BO mm	T	ID No LH	ID No RH
*	250	10	80	24 (20+4)	190232 □	190233 □
*	250	10	80	30 (25+5)	190234	190235
*	250	10	80	36 (30+6)	190236 □	190237 □
*	250	10	80	42 (35+7)	190238	190239
*	250	10	80	48 (40+8)	190240 □	190241 □
*	250	10	80	54 (45+9)	190242	190243
*	250	10	80	60 (50+10)	190264	190265

For mounting on quick change hydro clamping sleeve: tooth shape decreasing – optimised for machining along and across grain.

HZ 210-2 *

Class.	DIA mm	CW mm	BO mm	T	ID NO LH	ID NO RH
*	250	10	60	24 (20+4)	190244 □	190245 □
*	250	10	60	30 (25+5)	190246	190247
*	250	10	60	36 (30+6)	190248 □	190249 □
*	250	10	60	42 (35+7)	190250	190251
*	250	10	60	48 (40+8)	190252 □	190253 □
*	250	10	60	54 (45+9)	190254	190255
*	250	10	60	60 (50+10)	190266	190267

For standard flanged sleeves, Hydro-clamping and quick-clamping sleeves, see section clamping sleeves. Special flange sleeves available on request.

Order example:

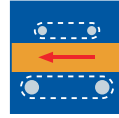
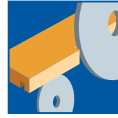
Left-hand hogging set DIA-250 mm for HOMAG machine:

Hogging set consisting of:

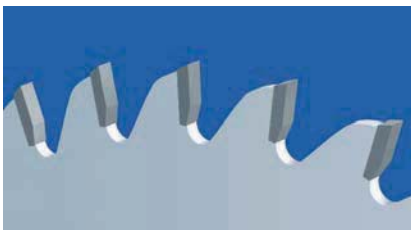
Hogging set in cutter design DT DIA-250/Z36 (30+6) ID No 190236

HF-Hydro clamping sleeve ID No 061701

Individual parts for segmental hogging set



Basic and extension hogger of steel (D-250-300 mm) and aluminium (D-350 mm). With 6 tungsten carbide tipped segments. The total cutting width of sawblade and basic hogger: DIA-250 mm/SB-30 mm; DIA-300 mm/SB-35 mm; DIA-400 mm/SB-40 mm.

**WZ 300-2 ***

Class.	DIM mm	T	Grind	QAL	ID No LH	ID No RH
*	250x26,0x80	6x7	FZ	TC	064410	● 064411 ●
*	300x31,5x30	6x9	FZ	TC	064412	● 064413 ●
*	350x36,5x30	6x10	FZ	TC	064414	● 064415 ●

Segments (6 pieces/hogger)

TM 170-2 *

Class.	DIM mm	T	Grind	QAL	ID No LH	ID No RH
*	D 250	7	FZ	TC	064958	● 064959 ●
*	D 300	9	FZ	TC	064960	● 064961 ●
*	D 350	10	FZ	TC	064962	● 064963 ●

Spare parts

Description	DIM	Remarks	ID No
Key	Torx 20		117503 ●
Key	SW 6		005494 ●
Spacer	115x11x80	for D = 250	028186 ●
Spacer	115x32x30	for D = 300	028187 ●
Spacer	115x42x30	for D = 350	028188 ●
Countersunk screw	M 6x16		006086 ●
Countersunk screw	M 6x12		006084 ●
Screw 4/0	M 8x17	for D = 250/350/300	006237 ●
Screw	M 8x18		005945 ●

Order example:

Left-hand hogger set DIA-250 mm,
mounted without extension hogger for IMA machine:

Hogger set consisting of:

Sawblade DIA-250 mm, Z 48 ID No. 061831

Basic hogger DIA-250 mm ID No. 064410

Flanged sleeve ID No. 061650

When ordering, all single ID No. should be stated as in the example above
incl. mounting description.

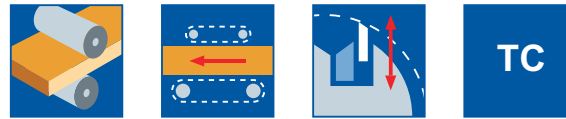
Flanged sleeves for other machine makes and quick-clamping sleeves,
see section 2.4.

Special flanged sleeves and DP-tipped segments available on request.

- available ex stock
- available at short notice



Planerhead HeliPlan with spirally arranged cutting edges



Ideal for high chip flow; low power requirements and significant noise reduction from spiral mounted 4-side turnblade knives. Can be used for finish planing depending on quality requirement.

Aluminum Tool body

WW 220-2-01 *

Class.	DIA mm	CW mm	BO mm	BO Inch	T	QK PCs.	RPM max. min ⁻¹	ID No
*	125	60	40		2/2	14	10000	030420
*	125	80	40		2/2	16	10000	030421
*	125	100	40		2/2	20	10000	030422
*	125	100		1 1/2"	2/2	20	10000	030432
*	125	100		1 13/16"	2/2	20	10000	030433
*	125	130	40		2/2	26	10000	030423 ●
*	125	150	40		2/2	30	10000	030424
*	125	170	40		2/2	32	10000	030425 ●
*	125	190	40		2/2	36	10000	030434
*	125	190		1 1/2"	2/2	36	10000	030435
*	125	190		1 13/16"	2/2	36	10000	030436
*	125	230	40		2/2	40	10000	030447 ●
*	125	240	40		2/2	46	10000	030426 ●
*	125	240		1 1/2"	2/2	46	10000	030437
*	125	240		1 13/16"	2/2	46	10000	030438
*	140	100	50		2/2	20	9000	030439
*	140	100		1 1/2"	2/2	20	9000	030440
*	140	100		1 13/16"	2/2	20	9000	030441
*	140	170	50		2/2	32	9000	030427
*	140	190	50		2/2	36	9000	030442
*	140	190		1 1/2"	2/2	36	9000	030443
*	140	190		1 13/16"	2/2	36	9000	030444
*	140	240	50		2/2	46	9000	030428
*	140	240		1 1/2"	2/2	46	9000	030445
*	140	240		1 13/16"	2/2	46	9000	030446

Spare knives

Description	QAL	DIM	PU PCs	ID No
Turnblade knives	HW	15x15x2,5	10	009535 ●

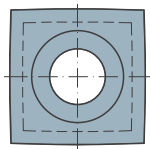
Spare parts

Description	DIM	ID No
Countersunk screw	M5x15,5-8,8 T20	007394 ●

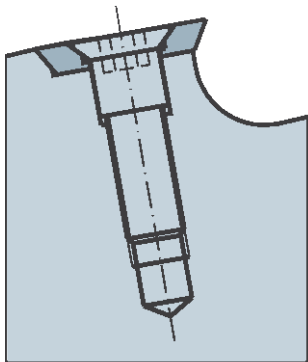
Accessories

Description	DIM	ID No
Key	Torx 25	117504 ●

With carbide knives.
Additional Dimensions and inch sizes on request.

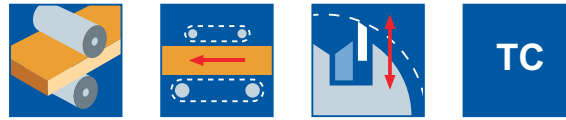
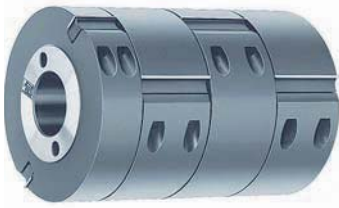


Turnblade knife



Knives mounted peripherally

Planerhead build-up system



Suitable for flexible cutting widths and cutting heights.
Combination of single cutterheads.
Low-noise from staggered HW knives.

Design Z-2

WW 200-2-03 *

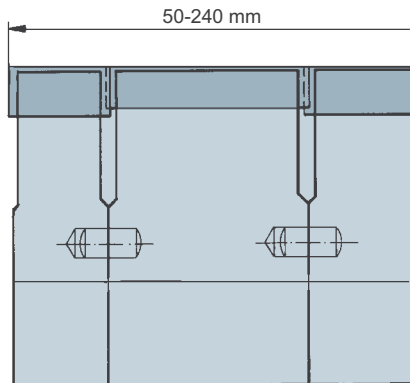
Class.	DIA mm	CW mm	BO mm	T	ID No
*	125	30	40	2	029030 ●
*	125	50	40	2	029033 ●

Spare knives

Description	QAL	DIM	PU PCs	ID No
Turnblade knife	TC	50x12x1,5	10	005086 ●

Spare parts

Description	DIM	ID No
Clamping wedges	28x14,2x9	005344 ●
Clamping wedges	48x14,2x9	005345 ●
Screw	DIN-915; M8x20	006043 ●
Key	SW 4	005445 ●



Build-up system cutterhead

Design Z-4

WW 200-2-04 *

Class.	DIA mm	CW mm	BO mm	T	ID No
*	125	30	40	4	029103 ●
*	125	50	35	4	029104 ●
*	125	50	40	4	029105 ●
*	125	50	50	4	029132 ●

Spare knives

Description	QAL	DIM	PU PCs	ID No
Turnblade knife	TC	50x12x1,5	10	005086 ●

Spare parts

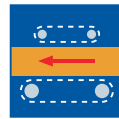
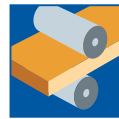
Description	DIM	ID No
Clamping wedges	28x14,2x9	005344 ●
Clamping wedges	48x14,2x9	005345 ●
Screw	DIN-915; M8x20	006043 ●
Key	SW 4	005445 ●

Larger bore sizes available on request.

- available ex stock
- available at short notice



Planerhead CentroStar



Ideal for low chip removal; easy knife change in axial or radial direction. Clamping system is positioned in an area protected against dust – easy to use – positioned behind the cutting edge.

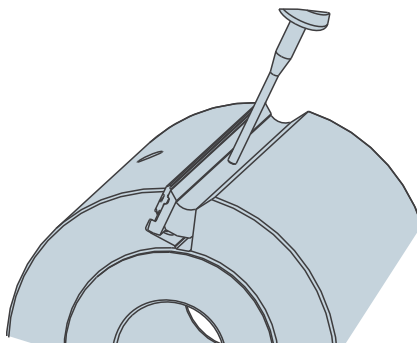
Tool body of aluminium

WW 240-2-20 *

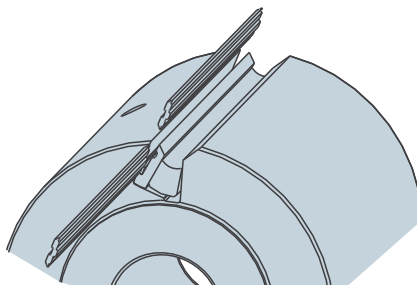
Class.	DIA mm	CW mm	TH mm	BO mm	BO max. mm	T	RPMmax. min ⁻¹	ID No	
								HS	TC
*	100	120	126	35		3	12000	130400	130401
*	100	190	196	35		3	12000	130402	130403
*	120	130	136	40		4	12000	130404	130405
*	120	136	142	40		4	12000	130406	130407
*	125	100	106	40	50	4	12000	130442	● 130443 □
*	125	120	126	40	50	4	12000	130444	● 130445 □
*	125	130	136	40	50	4	12000	130446	● 130447 □
*	125	150	156	40	50	4	12000	130450	● 130451 □
*	125	170	176	40	50	4	12000	130452	● 130453 □
*	125	180	186	40	50	4	12000	130454	● 130455 □
*	125	190	196	40	50	4	12000	130456	● 130457 □
*	125	210	216	40	50	4	12000	130458	130459
*	125	230	236	40	50	4	12000	130460	● 130461 □
*	125	240	246	40	50	4	12000	130462	● 130463 □

Spare knives

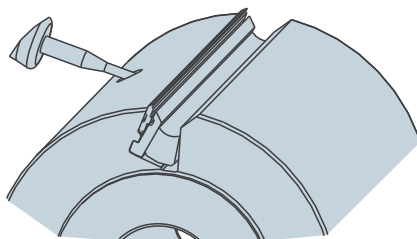
Description	QAL	DIM	PU PCs	ID No
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B100; 4 part	4	610203 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B120; 4 part	4	610204 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B130; 4 part	4	610205 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B136; 4 part	4	610206 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B150; 4 part	4	610208 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B170; 4 part	4	610210 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B180; 4 part	4	610211 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B190; 4 part	4	610212 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B210; 4 part	4	610213 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B230; 4 part	4	610214 ●
Turnblade knives-Set CentroStar, CentroFix, QuickFix	HS	B240; 4 part	4	610215 ●



Release the pressure of the knives



Remove the knives radially or axially



Activate the knife clamping pressure

Further dimensions and dimensions in inches available on request. CentroStar planerhead with steel tool body available on request.

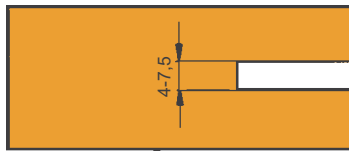


- available ex stock
- available at short notice

Adjustable grooving cutterset with spacers

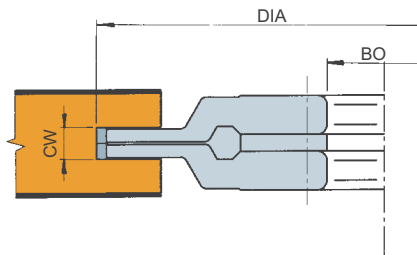


For cutting different groove widths in solid woods along and across grain, uncoated, veneered and coated timber products. For spindle moulders, moulders, edging and routing machines with/without CNC, double-end tenoners. Cutting width adjusted with spacers in 0.1 mm steps. 2-part set.



SW 501-1-01 *

Class.	DIA	CW	BO	BO _{max.}	T	GD	RPM	ID No
	mm	mm	mm	mm			min ⁻¹	
*	150	4,0 - 7,5	30	50	2/2	20	5200 - 10100	0128100 ●
*	180	4,0 - 7,5	30	50	2/2	35	4300 - 8400	0128101 ●
*	200	4,0 - 7,5	30	50	2/2	45	3900 - 7600	0128102 ●
*	250	4,0 - 7,5	30	50	2/2	60	3100 - 6000	0128103 ●

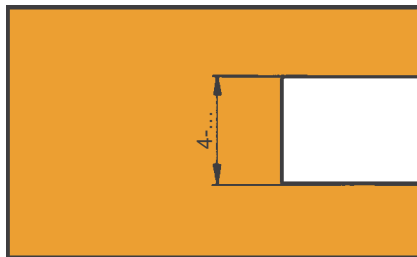


Additional parts

WW 200-1 *

Class.	DIA	CW	BO	BO _{max.}	Z	RPM	ID No
	mm	mm	mm	mm		min ⁻¹	
*	150	3,8	30	50	2	5200 - 10100	0128130 ●
*	180	3,8	30	50	2	4300 - 8400	0128131 ●
*	200	3,8	30	50	2	3900 - 7600	0128132 ●
*	250	3,8	30	50	2	3100 - 6000	0128133 ●

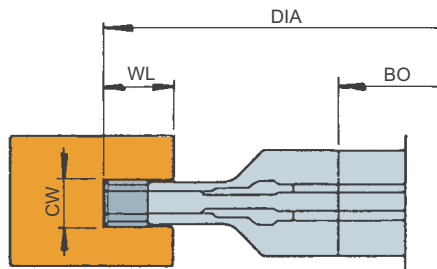
Each additional part increases the CW by 3,6 mm.



Spare parts

Part	mm	mm	mm	mm	DIM	QAL	ID No
					mm	min ⁻¹	
Turnblade knife (PU 10 pcs.)					18x18x1,95	TC	005114 ●
Nut							005653 ●
Spur (PU 10 pcs.)					14x14x1,2	TC	005130 ●
Nut							005654 ●
Key					T 15		117507 ●
Key					T 9		005463 ●
Setting gauge					0,3/0,8		005374 ●

PU = Packing unit



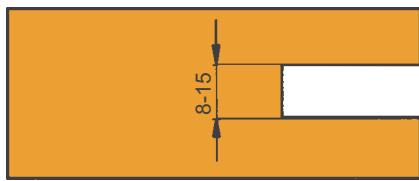
- available ex stock
- available at short notice



Adjustable grooving cutterset with spacers

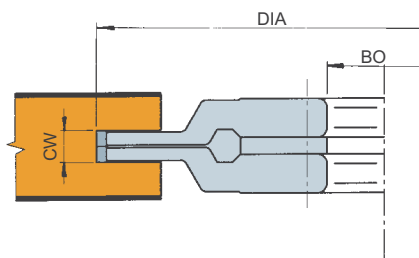


For cutting different groove widths in solid woods along and across grain, uncoated, veneered and coated timber products. For spindle moulders, moulders, edging and routing machines with/without CNC, double-end tenoners. Cutting width adjusted with spacers in 0.1 mm steps. 2-part set.



SW 501-1-01 *

Class.	DIA	CW	BO	BO _{max.}	T	GD	RPM	ID No
	mm	mm	mm	mm		mm	min ⁻¹	
*	150	8,0-15,0	30	50	2/2	20	5200 - 10100	128104 ●
*	180	8,0-15,0	30	50	2/2	35	4300 - 8400	128105 ●
*	200	8,0-15,0	30	50	2/2	45	3900 - 7600	128106 ●
*	250	8,0-15,0	30	50	2/2	60	3100 - 6000	128107 ●

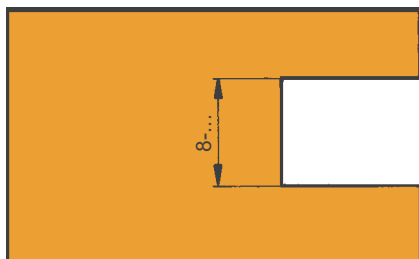


Additional parts

WW 200-1 *

Class.	DIA	CW	BO	BO _{max.}	T	RPM	ID No
	mm	mm	mm	mm		min ⁻¹	
*	150	7,7	30	50	2	5200 - 10100	128134 ●
*	180	7,7	30	50	2	4300 - 8400	128135 ●
*	200	7,7	30	50	2	3900 - 7600	128136 ●
*	250	7,7	30	50	2	3100 - 6000	128137 ●

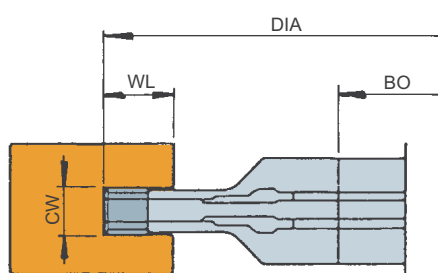
Each additional part increases the SB by 7,5 mm.



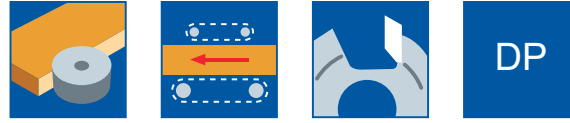
Spare parts

Part	DIM	QAL	ID No
	mm		
Turnblade knife (PU 10 pcs.)	7,7x8x1,5	TC	005053 ●
Spurs (PU 10 pcs.)	14,0x14x2,0	TC	005099 ●
Clamping wedge			009763 ●
Screw			007380 ●
Screw	M6x0,5x4,9		006243 ●
Key	T 15		117507 ●
Key	T 20		117503 ●
Setting gauge	0,3/0,8		005374 ●

PU = packing unit



Jointing cutter DiaMaster PRO
Low Noise/DiaMaster PLUS



Low noise design with staggered cutting edges. Deep tooth pockets for increased chip clearance delaying chip ejection. BO max. 40 mm. Cutting edge designed to produce hollow cuts for close fitting edge bandings (S-type design).

WF 230-2-DP *

Class.	DIA	CW	GD	PoH	BO	T	RPM _{max.}	ID No	ID No
	mm	mm	mm	mm	mm		min ⁻¹	LH	RH
*	100	34	36	1	30 DKW	3x3 as	17100	090830	090831
*	100	43,6	40,6	3	30 DKW	3x4 as	17100	090832	090833
*	100	48	25	2	30 DKW	2x4 as	17100	090822	090823
*	150	48	50	1	30 DKW	3x4 as	11400	090834	090835
*	200	34	35	1	35 DKW	6x2 s	8500	090819	090819

Diamaster PRO DFC design with delayed chip ejection, suitable for i-system.

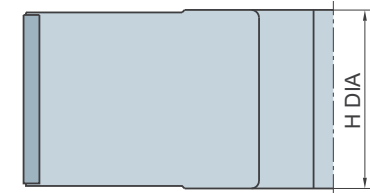
WF 230-2-DP *

Class.mach.	DIA	CW	GD	PoH	BO	T	RPM _{max.}	ID No	ID No
	mm	mm	mm	mm	mm		min ⁻¹	LH	RH
*	Homag	125	34	36	1	30 DKW 3x2 s	13600	090836	090836
*	Homag	125	43	40	1	30 DKW 3x4 s	13600	090837	090837
	Homag	125	63	40	2	30 DKW 3x6 s	13600	090838	090838
*	IMA	125	34	34	1	30 DKW 3x3 as	13600	090849	090850
*	IMA	125	43	42	1	30 DKW 3x4 as	13600	090843	090844
*	IMA	125	63	42	3	30 DKW 3x6 as	13600	090845	090846
*	Homag/ IMA	180	34	42	1	35 DKW 3x3 as	9500	090851	090852
*	Homag/ IMA	180	43	46	1	35 DKW 4x4 as	9500	090841	090842
*	Homag/ IMA	180	63	46	3	35 DKW 4x6 as	9500	090839	090840

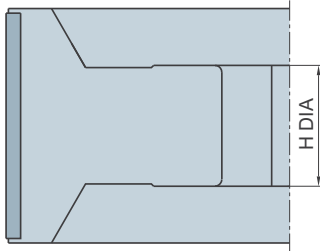
Diamaster PLUS design with larger DIA-tips: 10 to 15 times resharpenable.

WF 230 2 *

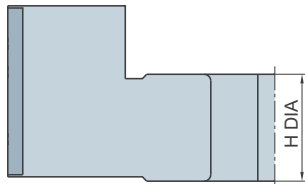
Class.	DIA	CW	GD	PoH	BO	T	RPM _{max.}	ROT	ID No
	mm	mm	mm	mm	mm		min ⁻¹		
*	180	34	34	1	35 DKW	6x3 as	9500	LH	090847
*	180	34	34	1	35 DKW	6x3 as	9500	RH	090848



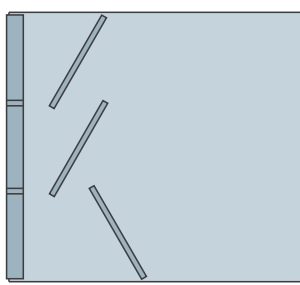
Hub length 1



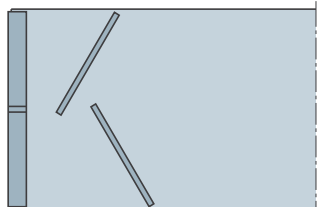
Hub length 2



Hub length 3

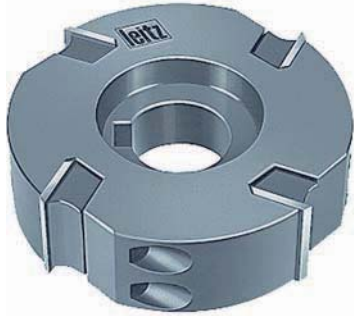


Cutters arrangement "as" = asymmetric

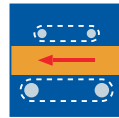
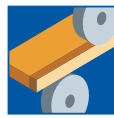


Cutter arrangement "s" = symmetric

- available ex stock
- available at short notice



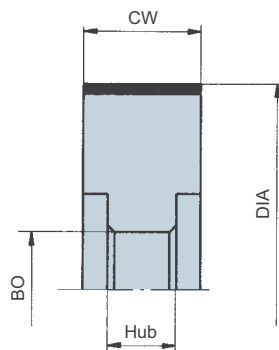
Turnblade cutterhead



Turnblade tool for pre-cutting plastic edge bandings and flush cutting veneer and solid wood edges, $n_{max.}$ 18.000 U min⁻¹.

WW 200-2-07 *

Class.	Make of machine	DIA mm	CW mm	BO mm	T	ID No LH	ID No RH
	Homag	70	20	20 DKW	4	025085 ●	025086 ●



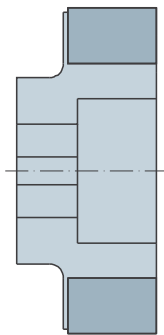
Trimming cutterhead for Brandt, Homag CW-12 and 20 mm

WW 200-2-06 *

Class.	Make of machine	DIA mm	CW mm	BO mm	T	ID No LH	ID No RH
	Brandt	70	12	16 DKW	4	025075 ●	025075 ●
	Homag	70	20	16 DKW	4	025079 ●	025079 ●
	Homag	70	20	16 DKW	6	025083	025083

Spare parts

Part	DIM mm	QAL	ID No LH	ID No RH
Turnblade knife (VE 10 pcs.)	12x12x1,5	TC	005081 ●	005081 ●
Turnblade knife (VE 10 pcs.)	20x12x1,5	TC	005083 ●	005083 ●
Clamping wedge	15		005271 ●	005271 ●
Clamping wedge	20		005272 ●	005272 ●
Screw	M 6x12			006035 ●
Key	SW 3			005444 ●



Trimming cutterhead for IMA CW-20 mm

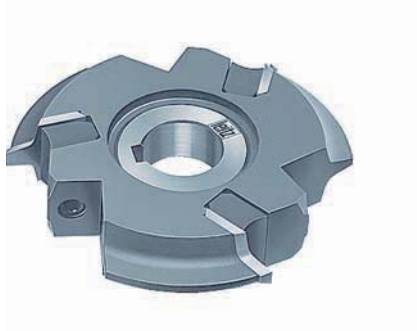
WW 210-2

Class.	Make of machine	DIA mm	CW mm	BO mm	T	ID No LH	ID No RH
	IMA	70	20	20 DKW	4	025129 ●	025120 ●

Spare parts

Part	DIM mm	QAL	ID No LH	ID No RH
Turnblade knife (PU 10 pcs.)	20x12x1,5	TC	005091 ●	005091 ●
Clamping wedge	21		009758 ●	009759 ●
Screw	M 6x12			006035 ●
Key	SW 3			005444 ●

PU = packing unit



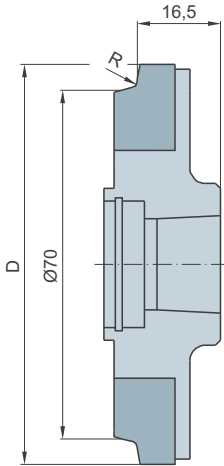
Radius turnblade cutterhead



Radius turnblade tool for Homag edge banding machines with HSK 25 R-spindles, RPM_{max.} 12.000 U min⁻¹.

Cutterhead with turnblade knife HSK 25 R
WE 500-2 *

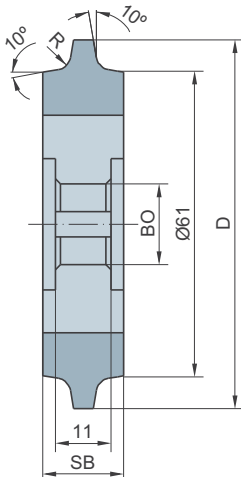
Class.	Make of machine	DIA mm	CW mm	R mm	T	ID No LH	ID No RH
*	Homag	79	12	2	4	073050	073051
*	Homag	79	12	3	4	073054	073055
*	Homag	85	12	4	4	073058	073059
*	Homag	85	12	5	4	073062	073063



Spare parts

Part	DIM mm	R mm	ID No LH	ID No RH
Turnblade knife	12	2	073554	073555
Turnblade knife	12	3	073558	073559
Turnblade knife	12	4	073562	073563
Turnblade knife	12	5	073566	073567

Radius-profile cutterhead WE 500-2 with HSK 25 R-bore



Radius-profile cutterhead WE 500-2-02 with cylindrical bore

Turnblade tool for profiled edge bandings, RPM_{max.} 18.000 U min⁻¹.

Cutterhead with turnblade knife
WE 500-2-02 *

Class.	Make of machine	DIA mm	CW mm	BO mm	R mm	T	ID No LH	ID No RH
*	Homag, Ott	73	16	16 KN	2	3		024993
*	Homag, Ott	73	16	16 KN	3	3		024994
*	Homag, Ott	73	16	16 KN	5	3		024996
*	Holz Her	73	16	20 KN	3	3		025024
*	IMA	82	16	20 KN	3	4	025115	025114

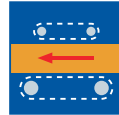
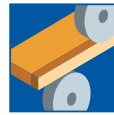
Spare parts

Part Nr.	WZ mm	DIM	QAL	R mm	ID No LH	ID No RH
Turnblade knife	1	16x17,5x2	TC	2		005132
Turnblade knife	1	16x17,5x2	TC	3	005133	005133
Turnblade knife	1	16x17,5x2	TC	4		005134
Turnblade knife	1	16x17,5x2	TC	5		005135
Clamping wedge	1					005325
Screw		M 6x12				006035
Key		SW 3				005444
Setting gauge						005372

- available ex stock
- available at short notice



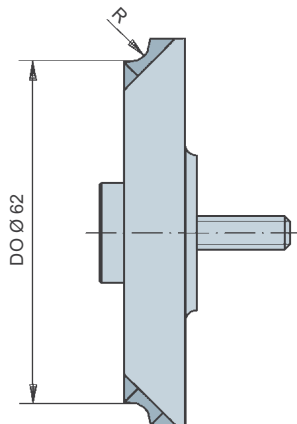
Profile cutter



PCD-tipped radius cutter for profiling plastic and solid wood edges on Homag and IMA machines, RPM_{max} 18.000 U min⁻¹. D0: reference diameter.

DP cutter
WF 501-2-DP *

Class.	DIA mm	D0 mm	BO mm	R mm	T	ID No LH	ID No RH
*	67	67	HSK 32 R	1,0	4	091500	091501
*	62	68	1,5	4		091502	091503
*	62	69	2,0	4		091504	091505
*	62	69	2,0	6		091650	● 091651 ●
*	62	70	2,5	4		091506	091507
*	62	71	3,0	4		091508	091509
*	62	71	3,0	6		091652	● 091653 ●
*	62	72	3,5	4		091510	091511
*	62	73	4,0	4		091512	091513
*	62	73	4,0	6		091654	091655
*	62	74	4,5	4		091514	091515
*	62	75	5,0	4		091516	091517
*	62	75	5,0	6		091656	091657

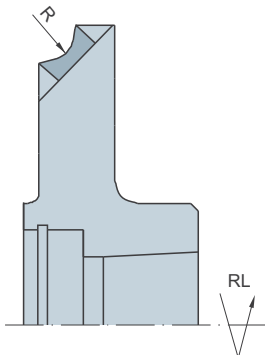


Radius cutter for FK-units with HSK 32-bore

PCD-tipped radius cutter for profiling plastic and solid wood edges on Homag and IMA machines, RPM_{max} 12.000 U min⁻¹. D0: reference diameter.

DP cutter
WF 501-2-DP *

Class.	DIA mm	D0 mm	BO mm	R mm	T	ID No LH	ID No RH
*	79	70	HSK 25 R	1,0	4	091740	091741 ●
*	79	70	HSK 25 R	2,0	4	091744	● 091745 ●
*	79	70	HSK 25 R	2,0	6	091660	● 091661 ●
*	79	70	HSK 25 R	3,0	4	091748	● 091749 ●
*	79	70	HSK 25 R	3,0	6	091662	091663 ●
*	85	70	HSK 25 R	4,0	4	091752	091753 ●
*	85	70	HSK 25 R	4,0	6	091664	091665 ●
*	85	70	HSK 25 R	5,0	4	091756	091757 ●
*	85	70	HSK 25 R	5,0	6	091666	091667 ●
*	85	70	HSK 25 R	6,0	4	091760	091761 ●
*	91	70	HSK 25 R	7,0	4	091764	091765 ●
*	91	70	HSK 25 R	8,0	4	091768	091769 ●
*	91	70	HSK 25 R	9,0	4	091772	091773 ●
*	97	70	HSK 25 R	10,0	4	091776	091777 ●
*	97	70	HSK 25 R	11,0	4	091780	091781 ●
*	97	70	HSK 25 R	12,0	4	091784	091785 ●



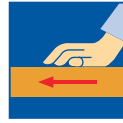
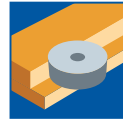
Radius cutter with HSK 25 R-bore



- available ex stock
- available at short notice



Rebate cutterhead



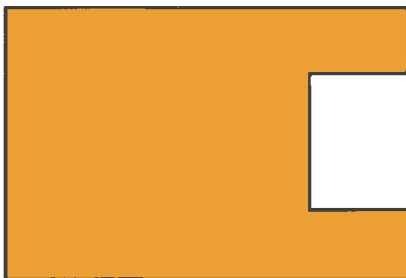
Cutterhead with knives in turnblade design and axially parallel cutting edges for rebating and jointing with and against feed. Spurs have four cutting edges. Spindle moulders against feed, double-end tenoners, edging machines etc., with or against feed.



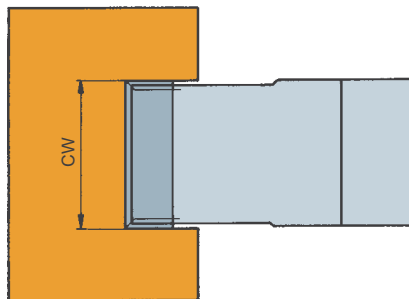
rebating from bottom



rebating from top



grooving



Rebate cutterhead

WW 420-1-01 *

Class.	DIA mm	CW mm	BO mm	BO _{max.} mm	T	S	RPM min ⁻¹	ID No	
*	85	50,4	30	35	2	4	9100 - 15700	024490	●
*	100	30,4	30	40	2	4	7800 - 13300	024491	●
*	100	50,4	30	40	2	4	7800 - 13300	024492	●
*	125	30,4	30	50	2	4	6200 - 10600	024493	●
*	125	30,4	35	50	2	4	6200 - 10600	024495	●
*	125	30,4	40	50	2	4	6200 - 10600	024496	●
*	125	30,4	50	50	2	4	6200 - 10600	024497	●
*	125	50,4	30	50	2	4	6200 - 10600	024498	●
*	125	50,4	35	50	2	4	6200 - 10600	024500	●
*	125	50,4	40	50	2	4	6200 - 10600	024501	●
*	125	50,4	50	50	2	4	6200 - 10600	024502	●
*	125	60,4	30	50	2	4	6200 - 10600	024503	●

Spare parts

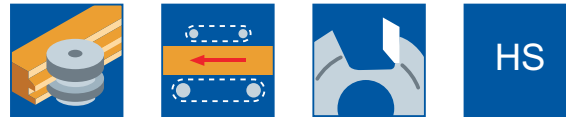
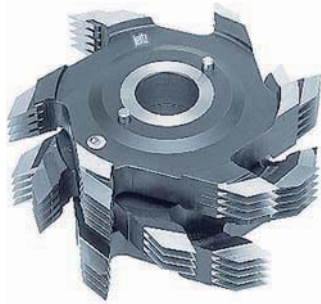
Description	DIM	Remarks	PU PCs	ID No	
Turnblade knife	TC 30x12x1,5	30,4	10	005084	●
Turnblade knife	TC 50x12x1,5	50,4	10	005086	●
Turnblade knife	TC 60x12x1,5	60,4	10	005087	●
Spur	TC 14x14x2		10	005099	●
Clamping wedge	30			005273	●
Clamping wedge	50			005275	●
Clamping wedge	60			005276	●
Screw	M6x12			006035	●
Screw	M6x0,5x4,9; T 20			006243	●
Key	SW3			005444	●
Key	T 20			117503	●
Setting gauge	1,0			005350	●

PU = packing unit

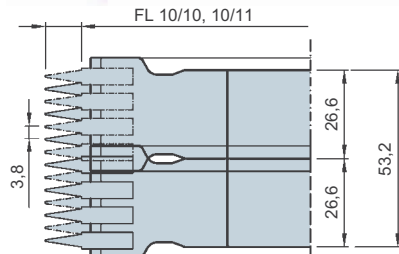
- available ex stock
- available at short notice



Minifinger joint cutter



Tipped minifinger cutter in rugged design in different cutting materials depending on workpiece material, with single brazed on **HS special** fingers to minimise breakages. Minifinger joint cutter, standard and double cutting width, HS special fingers.

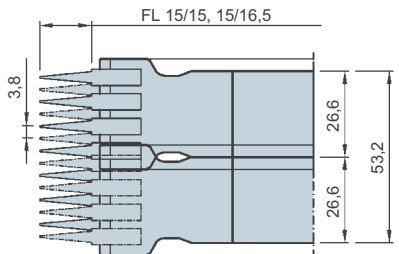


Minifinger joint cutter FL 10 mm, pitch 3,8 mm

Finger length 10 mm, pitch 3,8 mm

WF 620-2-05 *

Class.	DIA mm	CW mm	BO mm	T	QF STCK	QAL	RPM _{max} min ⁻¹	ID No FL 10/10	ID No FL 10/11
*	160	28,6	50	2/2	7	HS-spec.	8000	120010	● 120012 ●
*	160	55,2	50	2/2	14	HS-spec.	8000	120011	● 120013 ●
*	160	28,6	50	3/3	7	HS-spec.	8000		120016 ●
*	250	28,6	50	3/3	7	HS-spec.	6000		120014 ●
*	250	55,2	50	3/3	14	HS-spec.	6000		120015 ●

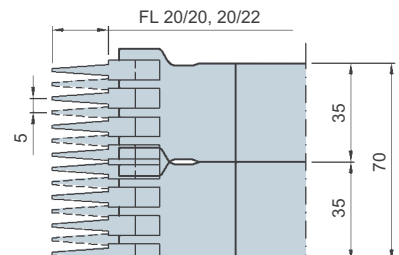


Minifinger joint cutter FL 15 mm, pitch 3,8 mm

Finger length 15 mm, pitch 3,8 mm

WF 620-2-05 *

Class.	DIA mm	CW mm	BO mm	T	QF PCs	QAL	RPM _{max} min ⁻¹	ID No FL 15/15	ID No FL 15/16,5
*	170	28,6	50	2/2	7	HS-spec.	8000	120110	● 120112 ●
*	170	55,2	50	2/2	14	HS-spec.	8000	120111	● 120113 ●
*	260	28,6	50	3/3	7	HS-spec.	6000		120114 ●
*	260	55,2	50	3/3	14	HS-spec.	6000		120115 ●

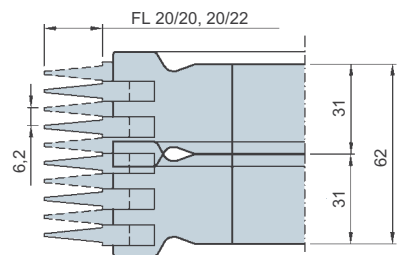


Minifinger joint cutter FL 20 mm, pitch 5,0 mm

Finger length 20 mm, pitch 5,0 mm

WF 620-2-05 *

Class.	DIA mm	CW mm	BO mm	T	QF PCs	QAL	RPM _{max} min ⁻¹	ID No FL 20/20	ID No FL 20/22
*	180	37	50	2/2	7	HS-spec.	8000	120202	120207
*	260	37	50	3/3	7	HS-spec.	6000		120208



Minifinger joint cutter FL 20 mm, pitch 6,2 mm

Finger length 20 mm, pitch 6,2 mm

WF 620-2-05 *

Class.	DIA mm	CW mm	BO mm	T	QF PCs	QAL	RPM _{max} min ⁻¹	ID No FL 20/20	ID No FL 20/22
*	180	33	50	2/2	5	HS-spec.	8000	120200	● 120203 ●
*	180	64	50	2/2	10	HS-spec.	8000	120201	● 120204 ●
*	260	33	50	3/3	5	HS-spec.	6000		120205 ●
*	260	64	50	3/4	10	HS-spec.	6000		120206 ●

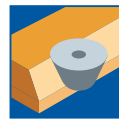
Table for quantity of cutters page 266 Leitz Lexicon 4



- available ex stock
- available at short notice



Variangle bevel cutterhead

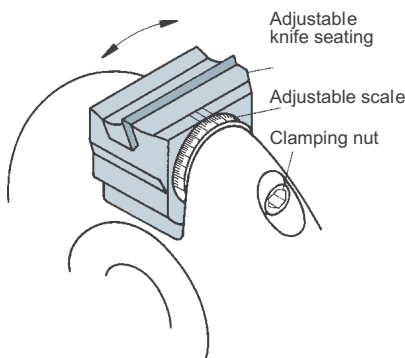


Adjustable turnblade cutterhead for cutting bevels from 0° to 85°, straight jointed edges, rebates and raised panels. Can be used as a rebate head with additional part with spurs.

Adjustable bevel angle

WW 341-1 *

Class.	DIA mm	D _{max.} mm	CW mm	BO mm/inch	BO _{max.} mm	Swivel range	RPM min ⁻¹	T	ID No
*	130	147	40	30	30	0° - 85°	6000 - 8000	2	024279 ●
*	150	174	50	30	40	0° - 85°	5000 - 8000	2	024275 ●
*	150	174	50	1 1/4	40	0° - 85°	5000 - 8000	2	024281 ●
*	150	174	50	40	40	0° - 85°	5000 - 8000	2	024288 ●
*	160	191	60	30	40	0° - 85°	5000 - 6000	2	024280 ●
*	170	194	50	50	60	0° - 85°	4500 - 6000	2	024278 ●
*	190	232	80	40	50	0° - 45°	4000 - 6000	2	024282 ●



Bevel cutterhead with swivelling knife seating

1. Adjustable knife seating
2. Setting scale
3. Clamping nut

Machine:

Spindle moulders, moulders, double-end tenoners, edging machines, etc.

Workpiece material:

Soft- and hardwood, chipboard and fibre materials (without coating, plastic coated, veneered, etc.), laminated woods.

Additional tool body with spurs

WW 590-1 *

Class.	DIA mm	D _{max.} mm	CW mm	BO mm	BO _{max.} mm	RPM min ⁻¹	T	ID No
*	150	174	40	30	30	5000 - 8000	V2	024300 ●
*	170	194	50	50	50	4500 - 6000	V2	024303 ●

Spare parts

Part	DIM mm	for DIA mm	ID No
For ID Nr. 024685 – 024689:			
Turnblade knife (PU 10 pcs.)	40x12x1,5		005085 ●
Turnblade knife (PU 10 pcs.)	50x12x1,5		005086 ●
Turnblade knife (PU 10 pcs.)	60x12x1,5		005087 ●
Turnblade knife (PU 10 pcs.)	80x13x2,2		005096 ●
Spur (PU 10 pcs.)	14x14x2,0		005099 ●
Clamping wedge	40		005348 ●
Clamping wedge	50		005346 ●
Clamping wedge	60		005349 ●
Clamping wedge	80		009273 ●
Screw	M6x12		006035 ●
Screw	M6x16		006036 ●
Screw	M5x6		005758 ●
Bolt clamping nut	18x70,5		009152 ●
Bolt clamping nut	16x13	130	005687 ●
Bolt clamping nut	16x15	150 - 190	005683 ●
Key	SW 8		005437 ●
Key	SW 3		005433 ●
Setting gauge			005352 ●

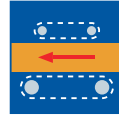
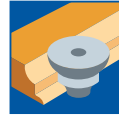
PU = packing unit

- available ex stock
- available at short notice





Profile cutterhead VariForm



Multi-purpose profile cutterhead for mechanical feed for HW profile knives and backing plates. Maximum profile depth of 20 mm.

Part profiled tool body, mech. feed, T 3 (U-profile)

Class	DIA mm	TBD mm	CW mm	BO mm	BO _{max.} mm	PD _{max.} mm	RPM _{max.} min ⁻¹	ID No
	150	135	40	30 DKW	30 DKW	20	8000	135200 ●
	150	135	50	30 DKW	30 DKW	20	8000	135201 ●
	150	135	60	30 DKW	30 DKW	20	8000	135202 ●

With clamping wedges, but without backing plates and without knives.

Part profiled tool body, mech. feed, 4 (U-profile)

Class	DIA mm	TBD mm	CW mm	BO mm	BO _{max.} mm	PD _{max.} mm	RPM _{max.} min ⁻¹	ID No
	180	165	40	35 DKW	35 DKW	20	7200	135203 ●
	180	165	50	35 DKW	35 DKW	20	7200	135204 ●
	180	165	60	35 DKW	35 DKW	20	7200	135205 ●
	180	165	40	30	50	20	7200	135206 ●
	180	165	50	30	50	20	7200	135207 ●
	180	165	60	30	50	20	7200	135208 ●

With clamping wedges, but without backing plates and without knives.

Part profiled tool body, mech. feed, 4 (U-profile) with mounting for Leitz-quick-clamping sleeve DIA=160 mm

Class	DIA mm	TBD mm	CW mm	BO mm	BO _{max.} mm	PD _{max.} mm	RPM _{max.} min ⁻¹	ID No
	200	185	40	60	60	20	6000	135209 ●
	200	185	50	60	60	20	6000	135210 ●
	200	185	60	60	60	20	6000	135211 ●

With clamping wedges, but without backing plates and without knives.

Blanks

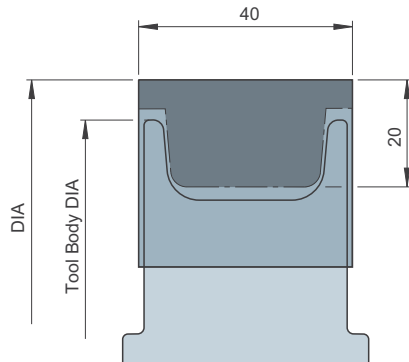
Knife height mm	CW mm	PD _{max.} mm	ID No Knife TC1	ID No Knife TC2
45	40	20	636239	636226 ●
45	50	20	636271	636283 ●
45	60	20	636275	636287 ●

Backing plates

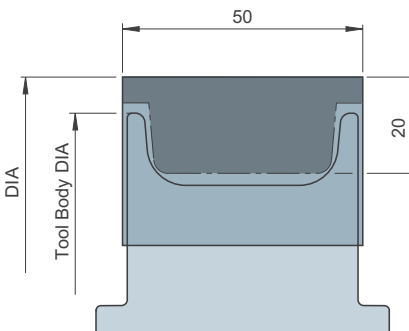
Knife height mm	CW mm	PD _{max.} mm	ID No
45	40	20	645004 ●
45	50	20	645005 ●
45	60	20	645006 ●

Spare parts

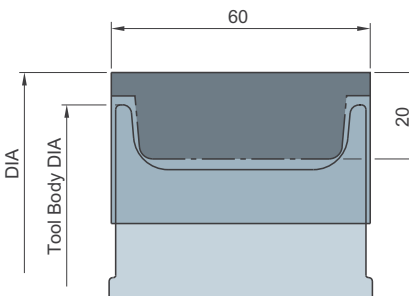
Part mm	DIM mm	for CW mm	ID No
Clamping wedge	36x13,21x25	40	009756 ●
Clamping wedge	44x13,21x25	50	009760 ●
Clamping wedge	56x13,21x25	60	009757 ●
Screw	DIN 915, M10x12		006044 ●
Key	SW 5		117506 ●



Tool body, U-profile, CW 40 mm



Tool body, U-profile, CW 50 mm



Tool body, U-profile, CW 60 mm

VariForm-system:

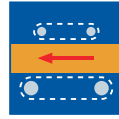
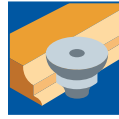
– Knives can be resharpened 3 to 4 times.



- available ex stock
- available at short notice



Profile cutterheads



Profile cutterhead with high precision 60° serrations, 1,6 mm pitch for serrated back blanks, 8 or 10 mm thick.

Technical information:

Knife height: up to 70 mm

Resharpener area: 6,4 mm

WM 501-2-05 *

Class.	TBD mm	CW mm	BO mm	BO _{max.} mm	T	RPM _{max.} min ⁻¹	ID No	
*	122	40	35	40	4	9000	135800	●
*	122	40	1 1/2"	40	4	9000	135801	□
*	122	40	40	40	4	9000	135802	●
*	122	80	35	40	2	9000	135803	●
*	122	80	1 1/2"	40	2	9000	135804	□
*	122	80	40	40	2	9000	135805	●
*	122	60	35	40	4	9000	135806	●
*	122	60	1 1/2"	40	4	9000	135807	□
*	122	60	40	40	4	9000	135808	●
*	122	80	40	40	4	9000	135809	●
*	122	100	35	40	4	9000	135810	●
*	122	100	1 1/2"	40	4	9000	135811	□
*	122	100	40	40	4	9000	135812	●
*	122	130	35	40	4	9000	135813	●
*	122	130	40	40	4	9000	135814	●
*	122	150	35	40	4	9000	135815	●
*	122	170	40	40	4	9000	135816	●
*	122	150	40	40	4	9000	135817	●
*	122	180	35	40	4	9000	135818	●
*	122	180	40	40	4	9000	135819	●
*	122	230	35	40	4	9000	135820	●
*	122	230	40	40	4	9000	135821	●
*	122	240	40	40	4	9000	135822	●
*	137	60	40	50	4	8700	135823	●
*	137	60	1 13/16"	50	4	8700	135824	□
*	137	60	50	50	4	8700	135825	●
*	137	80	50	50	4	8700	135826	●
*	137	100	40	50	4	8700	135827	●
*	137	100	1 13/16"	50	4	8700	135828	□
*	137	100	50	50	4	8700	135829	●
*	137	130	40	50	4	8700	135830	●
*	137	130	50	50	4	8700	135831	●
*	137	150	40	50	4	8700	135832	●
*	137	150	50	50	4	8700	135833	●
*	137	170	50	50	4	8700	135834	●
*	137	180	40	50	4	8700	135835	●
*	137	180	50	50	4	8700	135836	●
*	137	230	40	50	4	8700	135837	●
*	137	230	50	50	4	8700	135838	●
*	137	240	50	50	4	8700	135839	●

Cutterhead with clamping wedges, but without knives. Blanks see section 8.

Spare parts

Part	DIM mm	ID No	
Clamping wedge	40	620700	●
Clamping wedge	60	620701	●
Clamping wedge	80	620702	●
Clamping wedge	100	620703	●
Clamping wedge	120	620704	●
Clamping wedge	130	620705	●
Clamping wedge	150	620706	●
Clamping wedge	170	620707	●
Clamping wedge	180	620708	●
Clamping wedge	230	620709	●
Clamping wedge	240	620710	●
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	230	005313	●
Filler piece	240	620771	●
Screw	M 1031320	007396	●
Key	SW 5	117509	●

- available ex stock
- available at short notice





Cut production costs and shape your future - with Leitz tools



ProfilCut

Leitz ProfilCut is one of the finest custom insert tooling systems available. The combination of extremely tight cutter-head tolerances, exact positioning of knives, and polished micro grain carbide knives offer:

- Perfected cut and finish quality
- Precision fit of mating parts
- Reduction/elimination of sanding and scrap loss
- Maximum service life and machine output
- Reduced downtime due to cutter or knife changes
- Optimized productivity and profitability



ProFix

Leitz ProFix is the ONLY constant diameter, constant profile, re-sharpen-able carbide or diamond profiling option available.

The unique ProFix System offers:

- Profile and machine flexibility
- Excellent finish quality and fit of mating parts
- Exceptional service life, and low maintenance cost
- Minimal machine downtime due to knife changes
- Optimized productivity and profitability

Guide for selection of cutting material

Type of tool		Tipped tool					Tipped tool			Tool set				Single tool Tipped tool Tool set				
Application		Sawing					Hogging			Planing				Cutting				
Cutting material		ST	TCM	TCV	TCH	DP	TCV	TCH	DP	HL	HS	ST	TCV	SP	HL	HS	ST	
Workpiece material		Type																
Solidwood	Softwood	dry			◆		◆	◆			◆			◆	◆	◆	◆	
		wet	◆		◆					◆	◆	◆			◆	◆	◆	
	Hardwood	dry			◆		◆	◆			◆					◆	◆	
		wet	◆		◆						◆	◆					◆	◆
Panels	Glulam (plywood etc.)			◆			◆	◆			◆				◆	◆		
				◆			◆	◆			◆				◆	◆		
	Particle board (Chipboard)	without coating				◆	◆				◆					◆	◆	
		veneered				◆	◆				◆					◆	◆	
		melamine coating				◆	◆				◆					◆	◆	
		paper coating				◆	◆				◆					◆	◆	
	Fibre board (MDF)	without coating				◆	◆				◆					◆	◆	
		veneered				◆	◆				◆					◆	◆	
		melamine coating				◆	◆				◆					◆	◆	
		paper coating				◆	◆				◆					◆	◆	
	Hardboard				◆	◆				◆					◆	◆		
	Softboard				◆	◆				◆					◆	◆		
	High pressure Laminate (HPL)				◆	◆				◆					◆	◆		
	Plastics	Duro plastic (Pertinax...)				◆	◆				◆					◆	◆	
		Thermo plastic (PA, PE, PP...)				◆	◆				◆					◆	◆	
		Fibre reinforced (GFK, CFK...)				◆	◆				◆					◆	◆	
Polymer compound (Corian...)					◆	◆				◆					◆	◆		
Composite materials	Solid wood with HF, MDF...				◆	◆				◆					◆	◆		
	Panels coated with HPL, Kork...				◆	◆				◆					◆	◆		
	Plaster board				◆	◆				◆					◆	◆		
	Cement board				◆	◆				◆					◆	◆		
	Mineral wool			◆	◆					◆					◆	◆		
	Composite with light metal coating			◆	◆					◆					◆	◆		
	Composite with steel coating		◆	◆						◆					◆	◆		
Metal	Light metal	pure (99,5)			◆												◆	
		alloyed															◆	
	Lead alloy																◆	
Copper, zinc, brass																◆		

Type of tool		Single tool Tipped tool Tool set			Single tool Tipped tool Tool set						Single tool Tipped tool Tool set						
Application		Cutting			Routing						Drilling						
Cutting material		TCV	TCH	DP	SP	HL	HS	ST	TCV	TCH	DP	ST	HS	TCV	TCH	DP	
Workpiece material		Type															
Solidwood	Softwood	dry	◆				◆	◆	◆	◆			◆	◆	◆		
		wet					◆	◆	◆			◆	◆	◆			
	Hardwood	dry	◆				◆	◆	◆				◆	◆	◆	◆	
Panels	Glulam (plywood etc.)		◆	◆			◆	◆			◆		◆	◆	◆		
			◆	◆			◆	◆			◆		◆	◆	◆		
	Particle board (Chipboard)	without coating		◆	◆			◆	◆			◆		◆	◆	◆	
		veneered		◆	◆			◆	◆			◆		◆	◆	◆	
		melamine coating		◆	◆			◆	◆			◆		◆	◆	◆	
		paper coating		◆	◆			◆	◆			◆		◆	◆	◆	
	Fibre board (MDF)	without coating		◆	◆			◆	◆			◆		◆	◆	◆	
		veneered		◆	◆			◆	◆			◆		◆	◆	◆	
		melamine coating		◆	◆			◆	◆			◆		◆	◆	◆	
		paper coating		◆	◆			◆	◆			◆		◆	◆	◆	
	Hardboard		◆	◆			◆	◆			◆		◆	◆	◆		
	Softboard	◆	◆				◆	◆			◆		◆	◆	◆		
	High pressure Laminate (HPL)		◆	◆			◆	◆			◆		◆	◆	◆		
	Plastics	Duro plastic (Pertinax...)	◆	◆	◆			◆	◆			◆		◆	◆	◆	
		Thermo plastic (PA, PE, PP...)	◆	◆	◆			◆	◆			◆		◆	◆	◆	
		Fibre reinforced (GFK, CFK...)	◆	◆	◆			◆	◆			◆		◆	◆	◆	
Polymer compound (Corian...)		◆	◆	◆			◆	◆			◆		◆	◆	◆		
Composite materials	Solid wood with HF, MDF...	◆	◆	◆			◆	◆			◆		◆	◆	◆		
	Panels coated with HPL, Kork...	◆	◆	◆			◆	◆			◆		◆	◆	◆		
	Plaster board	◆	◆	◆			◆	◆			◆		◆	◆	◆		
	Cement board	◆	◆	◆			◆	◆			◆		◆	◆	◆		
	Mineral wool	◆	◆				◆	◆			◆		◆	◆	◆		
	Composite with light metal coating	◆	◆				◆	◆			◆		◆	◆	◆		
	Composite with steel coating	◆	◆				◆	◆			◆		◆	◆	◆		
Metal	Light metal	pure (99,5)	◆				◆	◆			◆		◆	◆	◆		
		alloyed	◆				◆	◆			◆		◆	◆	◆		
	Lead alloy	◆				◆	◆			◆		◆	◆	◆			
Copper, zinc, brass	◆				◆	◆			◆		◆	◆	◆				

◆ suitable ◆ partly suitable

Explanation of abbreviations

a_e	= cutting thickness (radial)	$m \text{ min}^{-1}$	= metres per minute
a_p	= cutting depth (axial)	$m \text{ s}^{-1}$	= metres per second
Abbrev.	= abbreviation	MU	= width side relieve
BDD	= thickness of shoulder	NAL	= position of hub
BO	= bore diameter	NB	= grooving width
$BO_{max.}$	= max. bore diameter	NoW	= no. of wiper teeth (=Lexicon 4 ARS)
CEL	= cutting edge length (=Lexicon 4 NL)	ND	= thickness of hub
CNC	= Computer Numerical Control	NFL	= grooving depth/length of tongue
CW	= cutting width (cutters)	NH	= zero height
DIA	= cutting circle diameter (=Lexicon 4 D)	NMR	= grooving knife
D0	= zero diameter	NT	= grooving depth
DB	= diameter of shoulder	OU	= without side relieve
DGL	= number of links	OAL	= over all length
Description	= description	Part	= article
DIN	= German industry standard	Part No	= article number (=Lexicon 4 ART Nr.)
DIM	= dimension (= Lexicon 4 ABM)	Plate	= thickness of tool (=Lexicon 4 TDI)
Downcut	= left hand twist / downcut	PW	= profile width (=Lexicon 4 PB)
DKW	= double keyway	PR. No.	= profile number
DP	= diamond polycrystalline	PD	= profile depth (=Lexicon 4 PT)
D Dia	= shank diameter	PG	= profile group
DTK	= reference diameter	PH	= pinhole dimensions (= Lexicon 4 NLA)
Fabr. Masch	= make of machine	QAL	= cutting edge quality
FAW	= bevel angle	QF	= quantity fingers
FB	= bevel width	R	= radius
FD	= thickness of tongue	RH	= right hand rotation
FL	= finger length	RPM	= Rotation per minute
FLD	= flange diameter	$RPM_{max}/n_{max.}$	= maximum permissible RPM
Fr. Nr.	= number of cutter	S	= shank dimension
f_z	= tooth pitch	SLB	= slotting width
$f_{z\text{eff}}$	= effective tooth feed	SLL	= slotting length
Grind	= grind tooth shape (cutting edge shape) (=Z)	SLT	= slotting depth
GD	= grooving depth	SP	= tool steel
H	= height	ST	= stellite
HD	= wood thickness (thickness of workpiece)	STD	= diameter of dowels
HL	= high-alloyed tool steel	TD	= diameter of tool body
HS	= high-speed steel (HSS)	TG	= pitch
ID No.	= ident number	Thickn.	= thickness (=Lexicon DIK)
ID Nr. LH	= ident number left hand rotation	PD	= profile depth
ID Nr. RH	= ident number right hand rotation	PU	= packing unit
IV	= insulation glazing	PoH	= position of hub
Kerf	= cutting width	RPM	= revolutions per minute (RPM)
Kerf	= cutting width (sawblades) = SB	Upcut	= upcut (=Lexicon right hand twist)
KLH	= clamping height	V	= no. of spurs
KM	= edge breakers	v_c	= cutting speed
KW	= keyway	v_f	= feed speed
KNW	= keyway width	VSB	= adjustment range
KND	= keyway depth (incl. bore)	W	= width (=Lexicon 4 B)
L	= length	WZ Nr.	= tool number
LEN	= leitz standard profiles	WL	= working length (=Lexicon 4 AL)
LH	= left hand rotation	Teeth	= no. of teeth (=Lexicon 4 Z)
M	= metric thread	T	= Teeth
MA	= measure A	TC / TCT	= tungsten carbide / tungsten carbide tipped
MB	= measure B		
MK	= morse taper		

Explanation of pictograms

	Sawing along grain		Scoring on top, on bottom		Grooving guiding groove		Jointing bevelling profiling		Grooving horizontal, vertical		Mech. feed		Noise reduced
	Sawing thin kerf		Hogging		Jointing		Plunging		Copy-shaping grooving		Manual feed		Optimized chip flow
	Sawing horizontal		Hogging along grain		Copy shaping		Through-hole boring		Jointing		Solid/regrindable one-part tool	SP	Alloyed tool steel
	Sawing single		Hogging across grain		Rebating		Counter-sinking		Rebating		Tipped tool regrindable	HL	High-alloy tool steel
	Sawing from top solid wood		Hogging folding		Bevelling		Step drilling		Bevelling		Mech. edge clamping exchangeable	HS	High-speed steel
	Sawing across grain trimming		Pre-planing horizontal		Bevelling rounding fluting		Slot mortising		Profiling		Mech. edge clamping reversible	ST	Stellite
	Sawing multi purpose		Pre-planing vertical		Profiling		Excentric		Bevelling rounding fluting		Centrifugal edge clamping reversible	TC	Tungsten Carbide
	Scoring sawing		Finish planing horizontal		Profiling glue joint		Boring/cutting		Finger jointing		Mech. edge clamping not regrindable	TCT	Tungsten carbide tipped
	Sawing packs		Finish planing vertical		Profiling finger joint		Carving		Mitre jointing		Mech. edge clamping not readjustable	TCM	Tungsten carbide for metal processing
	Sawing from top hollow profile		Planing profiling		Profiling mitre joint		Plug cutting		Counter-profile		Mech. edge clamping adjustable	TCV	Tungsten carbide for solid wood processing
	Sawing hollow profile		Grooving horizontal, vertical		Profiling counter-profiling		Interior cutting		Raised panels		Mech. edge clamping exchangeable and constant diameter	TCH	Tungsten carbide wood derived material processing
	Scoring hogging		Grooving lamello		Profiling tongue/groove		Exterior cutting roughing finishing		Mortising		Mech. edge clamping cassette system	DP	Poly-crystalline diamond (PCD)
	Trimming		Finger jointing		Panel raising		Copy shaping		Coated high-speed steel		Centrifugal edge clamping reversible and regrindable	DM	Mono-crystalline diamond (MCD)

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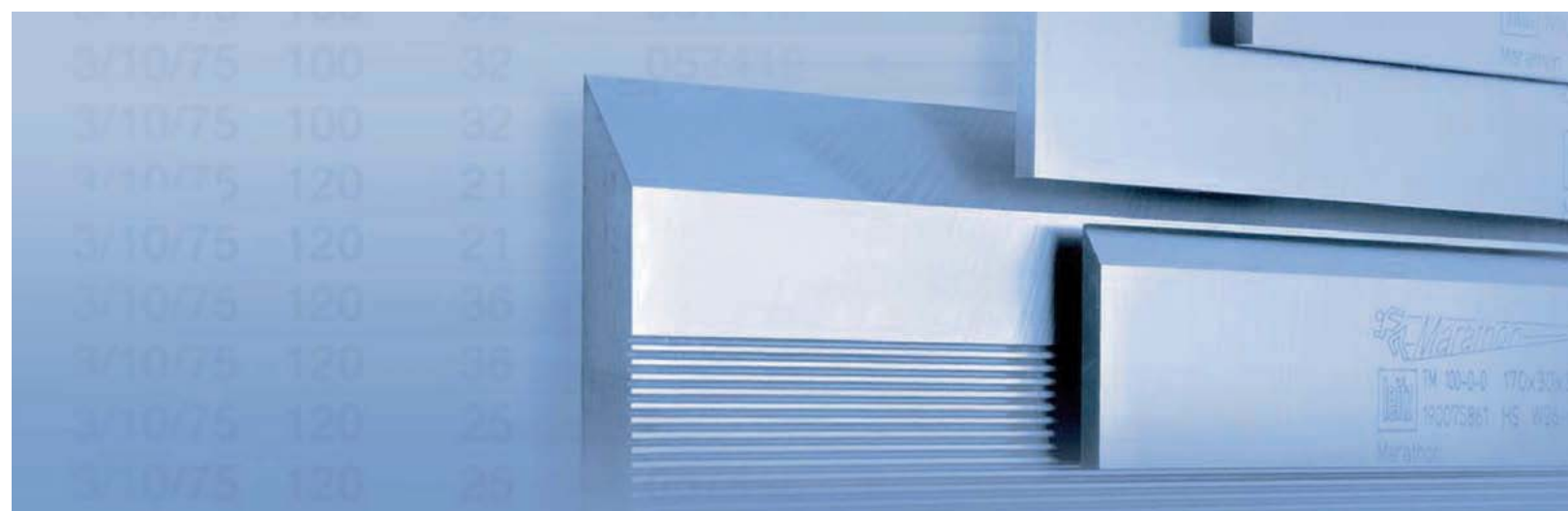
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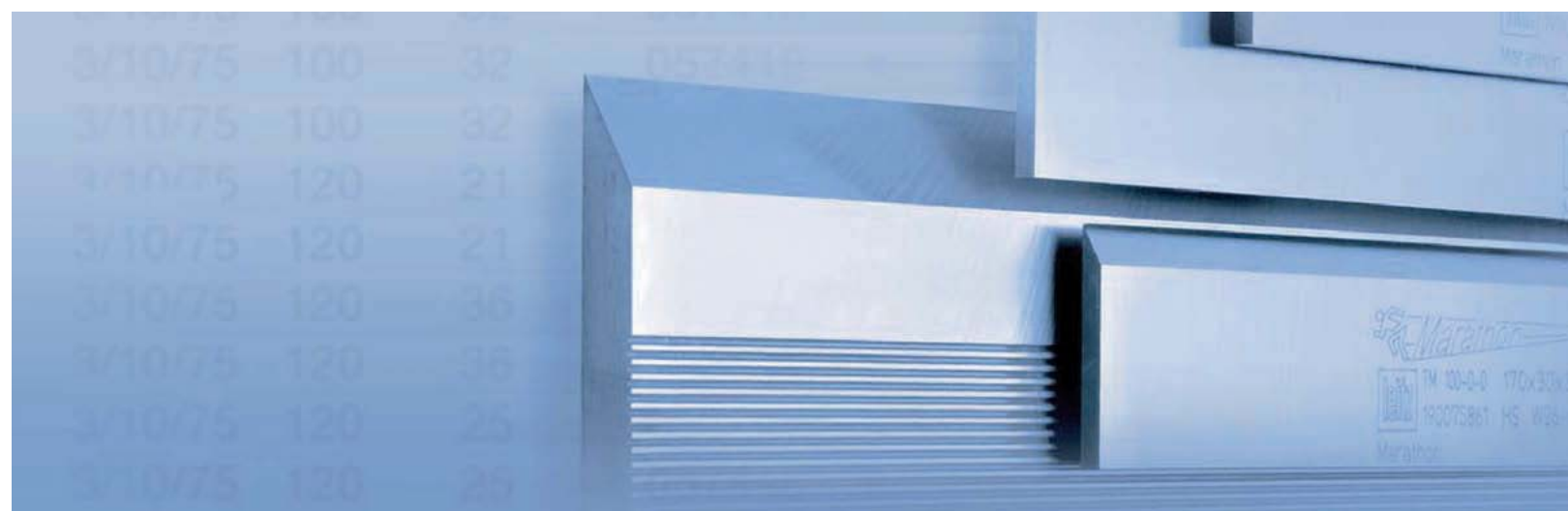
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